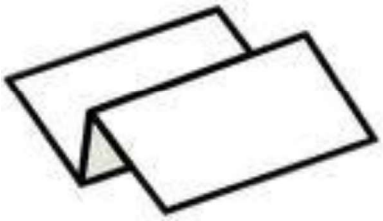
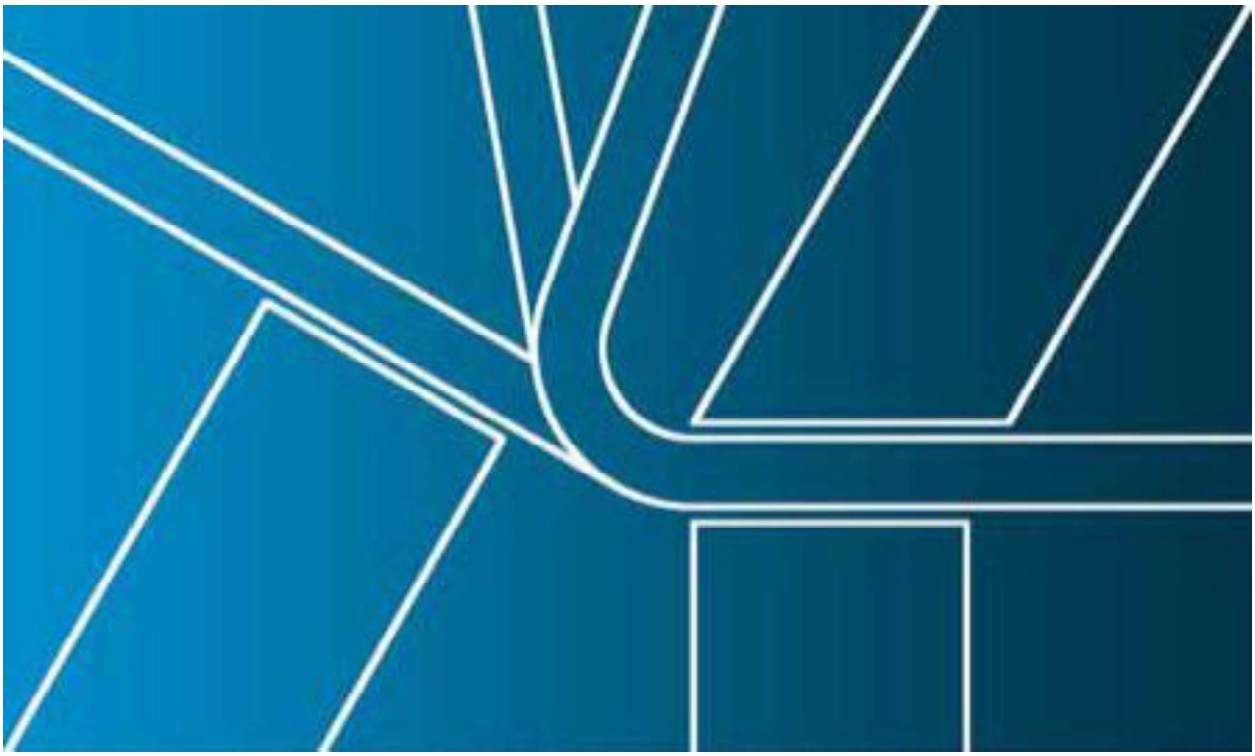
FORDING MACHINE

OPERATING INSTRUCTION MANUAL



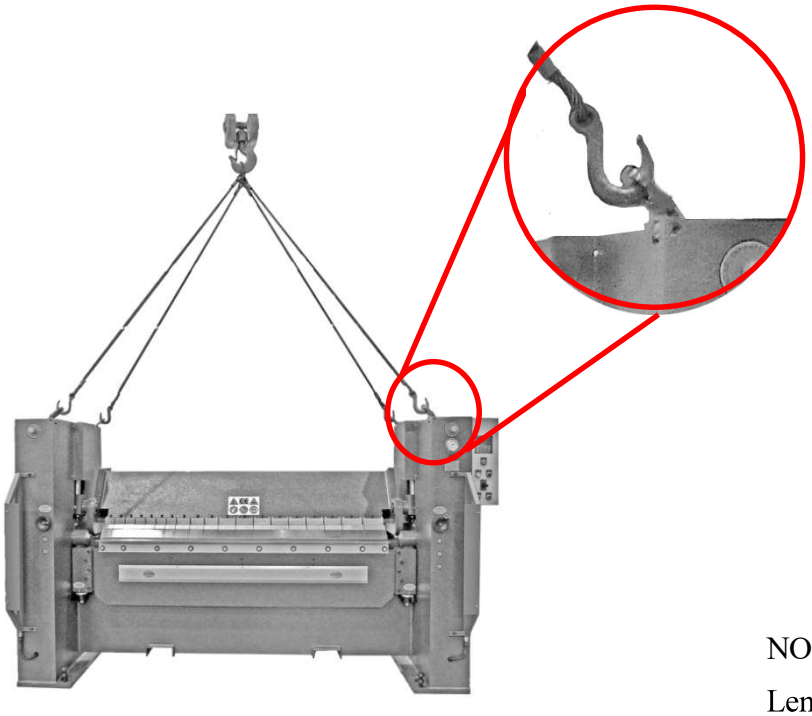


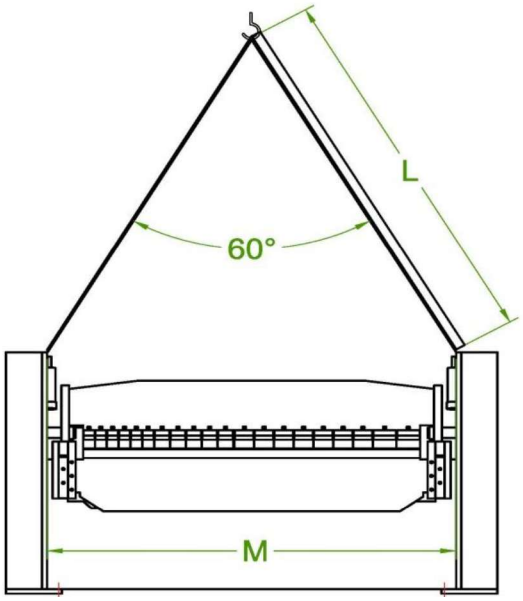
MODEL	**:**	**BB-12010H-NC**
SERIAL NO	**:**	**8894**
MAIN	**:**	**5HP / 3∅**
VOLTAGE	**:**	**220V / 60HZ**
DATE	**:**	**Jan. 2023**

Transportation after unpacking

By traveling crane

1. The carry capacity for the crane must over the total weight of the machine.
2. The carry capacity for the wire steel hook must over the total weight of the machine, and mind if there is any damage on the wire steel.
3. According to the following drawing shows, let the wire steel cross four corner hooks. And put the center of gravity to the middle of the crane. (Four wire steel hooks will be needed.)
4. When operation, mind the surface between wire steel and the machine painting, please use some paper or cloth to isolate, prevent damage on the painting surface of machine.
5. Mind the wire steel to avoid touching with the machine, please maintain balance and level.





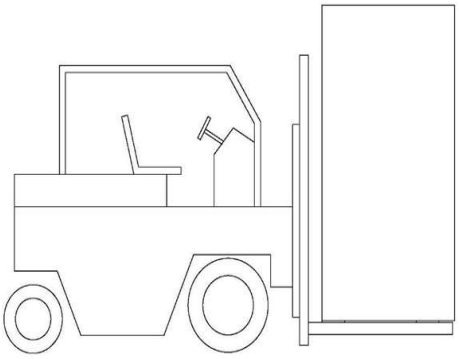
NOTIC:

Length of Wire Steel L ≥ M
Included Angle ≤ 60 degree

Please use forklift for mainly transportation. (Wire steel hook is suggested when the environment is negative.)

By forklift.

1. when use forklift to transportation, please move the center of gravity to the middle, the length of fork for forklift should be at least 500mm over the center of machine.
2. In transporting, please use the tool which strong than total weight of the machine
3. In transporting, machine position on the forklift, refer to the drawing as right, mind the stable of machine and balance of the gravity as well.



“CAUTION”-HYDRAULIC OIL SPECIFICATION

1. USE HYDRAULIC OIL AW46 SHELL BRAND or EQUIVALENT SPECIFICATION OF OTHER BRANDS.

2. FILL HYDRAULIC OIL INTO HYDRAULIC TANK UP TO 90% FULL. (BEFORE RUNNING THIS MACHINE, PLEASE DO NOT FORGET TO FILL HYDRAULIC OIL AW46 SHELL BRAND 60 LITERS INTO OIL TANK.)

DO NOT RELY ON OIL GAUGE WHICH SOMETIMES GIVE INCORRECT OIL-LEVEL INDICATION.
DOUBLE-CHECK TO OIL TANK AND MAKE SURE OIL TANK IS, AT LEAST, 90% FULL.

SHORTAGE OF HYDRAULIC OIL WILL CAUSE HYDRAULIC SYSTEM/PUMP BREAK-DOWN AND DAMAGE TO MAJOR MECHANICAL PARTS BECAUSE OF OVERHEAT.

3. CHANGE HYDRAULIC OIL EVERY 6 MONTHS.

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FOREWORD

For the satisfactory performance of **VH** series and the high level of their product, it is essential that all personnel concerned with their operation, maintenance and production management be fully familiarized with the specifications and capabilities, constructions and functions of the machines, their components and related equipment as well as the correct methods for their operation, maintenance, etc.

This Manual has been prepared as a guide not only for shop workers but for shop managers to meet the above mentioned requirements. The Manual covers the specifications, constructions, operations and lubrication, etc.

As the policy of **MANUFACTURER**, is one of progressive in prove in design and construction, the machines referred to in this Manual may be subject to change in keeping with this policy. The manufacturers therefore, reserve the right to make these changes without giving prior notice.

NOTE: Working capacity is based on mild steel, approximately 55,000 PSI tensile.

We reserve the right to modify specifications of change design without notice.

For security reason, please read weight list first.

CAUTION: THIS MACHINE MIGHT BE DANGEROUS, IF NOT USED PROPERLY.

PREPARATION

CONTINUOUS EFFORTS IN OPERATION PREPARATION, REGULAR MAINTENANCE AND PROPER OPERATION, ENSURE YOU PERFECT FUNCTIONS AND EFFICIENCY. SO, PLEASE NOTICE THE FOLLOWINGS:

UNPACKING

Unpack the machine as soon as you receive it on hand and check and see whether there is any damage caused during transportation. Please immediately notify the transportation company, the insurance company or us, if needed. Inspect all parts and accessories with particular care. In order to save the transportation space, some parts and successors are bulk packing on some machines. You only have to take them out and re-assemble them according to the illustrations.

INSTALLING

A space of one meter or wider must be reserved on front, rear, left and right sides. The light must be not less than 100W. When install machines, please pay attention to machine's level.

