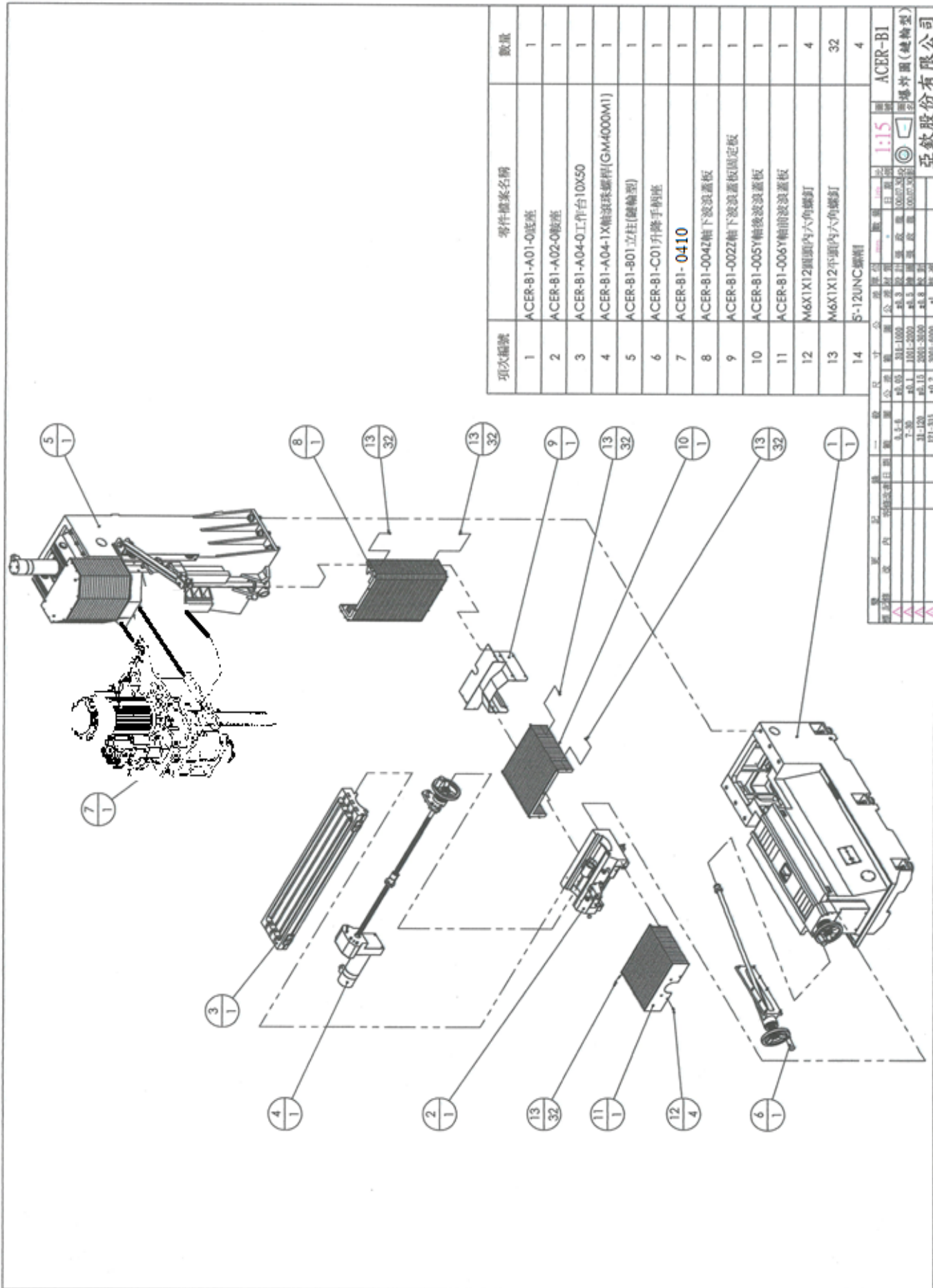


11. Mechanical Drawings & Parts Breakdown List

Note: When ordering parts, please be prepared with,

1. Machine model & serial number.
2. Item number.
3. Part number and description.
4. Year of Production.
5. Voltage & horsepower.
6. Quantity

11-1. ACER-B1 ASSEMBLY DRAWING



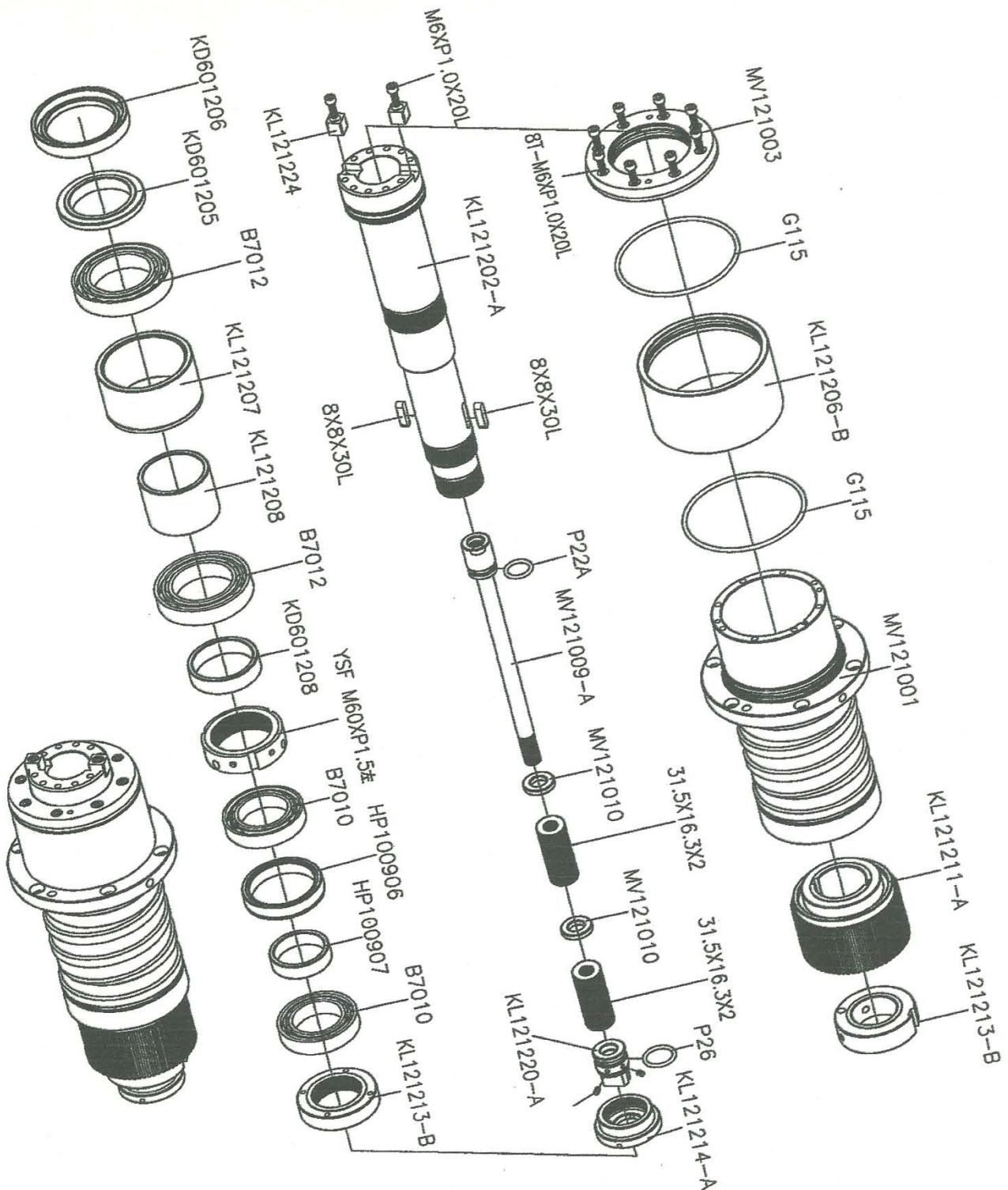
項次編號	零件圖案名稱	數量
1	ACER-B1-A01-0底座	1
2	ACER-B1-A02-0底座	1
3	ACER-B1-A04-0工作台10X50	1
4	ACER-B1-A04-1X輸滾珠螺桿(GM4000M1)	1
5	ACER-B1-901立柱(鏈輪型)	1
6	ACER-B1-C01升降手柄座	1
7	ACER-B1-0410	1
8	ACER-B1-004Z軸下波浪蓋板	1
9	ACER-B1-002Z軸下波浪蓋板固定板	1
10	ACER-B1-005Y軸後波浪蓋板	1
11	ACER-B1-006Y軸前波浪蓋板	1
12	M6X1X12圓頭內六角螺釘	4
13	M6X1X12平頭內六角螺釘	32
14	5-12UNC螺絲	4

