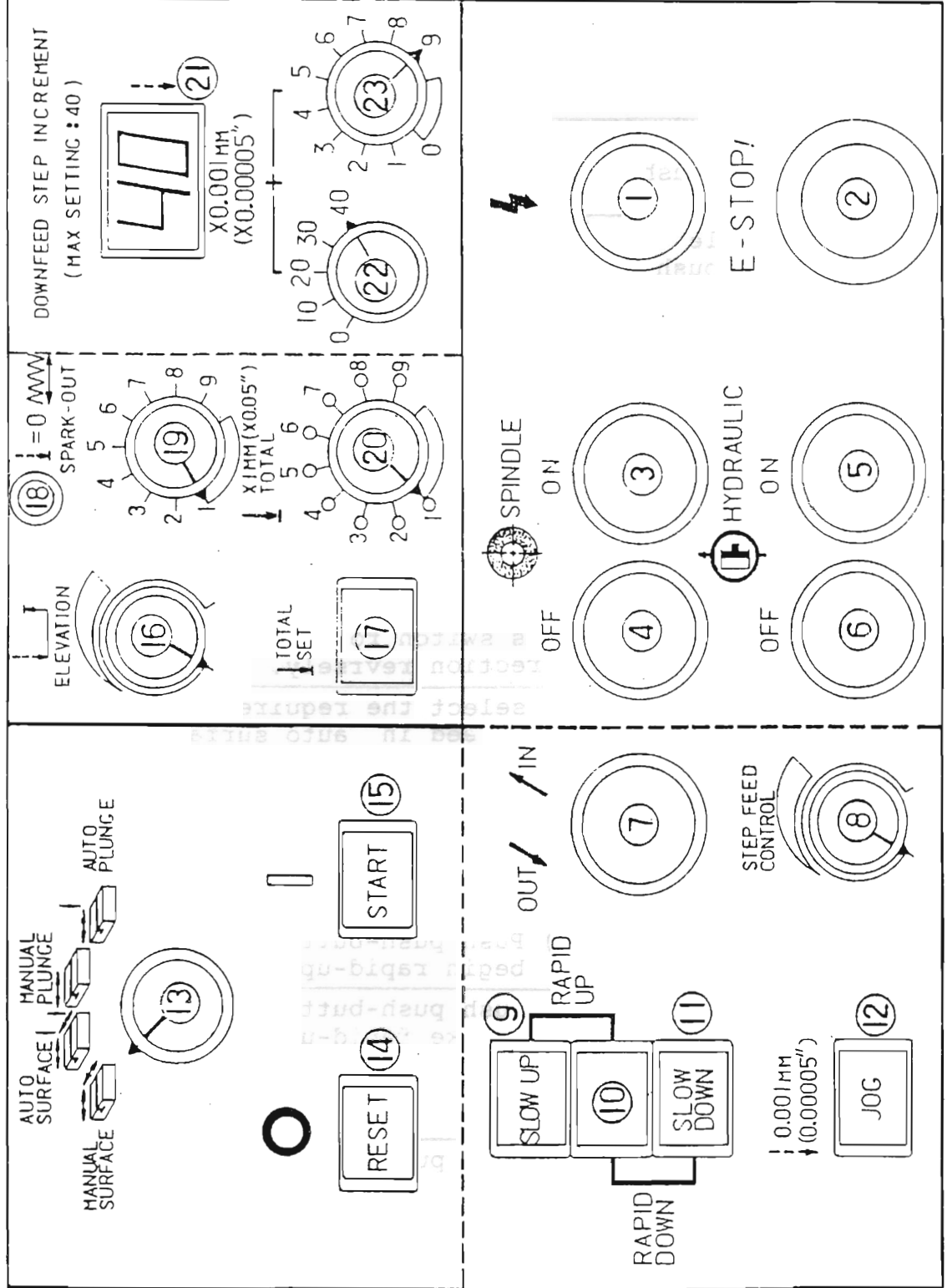


PARTS LIST

MODEL: **Supra 618AH/AHD**
818AHD



DEFINITION OF AHD CONTROL PANEL (OPERATION INSTRUCTION)

NO	ELECTRICAL CODE NO	SYMBOLIC DEFINITION	DESCRIPTION
1		Power indicator lamp	Light-on represents normal power supply
2		Emergency stop push-button	To stop all motors and functions
3		Spindle start push-button	To start the spindle(wheel head)
4		Spindle stop push-button	To stop the spindle(wheel head)
5		Hydraulic start push-button	To start hydraulic system for table reversal motion
6		Hydraulic stop push-button	To stop hydraulic system
7		Rapid in/out switch	To select rapid inward or outward saddle motion In auto surface mode, the operator can use this switch to toggle the proceeding direction revrsely.
8		Variable step increment of crossfeed selector	To select the required step increment of crossfeed in auto surface mode
9		Wheelhead slow-up push-button	a) Push push-button (9) to begin slow-up motion on wheelhead b) Push push-button (9) & 10 together to begin rapid-up motion on wheelhead
10		Rapid up/down push-button	a) Push push-button (9) & (10) together to invoke rapid-up motion on wheelhead b) Push push-button (11) & (10) together to invoke rapid-down motion on wheelhead
11		Wheelhead slow-down push-button	a) Push push-button (11) to invoke slow-down motion on wheelhead b) Push push-button (11) & (10) together to invoke rapid-down motion on wheelhead
12		Downfeed jogging push-button	In inches, 0.00005" downfeed increment/ per push In metric, 0.001mm downfeed increment/ per push

DEFINITION OF AHD CONTROL PANEL (OPERATION INSTRUCTION)

NO	ELECTRICAL CODE NO	SYMBOLIC DEFINITION	DESCRIPTION
13		Grinding mode selector	<p>There are four selections as follows:</p> <p>A. Manual surface mode: In this mode, (a) When light of button ⑭ is on, below functions are available: 1) Rapid in/out by push-button ⑦ 2) Rapid/slow up/down by push-button ⑨ , ⑩ , ⑪ 3) Jogging by push-button ⑫</p> <p>(b) When light of button ⑮ is on, and the the table has been started by turning table speed control and the required step increment of crossfeed has been set on selector ⑧ , 1) Table running direction toggle by switch ⑦ 2) Workpiece approaching by push-button ⑨ , ⑩ , ⑪ 3) Jogging by push-button ⑫</p> <p>B. Auto surface mode: In this mode, (a) When light of push-button ⑭ is on, below functions are available: 1) Rapid in/out by push-button ⑦ 2) Jogging by push-button ⑫</p> <p>(b) When light of push-button ⑮ is on, aut downfeed surface mode is already invoked, and auto downfeed will start on the access of table and saddle motion</p> <p>The wheelhead is raised up and all motors stopped automatically upon completion of spark-out passes</p> <p>1) Step increment of crossfeed by selector ⑧ 2) Table running director toggle by switch ⑦ 3) Jogging by push-button ⑫ 4) Selector ⑯ , ⑰ , ⑱ , ⑳ , ㉑ , ㉒ may be adjusted in the cycle, but the change will effect the current cycle.</p> <p>C. Manual plunge mode: In this mode,</p>

DEFINITION OF AHD CONTROL PANEL (OPERATION INSTRUCTION)

NO	ELECTRICAL CODE NO	SYMBOLIC DEFINITION	DESCRIPTION
			<p>Auto step feed, rapid in/out on cross travel are disabled, only manual feed on cross travel available.</p> <p>1) Jogging by push-button ⑫ 2) Rapid/slow up/down by push-button ⑨, ⑩, ⑪</p> <p>D. Auto plunge mode: In this mode,</p> <p>a) When light of push-button ⑮ on, auto downfeed plunge mode is already invoded, and auto downfeed will start upon the access of table strokes.</p> <p>The wheelhead is raised and all motors are auotmatically stopped upon completion of spark-put passes.</p> <p>1) Jogging by push-button ⑫ . 2) Selector ⑯, ⑰, ⑱, ⑳, ㉑, ㉒ may be adjusted in the cycle, and the cange will effect the current cycle.</p> <p>b) When light of push-button ⑭ on,</p> <p>1) Jogging by push-button ⑫ . 2) Rapid up/down, rapid in/out not available.</p>
14		Reset push-button	To cancel the previous setting on selector ⑬, which have been in effect.
15		Set push-button	To invoke the current setting on selector ⑬, put the setting into effect.
16		Elevation amount selector	To set the required amount to be elevated upon the completion of spark-out passes.
17		Total amount setting push-button	<p>To invoke the current setting on total amount selector ㉑ .</p> <p>The setting on total amount selector ㉑ won't re-effect the current downfeed</p>

DEFINITION OF AHD CONTROL PANEL (OPERATION INSTRUCTION)

NO	ELECTRICAL CODE NO	SYMBOLIC DEFINITION	DESCRIPTION
			<p>Useful occasion:</p> <p>After the workpiece changed and the required total downfeed amount selected, push this push-button as confirmation of the current setting.</p> <p>pushing this push-button during the proceeding downfeed cycle will change the proceeding total downfeed amount</p>
18		Zero downfeed indicator lamp	The lamp light goes on on completion of downfeed increments, preset spark-out passes will be proceeded at this time.
19		Sparks-out passes selector	To set the required spark-out passes, which will be proceeded upon completion of downfeed increments.
20		Total downfeed amount (increments) selector	To set the required downfeed increments for either auto plunge mode or auto surface mode.
21		Downfeed step increment display window	<p>The display window shows the current downfeed increment being proceeded.</p> <p>Actual downfeed step increment</p> <p>=displayed value X 0.001mm(in metric),</p> <p>=displayed value X 0.00005"(in inches)</p>
22 23		Downfeed step increment selector	<p>In metric:</p> <p>Selectable downfeed step increment goes from 0.001,0.002,0.003,.....,0.039, 0.040mm(40 steps).</p> <p>Downfeed step increment= selected value on selector ② X 0.001mm + selected value on selector ③ X 0.001mm</p> <p>In inches:</p> <p>Selectable downfeed step increment goes from 0.00005", 0.00010",....., 0.002"(40 steps).</p> <p>Downfeed step increment= selected value on selector ② X 0.00005" + selected value on selector ③ X 0.001mm</p>

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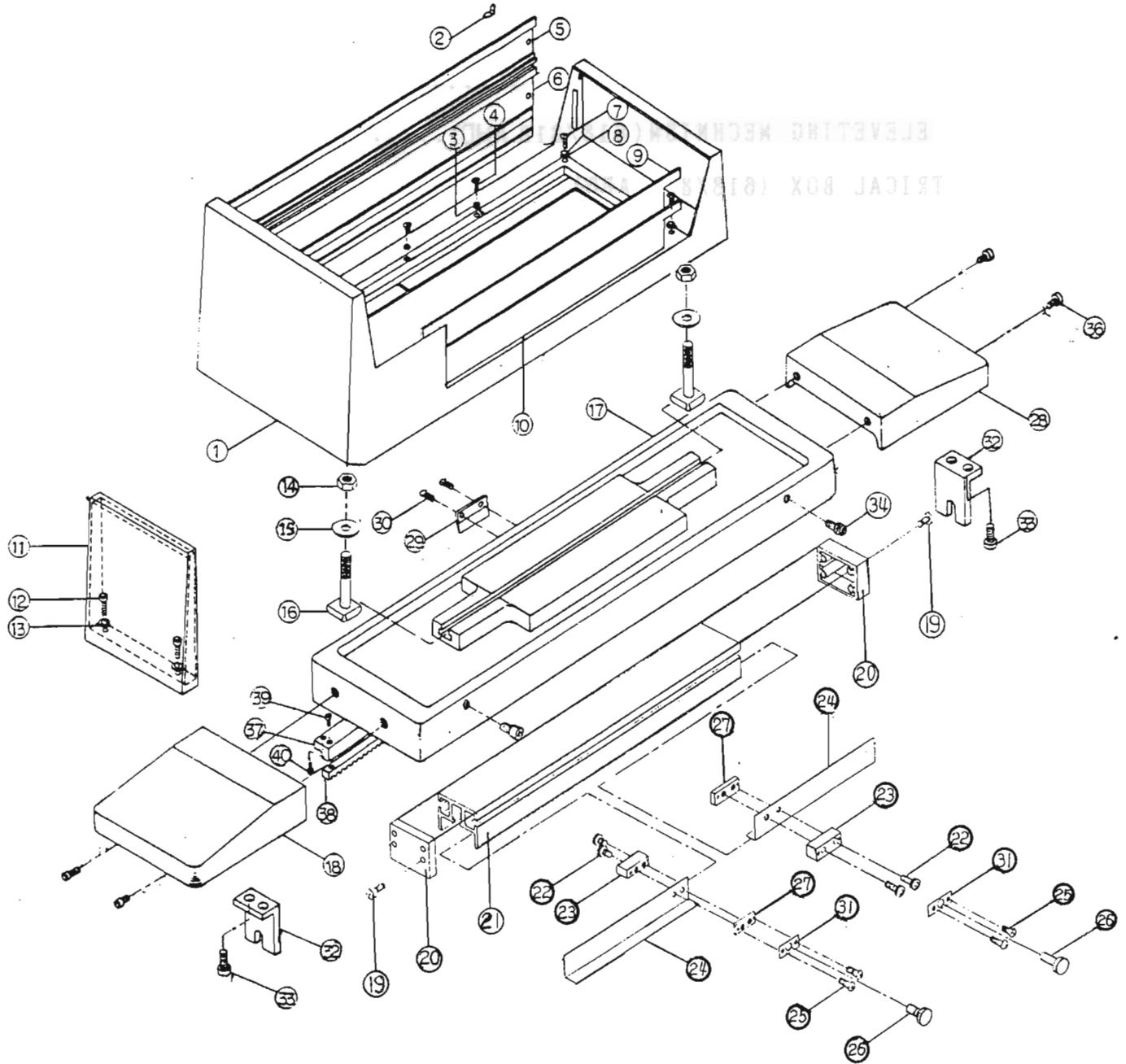
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QHA 8187818 2 HAB78