CLEANING

Use a liquid solvent such as kerosene or white spirit to remove the protective coating and any dirt from the unpainted surfaces of the machine. Do not disturb any moving parts until all surfaces have been cleaned.

OIL FILLING

Do not forget to fill oil before the pump starts.

LUBRICATING

Lubricate the moving parts of the machine with light grease or heavy oil. Lasting accuracy depends on proper lubrication.

CAUTION: THIS MACHINE MIGHT BE DANGEROUS, IF NOT USED PROPERLY.

SAFETY PRECAUTIONS

IMPORTANT SAFETY INFORMATION:

PROHIBITION:

Untrained operators are prohibited to use this machine.

Modifications that change the function or specification of this machine should be prohibited.

Operation before reading through this manual is prohibited.

LIGHTING:

Appropriate lighting must be provided, according to local regulation.

ENVIRONMENT:

Ambient air temperature:

+5˚c ~ +55˚c in free air, and the average ambient air temperature over a period of 24 hours shall not exceed +50 ˚c

Humidity: 30%~95%.

Altitude: up to 1000m above mean see level.

Transportation & Storage condition:

—25˚C ~ +55˚C, and for short periods not exceeding 24 hours up to +70˚c.

SAFETY RULES DURING AND/OR BEFORE OPERATION

Tools and any unnecessary items are not allowed on the machine, moving parts, or similar locations.

Before pressing/switching any button/switch always confirm that the button/switch is the correct one and never touch a switch accidentally. Malfunction and potential danger might result.

Do not operate when wearing gloves or loose clothing. Malfunction and potential danger might result.

Do not touch switches with wet hands, an electric shock could occur.

If a work requires two or more operators, the cooperation among each operator must be well organized; every step of each operator should be clarified to avoid potential danger.

Tools should be consisting with the machine's specifications, such as dimensions, weight and types.

Grip work pieces carefully to minimize movement and vibration between work pieces. Too much movement/vibration might result in injuries of personnel, or damage the machine or work piece.

Stop the machine before replacing work piece, and reserve sufficient distance between work piece and machine.

SAFETY FOR THE ELECTRICAL CONNECTION/DISCONNECTION

ELECTRICAL CONNECTION:

A cable with four wires is supplied to connect your machine into the 3 phase power supply.

The exact power source voltage, frequency, and number of phase shall be checked according to the installation diagram and circuit diagram.

The correct direction of spindle should be checked after connecting.

Electrical disconnection:

Be sure to disconnect this machine from power source, when you want to stop the job for maintenance or adjustment.

GROUNDING

The grounding of this model is carried out by connecting the yellow/green terminal of supply cable to the grounding terminal of power source. Be sure to ground your machine before connecting machine to power source in any situation.

Warning!
Do not disconnect grounding terminal before disconnecting power source!

THE EMERGENCY STOP DEVICE:

The machine is designed to be immediately stopped under emergency situation. As soon as this device is actuated, any movement will be stopped in a short time after the actuation of emergency button.

Be sure to check that machine action will stop immediately after this button is pressed and will not cause any action when this button is disengaged.

SAFETY INSPECTION

To ensure safety, it is necessary to do the following inspections for this machine after installation.

Check if the transportation procedure has influenced the accuracy and functions of the machine.

Check if the foundation of the machine is appropriate.

Check if the factory has the correct thunder - preventing system under 25. The machine's main power switch should also have earth wiring connected.

Use the multi tester to check the stability of the three-phase voltage

Check if the control panel functions and push button are functioning

Check emergency stop function.

Check if safety protection accessories are functioning well

Check if other accessories, including hydraulic and pneumatic ones, are connected well (including transformer etc.)

Check if the oil amount indicator and air pressure indicator are normal.

Make sure no obstacle is around machine and control system.

Make sure no personnel are in dangerous area.

INSTALLATION

SLINGING

Make sure of the followings before slinging:

Make sure that the sling is of adequate load-carrying capacity.

Adjust the position of carriage for balancing.

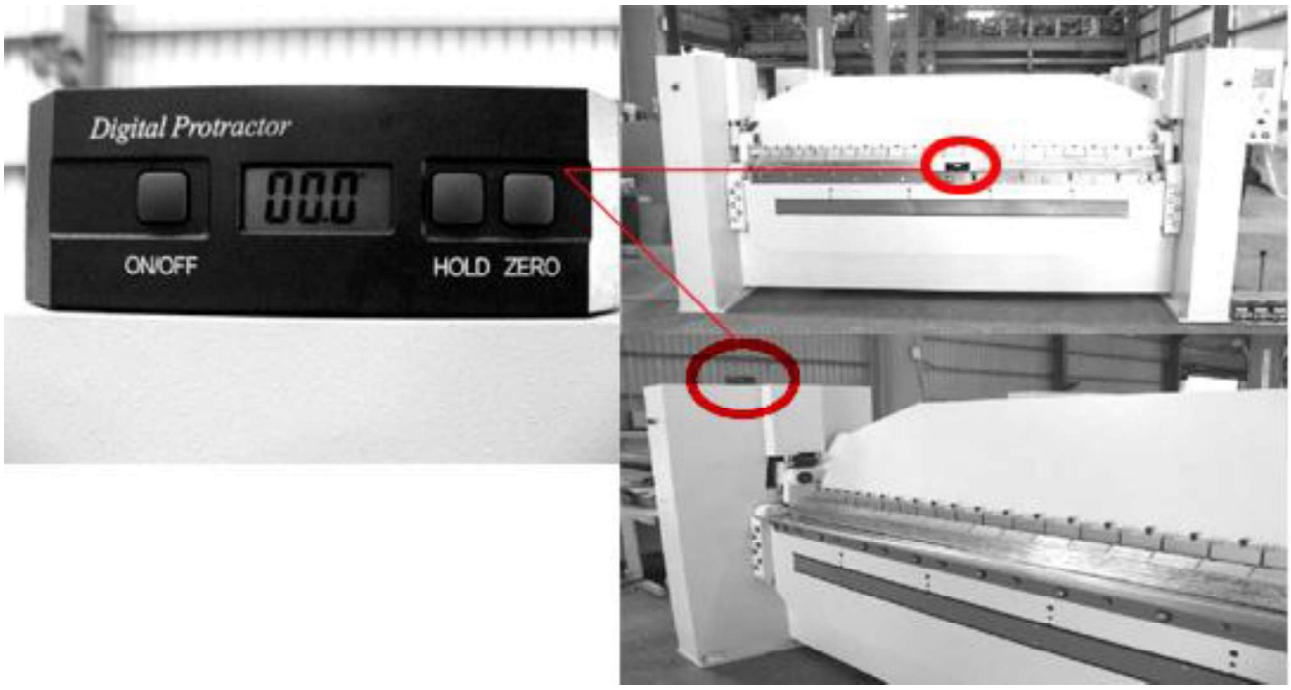
LEVELING

The machine should be sited on a level, concrete floor foundation. Provision is made for securing the machine with foundation bolts which should be in position prior to machine installation. The production accuracy of all precision machinery depends on the accuracy with the machine is installed.

Install the machine according to the followings:

1. Lower the machine on the prepared foundation.
2. Place the machine on the leveling plates.
3. Adjust the level using Jack Bolts.
4. Put Anchor Bolt and mortar into pits, and fasten the nuts only when the mortar is thoroughly hard.
5. When you adjust the machine level, you should use a level gauge so that the machine has the accuracy with 0.1 mm / 1000 mm.

Adjust the level in the front-rear direction; you check it at the both sides of the table, and in the right-left direction, check at the center.



LUBRICATION

The machine tools in service will as long and will work smoothly, when its lubricants are of those types specified by the manufacturer and if lubricating attentions are given at regular intervals are prescribed.

Lubricant specifications and prescribed lubricating procedures for the present Press are as follows:

LUBRICANT SPECIFICATIONS

Lubricants must be mineral oils: this is a fundamental requirement. Never use any vegetable or animal oil as a lubricant. Such a lubricant used on bearings, for example, will soon result in seized bearings due to overheating. Guide points for selection of a lubricant are:

1. A good lubricant does not change its properties when left in storage.
2. A good lubricant does not present a cloudy appearance.
3. A good lubricant is neutral in chemical reaction.
4. A good lubricant does not mix with water, that is, is hard to emulsify.
5. Carbon forming tendency is low with a good lubricant.
6. Viscosity does not very widely with temperature in a good lubricant.

Lubricant color is no yardstick for judging the quality. Each brand of lubricant has its own color.

HYDRAULIC OIL

The hydraulic oil is primarily the medium of transmitting pressure, but has to function as a lubricant for the various parts of the press. It has to satisfy a number of conflicting requirements: it must be viscous enough to minimize internal leakage within the pump and valves; it must be thin enough to flow in the pipe with minimize hydraulic friction; and it must lubricate the running parts of the pump.

The type of hydraulic oil to be used in the present press brake equipment is specified in the table below. In selecting the oil from a host of oils commercially available, in order to meet the itemized requirements included in the manufacturer's type specifications, the following quality tractors must be referred to:

1. Viscosity number (The oil must be of the specified viscosity number.)
2. Viscosity index (A high viscosity index oil is a better oil)
3. Low pour point.
4. Importing the oil film building up and anti-wear protective properties
5. Resistant to emulsification
6. High oxidation stability
7. Low foaming tendency
8. Non-corrosive property

GREASE

Select a heat-resistant, water-resistant, non-corrosive and stable grease having a high film strength and capable of being applied with the grease gun.

STANDARD LUBRICATING PROCEDURES

How often the hydraulic oil and grease should be inspected, and examined for quality, is indicated in Table2.1 ~ 2.3.

1. Have a complete understanding of the lubricated parts as to their locations, methods of giving lubricating attention and type of lubricant used. This understanding must be had before placing the equipment in initial operation.
2. Cleanliness must be utmost in the mind of one giving lubricating attentions. The filler, level inspection point, grease nipple and lubricating tools must be clean when adding oil, pour through a 60 mesh strainer screen.
3. When refilling and oil tank, take care not to overfill. Too much oil in the tank can result in leakage. Be sure to refer to the level gauge. Leakage of oil can lead to trouble.
4. When refilling the hydraulic oil tank, be sure that the ram is up at upper limit. Filling this tank to the level with the ram down might cause the oil to overflow from the tank.
5. Overcharging the grease is just as bad as undercharging.
6. Do not allow different brands of oil to be mixed in the oil tank. If a different brand has to be used, remove the existing lubricant completely and add the new oil. This applies to the grease, of course.
7. Where the ambient temperature varies widely from one season to another, the lubricant must be changed to suit the current condition. The factor for this change is "viscosity" for oil or "consistency" for grease.
8. To replace the oil by a new supply, effect the replacement in the following sequence:
    a. Drain out the existing oil when the equipment has just been shut down after the day's work.
    b. Contaminated oil drains out more quickly and thoroughly.
    c. If possible, flush the oil circuits with a flushing oil. Do not allow the flushing oil to enter the pump and hydraulic cylinders. Remove the flushing oil completely after flushing.
    d. Whether the flushing oil has been used or not, clean the interior of the oil tank and other accessible parts.
    e. Fill the tank up to level with the fresh supply of oil.