圖號	ACER-B1
圖名	ACER-B1
比例	1:1.5
圖示	爆炸圖(鏈輪型)
製圖	黃政
繪圖	黃政
校核	黃政
審核	黃政
日期	1007.03.02
圖號	1007.03.02
圖名	ACER-B1
比例	1:1.5
圖示	爆炸圖(鏈輪型)
製圖	黃政
繪圖	黃政
校核	黃政
審核	黃政
日期	1007.03.02
圖號	1007.03.02

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Drawing #: ACER-B1			
Item #	Assembly #	Assembly Description	Quantity
1	ACER-B1-A01-0	Machine Base Assembly	1
2	ACER-B1-A02-0	Saddle Assembly	1
3	ACER-B1-A04-0	Table Assembly	1
4	ACER-B1-A04-1	X Axis Travel Assembly	1
5	ACER-B1-B01	Column Assembly-Balancing Block Type	1
6	ACER-B1-C01	Elevation Crank Assembly	1
7	ACER-B1-0410	Spindle Housing Assembly	1
8	ACER-B1-004	Z Axis Accordion Way Cover-Lower One	1
9	ACER-B1-002	Z Axis Accordion Way Covers Locating Plate	1
10	ACER-B1-005	Y Axis Accordion Way Cover-Back	1
11	ACER-B1-006	Y Axis Accordion Way Cover-Front	1
12	M6x1x12R	Socket HD Round Top Cap Screw	4
13	M6x1x12F	Socket HD flat Top Cap Screw	32

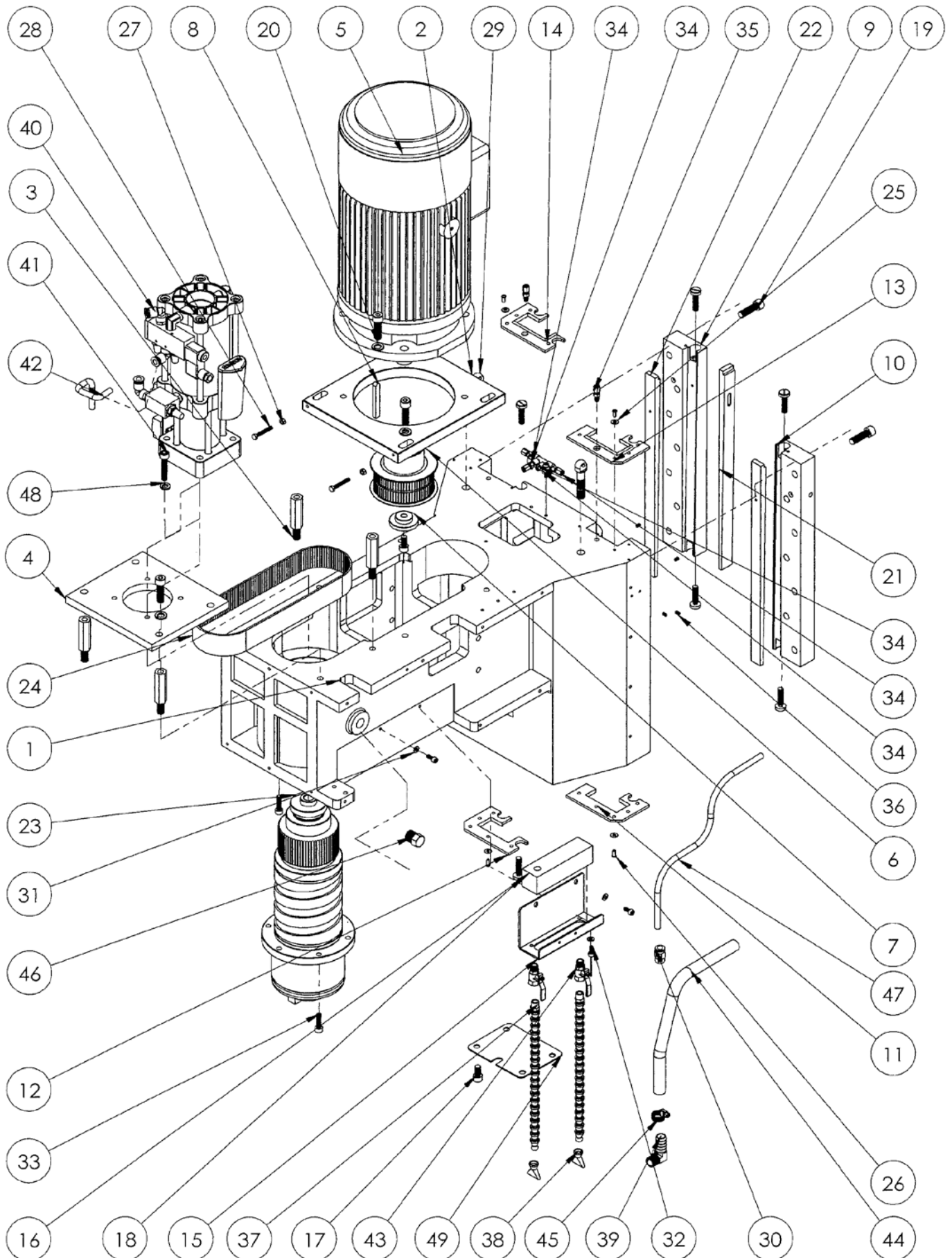
11-2. 7.5 HP SPINDLE ASSEMBLY



品名	圖號	數量
軸心	KL121202-A	1
外水套	KL121206-B	1
外隔環	KL121207	1
內隔環	KL121208	1
皮帶輪	KL121211-A	1
螺母	KL121212	1
磁性開關座	KL121213-B	1
後螺母	KL121214-A	1
拉桿螺母	KL121220-A	1
定位塊	KL121224	1
軸管	MN121001	1
前蓋	MN121003	1
拉桿	MN121009-A	1
墊片	MN121010	2
外隔環	HP100906	1
內隔環	HP100907	1
前防護蓋	KD601205	1
前防護蓋	KD601206	1
內隔環	KD601208	1
軸承	B7012	2
軸承	B7010	2
無頭螺絲	M5XP0.8X6L	6
內六角螺絲	M6XP1.0X20L	10
O型環	P22A	1
O型環	P26	1
O型環	G115	2
螺母	YSR M60XP1.5 左	1
雙頭圓錐	8X8X30L	2
碟型簧片	31.5X16.3X2	90

Spindle Assembly			KL1212
Item#	Part #	Description	Quantity
1	KL121202-A	Spindle Shaft	1
2	KL121206-B	External Jacket	1
3	KL121207	Spacer	1
4	KL121208	Spacer	1
5	KL121211-A	Spindle Pulley	1
6	KL121212	Screw Nut	1
7	KL121213-B	Magnetic Switch Seat	1
8	KL121214-A	Screw Nut	1
9	KL121220-A	Nut of Drawbar	1
10	KL121224	Alignment Key	1
11	MV121001	Spindle Housing	1
12	MV121003	Front Cover	1
13	MV121009-A	Drawbar	1
14	MV121010	Washer	2
15	HP100906	Spacer	1
16	HP100907	Spacer	1
17	KD601205	Dust Proof Cap	1
18	KD601206	Dust Proof Cap	1
19	KD601208	Spacer	1
20	B7012	Ball Bearing	2
21	B7010	Ball Bearing	2
22	M5xP0.8x6L	Set Screw	6
23	M6xP1.0x20L	Socket HD Cap Screw	10
24	P22A	O Ring	1
25	P26	O Ring	1
26	G115	O Ring	2
27	YSR M60XP1.5	Precision Ground Lock Nut-Left Hand Thread	1
28	8x8x30L	Key	2
29	31.5x16.3x2	Disk Spring	90
30	BT40-45°	Clamping Jaw-same for CAT#40	1