A:618AH

TABLE

B:818AHD

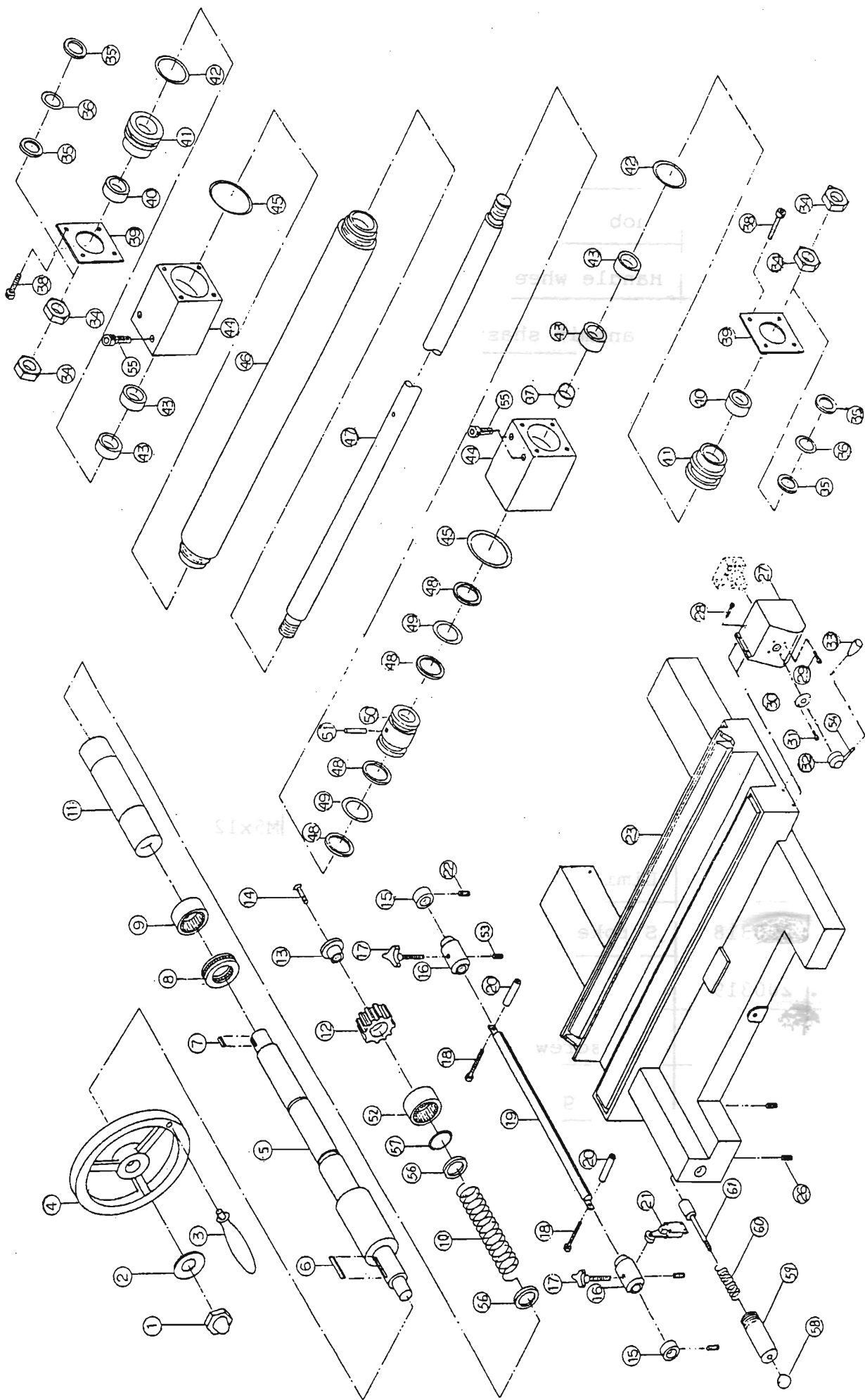
NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
1.	100809 100822	Splash guard	1		A B
2.		Wing nut	2	1/4"	
3.		Plate washer	4	φ 6	
4.		Cross head screw	4	M6x25L	
5.	100810	Rear splash plate	1		
6.	100810	Rear splash plate	1		
7.		Cross head screw	4	M6x25L	
8.		Plate washer	1	φ 6	
9.	100811	Front splash guard	1		
10.	100811	Front splash plate	1		
11.	100808 214004	Left-hand splasher	1		A B
12.		Hex screw	2	M6x25L	
13.		Plate washer	2	φ 6	
14.		Hex nut	2	3/8"	
15.		Plate washer	2	φ 10	
16.	100432-1	T-nut	2		
17.	100401 224001	Table	1		A B
18.	200407 224002	Left-end cover	1		A B
19.		Cross head screw	8	M4x16L	
20.	200431	Side cover of induction rail	2		
21.	200425	Longitudinal induction rail	1		
22.		Sock head cap screw	4	M5x14L	
23.	200432	Locking block of sensor-detected sheet	2		
24.	200434	Longitudinal sensor-detected sheet	2		

TABLE

A:618AH

B:818AHD

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
25.		Cross head screw	4	M4x20L	
26.	200436	Cross head screw	2		
27.	200427	Clamping block of sensor-detected sheet	2		
28.	200408 224003	Right end cover	1		A B
29.	100428	Anti-water plate	1		
30.		Hex screw	1	M4x10L	
31.	200428-1	Longitudinal sensor adjusting block	2		
32.	200409	Cylinder supporter	2		
33.		Hex screw	4	M8x25L	
34.		Sock head cap screw	2	M6x16L	
36.		Hex screw	4	M8x20L	
37.	200403	Longitudinal rack seat	1		
38.	200404	Longitudinal rack	1		
39.		Hex screw	6	M6x20L	
40.		Hex screw	5	M6x12L	



SADDLE

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
1.		Cup nut	1	M12	
2.		Washer	1	φ12	
3.	100430	Knob	1		
4.	100422	Handle wheel	1		
5.	200410-1 224004	Transmit shast	1		A B
6.		Wood ruff key	1	5x5x20L	
7.		Wood ruff key	1	4x4x12L	
8.		Thrust bearing	1	51103	
9.		Needle bearing	1	DHK1712	
10.					
11.	200402-1 224005	Shaft sleeve	1		A B
12.	200405	Gear	1		
13.	200406	Washev	1		
14.		Inner hex screw	1	M5x12L	
15.	200317	Limit ring	2		A,B
16.	200318	Stroke seat	2		A,B
17.	200319	Fixing handle	2		A,B
18.		Hex screw	2	M6x60L	A,B
19.	200316 223004	Cross guide rod	1		A B
20.	200315	Fixing pin	2		C,D
21.		Cross limit switch	2	TEND TZ8104	C,D
22.		Inner hex screw	2	M6x6L	C,D
23.	200301 223001	Saddle	1		A B
24.					

A:618AH/AHD

B:818AHD

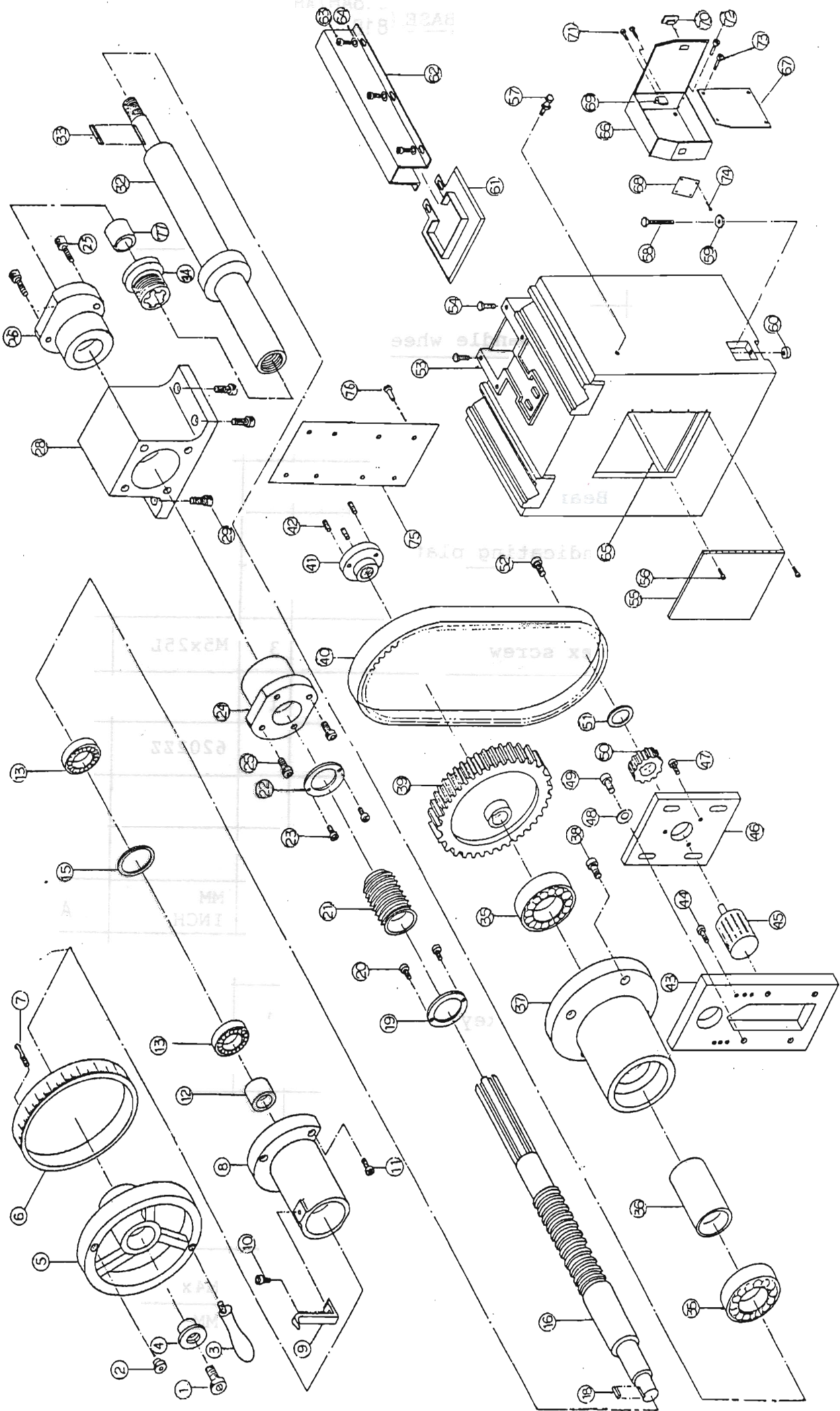
SADDLE

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
25.					
26.		Inner hex screw	2	M6x14L	
27.	200615	Throttle valve seat	1		
28.		Hex screw	2	M6x22L	
29.		Hex screw	4	3/16"x3/4L	
30.	101014	Throttling indicator plate	1		
31.		Cross head screw	2	M4x8L	
32.	200605	Handle seat	1		
33.	200606	Handle	1		
34.		Hex nut	4	M12	
35.		Plate washer	4	φ12	
36.		Spring washer	8	φ25xφ12.2 x0.9	
37.		Anti-abrassive ring	2	1410DU	
38.		Hex screw	8	M4x10L	
39.	200613	Sealing plate	2		
40.		Protecting oil ring	2	DH-14	
41.	200611	Sealing seat	2		
42.		O-ring	2	P28	
43.		Seal	4	UHS14	
44.	200610 -1	Cylinder head	2		
45.		O- ring	2	P29	
46.	200607	Cylinder	1		
47.	200608-1	Piston rod	1		
48.		Piston ring	4	FD21	

SADDLE

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
49.		Oring	2	P21	
50.	200609-1	Piston	1		
51.		Taper pin	1	4#x22L	
52.		Neddle bearing	1	DHK1416	
53.		Inner nex screw	2	M5x5L	A, B
54.	200606	Handle	1		
55.		Hex screw	4	M6x60L	
56.	200415	Washer	2		
57.		Snap ring	1	∅14	
58.	200418	Circular handle	1		
59.	200416	Positing seat	1		
60.	200419	Spring	1		
61.	200417 224010	Moving pin			A B

BASE (618AH/AHD)
818AHD



BASE (618AH/AHD)
(818AHD)

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMAFKS
1.		Hex screw	1	M4x20L	
2.	100217	Locking nut	1		
3.	100237	Handle	1		
4.	100415	Washer	1		
5.	100318	Cross handle wheel	1		
6.	100319 100320	Scale ring	1	MM INCH	
7.	100218	Key-screws	1		
8.	100314	Bearing seat	1		
9.	100321	Indicating plate	1		
10.		Cross head screw	1	M5x8L	
11.		Hex screw	3	M5x25L	
12.	100317	Sleeve	1		
13.		Bearings	2	6202ZZ	
14.					
15.	100315-1	Washer	1		
16.	200307-1 200308-1	Cross transfer shaft	1	MM INCH	A
16.	223002 ^A _B	"			B
18.		Setting key	1	5x5x12L	
19.	100324	Washer	1		
20.		Cross head screw	2	M4x10L	
21.	100323	Protect plastic cover	1		
22.	100324	Ring washer	1		
23.		Cross head screw	2	M4x10L	
24.	100305-1 100306-1	Tront t-thread nut	1	MM INCH	