TABLE 2.1 LUBRICATION STANDARD (OIL)

Lubricate point	Level check	Adding	Oil quality check
Main oil tank	Daily	Every six months	Every year

TABLE 2.2 LUBRICATION STANDARD (GREASE)

Lubricate point	Check	Adding	Application
Main motor	Every 4000 / hours	Every 4000 / hours	Grease gun

TABLE 2.3 OPERATING OIL AND GREASE RECOMMENDED

Operating oil	ESSO Teresso 32	MOBIL DTE Oil Light	SHELL Tellus 32
Grease	ESSO Beacon 2	MOBIL Mobillux 2	SHELL Alvania 2

CLAMPING PRESSURE

If your machine has clamping beam pressure adjustment, please adjust the pressure according to the workpiece.

If the pressure is too high, it might damage the surface of the workpiece; In the other hand, if it is too small, will cause the displacement of workpiece and cannot reach the size that you needed.

Table 3.1 CLAMP FORCE VH-XX35SERIOUS

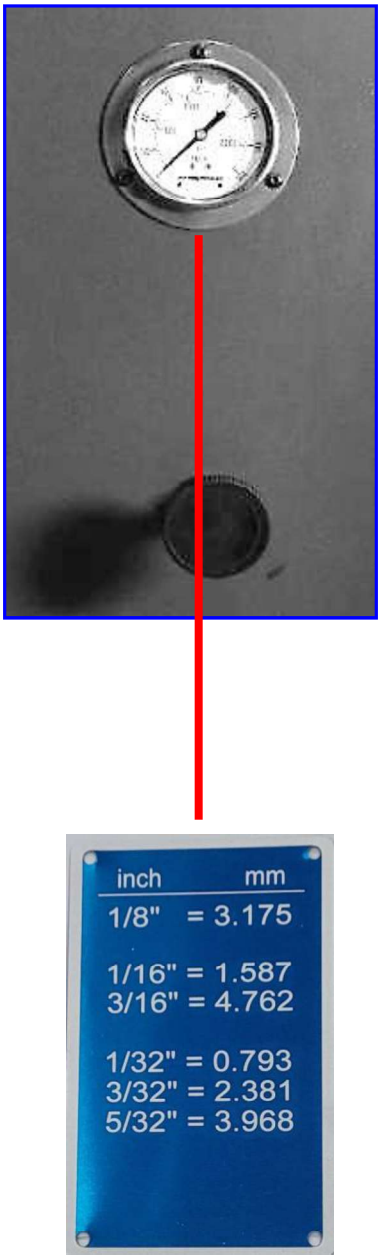
Pressure (kg/cm^2)	50	70	90	110	130
Thickness (mm)	0.5	1	1.5	2	3

Table 3.2 CLAMP FORCE VH-XX45 SERIOUS

Pressure (kg/cm^2)	60	80	100	120	140
Thickness (mm)	0.8	1.2	2	3	4.5

Table 3.3 CLAMP FORCE VH-XX65SERIOUS

Pressure (kg/cm^2)	90	110	130	150	200
Thickness (mm)	1	2	3	4.5	6.5



CLAMPING GAP ADJUSTMENT

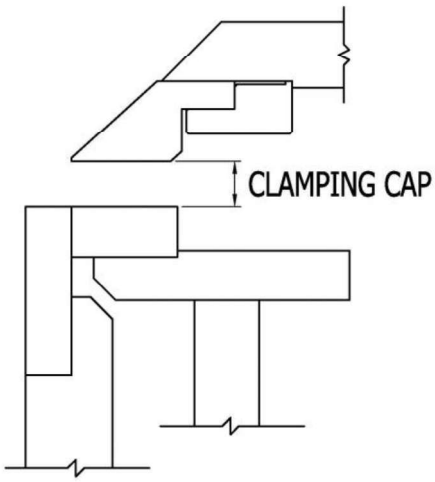
DIRECTION:

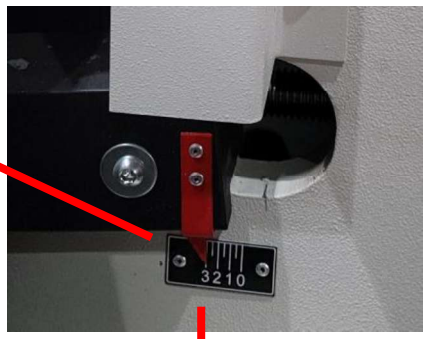
Adjust the clamping pressure In accordance with the thickness of the work piece

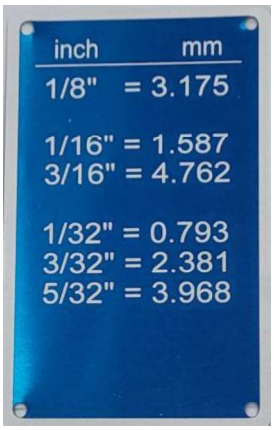
Please follow the following steps:

1. Open the top beam.
2. Switch the front hand wheel according to the workpiece's thickness. Assume the workpiece thickness is 3mm, and then point the guideline to 3









BENDING GAP ADJUSTMENT

DIRECTION:

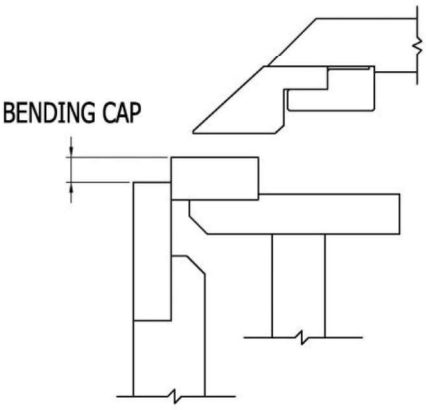
Adjust the bend gap according to the difference of the thickness of workpiece.

Bending Gap ≒ Metrical Thickness X (1.2~1.5)

Please follow the following steps:

1. Open the top beam.
2. Use the hook wrench to adjust the two sides of bending leaf indicator as below drawing. Assume the thickness of workpiece is 3mm, then the guideline will point to 3.6~4.5







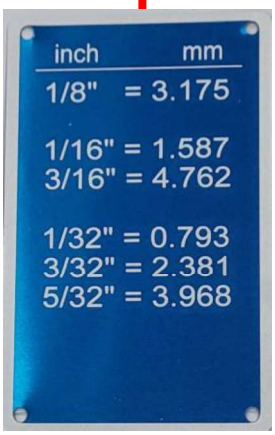
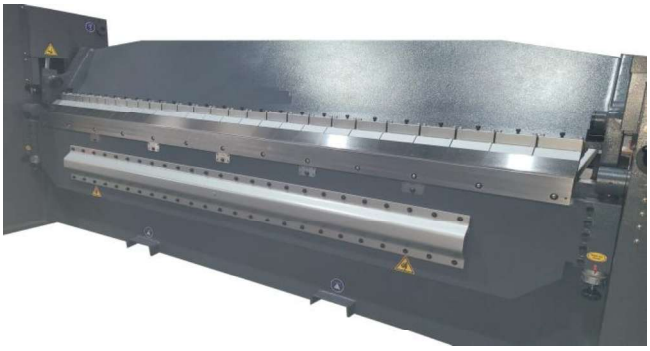


TABLE CROWNING COMPENSATION 1

DIRECTION:
Sometimes the workpiece is too wide, cause the middle angle of the finished workpiece is not enough (As below drawing). Meanwhile, need adjust the bending leaf and the under seat's screw to make some compensation:

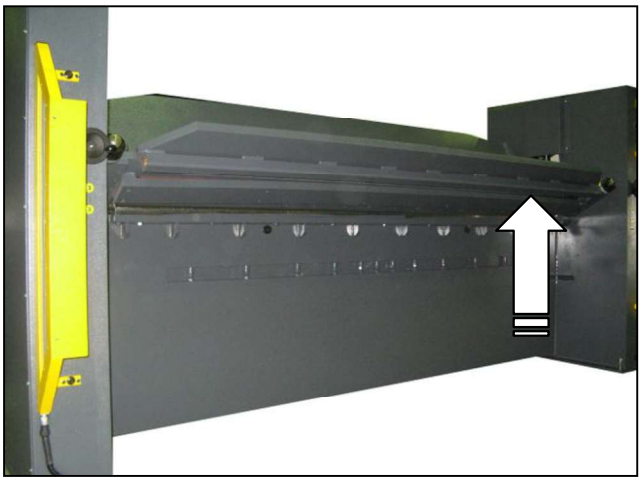






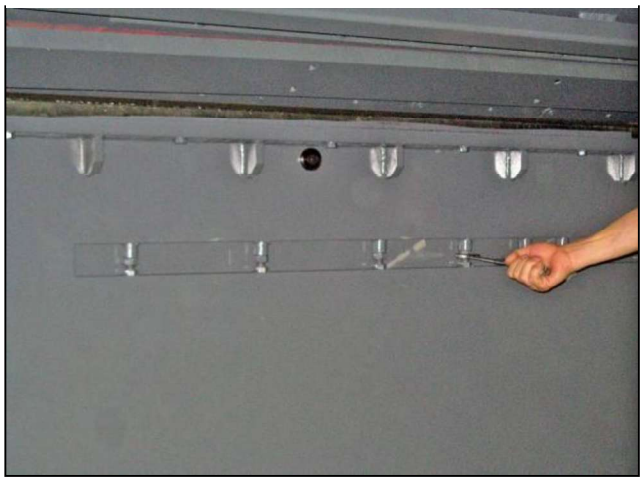
STEP1

Make some compensation adjustment from the middle to both sides according to the workpiece.



STEP2

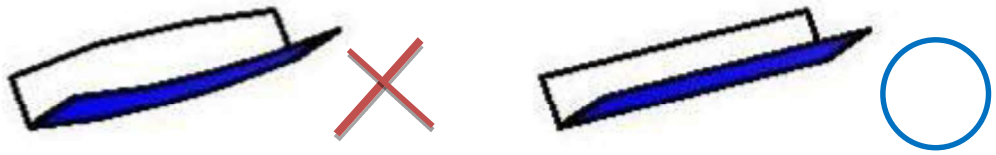
Open the folding leaf.



STEP3

Make some compensation adjustment from the middle to both sides according to the workpiece.

TABLE CROWNING COMPENSATION 2



Please follow the instruction to do adjustment:

1. Firstly, loosen the middle screws of INSERT BAR.
   ATTENTION: the end at both side screws DO NOT MOVE THEM AND KEEP FIXING.
2. Divide the table crowning compensation into three parts before start adjusting (see Figure 3).
3. The first part is been adjusted by priority (see Figure 10-2), use a wrench and clockwise or anticlockwise rotating the screws, the compensation value will increased alone with rotating the adjust-knob in clockwise direction
4. After done of first part, then start adjusting the 2nd part and make both them crowning up to touch bending beam as well (There is no need to have same adjustment like the first part)
5. After that, going to the 3rd one and repeat Step 4 ensure them crown up and touch the bending beam.
6. After above steps and adjustments are completed, tighten all of screws in bending beam.
7. In case, when bending a thing/shorter material got the over-bend result in the middle side, you can reversely operating the above steps (Release crowning power).