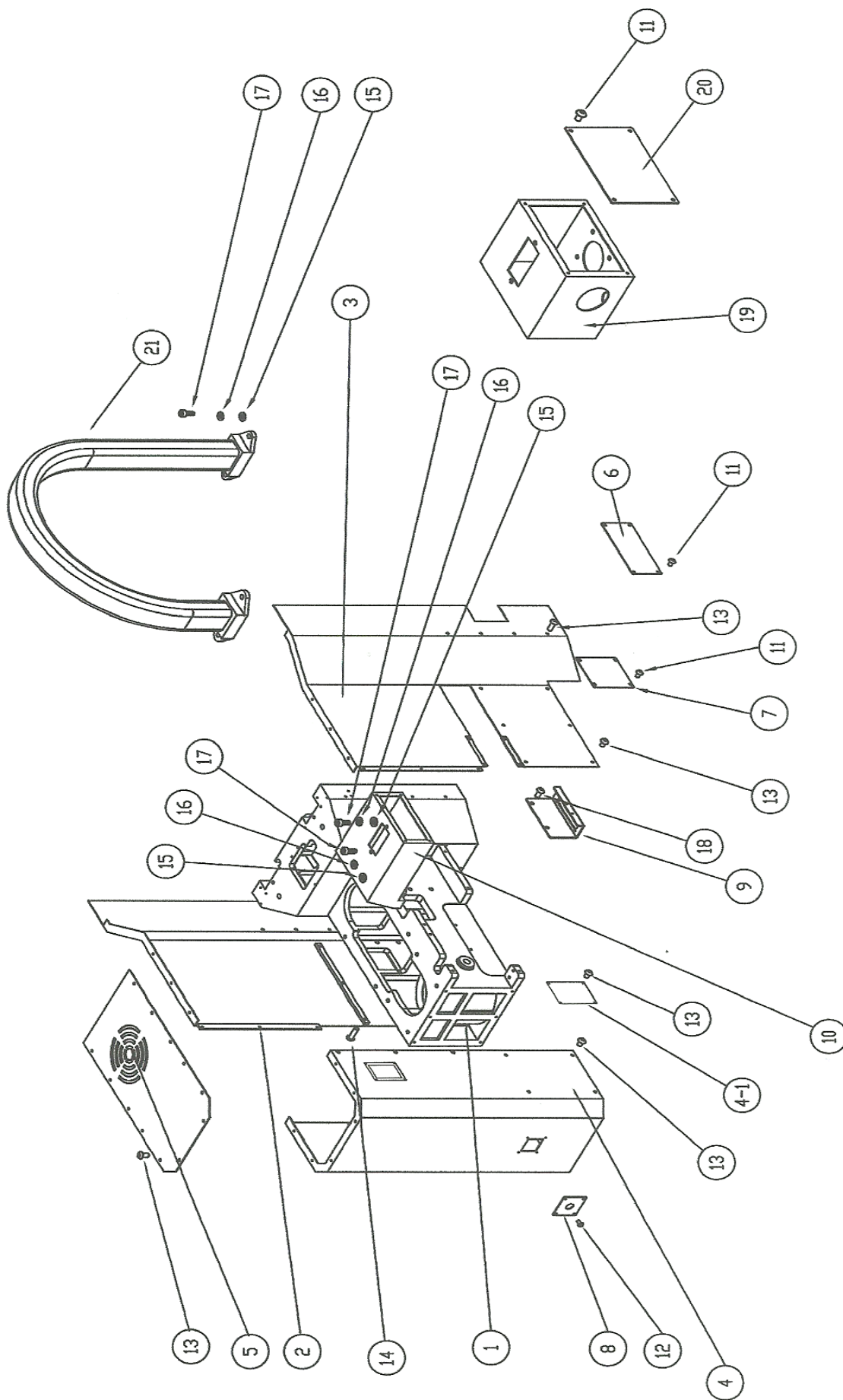
11-3. ACER-B1-0410 SPINDLE HOUSING ASSEMBLY



Item #	Part #	Description	Quantity
1	ACU-020	#40 Spindle Housing	1
2	ACU-021	Motor Locating Plate	1
3	1020L3Z3121	Extension Rod for Tool Grabbing Cylinder	4
4	1020L3Z3091	Locating Plate for Tool Grabbing Cylinder	1
5	ACU-034	7.5HP Spindle Motor	1
6	ACU-035	Spindle Motor Pulley	1
7	ACU-036	End Cover for Motor Pulley	1
8	ACU-037	Key for Spindle Pulley	1
9	ACER-B1-B003	Gib Pate-Left	1
10	ACER-B1-B004	Gib Pate-right	1
11	ACER-B1-B016	Way Wiper-Right Bottom	1
12	ACER-B1-B015	Way Wiper-Left Bottom	1
13	ACER-B1-B013	Way Wiper-Right Top	1
14	ACER-B1-B014	Way Wiper-Left Top	1
15	ACU-B12	Locating Bracket for Manifold	1
16	MCSMS-004	Coolant Distributor	1
17		M10x20L Socket Head Cap Screw	2
18	3-24UNF	3/8"x24UNF Gib Screw	6
19		M12x40L Socket Head Cap Screw	14
20		M12 Spring Washer	4
21	ACER-B1-B005	Gib- Center	1
22	ACER-B1-B006	Gib-Two Sides	2
23	KL1212	Spindle Assembly	1
24	ACU-023	Timing Belt HTD-5M-820	1
25		M5 Flat Washer	16
26		M5x12L + Round Head Cap Screw	16
27		M6 Hex Nut	2
28		M6x50L Socket Head Cap Screw	2
29		Chain Locating Screw	2
30	ACU-024	PT3' 10mm Air Hose Fitting	1
31		M6 Spring Washer	2
32		M6x1.0x15 Socket Head Cap Screw	2
33		M8x1.25x30 Socket Head Cap Screw	6
34	MP9021	A4 Distributing Joint	1
35	ACU-025	M8x1 Check Valve	5
36		M5x0.8x8 Set Screw	6
37	MCSMS-002-1	Nozzle Tubing	4
38	MCSMS-002-2	Coolant & Air Nozzle	4
39	ACU-029	1/2" 90° Elbow Joint	1
40	BC3T13S07	Floating Air Cylinder Assembly	1
41		M10x1.5x50 Socket Head Cap Screw	4
42	ACU-030	Air Hose 10mm	1
43	MCSMS-003	Valve	4

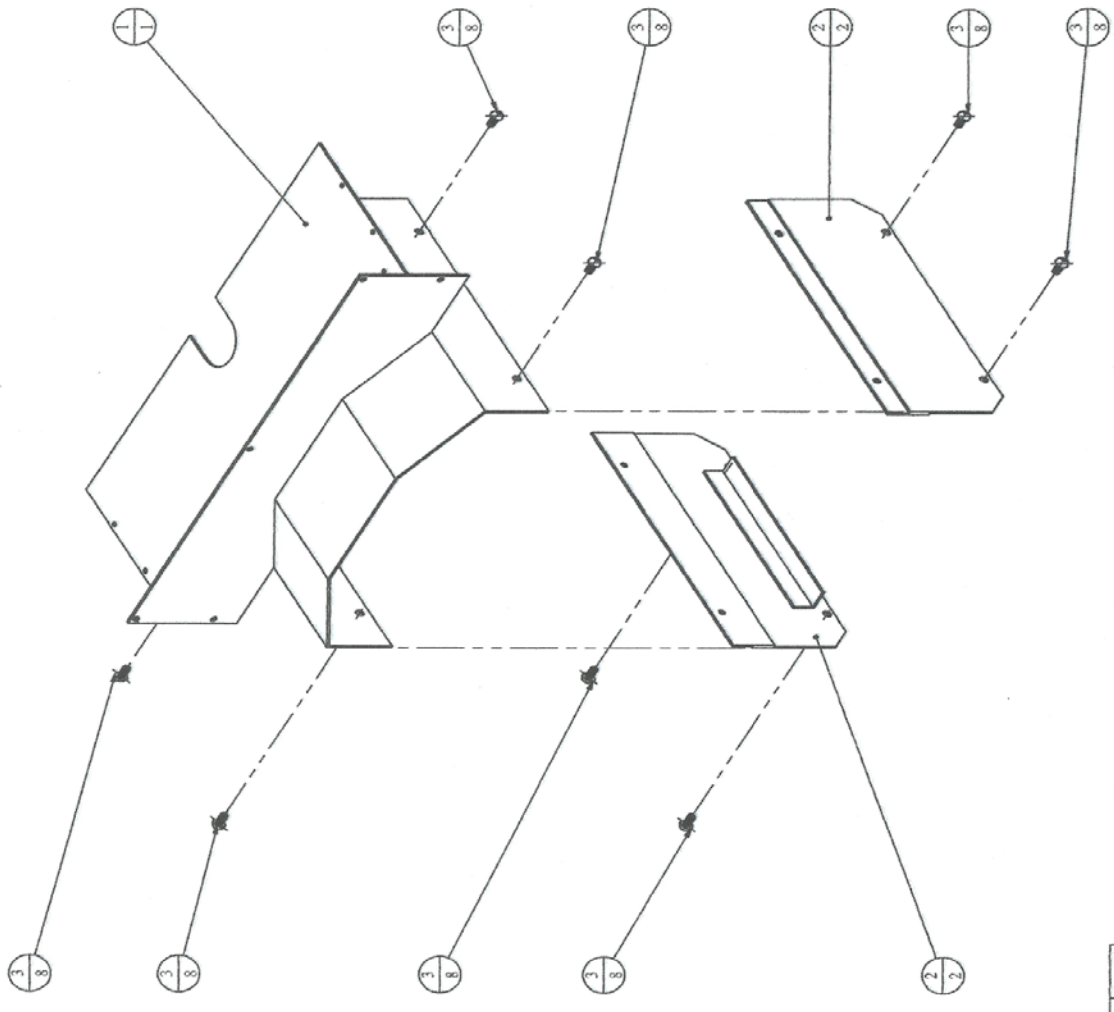
Item #	Part #	Description	Quantity
44	ACU-031	Coolant Hose 1/2"	1
45	ACU-032	1/2" Stainless Adjustable Strap	1
46	ACU-033	1/2" Plug	1
47	ACU-030	Air Hose 10mm	1
48		M10 Spring Washer	4
49	ACU-B11	Lower Housing Cover	1