BASE (618AH/AHD)
818AHD

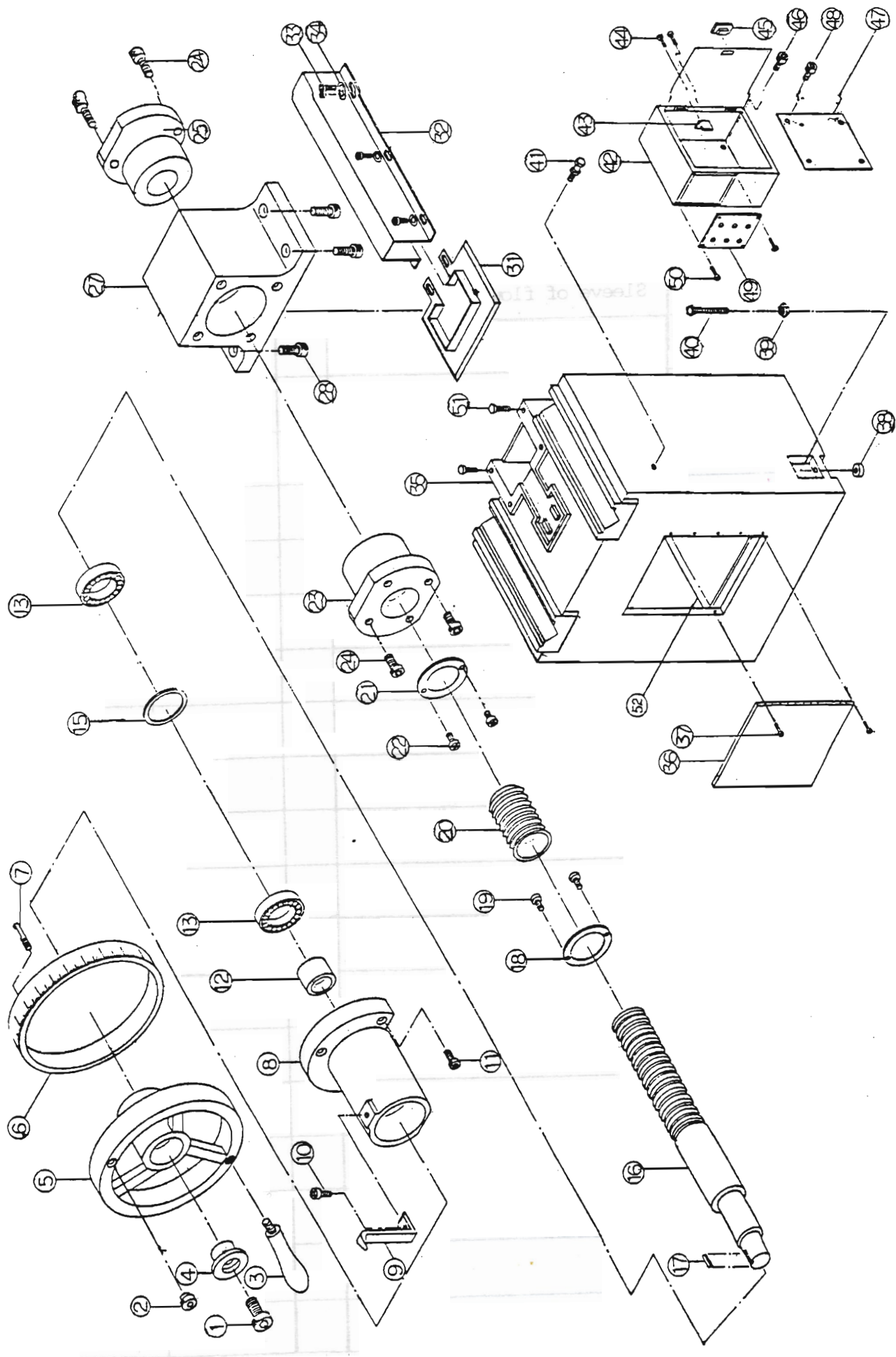
NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMAFKS
25.		Hex screw	4	M5x20L	
26.	100307 -1 100308 -1	T-thread nut	1	MM INCH	
27.					
28.	100309 -1	Nut seat	1		
29.		Hex screw	4	M8x45L M8x50L	A B
30.					
31.					
32.	200306-1 223003	Connecting shaft	1		A B
33.		Setting Key	1	5x5x16L	
34.	200321	Internal six-Spline sleeve			
35.		Bearings	2	6007Z	
36.	200314-1	Bearing sleeve	1		
37.	200305-1	Bearing seat	1		
38.		Hex screw	4	M8x25L	
39.	200309	Timing belt pully	1		
40.	200320	Timing belt	1		
41.	200311	Locking nut	1		
42.		Inner hex screw	3	M6x12L	
43.	200304	Motor supporter	1		
44.		Hex screw	6	M8x40L	
45.		Cross morement motor	1	220v-40w 516A	
46.	200303	Motor fixing plate	1		
47.		Hex head	3	M6x16L	
48.		Plate washer	4	ø8	

618AH/AHD,
BASE 818AHD

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMAFKS
49.		Hex screw	4	M8x20	
50.	200310	Timing belt pully (small)	1		
51.	200312	Ring washer	1		
52.		Hex screw	1	M4x14L	
53.	100501 215001	Base	1		A B
54.		Hex screw	4	M16x60L	
55.	100502	Door	1		
56.		Cross head screw	5	M5x10L	
57.	100504	Eye bolt	4		
58.	100505	Levelling plate	3 5		A B
59.		Hex nut	3 5	M22	A B
60.	100506	Levelling plate	3 5		A B
61.	100322	Oil cover	1		
62.	100302 213003	Shaft cover	1		A B
63.		Cross head screw	6	M5x10L	
64.		Washer	6	φ5	
65.	100501 215001	Cabinet	1		A B
66.	200901	Electric box	1		
67.	200902	Electric assemole plate	1		
68.	101012-1	Control pannel	1		
69.	100903	Fixing plate	1		
70.	200901-1	Pressure button	1		
71.		Cross head screw	1	M5x10L	
72.		Hex screw	4	M8x20L	

618AH/AHD,
BASE (818AHD)

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMAFKS
73.		Hex screw	4	M6x20L	
74.		Cross head screw	4	M4x10L	
75.	200302	Safrty cover	1		
76.		Crass head screw	8	M5x10L	
77.		Sleeve of flowing oil	1		



BASE (618H)

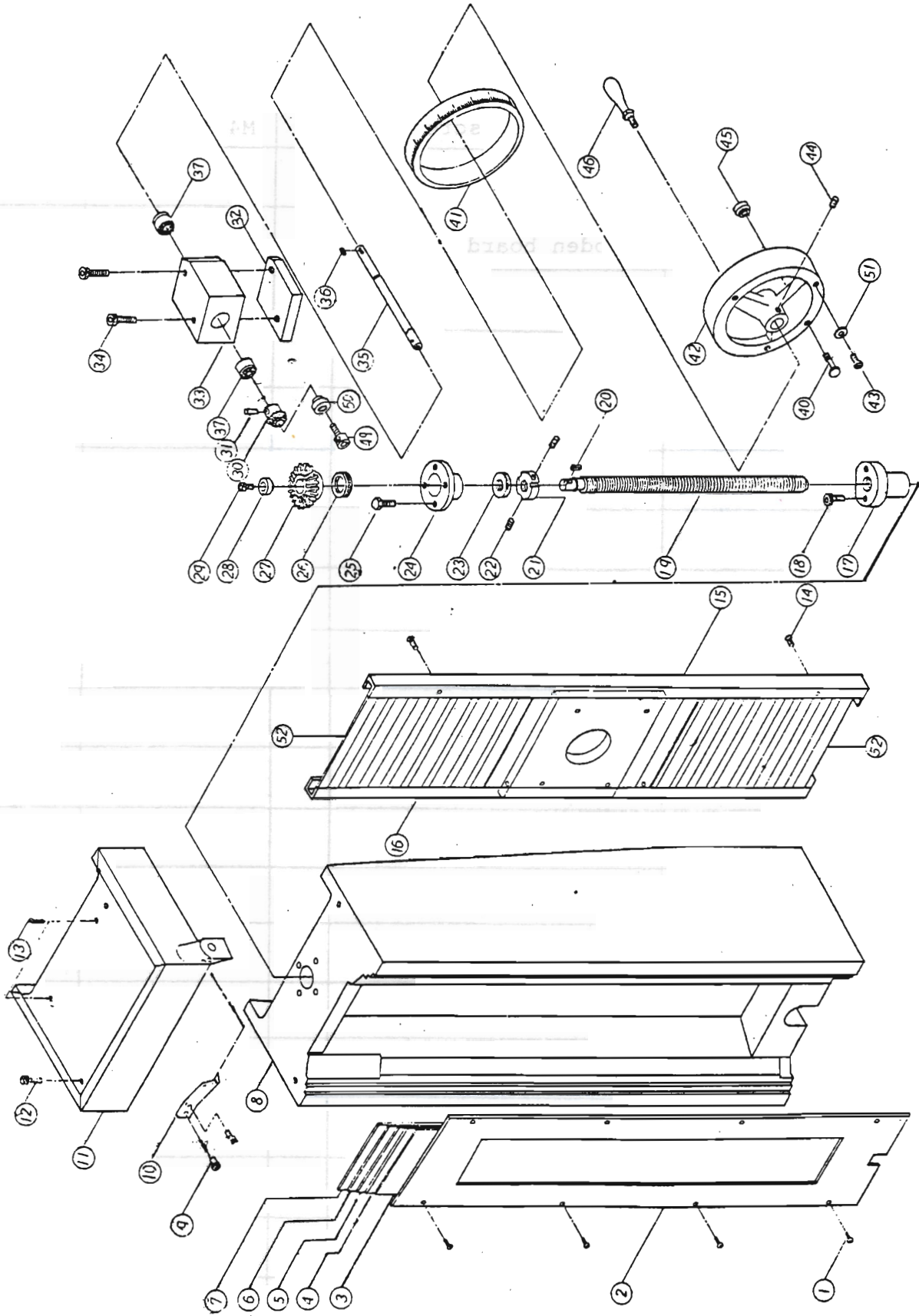
NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
1.		Lock screw	1	M4x20L	
2.	100217	Lock nut	1		
3.	100232	Knob	1		
4.	100415	Washer	1		
5.	100318	Handwheel	1		
6.	100319 100320	Handwheel dial	1	MM INCH	
7.	100218	Fix pin	1		
8.	100314	Bearing seat	1		
9.	100321	Indicator	1		
10.		Cross head screw	1	M5x8L	
11.		Socket screw	3	M5x25L	
12.	100317	Collar	1		
13.		Ball bearing	2	6202ZZ	
15.	100315 -1	Outer spacer	1		
16.	100303 100304	Cross leadscrew	1	MM INCH	
16.	213002 ^A _B	Cross leadscrew	1	MM INCH	
17.		Setting key	1	5 x 5 x 12L	
18.	100324	Fixed ring	1		
19.		Cross head screw	2	M4 x 10L	
20.	100323	Telescopic cover	1		
21.	100324	Fixed ring	1		
22.		Cross head screw	2	M4 x 10L	
23.	100305 -1 100306 -1	Leadscrew nut	1	MM INCH	
24.		Socket screw	4	M5x20L	

BASE (618H)

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
25.	100307 -1 100308 -1	Leadscrew nut	1	MM INCH	
26.					
27.	100309-1	Leadscrew seat	1		
28.		Socket screw	4	M8x45L M8x50L	
29.					
30.					
31.	100322	Tank cover	1		
32.	100302 213003	Leadscrew metal cover	1		
33.		Cross head screw	6	M5 x 10L	
34.		Washer	6	ø5	
35.	100501 215001	Base	1		
36.	100502	Door of tool cabinet	1		
37.		Cross head screw	5	M5 x 10L	
38.	100506	Levelling block	3 5		
39.		Hex nut	3 5	M22	
40.	100505	Levelling screw	3 5		
41.	100504	Lifting bolt	4		
42.	200901	Control box	1		
43.	100903	Switch bracket	1		
44.		Cross head screw	2	M5 x 10L	
45.	200901-1	Door lock	1		
46.		Socket screw	4	M8x20L	
47.	200902-1	Electrical board	1		
48.		Socket screw	4	M6x20L	

BASE (618H)

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
49.	101012 -1	Operation panel	1		
50.		Cross head screw	4	M4 x 10L	
51.		Hex screw	4	M16 x 60L	
52.	100503 215002	Wooden board	1		