Figure 1



Figure 2

Figure 1-1

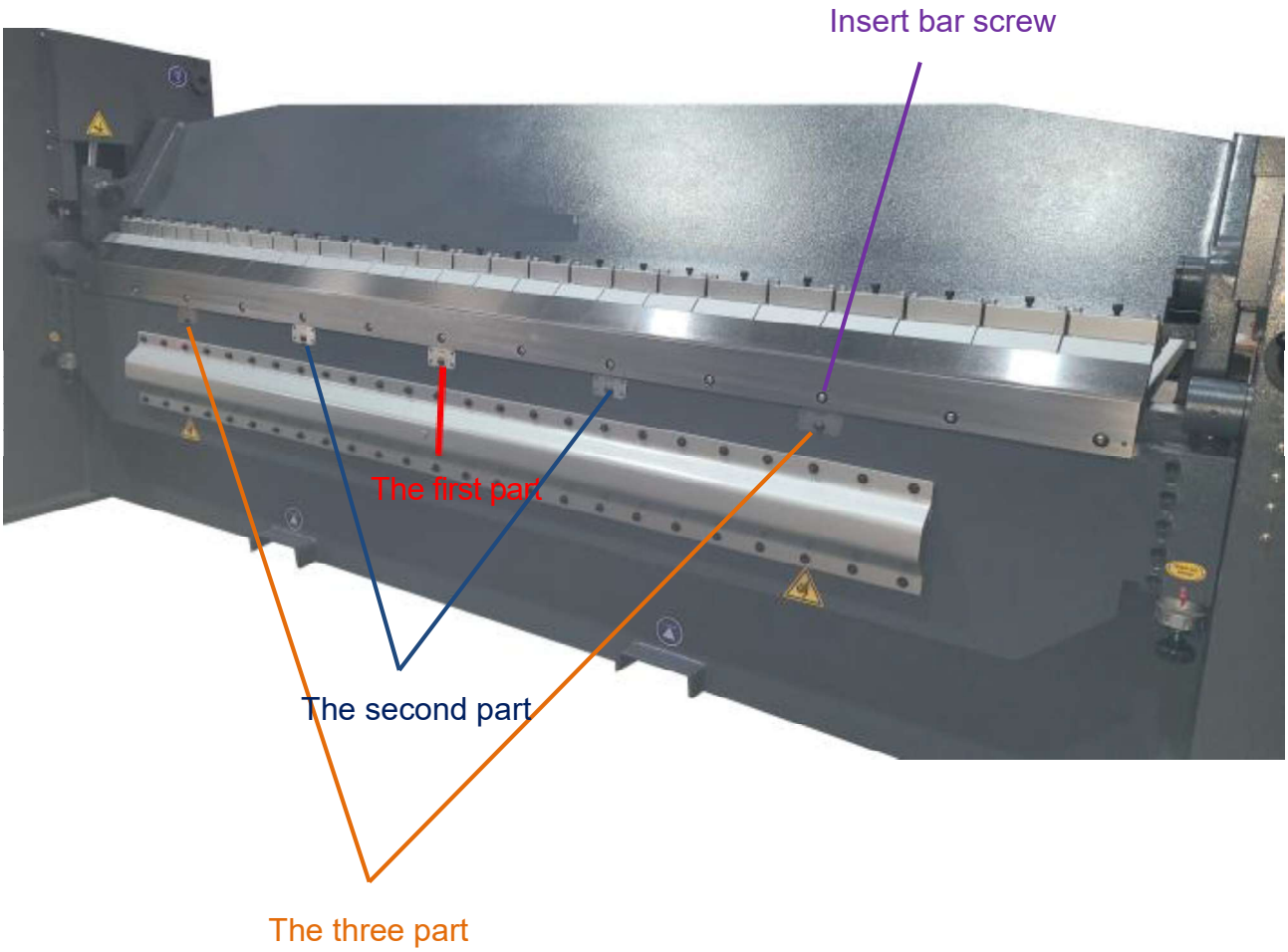


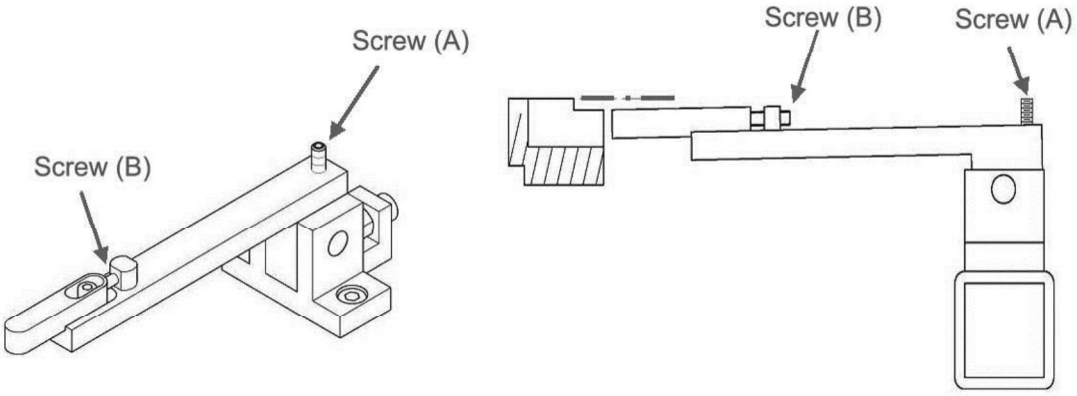
Figure 3

Figure 10-2

POWER BACK GAUGE OPERATION

OPERATION

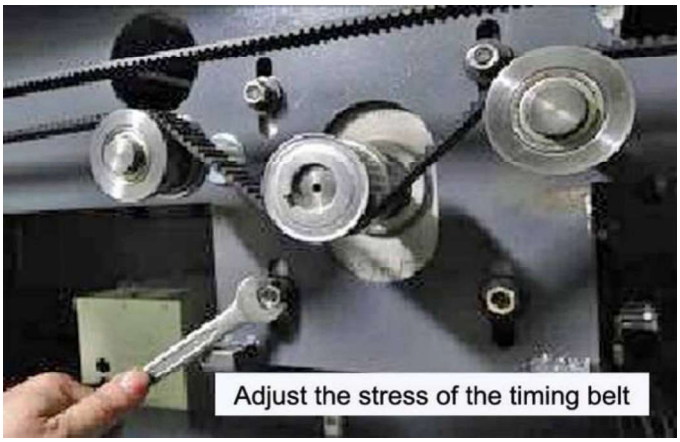
1. Select two sets of stopper in accordance with the material's length
2. Tighten screw (A) on all the other stoppers, make sure that the stoppers are lower than the surface of bottom die
3. Adjust the screw (B) on the two selected stopper, set size



TIMING BELT

The accuracy of back gauge will be affected when the timing belt is too tight or too loose.

Loosen the screw on back gauge's motor, adjust the stress of the timing belt, and make sure the back gauge can operate smoothly.



CE SAFETY BARRIERS

DIRECTION

CE safety barriers are the safety model depends on the clients need.

CE safety barriers has detection eye device in the back and front, also can be quip to the side electronic box.

FRONT SIDE BARRIERS:

If the front detection eye is blocked before bend. Meanwhile, the machine cannot do the bending move, but it can still press the workpiece. Once remove the blocker. Machine can start to bend the workpiece.

If the front detection eye is blocked when its bending, the machine shall automatic stop immediately. Remove the stop as below.

1. Select **Schneider** controller in manual page
2. Press bend(Y) DOWN, let the bend leaf back to origin point (0°).

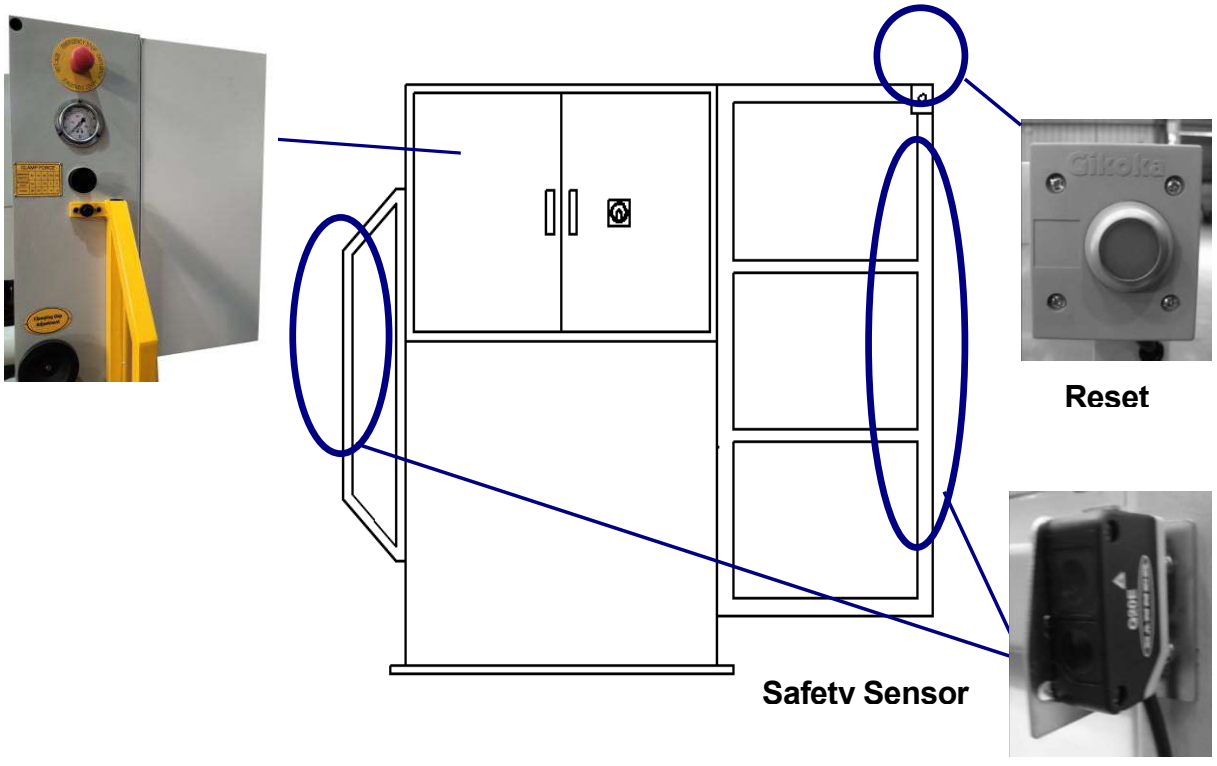
BACK SIDE BARRIERS:

If the back detection eye is blocked, the machine cannot move at all.
Remove the stop as below.