11-4. SPINDLE HOUSING SHEETMETAL



Item#	Part#	Description	Quantity
1	ACU-020	#40 Spindle Housing	1
2	ACU-B03	Spindle Housing Cover-Right	1
3	ACU-B02	Spindle Housing Cover-Left	1
4	ACU-B01	Spindle Housing Cover-Front	1
4-1	ACU-B01-1	Spindle Housing Cover-Front Side Cover	1
5	ACU-B04	Spindle Housing Cover-Top	1
6	ACU-B08A	Junction Box Cover	1
7	ACU-B05	Spindle Housing Cover-Small Right	1
8	ACU-B06	Tool Release Button Plate	1
9	ACU-B12	Bracket for Air/Coolant Manifold	1
10	ACU-B07S	Tubing Junction Box w/Square Cut-out Hole	1
11		M5*0.8*8 Round Head Socket Cap Screw	12
12		M4*0.7*8 +Round Head Cap Screw	4
13		M6*1.0*10 Round Head Socket Cap Screw	40
14		M6*1.0*25 Round Head Socket Cap Screw	10
15		M6 Flat Thin Washer	4
16		M6 Spring Washer	4
17		M6*1*15 Socket Head Cap Screw	4
18		M6*1.0*12 Round Head Socket Cap Screw	2
19	ACU-B09+	Tubing Junction Box w/Square Cut-out Hole	1
20	ACU-B10+	Junction Box Cover	1
21		Square Interlocking Protection Tube (Type B II)	1

11-5. ACER-B1-002 Z AXIS ACCORDION WAY COVERS LOCATING PLATE



圖號	ACER-B1-002	
圖名	Z軸下滾珠蓋板固定板爆炸圖	
比例	1:5	投影
日期	10/07/20	10/07/20
數量	1	1
單位	mm	mm
公差	±0.3	±0.5
尺寸	315-1000	1001-2000
公差	±0.05	±0.1
範圍	0.5-6	7-30
日期	31-120	121-315
公差	±0.15	±0.2
範圍	2001-3000	3001-6000
公差	±0.8	±1
材料	鋼	鋼
設計	張政豐	張政豐
繪圖	張政豐	張政豐
校對	張政豐	張政豐
核准	張政豐	張政豐

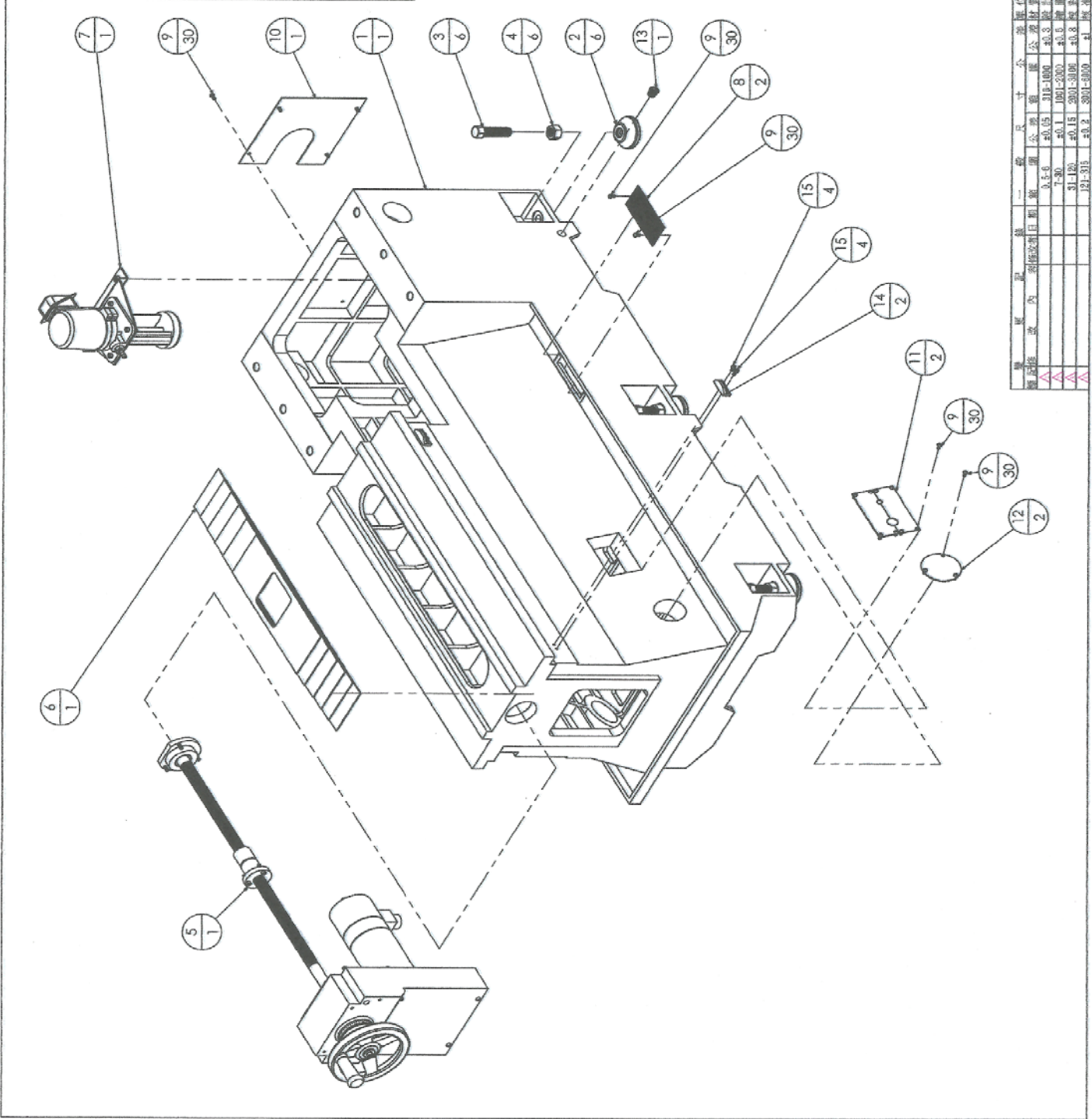
序次	零件名稱	數量
1	ACER-B1-002Z軸下滾珠蓋板固定上板	1
2	ACER-B1-002Z軸下滾珠蓋板固定下板	2
3	M6X1X12圓頭內六角螺釘	8

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Drawing #: ACER-B1-002			
Item #	Part #	Description	Quantity
1	ACER-B1-003	Z Axis Accordion Way Cover Locating Bracket	1
2	ACER-B1-002	Z Axis Accordion Way Cover Locating Plate	2
3	M6x1x12R	Socket HD Round Cap Screw	8