COLUMN

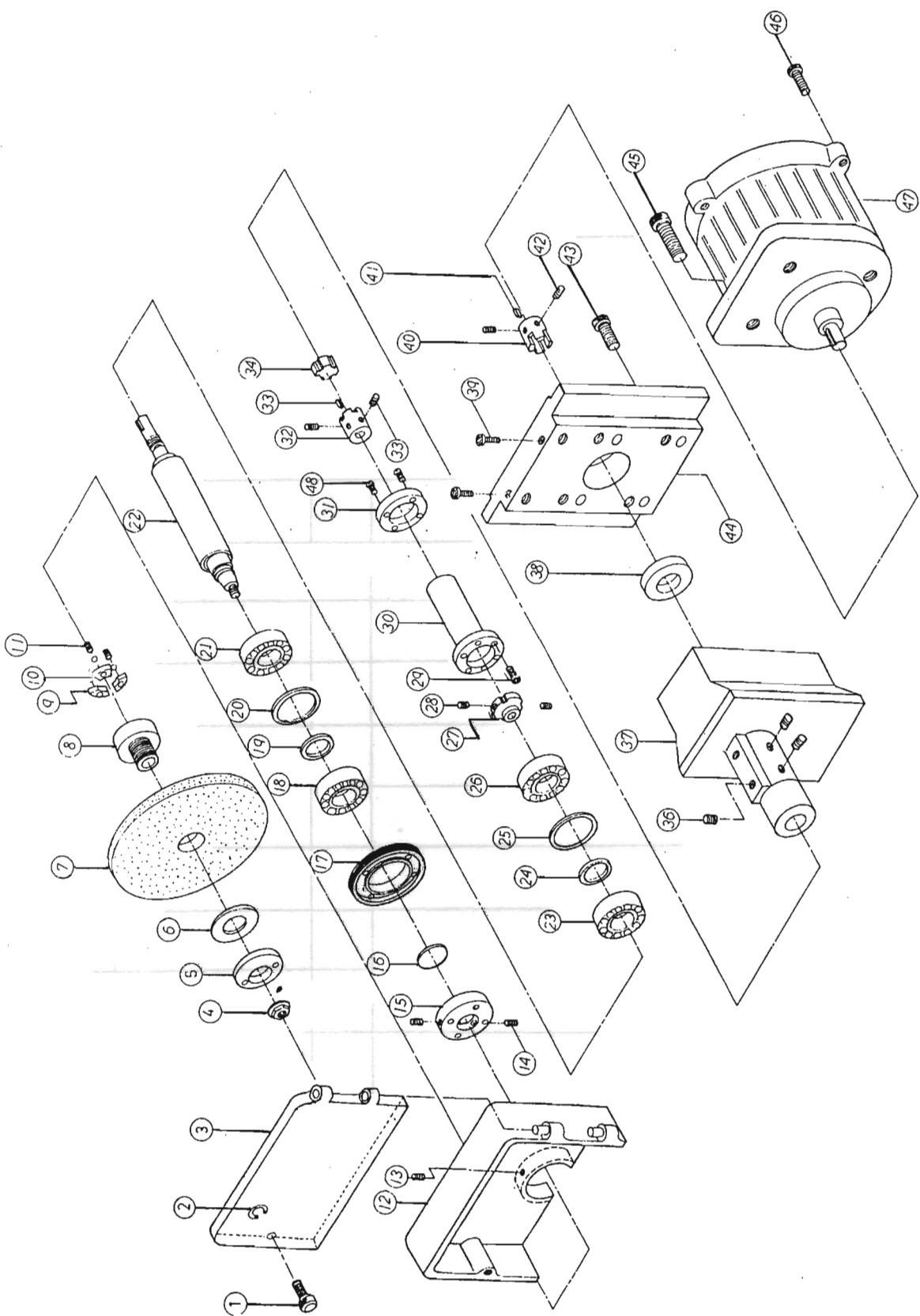
NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS.
1.		Round head screw	8	M6x20L	
2.	100221 212002	Front guard	1		A B
3.	100222 212004	Front guard	1		A B
4.	100223 212005	Front guard	1		A B
5.	100224 212006	Front guard	1		A B
6.	100225 212008	Front guard	1		A B
7.	100226 212008	Front guard	1		A B
8.	100201	Column	1		
9.		Round head screw	2	M4x8L	
10.	100219	Indicator	1		
11.	100220	Top cover	1		
12.		Socket head screw	2	M6x85L	
13.		Round head screw	8	M4x8L	
14.		Round head screw	4	M4x10L	
15.	100227	Plate seat .	1		
16.	100228	Plate seat	1		
17.	100204 100205	Leadscrew nut	1	MM INCH	
18.		Hex. screw	2	M6x20L	
19.	100202 100203	Elevating leadscrew	1	MM INCH	
20.		Setting key	1	5x5x15L	
21.	100111	Lock nut	1		
22.		Socket screw	2	M5x8L	
23.		Thrust needle bearing	1	ANK1730 AS1730, CS1730	
24.	100207	Bearing seat	1		

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
25.		Hex. screw	4	M5x15L	
26.		Thrust ball bearing	1	51103	
27.	100209	Bevel gear	1		
28.	100208	Washer	1		
29.		Socket screw	1	M6x16L	
30.	100210	Pinion gear	1		
31.		Taper pin	1	#1x27L	
32.	100235	Height pad	1		
33.	100213	Shaft seat	1		
34.		Hex. screw	2	M6x65L	
35.	100211-1	Shaft	1		
36.		Setting key	1	4x4x12L	
37.		Ball bearing	2	6002NR	
38.					
39.					
40.	100218	Bolt	1		
41.	100215 100216	Index disc	1	MM INCH	
42.	100231	Hand wheel	1		
43.		Socket screw	2	M4x6L	
44.		Socket screw	2	M5x8L	
45.	100217	Setting nut	1		
46.	100232	Adjusting handle	1		
47.					
48.					

COLUMN

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
49.		Hex screw	1	M5 x 14L	
50.	100234	Washer	1		
51.		Flat washer	2	Ø4	
52.	100229-1	Telescopic cover	2		

SPINDLE



A:618AH/AHD

SPINDLE

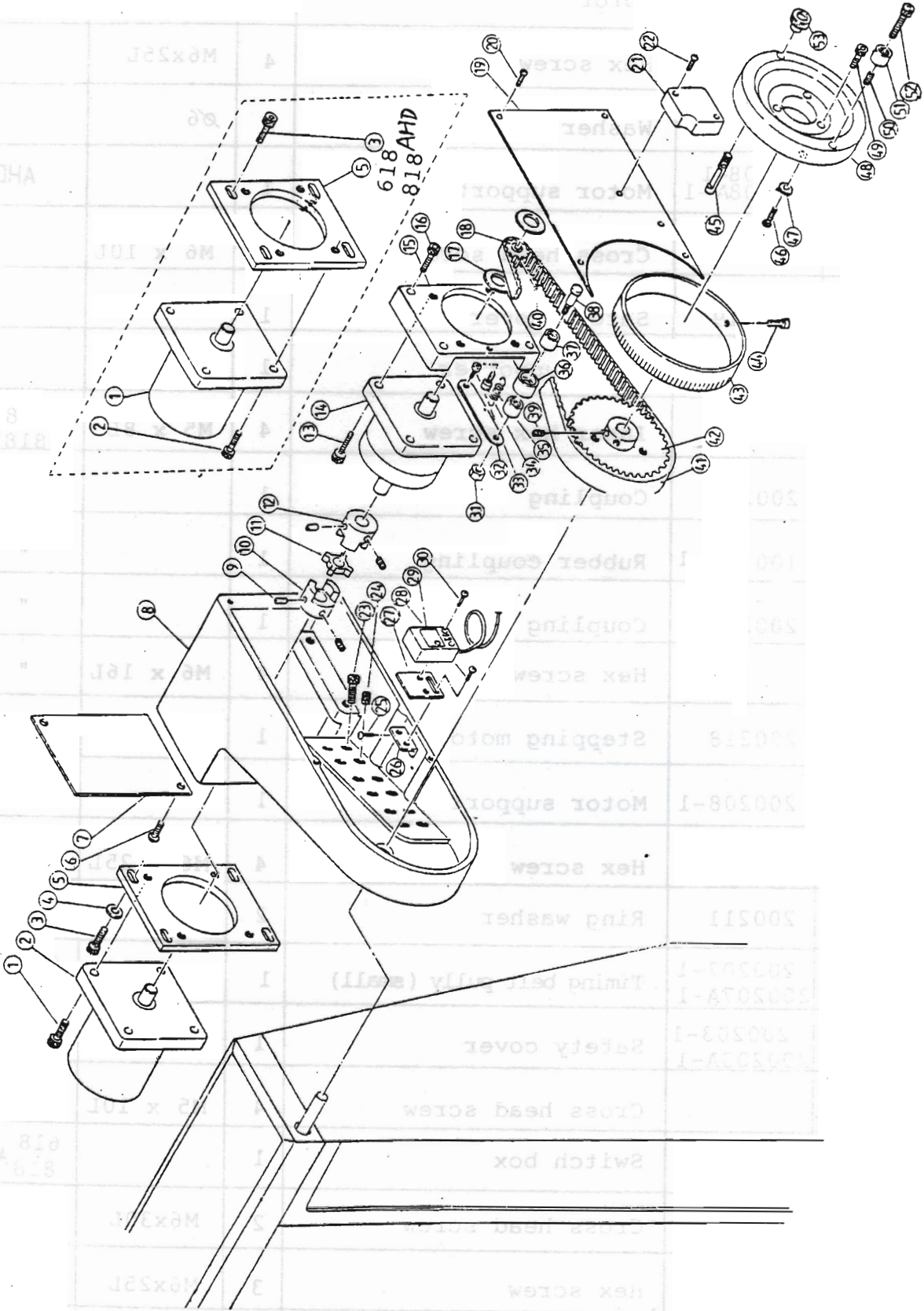
B:818AHD

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
1.	100127	Lock screw	1		
2.		Retaining ring	1	E8	
3.	100125	Wheel guard door	1		
4.	100115	Nut	1		
5.	100117-1	Wheel setting nut	1		
6.	100116-1	Washer	1		
7.	100131	Grinding wheel	1		
8.	100113	Wheel hub	1		
9.	100119	Balance block	3		
10.		Steel ball	3	ø4	
11.		Socket screw	3	M5 x 6L	
12.	100126	Wheel guard	1		
13.		Bolt	1	M8x8L	
14.		Headless screw	2	M5x6L	
15.	100110	Setting nut	1		
16.	100108	O-ring	1		
17.	100109	Pressing plate	1		
18.		Ball bearing	1	#7006C	
19.	100104	Bearing washer	1		
20.	100105	Bearing washer	1		
21.		Ball bearing	1	#7006C	
22.	100102 211002	Spindle	1		A B
23.		Ball bearing	1	#7204C	
24.	100106	Bearing washer	1		

SPINDLE

NO.	PART NO.	DESCRIPTION	Q'TY	SPECIFICATION	REMARKS
25.	100107	Bearing washer	1		
26.		Ball bearing	1	#7204C	
27.	100111	Setting nut	1		
28.		Headless screw	2	M6 x 8L	
29.		Hex. screw	6	M6 x 30L	
30.	100103 211003	Spindle housing	1		A B
31.	100112	Rear cover	1		
32.	100120	Coupling	1		
33.		Pin	1	6x6x15L	
34.	100121-1	Rubber coupling	1		
35.		Socket screw	2	M6 x 8L	
36.		Socket screw	6	M6 x 12L	
37.	100101 211001	Headstock	1		A B
38.	100123	Bushing	1		
39.		Screw	4	M4x12L	
40.	100120	Coupling	1		
41.		Setting key	1	6x6x15L	
42.		Socket screw	2	M8 x 8L	
43.		Socket screw	6	M8 x 25L	
44.	100122A 100122B	Motor support	1		A B
45.		Inner hex screw Outer hex screw	4	M10 x 35L	1.5HP 2.0HP
46.		Socket screw	3	M6 x 30L	
47.	100124 211004	Motor	1	1.5HP 2.0HP	
48.		Round head screw	4	M6x16L	

AUTO ELEVATING MECHANISM (618AHD)
818AHD



AUTO ELEVATING MECHANISM

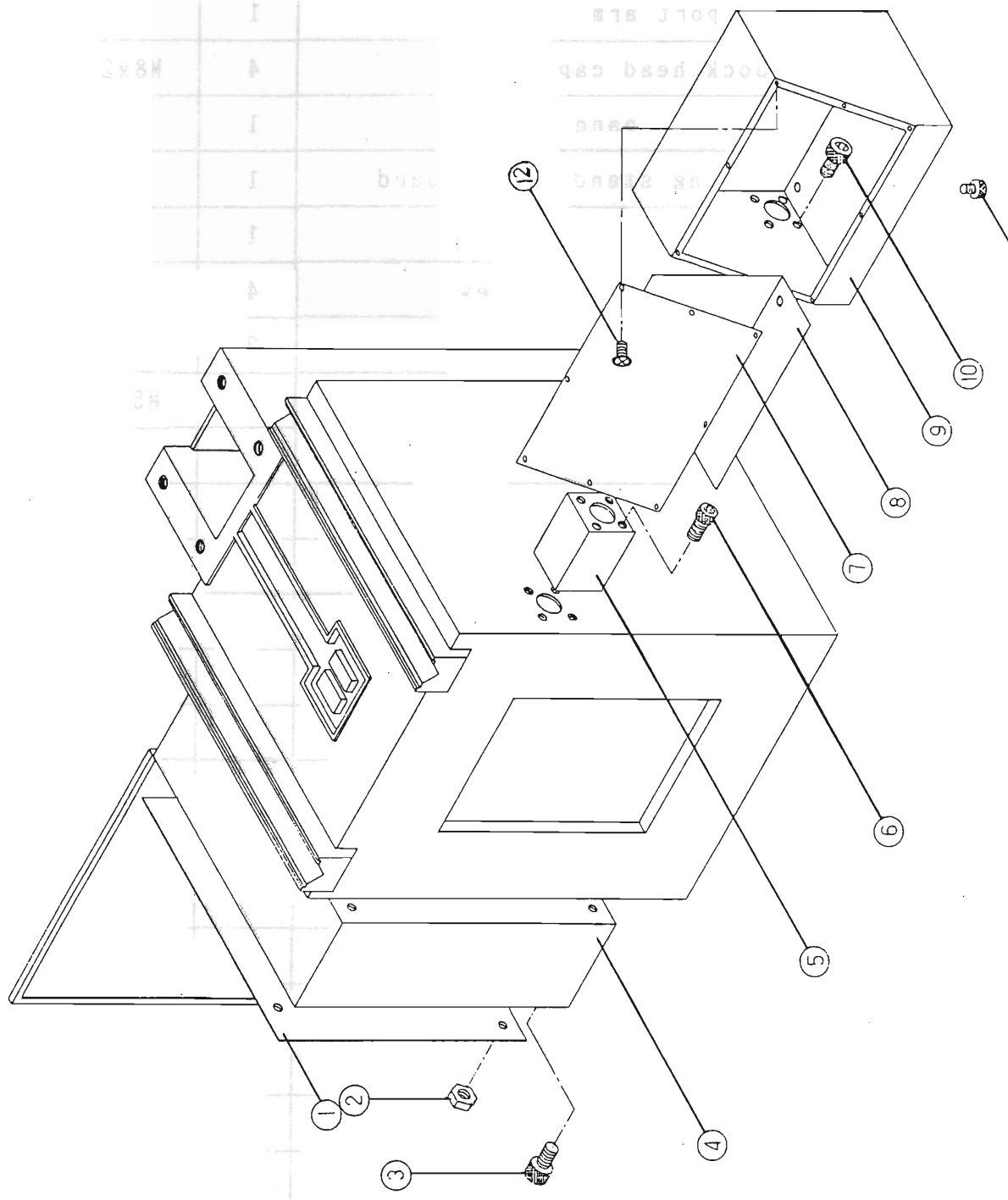
618AHD
(818AHD)