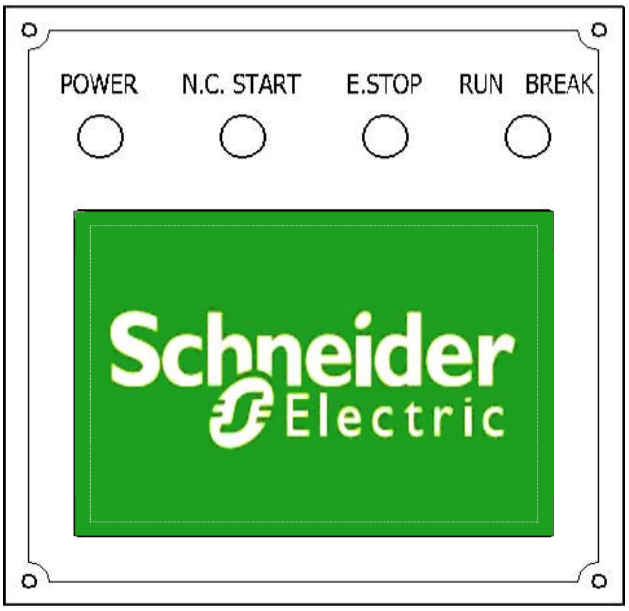
1. Press RESET button at the back barriers.
2. Select **Schneider** controller in manual page
3. Follow the screen display message to exclude the error

ELECTRONIC BOX

When the side of the electronic box has been opened, the machine cannot do any bending action.



OPERATION PANEL DISCRIPTION



POWER Machine power light.

NC. START To start controller power

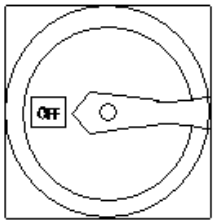
E.STOP release work piece
（activated when stepped on）

RUN/BREAK When program is operating.

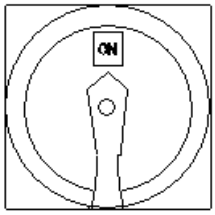
RUN:
Automatically bend workpiece after workpiece is compressed

BREAK:
After workpiece is compressed, you need to step foot pedal once again (BEND) to start bending

START MACHINE POWER

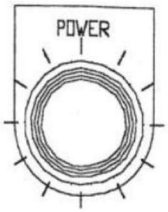


➔



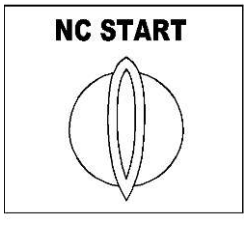
Turn clockwise direction to “ON” position

➔

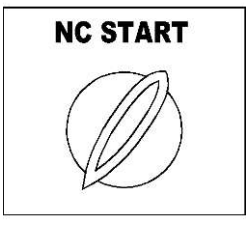


Power lamp is “ON”

START CONTROLLER POWER



➔



Turn clockwise direction to “ON” position

FOOT SWITCH OPERATION

MANUAL PAGE:

Bend: not active

Clamp: clamp work piece（activated when stepped on）

Unclamp: release work piece（activated when stepped on）

AUTO & PROGRAM PAGE:

Bend: Step on Bend pedal once to complete the folding and then it reverse back to origin.

Clamp: Step on the foot pedal once, and the upper beam will start clamping until the upper beam is around 15mm(1s) away from the lower beam, the upper beam will automatically stop
Step on the foot pedal again to clamp the work piece

Unclamp Release work piece（activated when stepped on）



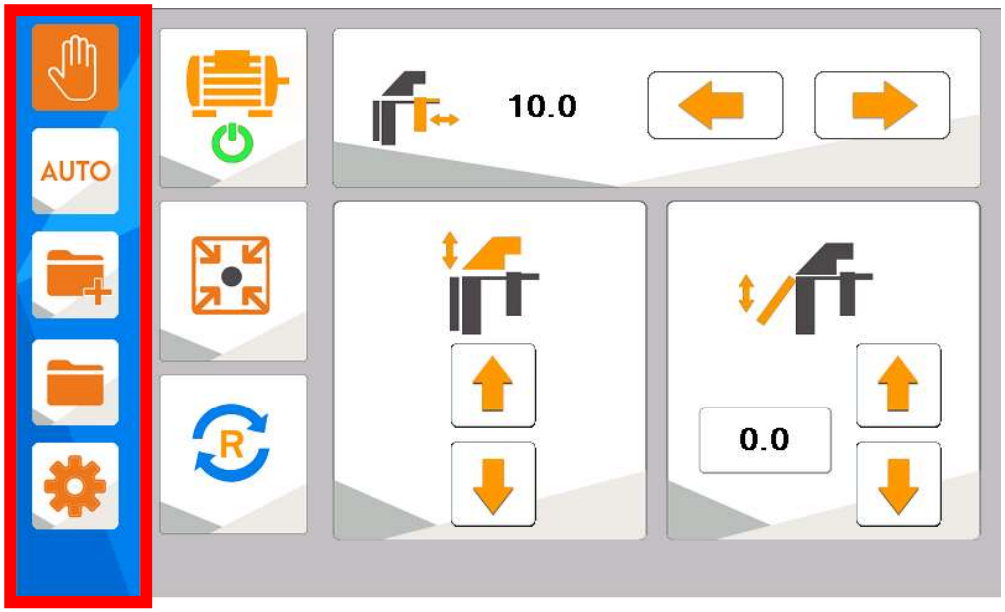
INITIAL DISPLAY NC START



Touch screen to start operation

MODE SELECT

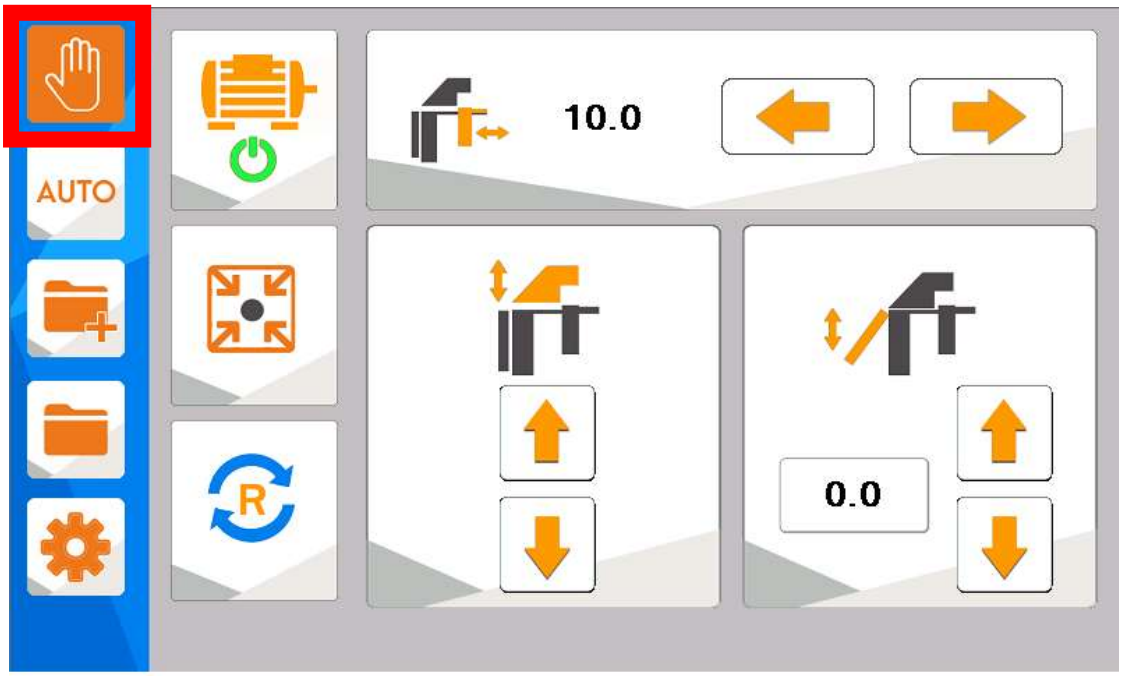
Touch the icon of red mark position to select the machine mode.



Option	Description
	**Manual mode**
	**Auto mode**
	**Program edit mode**
	**Program mode**
	**Setting mode**



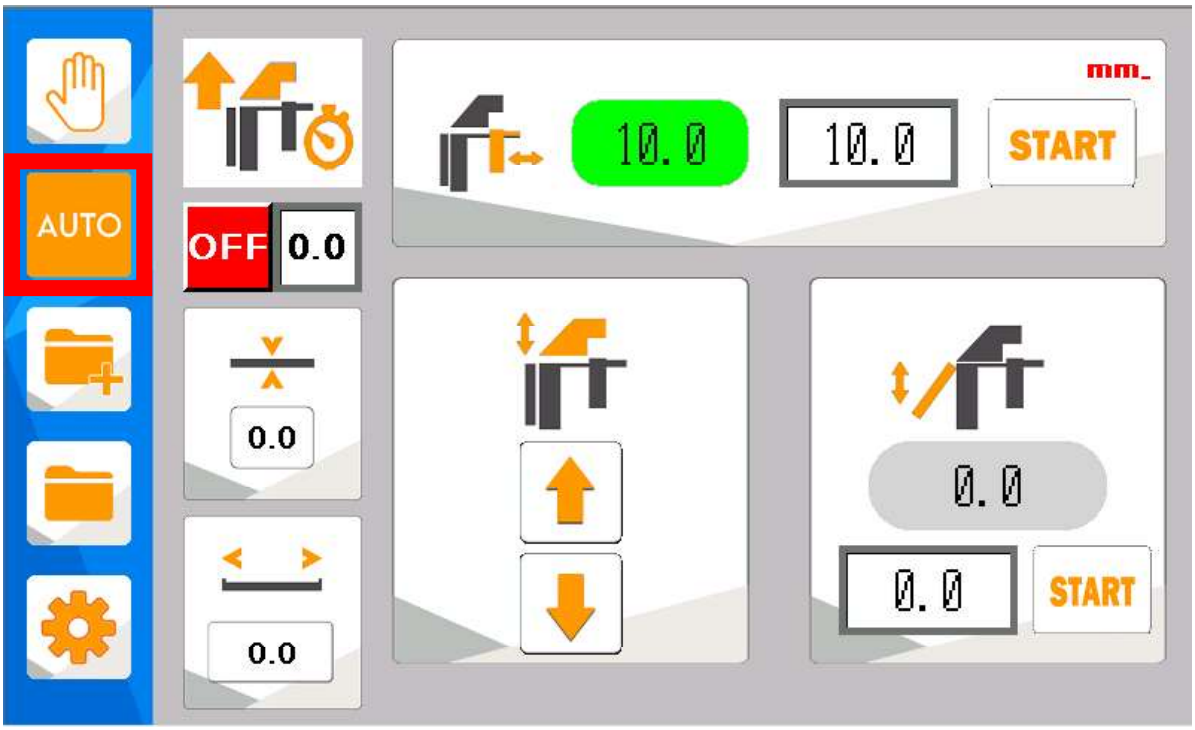
MANUAL MODE



Option	Description
	Motor pump start
	Motor pump stop
	Original return
	Reset
	Back gauge forward  / backward 
	Clamping Up  / Down 
	Bending Up  / Down 