11-6. ACER-B1-A01-0 MACHINE BASE ASSEMBLY

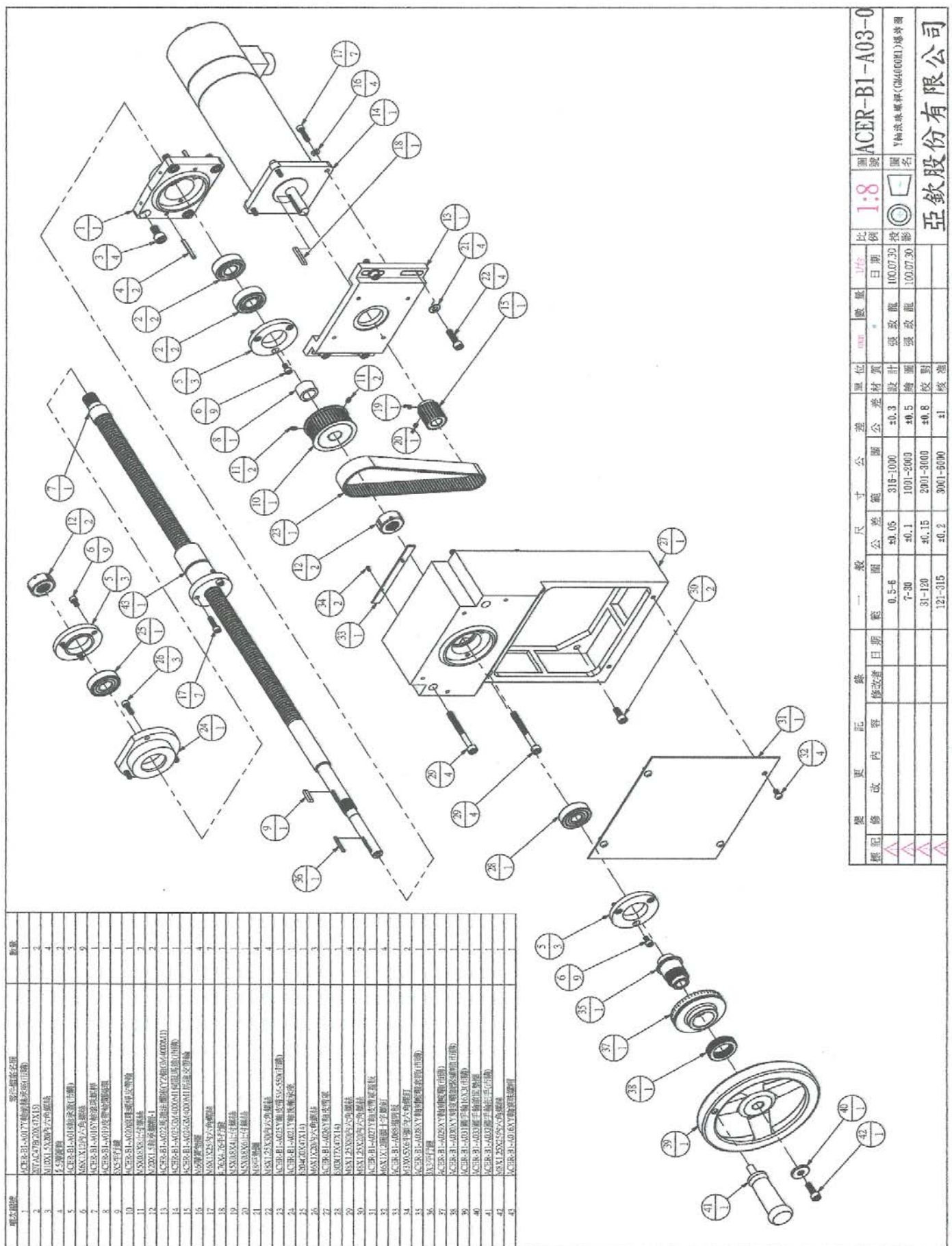
項次編號	零件名稱	數量
1	ACER-B1-A01 底座	1
2	ACER-B1-A02 螺絲鎖(自備)	6
3	ACER-B1-A03 螺絲鎖(8-9unc 自備)	6
4	ACER-B1-A04-9/32-9UNC 螺絲(自備)	6
5	ACER-B1-A05-01 軸線螺絲(GM400M1)	1
6	ACER-B1-A01-1 防撞蓋板	1
7	ACER-B1-A06-06 螺絲蓋	1
8	ACER-B1-A04 螺絲蓋	2
9	MSD08X12圓頭十字螺絲	30
10	ACER-B1-A0271 螺絲蓋板 (用於螺絲蓋和螺絲蓋口)	1
11	ACER-B1-A056 螺絲刀孔蓋板	2
12	ACER-B1-A055 螺絲刀孔蓋板	2
13	PD.S14UNC 止滑螺絲	1
14	ACER-B1-A047 螺絲(自備)	2
15	MSD08X12 六角螺絲	4



圖號		比例		單位		日期		圖名		圖號	
ACER-B1-A01-0	1:6	底座	底座	1007	1007	1007	1007	底座	底座	底座	底座
ACER-B1-A01-0	1:6	底座	底座	1007	1007	1007	1007	底座	底座	底座	底座

Drawing #: ACER-B1-A01-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A001	Machine Base	1
2	ACER-B1-A002	Leveling Pad	8
3	ACER-B1-A003	Leveling Screw	8
4	ACER-B1-A004	Hex Nut	8
5	ACER-B1-A03-0	Y Axis Travel Assembly	1
6	ACER-B1-A01-1	Chip Cover Assembly	1
7	ACER-B1-A05-0	Coolant Pump Assembly	1
8	ACER-B1-A054	Wire Mesh	2
9	M5x0.8x12	Round Hd Cap + Screw	4
10	ACER-B1-A027-B1	Machine Base Cover	1
11	ACER-B1-A056	Cable Cover Plate	2
12	ACER-B1-A055	Round Cover Plate	4
13	Pt0.5"-14 UNC	Coolant Plug	1
14	ACER-B1-A047	Axis Positioning Block	2
15	M5x0.8x12	Socket HD Cap Screw	4

11-7. ACER-B1-A03-0 Y AXIS TRAVEL ASSEMBLY



零件圖號	零件名稱	數量
1	ACER-B1-A017Y軸行程組(含齒輪)	1
2	BITAC17020X11D	2
3	ADXL 5X20吋六角螺絲	4
4	5.5螺絲帽	2
5	ACER-B1-A017Y軸行程組(上蓋)	2
6	MSX125X20吋六角螺絲	9
7	ACER-B1-A017Y軸行程組(下蓋)	2
8	ACER-B1-A017Y軸行程組(彈簧)	2
9	MSX125X20吋六角螺絲	9
10	MSX125X20吋六角螺絲	2
11	MSX125X20吋六角螺絲	2
12	MSX125X20吋六角螺絲	2
13	ACER-B1-A017Y軸行程組(彈簧)	2
14	ACER-B1-A017Y軸行程組(彈簧)	2
15	ACER-B1-A017Y軸行程組(彈簧)	2
16	MSX125X20吋六角螺絲	4
17	MSX125X20吋六角螺絲	4
18	5.7X3.7螺絲帽	1
19	MSX125X20吋六角螺絲	1
20	MSX125X20吋六角螺絲	4
21	MSX125X20吋六角螺絲	4
22	ACER-B1-A017Y軸行程組(彈簧)	2
23	ACER-B1-A017Y軸行程組(彈簧)	2
24	ACER-B1-A017Y軸行程組(彈簧)	2
25	MSX125X20吋六角螺絲	3
26	MSX125X20吋六角螺絲	3
27	ACER-B1-A017Y軸行程組(彈簧)	2
28	MSX125X20吋六角螺絲	1
29	MSX125X20吋六角螺絲	2
30	MSX125X20吋六角螺絲	2
31	ACER-B1-A017Y軸行程組(彈簧)	4
32	MSX125X20吋六角螺絲	4
33	ACER-B1-A017Y軸行程組(彈簧)	2
34	MSX125X20吋六角螺絲	2
35	ACER-B1-A017Y軸行程組(彈簧)	2
36	MSX125X20吋六角螺絲	2
37	MSX125X20吋六角螺絲	2
38	ACER-B1-A017Y軸行程組(彈簧)	2
39	ACER-B1-A017Y軸行程組(彈簧)	2
40	ACER-B1-A017Y軸行程組(彈簧)	2
41	ACER-B1-A017Y軸行程組(彈簧)	2
42	MSX125X20吋六角螺絲	2
43	ACER-B1-A017Y軸行程組(彈簧)	2
44	ACER-B1-A017Y軸行程組(彈簧)	2