1.		Hex screw	4	M6x20L	
2.	200209-1	Motor	1		
3.		Hex screw	4	M6x25L	
4.		Washer	4	∅6	
5.	200208-1 200208A-1	Motor support	1		AHD
6.		Cross head screw	2	M6 x 10L	
7.	200219	Safety cover	1		
8.	200202-1	Moto supporter	1		
9.		Inner hex screw	4	M5 x 8L	618 818 AHD
10.	200215	Coupling	1		"
11.	100121-1	Rubber coupling	1		"
12.	200214	Coupling	1		"
13.		Hex screw	4	M6 x 16L	"
14.	200218	Stepping motor	1		"
15.	200208-1	Motor support	1		"
16.		Hex screw	4	M6 x 25L	"
17.	200211	Ring washer	2		
18.	200207-1 200207A-1	Timing belt pully (small)	1		618,818AHD
19.	200203-1 200203A-1	Safety cover	1		"
20.		Cross head screw	4	M5 x 10L	
21.	200204	Switch box	1		618 818 AHD
22.		Cross head screw	2	M6x30L	"
23.		Hex screw	3	M6x25L	
24.		Inner hex screw	1	M8x20L	

25.		Inner hex screw	2	M5x16L	618 818AHD
26.	200213	Switch bracket	1		"
27.	220212	"	1		"
28.		Cross head screw	1	M5x8L	"
29.		Proximity switch	1	TL-B5NE1	"
30.		Cross head screw	2	M5x25L	"
31.		Hexagonal nut	1	M8	"
32.	200316	Pressing bar of belt	1		"
33.		Hex screw	1	M6x20L	"
34.		"	1	M4 x 10L	"
35.		Spring	1		"
36.	100409	Bushing	1		"
37.		Needle bearing	2	DHK-1212	"
38.	100408-1	Gear shaft	1		"
39.		Inner hex screw	2	M5 x 8L	
40.		"	2	"	
41.	200210	Timing belt	1		
42.	200206	Timing belt pully	1		
43.	100215 100216	Index disc	1	MM INCH	
44.		Hex screw	1	M4 x 6L	
45.	100218	Bolt	1		
46.		Cross head screw	2	M4 x 8L	
47.		Washer	2	φ4	
48.	200205	Hand wheel	1		

49.		Hex screw	3	M6 x 16L	
50.		Inner hex screw	1	M10 x 10L	
51.		Needle bearing	1	DHK-1212	
52.		Inner hex screw	1	M10x35L	
53.	100217	Setting nut	1		

ELECTRICAL BOX (618 AHD.)
(818 AHD.)



ELECTRICAL BOX (618/818 AHD)

NO.	PART NO.	DESCRIPTION	Q'TY	SIZE	REMARKS
1.	229007-1	Electrical fixing plate	1		
2.		Hex socket nut	4	M6	
3.		Sock head cap screw	4	M8x16L	
4.	229006-1	Electrical box	1		
5.	229009	Support arm	1		
6.		Sock head cap screw	4	M8x20L	
7.	101012-2	Control panel	1		
8.	229010	Fixing stand of pc board	1		
9.	229008	Control box	1		
10.		Sock head cap screw	4	M8x20L	
11.		Sock head cap screw	2	M6x12L	
12.		Cross head screw	8	M5x10L	

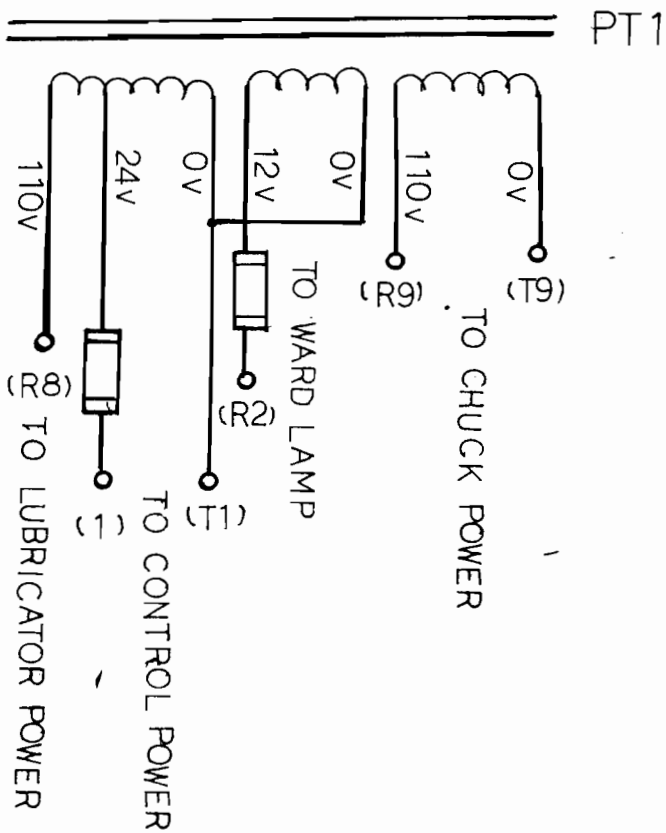
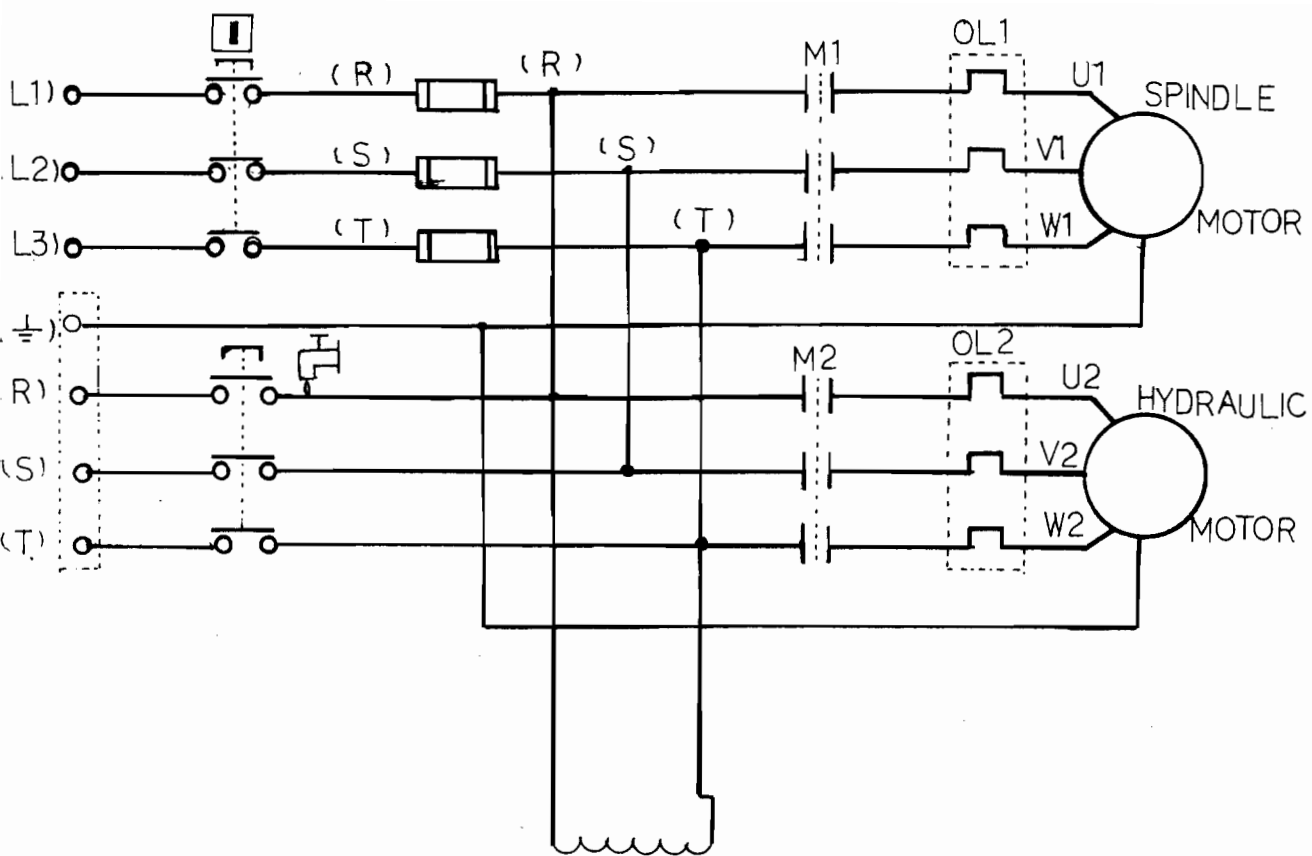
ELECTRIC DIAGRAM

MODEL: **Supra** **618AH**
 618AH/818AHD

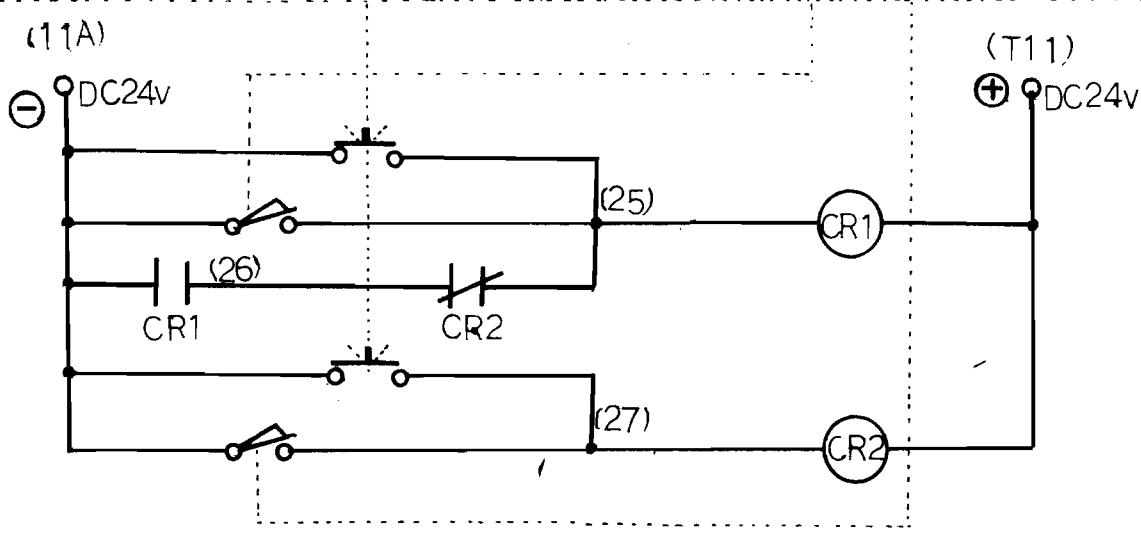
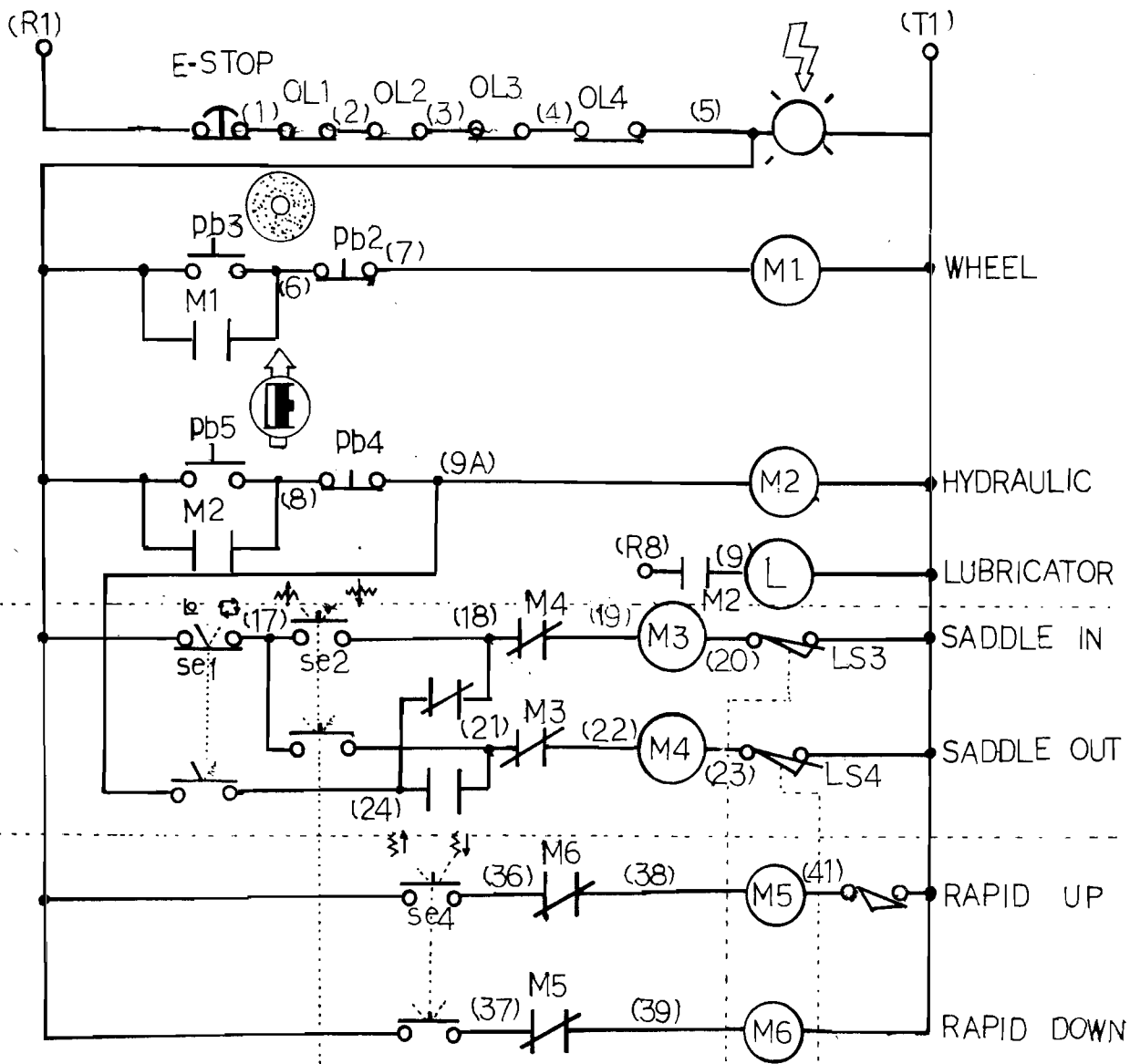
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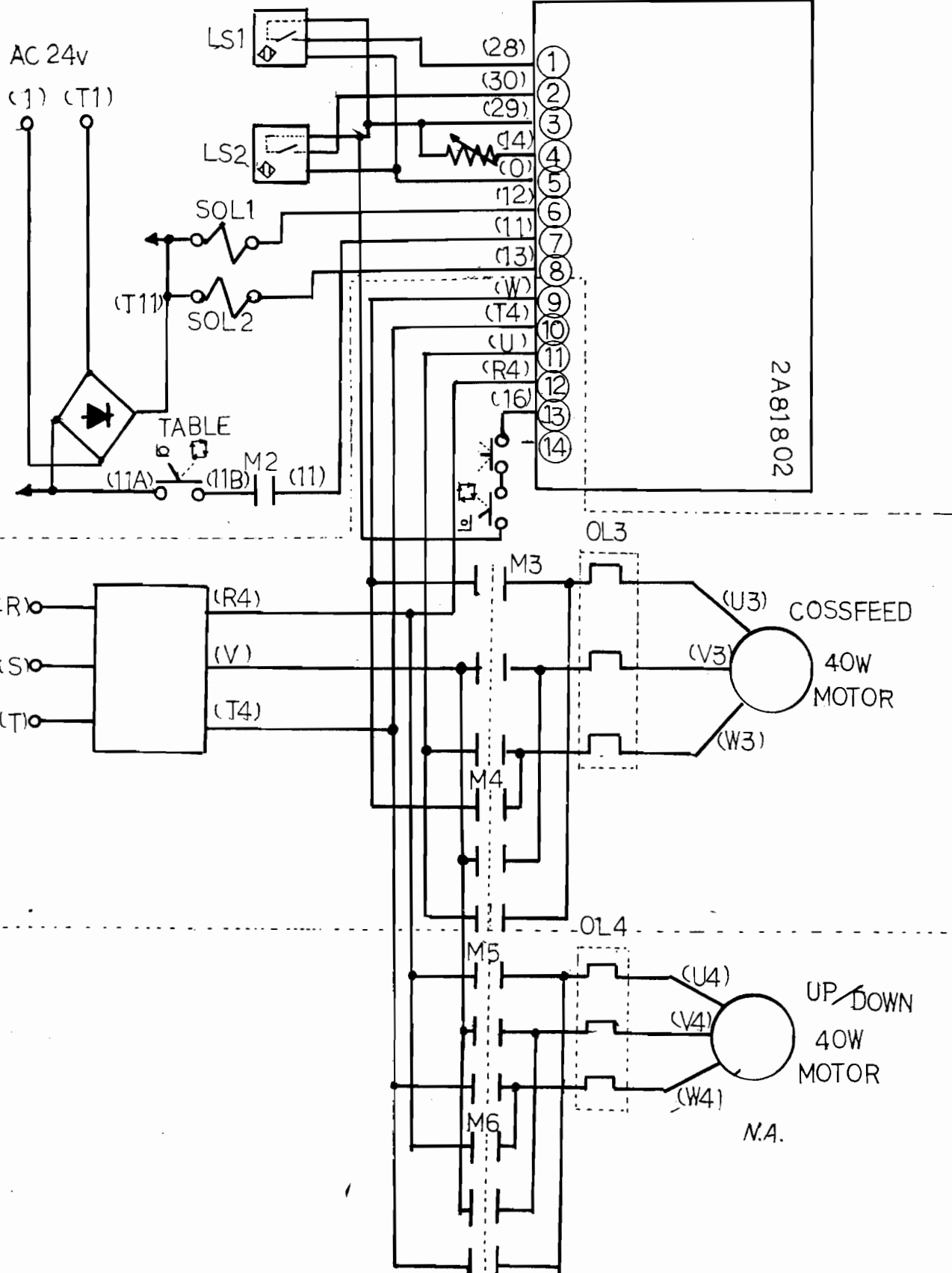
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2. ELECTRIC DIAGRAM OF 618/818 AHD..... 69