AUTO

AUTO MODE



Option	Description
	Back gauge forward / backward
	10.0 Current Value
	100.0 Setting Value
	START Start
	Clamping Up / Down
	Bending Up / Down
	0.0 Current Value
	0.0 Setting Value

START Start

Clamping tools automatic open

OFF ON：Automatic open function - On /

OFF：Automatic open function - Off

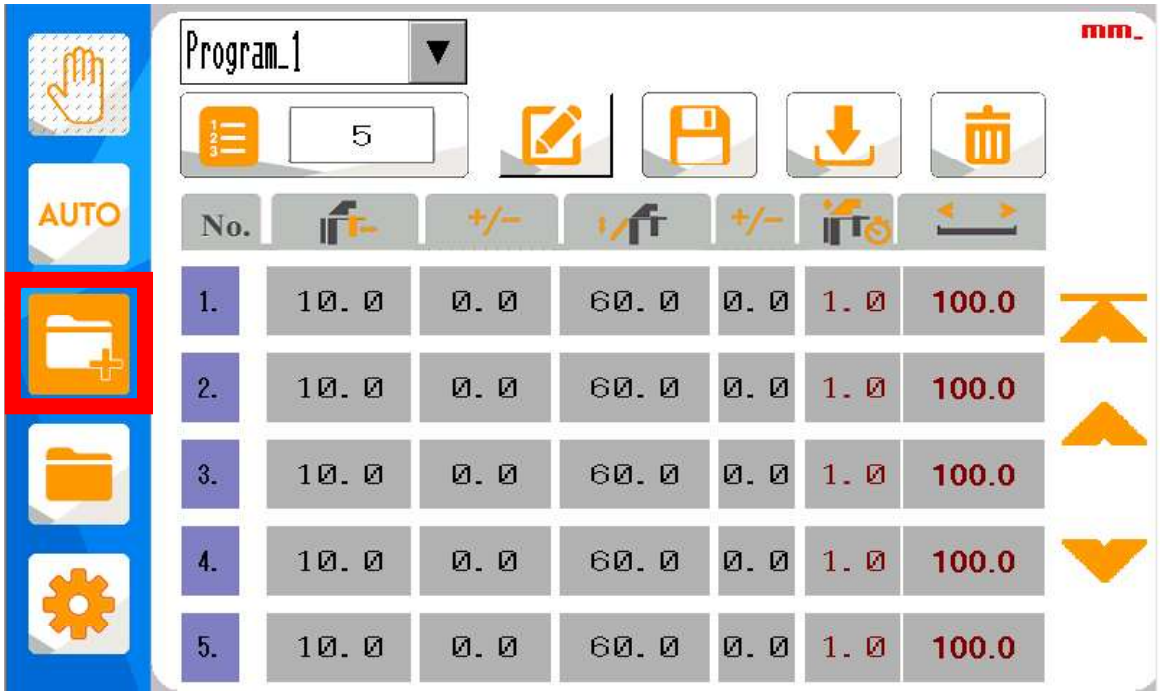


0.0 Setting Value

Open time setting ------ (2 - 8 sec)

Remark: The automatic open function will not remember your last setting status after reboot the machine

PROGRAM EDIT MODE



Option	Description
Program_1 ▼	Edit / Program name, Drop down menu
	Program steps set, Maximum 50 steps
	Add new program (Maximum 255 new program)
	Save Program
	Program Download



Delete Program, Show window





Clamp delay open time



Return to first page



Previous page



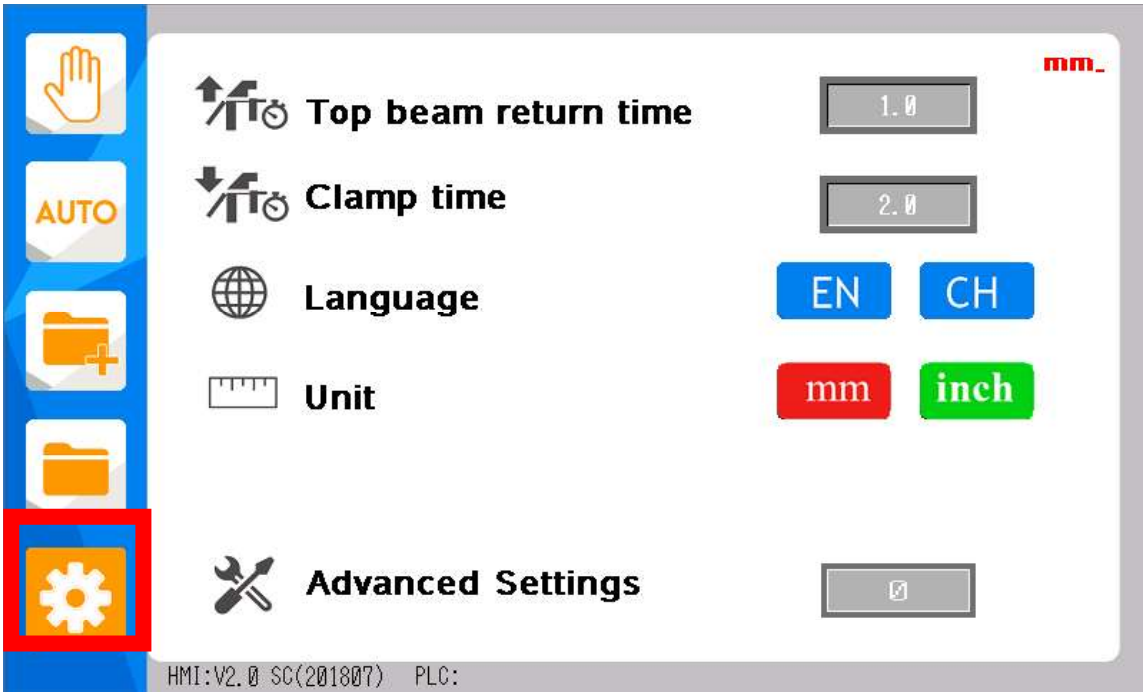
Next page

PROGRAM MODE



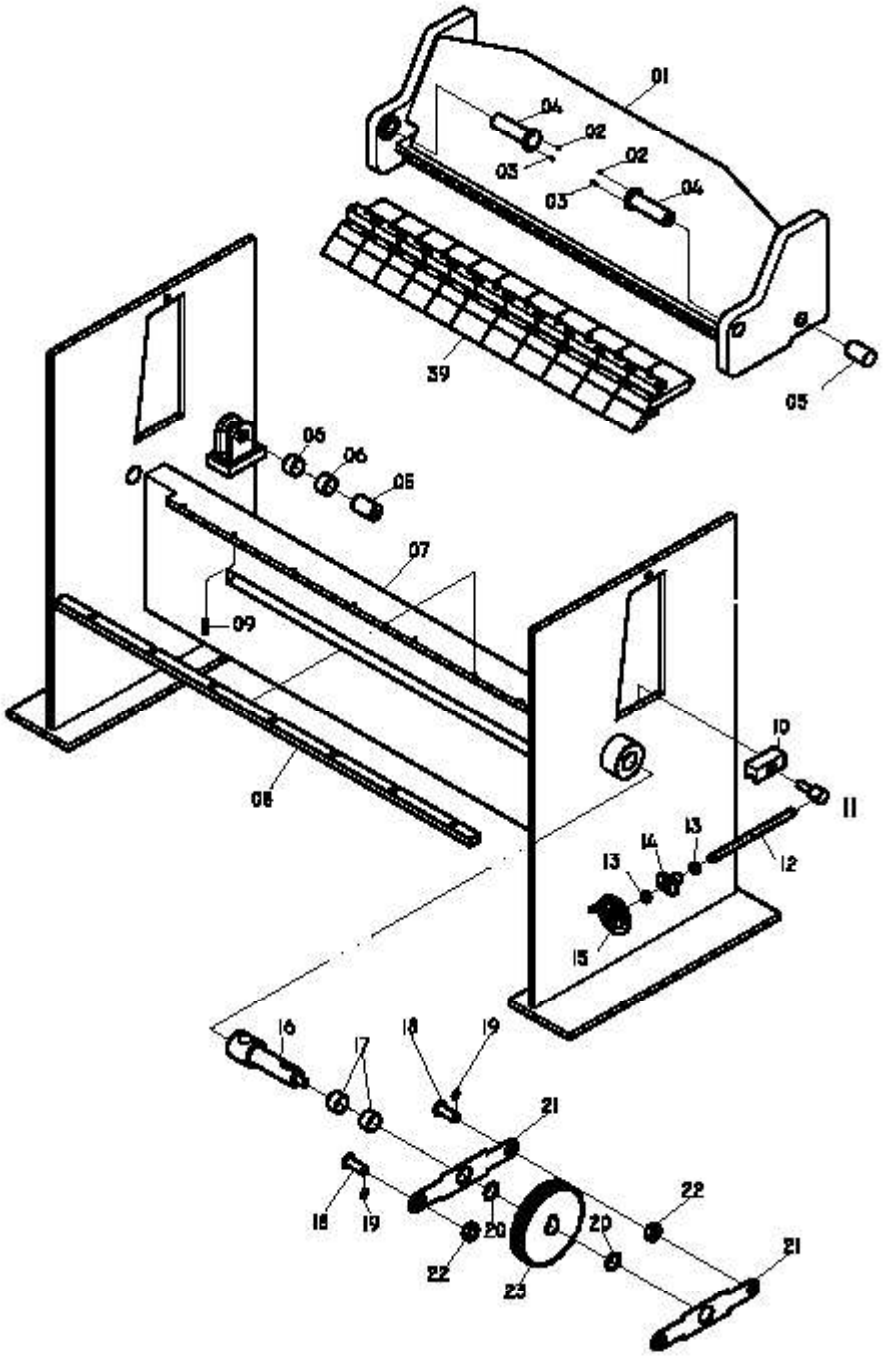
Option	Description
Program_1	Program name
10	Total steps of this program
0	Current processing step
START	Start
STOP	Stop