標記	變更	內容	日期	設計	審核	日期	比例	圖號	圖名
△							1:8	ACER-B1-A03-0	Y軸行程組(含齒輪)
△									
△									

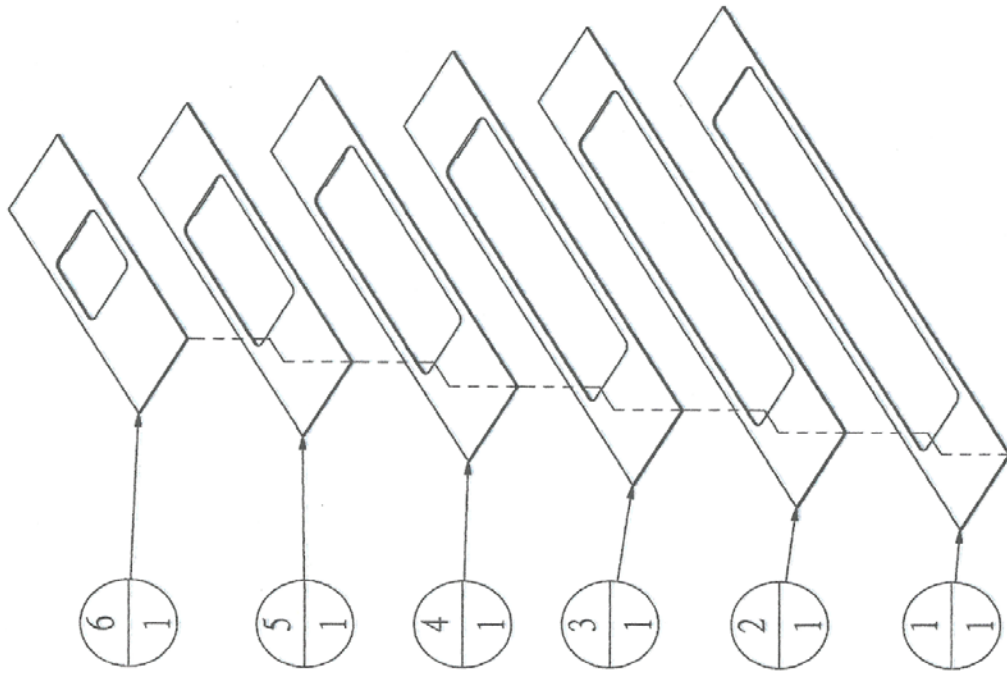
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Drawing #: ACER-B1-A03-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A017	Cross Feed Bearing Bracket-Aluminum	1
	ACER-B1-A017C	Cross Feed Bearing Bracket-Cast Iron	1
2	20TAC47B	Ball Screw Support Ball Bearing	2
3	M10x1.5x20	Socket Hd Cap Screw	4
4	Φ5	Roll Pin	2
5	ACER-B1-A018	Bearing Cap	3
6	M6x1x12	Socket Hd Cap Screw	9
7	ACER-B1-A016	Y Axis Ball Screw	1
8	ACER-B1-A019	Spacer	1
9	M5x5x20	Key	1
10	ACER-B1-A020	Ball Screw Pulley for 750W	1
	ACER-B1-A020-1K	Ball Screw Pulley for 1KW	1
	ACER-B1-A020-F	Ball Screw Pulley for Fagor Servo Motor	1
11	M5x0.8x8	Set Screw	2
12	M20x1.5	Precision Lock Nut	2
13	ACER-B1-A022	Motor Plate for 750W Motor	1
	ACER-B1-A022-1K	Motor Plate for 1KW Motor	1
	ACER-B1-A022-F	Motor Plate for Fagor Servo Motor	1
14	ACER-B1-A023	Servo Motor 750W	1
	ACER-B1-A023-1K	Servo Motor 1KW	1
	ACER-B1-A023-F	Servo Motor Fagor	1
15	ACER-B1-A024	Motor Pulley for 750W	1
	ACER-B1-A024-1K	Motor Pulley for 1KW	1
	ACER-B1-A024-F	Motor Pulley for Fagor Servo Motor	1
16	M6	Spring Washer	4
17	M6x1x25	Socket Hd Cap Screw	4
18	M4.76x4.76	Key	1
19	M5x0.8x4	Set Screw	1
20	M5x0.8x6	Set Screw	1
21	M8	Flat Washer	4
22	M8x1.25x30	Socket Hd Cap Screw	4
23	ACER-B1-A025	Timing Belt for 750W (5Mx550)	1
	ACER-B1-A025-1K	Timing Belt for 1KW	1
	ACER-B1-A025-F	Timing Belt for Fagor Servo Motor	1
24	ACER-B1-A021	Ball Bearing Seat	1
	ACER-B1-A021L	Ball Bearing Seat with OD120mm	1
25	6204ZZ	Ball Bearing (20x47x14)	1
26	M6x1x20	Socket Hd Cap Screw	3
27	ACER-B1-A026	Y Axis Front Cover Assembly	1

Item #	Part #	Description	Quantity
28	6303ZZ	Ball Bearing (17x47x14)	1
29	M8x1.25x80	Socket Hd Cap Screw	4
30	M8x1.25x20	Socket Hd Cap Screw	2
31	ACER-B1-A027	Front Cover Plate	1
32	M6x1x12R	Round Hd Cap + Screw	4
33	ACER-B1-A068	Chip Plate	1
34	M3x0.5x6F	Socket Hd Flat Cap Screw	2
35	ACER-B1-A028	X, Y Axis Dial Holder	1
36	M3x3x25	Key	1
37	ACER-B1-A029	Dial (2012)	1
38	ACER-B1-A030	Dial Lock Nut (2016)	1
39	ACER-B1-A031	Handwheel (5/8"x3mm)	1
40	ACER-B1-A033	Handwheel Washer	1
41	ACER-B1-A032	Handle	1
42	M8x1.25x25	Socket Hd Cap Screw	1
43	ACER-B1-A016	X, Y Ball Screw Nut	1

11-8. ACER-B1-A01-1 CHIP COVER ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-A009防塵蓋板1	1
2	ACER-B1-A010防塵蓋板2	1
3	ACER-B1-A011防塵蓋板3	1
4	ACER-B1-A012防塵蓋板4	1
5	ACER-B1-A013防塵蓋板5	1
6	ACER-B1-A014防塵蓋板6	1



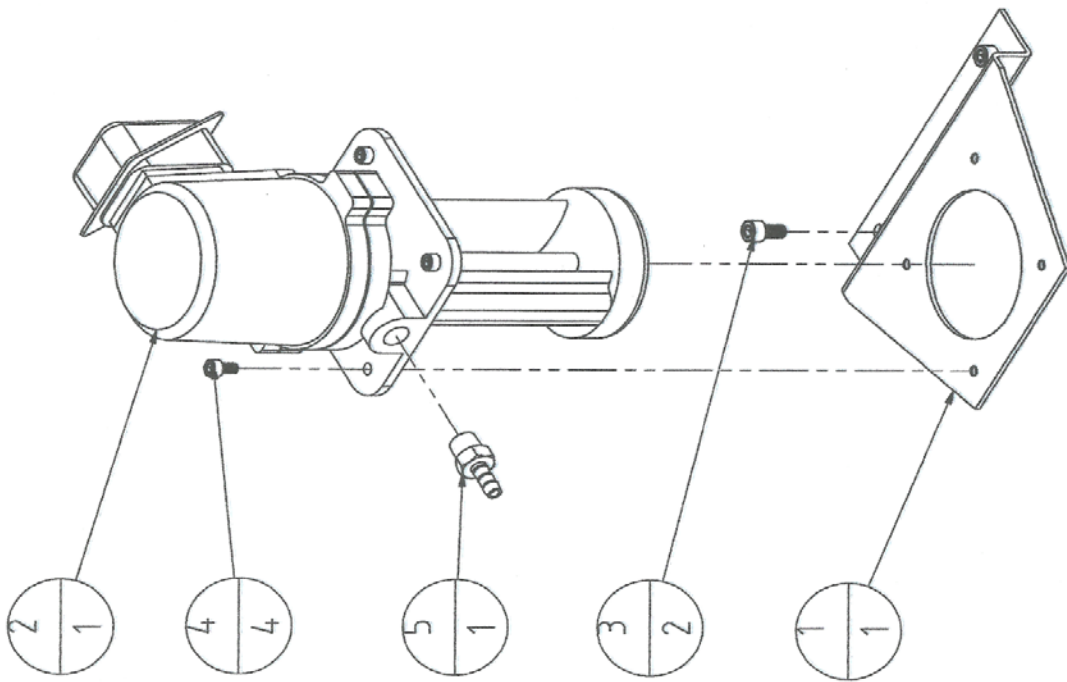
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			範圍	公差								
△			0.5-6	±0.05	±0.3	設計	張	政龍	100.07.30	1:8	ACER-B1-A01-1	防塵蓋板爆炸圖
△			7-30	±0.1	±0.5	繪圖	張	政龍	100.07.30			
△			31-120	±0.15	±0.8	校對						
△			121-315	±0.2	±1	核准						