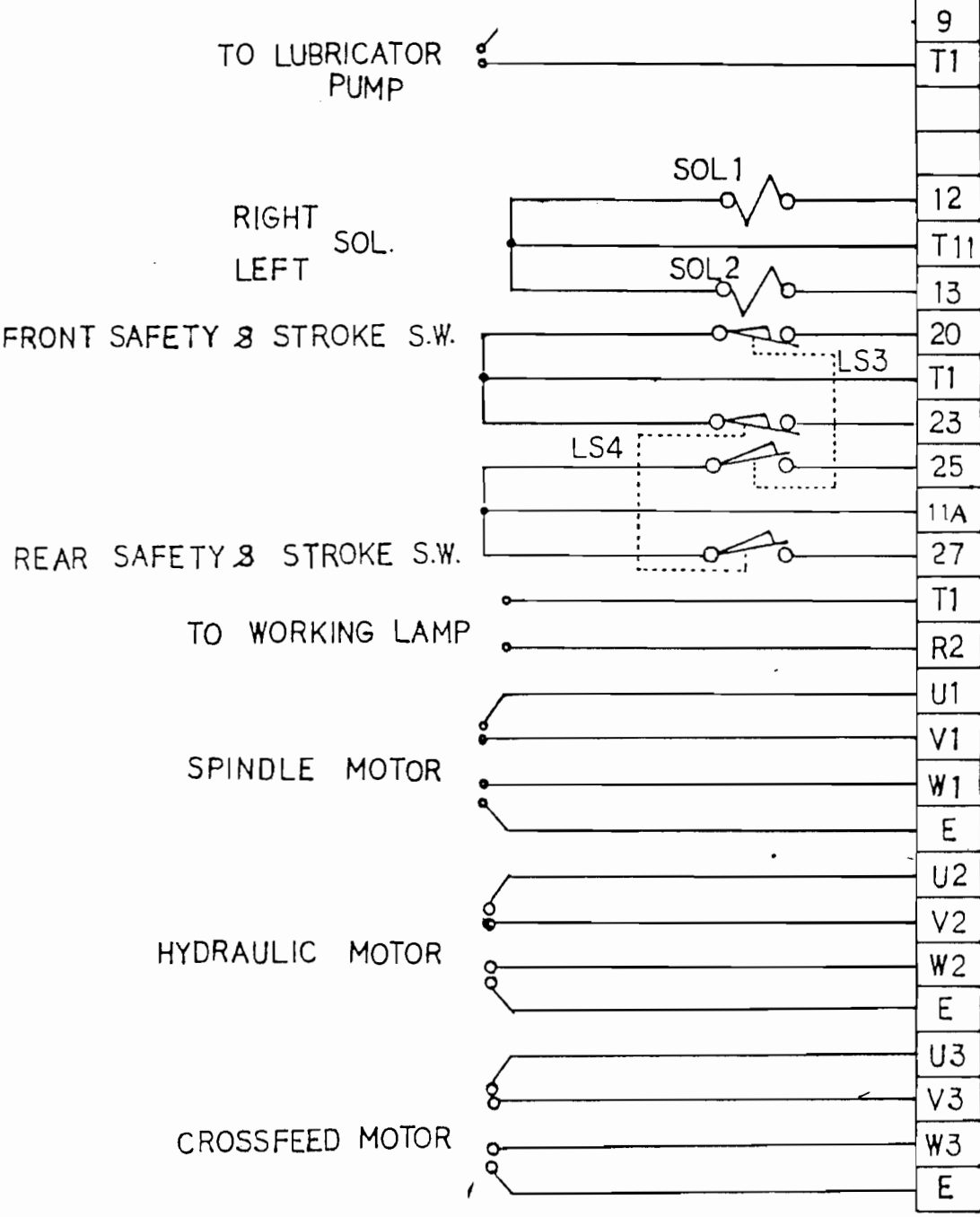
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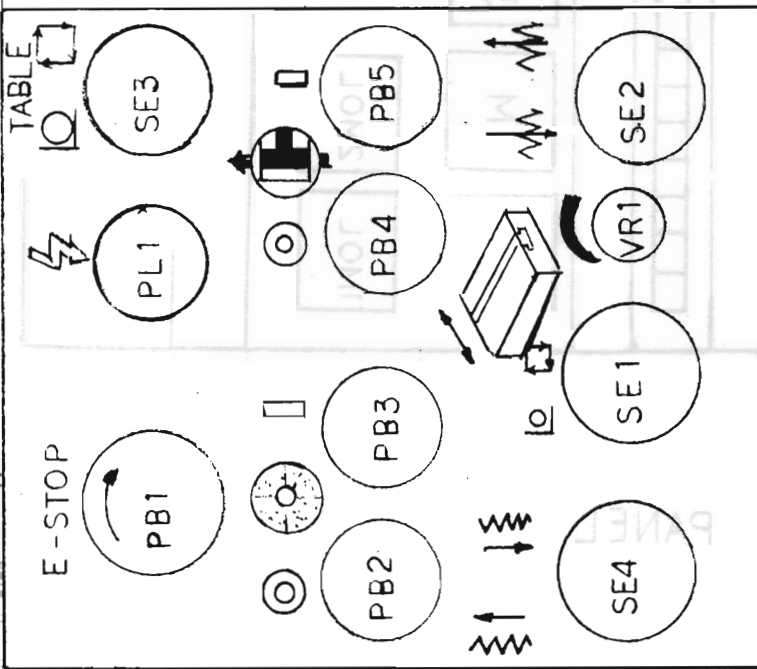
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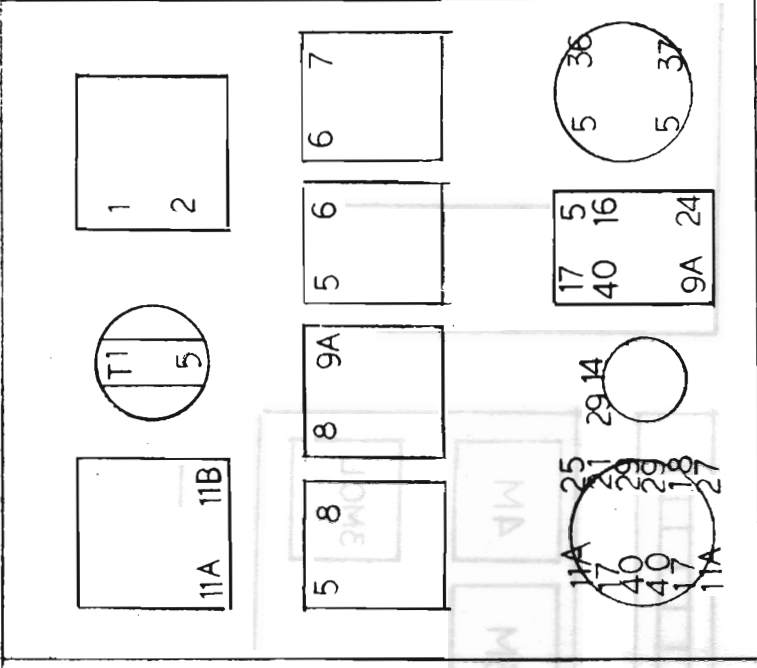
MODEL: 618AH