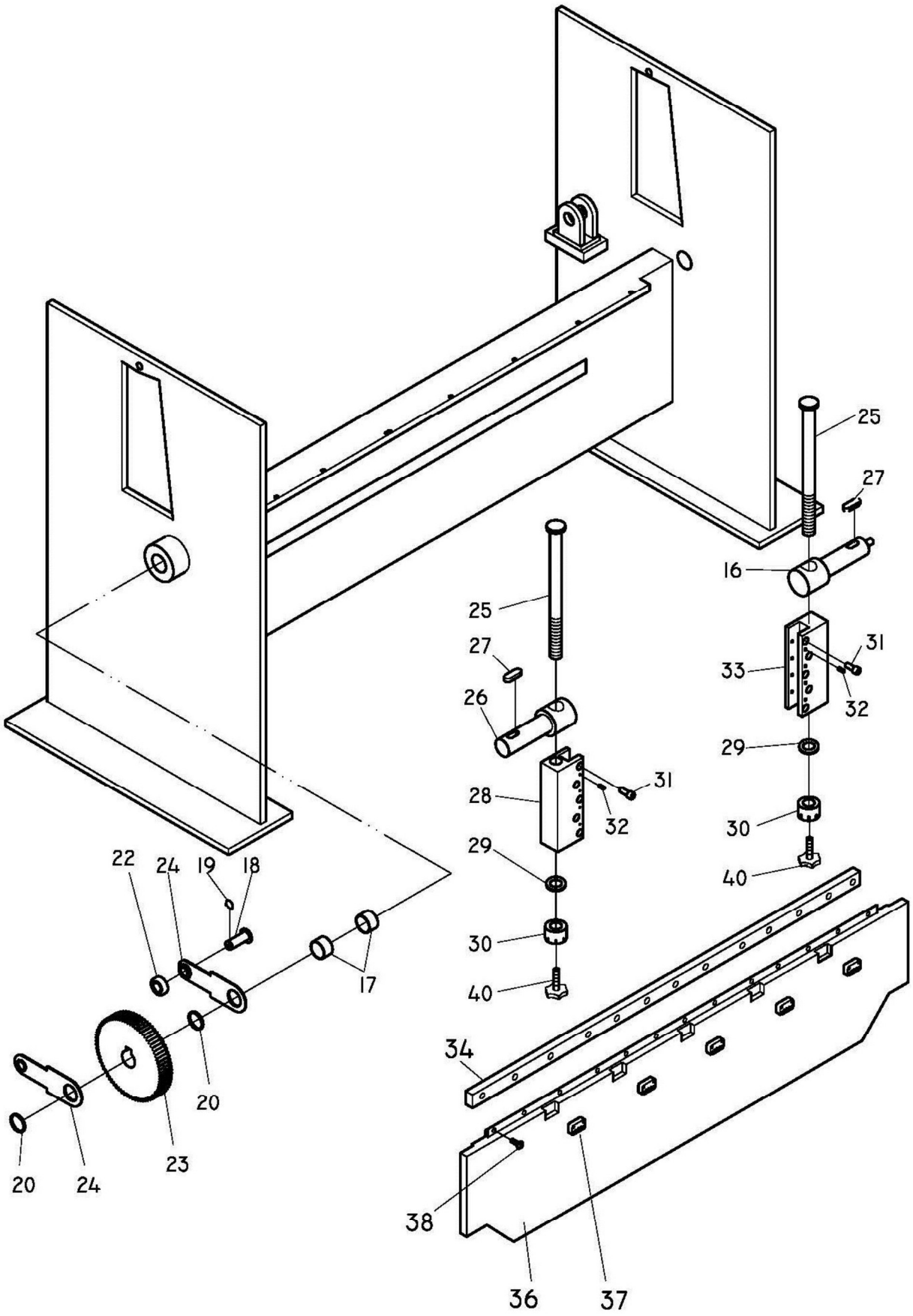
SETTING MODE



Top beam return time	2.0		
Clamp time	3.0		
X-axis Pulse	0	Y-axis Pulse	0
Back gauge(x) Jogging speed	300	Y-axis stroke distance	2000
Back gauge(x) position speed	500	Bend(Y) total angle	357
Back gauge(x) Min. value of distance	10.0	Bend(Y) min. value of angle	0
Back gauge(x) Max. value of distance	800	Bend(Y) max. value of angle	135
Back gauge(x) origin distance	13.4	Bend(Y) position angle time	1.0
Back gauge(x) servo compensatory	2.0	Bend(Y) angle return of slow speed	10.0
Clamp delay open time	1.0	Bend(Y) angle position of slow speed	4.0
Inner Timer Setup	0	Bend(Y) angle tolerance	ON 0.5

REPAIR PARTS IILLUSTRATIONS




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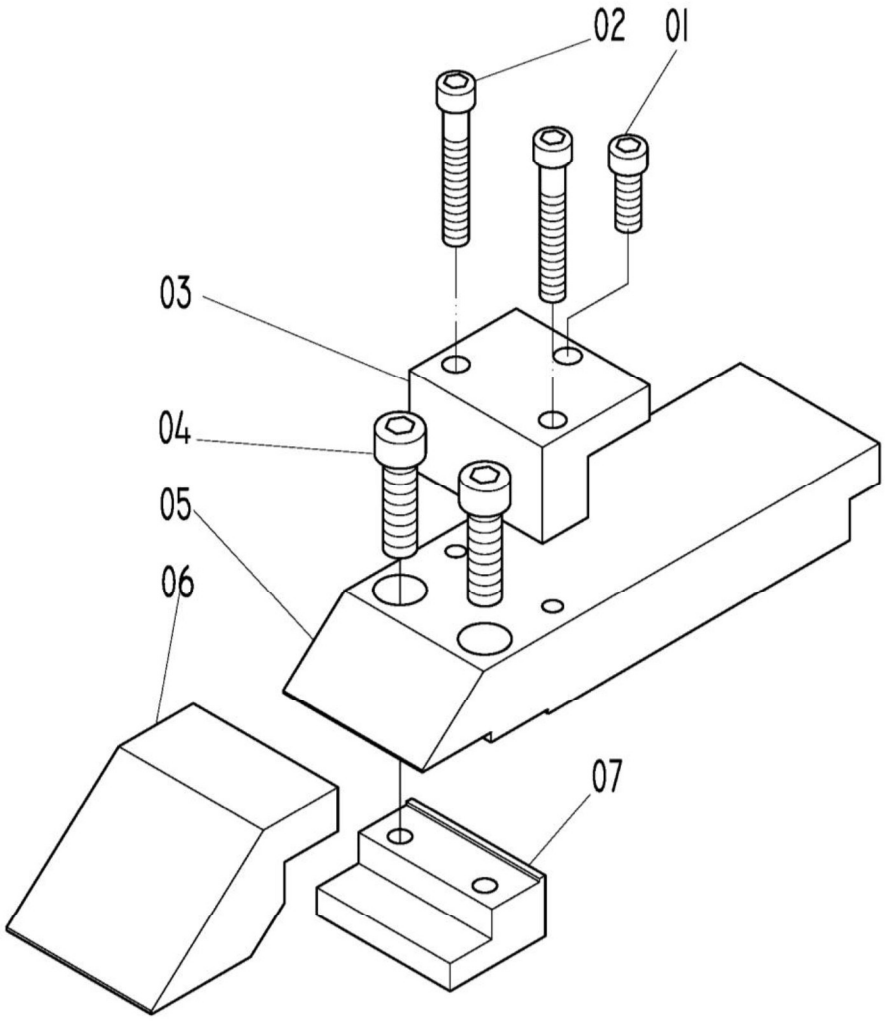
BASIC UNIT

INDEX NO.	DESCRIPTION
1	Clamping Beam Assy.
2	Set Screw
3	Screw
4	Cylinder Pin
5	Clamping Beam Hinge Pin
6	Clamping Beam Hinge Pin Bushing
7	Machine Bottom Base
8	Bottom Die
9	Screw
10	Wedge Block
11	Wedge Block Connecting Pin
12	Screw Rod
13	Bearing
14	Bearing Base
15	Hand Wheel
16	Bending Leaf Hinge Pin - Right Side
17	Bending Leaf Hinge Pin Bushing
18	Rack Set Pin
19	Spring Hook
20	Bush
21	Rack Set Plate – Right Side
22	Bearing
23	Gear
24	Rack Set Plate – Left Side
25	Oscillating Rod
26	Bending Leaf Hinge Pin - Left Side
27	Key
28	Bending Leaf Side Plate
29	Copper Washer
30	Dial
31	Screw
32	Set Screw
33	Bending Leaf Side Plate
34	Insert Bar
35	Clamping Bar
36	Bending Leaf
37	Bending Leaf Deflect Compensation
38	Screw
39	Upper Knife
40	Knob

FINGER BLADE ASSEMBLY

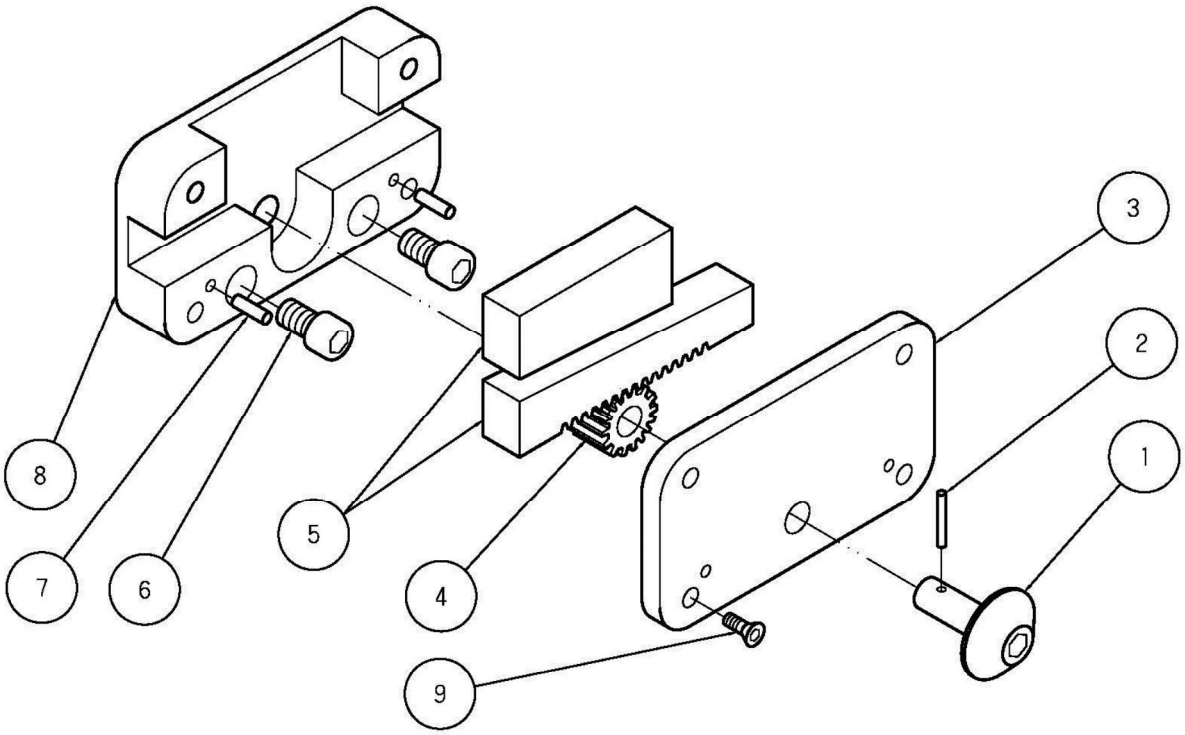
INDEX NO.	DESCRIPTION
39-1	Screw
39-2	Screw
39-3	Clamping Holder-Up
39-4	Screw
39-5	Upper Blade Base
39-6	Finger Blade
39-7	Clamping Holder-Bottom