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Drawing #: ACER-B1-A01-1			
Item #	Part #	Description	Quantity
1	ACER-B1-A009	Chip Cover 1	1
2	ACER-B1-A010	Chip Cover 2	1
3	ACER-B1-A011	Chip Cover 3	1
4	ACER-B1-A012	Chip Cover 4	1
5	ACER-B1-A013	Chip Cover 5	1
6	ACER-B1-A014	Chip Cover 6	1

11-9. ACER-B1-A05-0 COOLANT PUMP ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-A052冷卻油泵固定板	1
2	ACER-B1-A053冷卻油泵(市購)	1
3	M8X1.25X16內六角螺絲	2
4	M6X1X12內六角螺絲	4
5	3'冷卻軟管接頭	1



變更 標記	修改 內容	日期	修改者	錄				圖號	圖名
				一般	尺寸	公差	單位		
△				0.5-6	±0.05	±0.3	mm	1:4	ACER-B1-A05-0
△				7-30	±0.1	±0.5	張	投	冷卻油泵爆炸圖
△				31-120	±0.15	±0.8	張	影	
△				121-315	±0.2	±1	張		

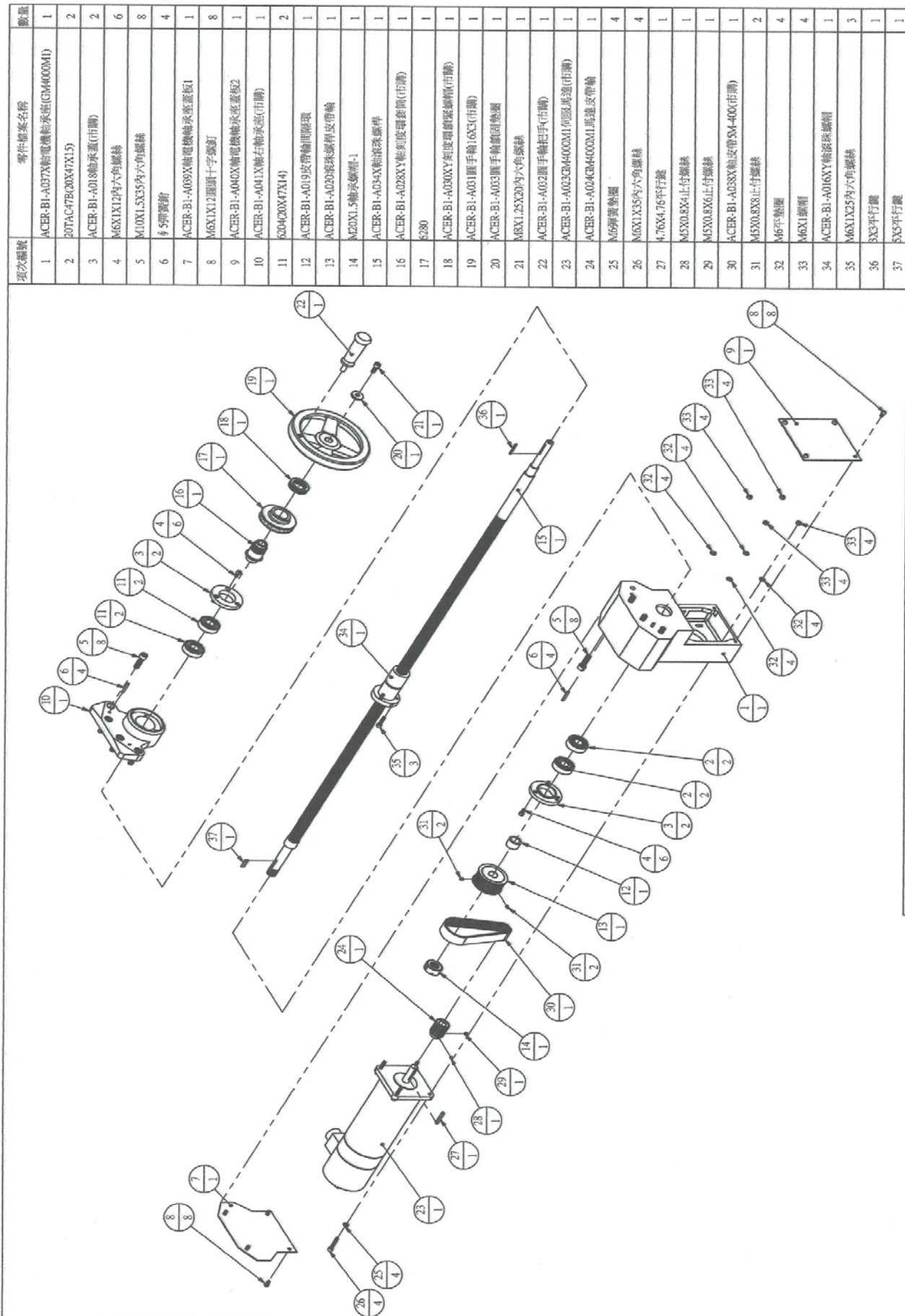
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Drawing #: ACER-B1-A05-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A052	Coolant Pump Locating Bracket	1
2	ACER-B1-A053	Coolant Pump 1/8HP	1
3	M8x1.25x16	Socket Hd Cap Screw	2
4	M6x1x12	Socket Hd Cap Screw	4
5	1/2"	Coolant Fitting	1

Drawing #: ACER-B1-A02-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A005	Saddle	1
2	ACER-B1-A008	Gib	3
3	ACER-B1-A007	Gib Support Right (4H-3050)	1
4	ACER-B1-A006	Gib Support Left (4H-3050)	1
5	3-24UNF	Gib Screw	8
6	ACER-B1-A036	Saddle/Table Gib (3026)	1
7	M12x1.75x40	Socket HD Cap Screw	8
8	M6x1x20	Socket HD Cap Screw	2
9	M6	Washer	2
10	ACER-B1-A042	X, Y Limit Switch Locating Plate	1
11	ACER-B1-A044	Limit Switch	2
12	M6x1x16	Socket HD Cap Screw	2
13	M5x0.8x20	Socket HD Cap Screw	4
14	ACER-B1-A048	Felt Wiper (4H-3037)	1
15	ACER-B1-A050	Wiper Plate (4H-3037-1)	2
16	ACER-B1-A049	Felt Wiper (4H-3037)	1
17	M5x0.8x12	Round HD Cap + Screw	10
18	ACER-B1-A043	X Axis Limit Switch Bracket	1
	ACER-B1-A043S	X Axis Limit Switch Bracket-Small	1
19	ACER-B1-A058	Table Lock Plunger (H-3029)	1
20	ACER-B1-A059	Table Lock Plunger (H-3029)	1
21	3030+3031	Table Lock Assembly	4
22	ACER-B1-A057	Saddle Lock Plunger (4H-3032)	2
23	ACER-B1-A015	Yoke	1
24	3/8"x1"	Socket HD Cap Screw	4
25	M5	Washer	2
26	M5x0.8	Hex Nut	2
27	-		
28	M5x35	Roll Pin	2

Drawing #: ACER-B1-A04-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A035	Table 10"x50"	1
	ACER-B1-A036	Table 10"x54"	1
2	ACER-B1-A045	X Axis Travel Locating Plate	2
3	ACER-B1-A047	Axis Positioning Block	2
4	M5x0.8x12	Socket HD Cap Screw	4
5	M6x1x16	Socket HD Cap Screw	4
6	ACER-B1-A046	Traveling Locating Back Plate	2
7	ACER-B1-A051	Table End Rubber Stopper	6
8	1/2"PT	Coolant Plug	2