MODEL: 618AH

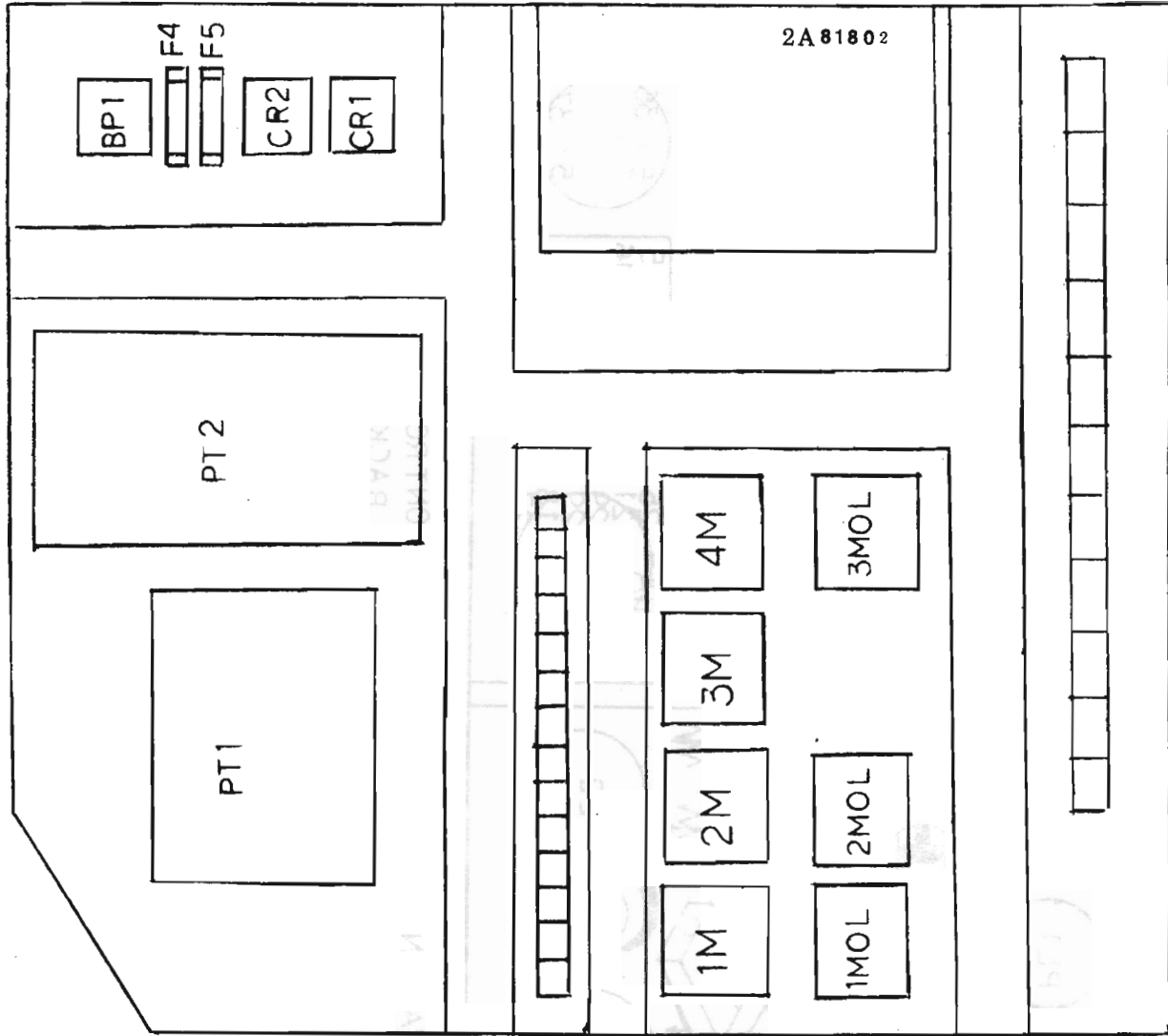


CONTROL STATION

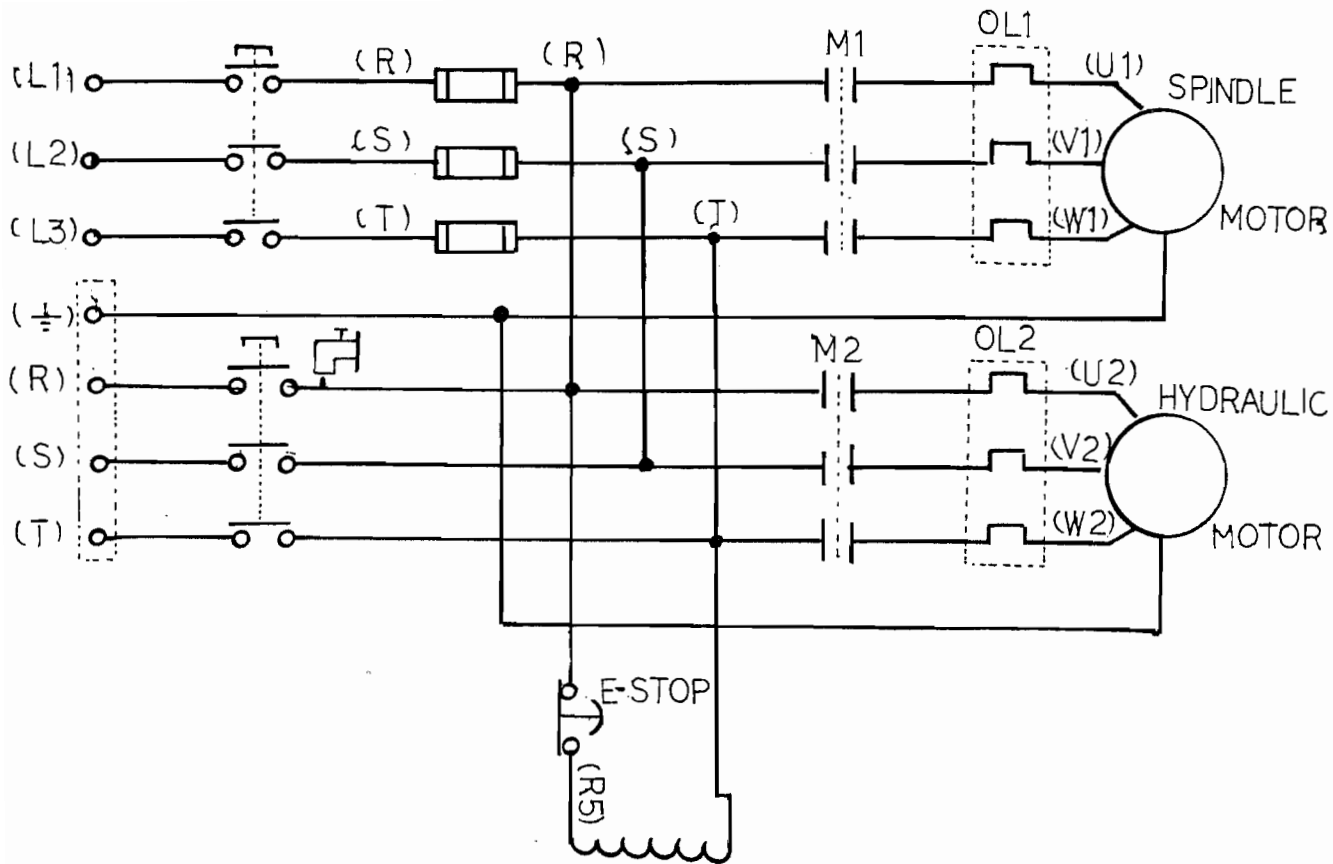


CONTROL STATION
BACK VIEW

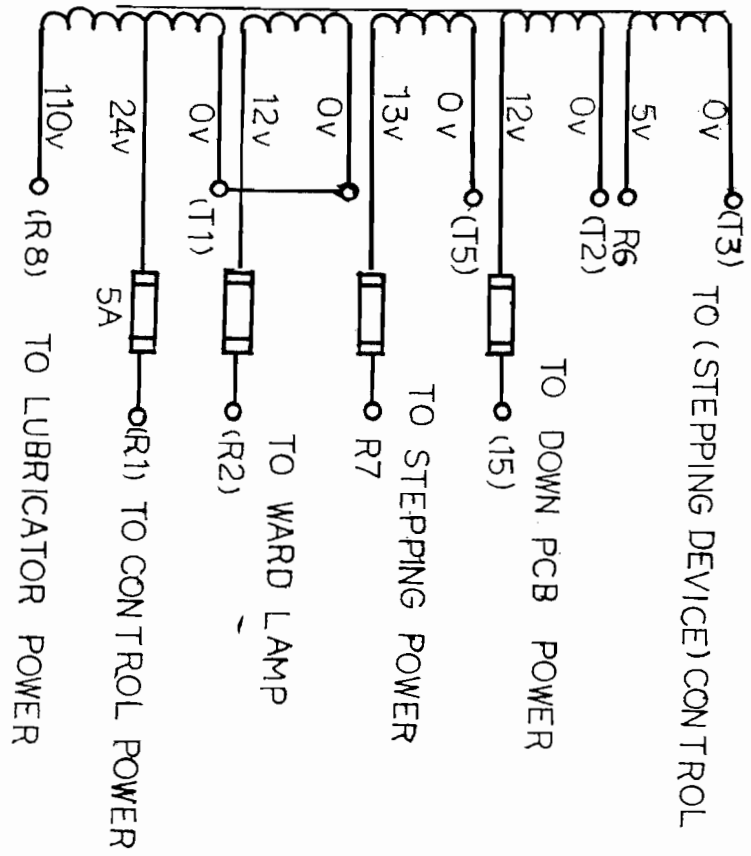
CONTROL PANEL



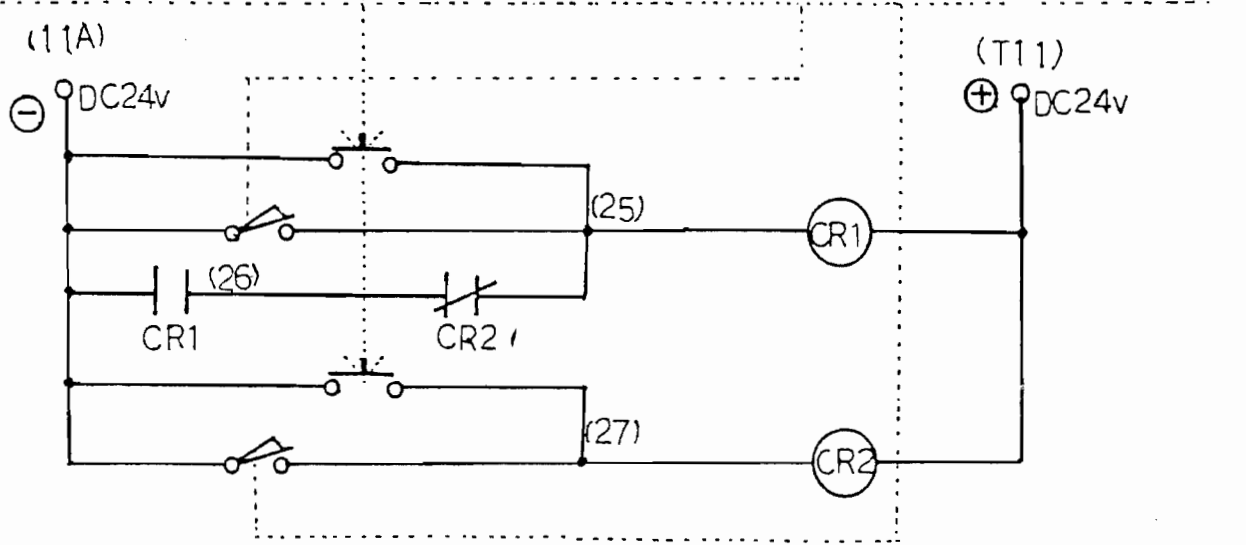
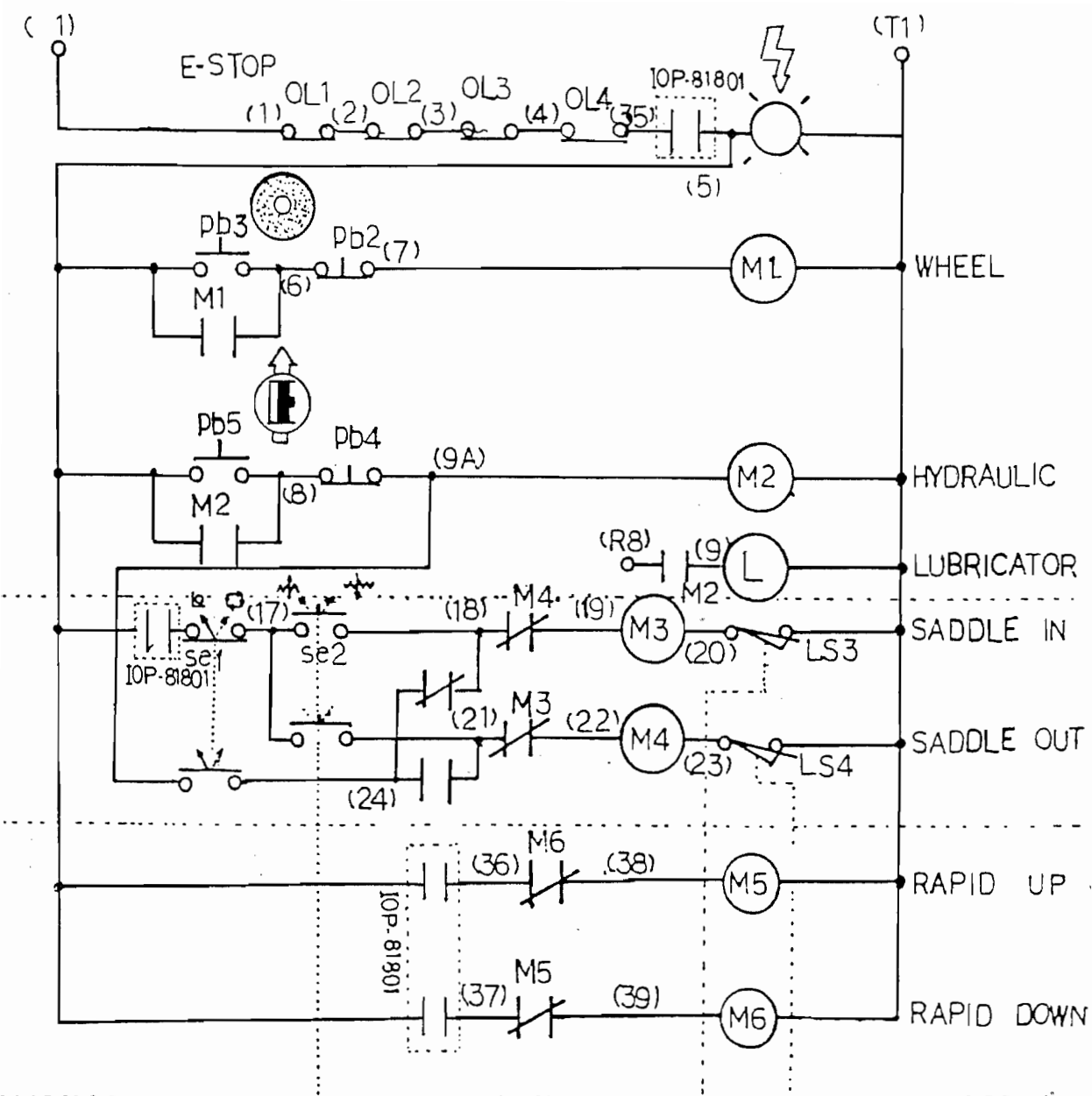
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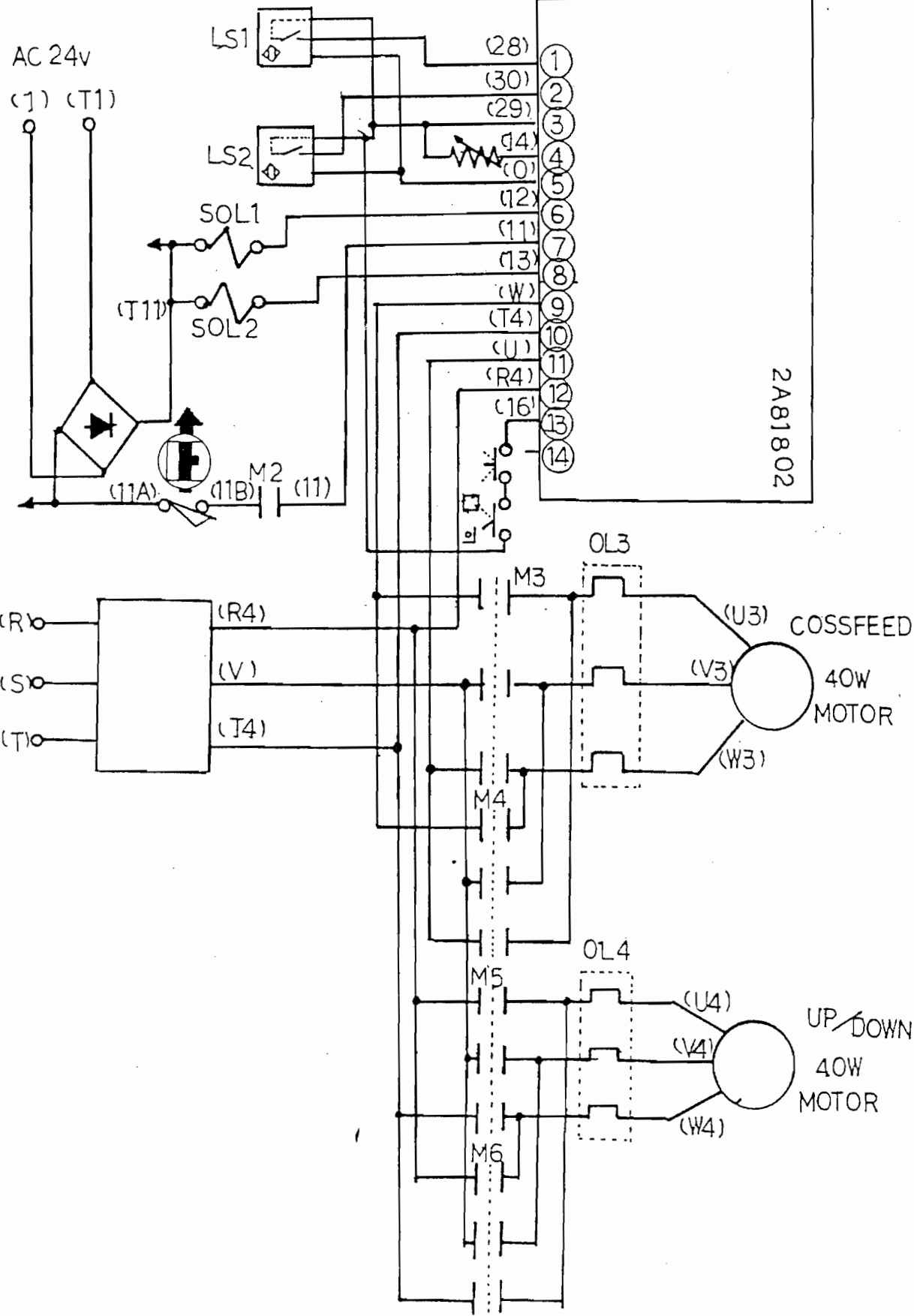
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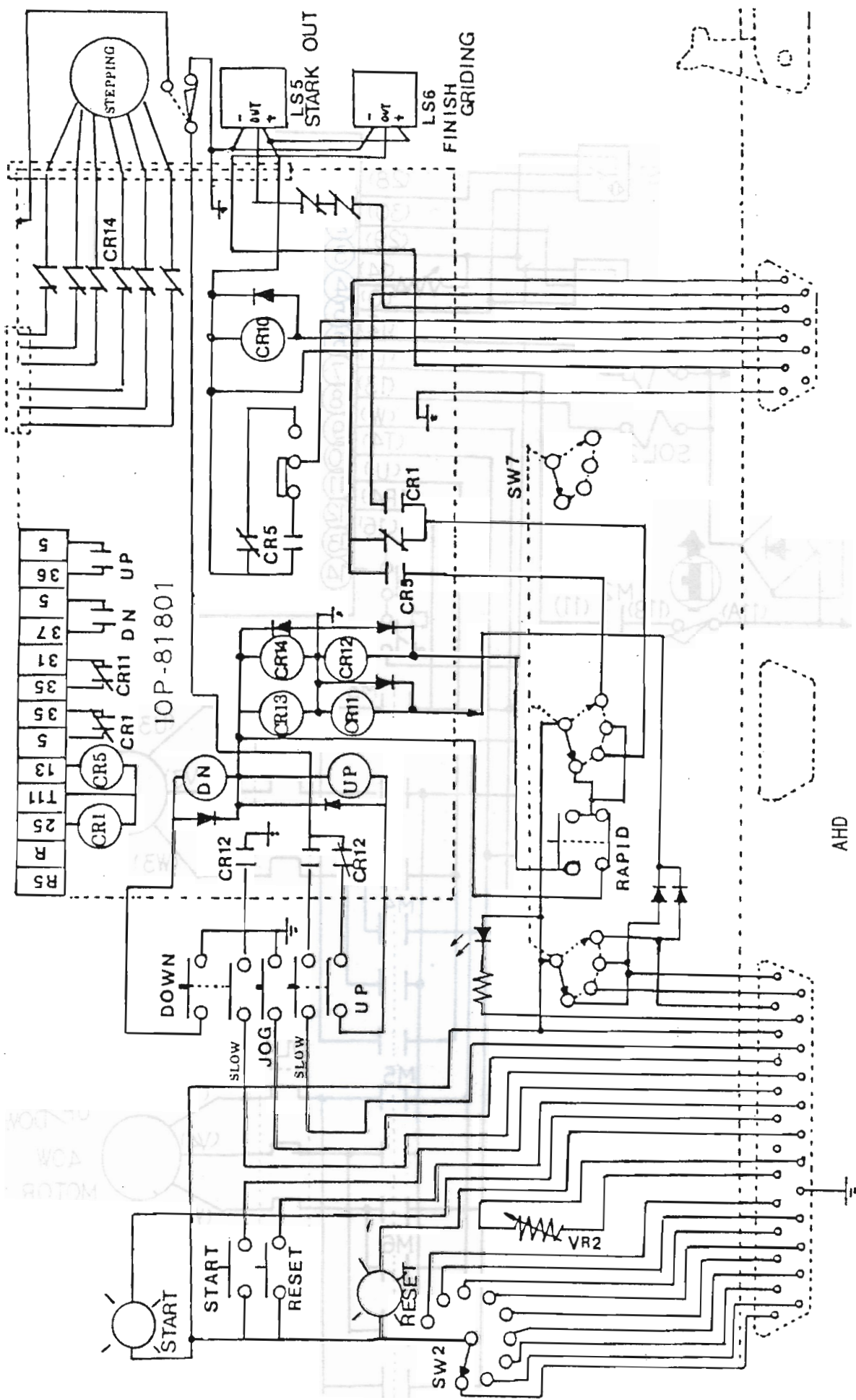
MODEL:
618/818AHD