FINGER BLADE SIZES (mm)	75	100	125	150
QTY. OF FINGERS	6	5	10	6



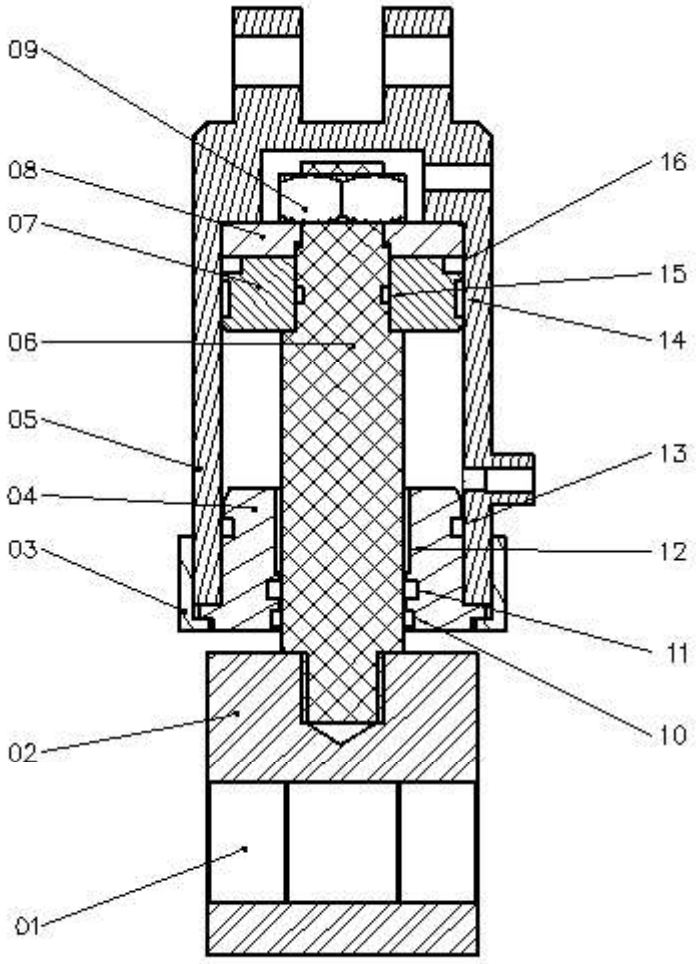
BENDING LEAF DEFLECT COMPENSATION DEVICE

INDEX NO.	DESCRIPTION	REMARKS
37-1	Adjustment Screw	
37-2	Round Shaft	
37-3	Cover	
37-4	Gear	
37-5	Gear Rack&Blokc	0.5
		0.8
		1.0
		1.5
		2.0
37-6	Screw	
37-7	Locking Pin	
37-8	Mounting base	
37-9	Screw	



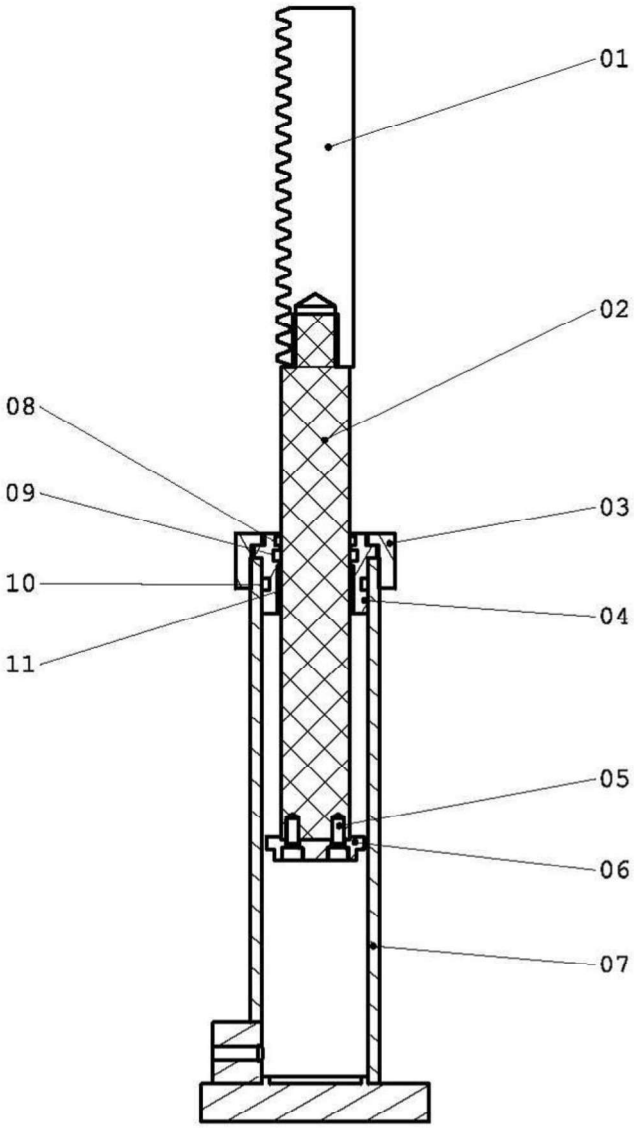
CLAMPING HYDRAULIC CYLINDER ASSEMBLY

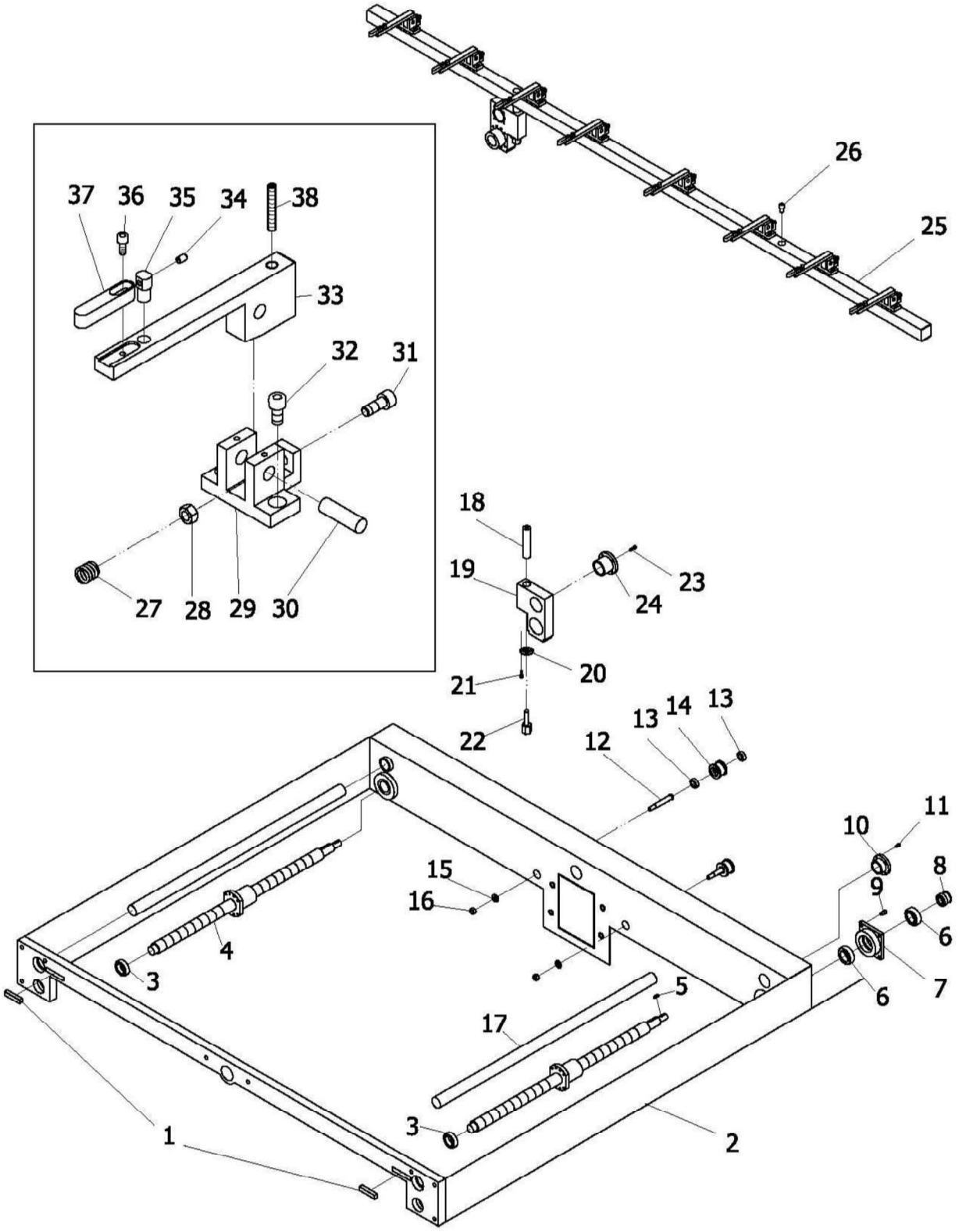
INDEX NO.	DESCRIPTION
1	Bushing
2	Connector Block
3	Cylinder Head Cover
4	Cylinder Head
5	Cylinder Pipe
6	Piston Rod
7	Main Piston
8	Piston
9	Piston Rod Bottom Nut
10	Wiper Seal
11	Rod Seal
12	DU
13	O-Ring
14	Wear-Resistant Ring
15	Piston Seal Double Action & O-Ring
16	Piston Seal



BENDING HYDRAULIC CYLINDER ASSEMBLY

INDEX NO.	DESCRIPTION
1	Rack
2	Piston Stem
3	Piston Head Cover
4	Piston Head
5	Screw
6	Piston
7	Cylinder Pipe
8	Wiper Seal
9	Rod Seal
10	O-Ring
11	Piston Stem Bushing




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NC. BACK GAUGE ASSEMBLY

INDEX NO.	DESCRIPTION
1	Key
2	Back Gauge Base
3	Bearing
4	Ball Screw
5	Key
6	Bearing
7	Bearing Base
8	Tim Belt Wheel
9	Screw
10	Rod Rear Base
11	Screw
12	Axle Of Idle Wheel
13	Bearing
14	Idle Wheel
15	Washer
16	Nut
17	Guide Bar
18	Supporting Rod
19	Ball Screw Bearing Block
20	Bushing
21	Screw
22	Adjusting Nut
23	Screw
24	Bearing Base
25	Square Pipe
26	Screw
27	Spring
28	Nut
29	Stopper Unit Base
30	Hinge Pin
31	Screw
32	Screw
33	stop finger
34	Screw
35	Adjusting Rod
36	Screw
37	Stop Finger
38	Screw
39	Time Belt Wheel Of Motor
40	Time Belt
41	Back Gauge Motor