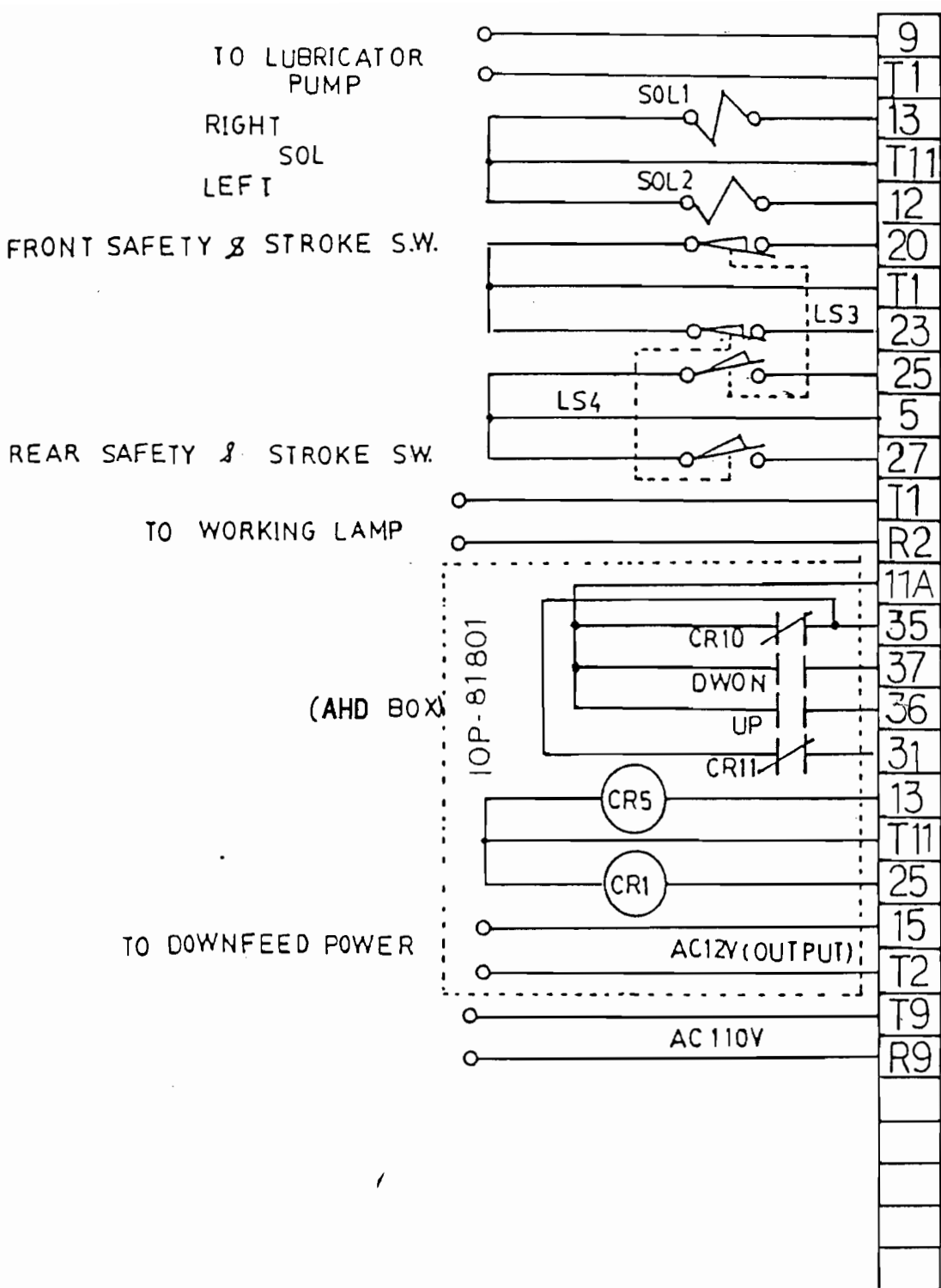
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618/818AHD



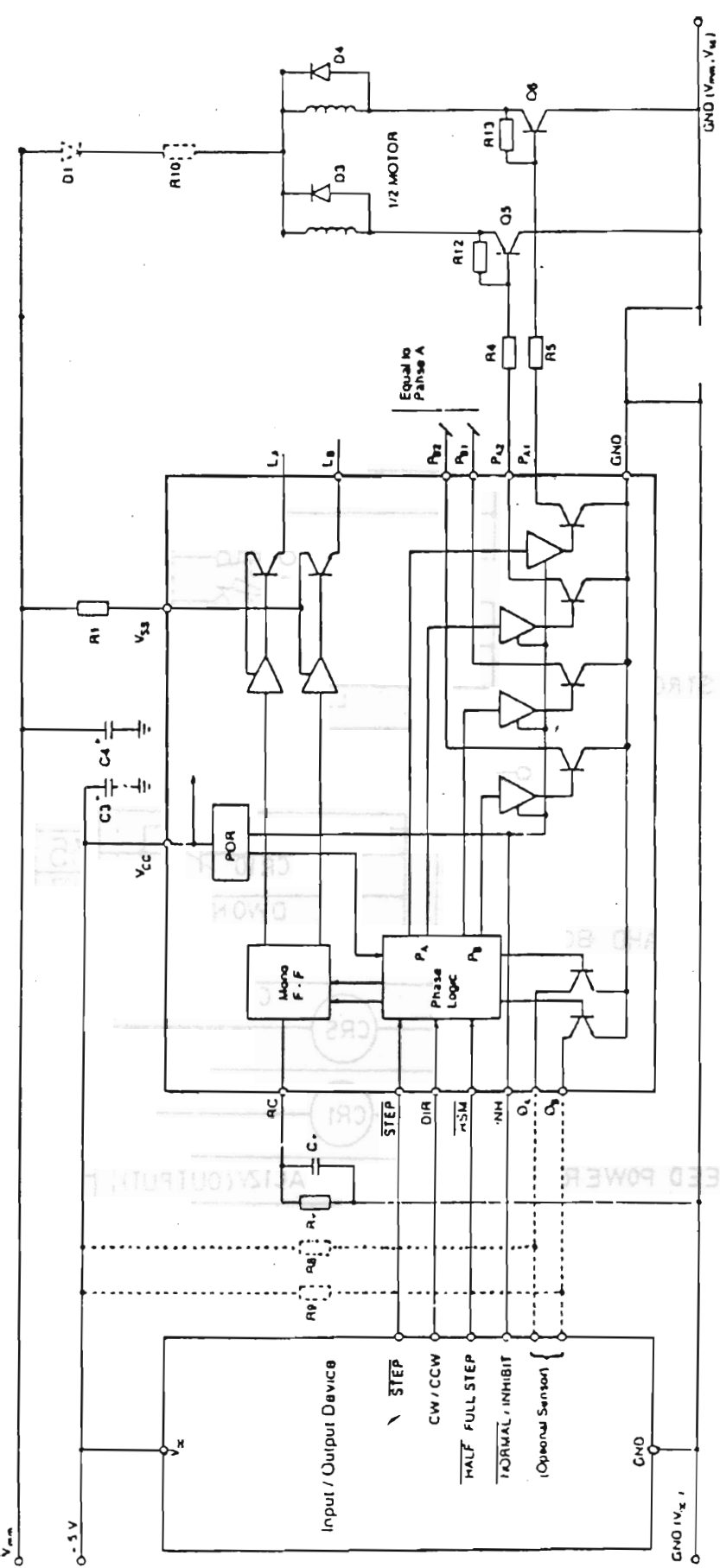
MODEL:
618/818AHD



MODEL:
618/818AHD



MODEL :
618/818AHD



STEPPING DEVICE

MODEL:
618/818AHD