11-12. ACER-B1-AO4-1 X AXIS TRAVEL ASSEMBLY



現之編號	零件名稱	數量
1	ACER-B1-A037X軸電機軸承座(GM4000M1)	1
2	20TAC47B(20X47X15)	2
3	ACER-B1-A018軸承蓋(市購)	2
4	M6X11.2內六角螺絲	6
5	M10X1.5X35內六角螺絲	8
6	φ 5彈簧銷	4
7	ACER-B1-A089X軸電機軸承蓋板1	1
8	M6X11.2圓頭十字螺釘	8
9	ACER-B1-A040X前電機軸承蓋板2	1
10	ACER-B1-A041X前左軸承蓋(市購)	1
11	5204(200X7X14)	2
12	ACER-B1-A019皮帶輪圓環	1
13	ACER-B1-A020滾珠螺絲桿皮帶輪	1
14	M20X1.5軸承螺絲-1	1
15	ACER-B1-A034X軸滾珠螺絲桿	1
16	ACER-B1-A028XY軸皮帶環套(市購)	1
17	8380	1
18	ACER-B1-A000XY刻度環螺絲帽(市購)	1
19	ACER-B1-A011圓手輪1.6X3(市購)	1
20	ACER-B1-A003圓手輪圓環	1
21	M8X1.25X20內六角螺絲	1
22	ACER-B1-A002圓手輪把手(市購)	1
23	ACER-B1-A003GM4000M1何國馬達(市購)	1
24	ACER-B1-A004GM4000M1馬達皮帶輪	1
25	M6彈簧墊圈	4
26	M6X1X35內六角螺絲	4
27	4.76X4.76平行鍵	1
28	M5X0.8X4止付螺絲	1
29	M5X0.8X6止付螺絲	1
30	ACER-B1-A033X軸皮帶SM-400(市購)	1
31	M5X0.8X8止付螺絲	2
32	M6平墊圈	4
33	M6X1螺帽	4
34	ACER-B1-A016XY軸滾珠螺絲帽	1
35	M6X1X25內六角螺絲	3
36	3X3平行鍵	1
37	5X5平行鍵	1

變更	日期	內容	修改者	日期	圖號	單位	mm	數量	比例
▲		設計	張政龍	100.07.30	1:8	ACER-B1-AO4-1			圖名
▲		繪圖	張政龍	100.07.30					圖名
▲		校對							
▲		核准							

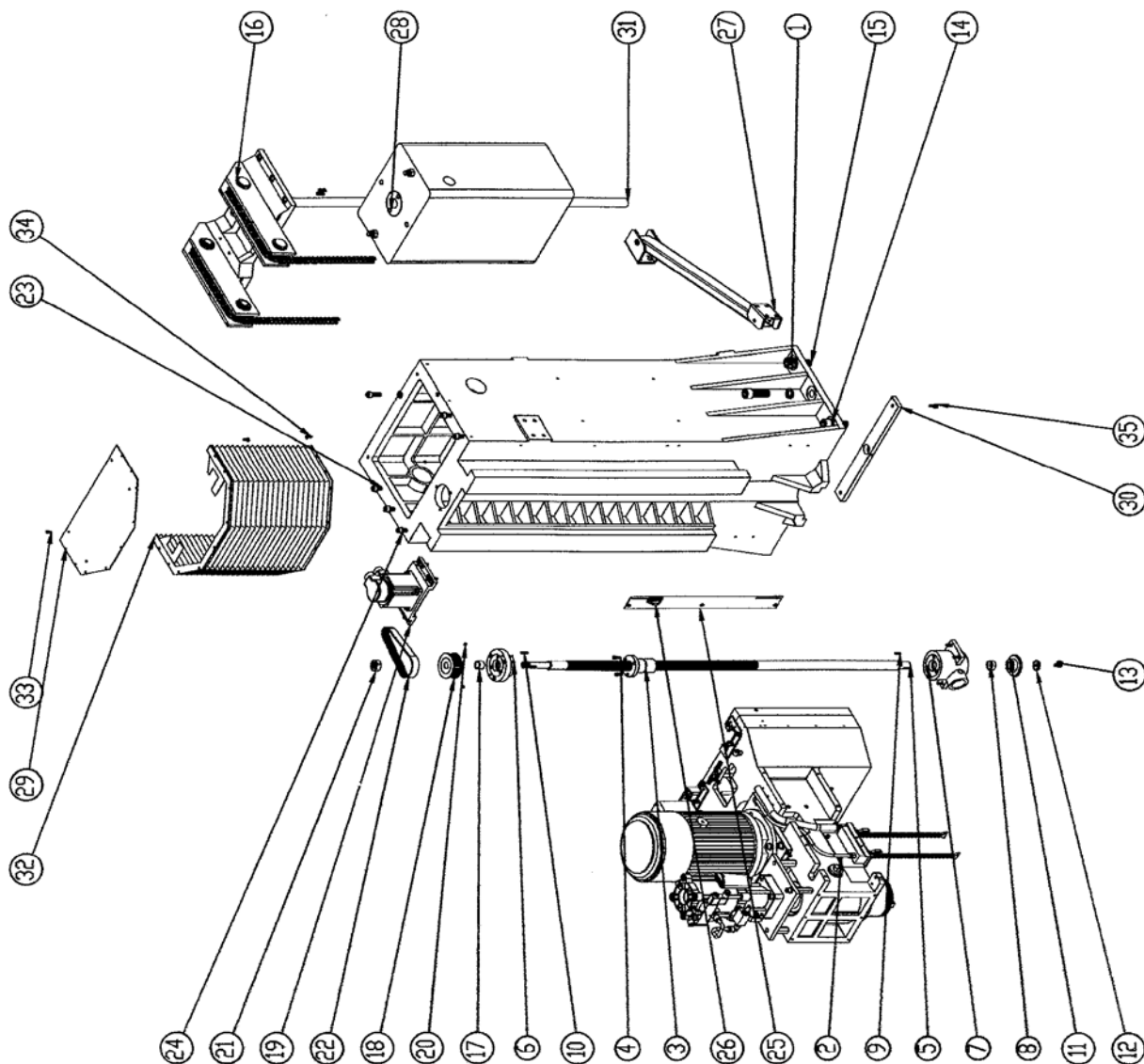
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Drawing #: ACER-B1-A04-1			
Item#	Part #	Description	Quantity
1	ACER-B1-A037	X Axis Servo Motor Bracket-750W	1
	ACER-B1-A037-M	X Axis Servo Motor Bracket for Mills	1
	ACER-B1-A037-1K	X Axis Servo Motor Bracket-1KW	1
	ACER-B1-A037-F	X Axis Servo Motor Bracket-Fagor Servo Motor	1
2	20TAC47B	Ball Screw Support Ball Bearing	2
3	ACER-B1-A018	Bearing Cap	2
4	M6x1x12	Socket Hd Cap Screw	6
5	M10x1.5x35	Socket Hd Cap Screw	8
6	Φ5	Roll Pin	4
7	ACER-B1-A039	X Axis Bracket Cover 1	1
	ACER-B1-A039C	X Axis Servo Motor Cover	1
8	M6x1x12RC	Round HD Cap + Screw	8
9	ACER-B1-A040	X Axis Bracket Cover 2	1
10	ACER-B1-A041	X Axis Bearing Bracket-Aluminum	1
	ACER-B1-A041C	X Axis Bearing Bracket-Cast Iron	1
11	6204ZZ	Ball Bearings (20x47x14)	2
12	ACER-B1-A019	Spacer	1
13	ACER-B1-A020	Ball Screw Pulley for 750W	1
	ACER-B1-A020-1K	Ball Screw Pulley for 1KW	1
	ACER-B1-A020-F	Ball Screw Pulley for Fagor Servo Motor	1
14	M20x1.5	Precision Lock Nut	1
15	ACER-B1-A034-54	X Axis Ball Screw Assembly for 54" Table	1
	ACER-B1-A034-50	X Axis Ball Screw Assembly for 50" Table	1
16	ACER-B1-A028	X, Y Axis Dial Holder (2014)	1
17	ACER-B1-A029	Dial (2012)	1
18	ACER-B1-A030	Dial Lock Nut (2016)	1
19	ACER-B1-A031	Handwheel (5/8"x3mm)	1
20	ACER-B1-A033	Handwheel Washer	1
21	M8x1.25x20	Socket Hd Cap Screw	1
22	ACER-B1-A032	Handle	1
23	ACER-B1-A023	Servo Motor 750W	1
	ACER-B1-A023-1K	Servo Motor 1KW	1
	ACER-B1-A023-F	Servo Motor Fagor	1
24	ACER-B1-A024	Motor Pulley for 750W	1
	ACER-B1-A024-1K	Motor Pulley for 1KW	1
	ACER-B1-A024-F	Motor Pulley for Fagor Servo Motor	1
25	M6	Spring Washer	4
26	M6x1x35	Socket Hd Cap Screw	4
27	4.76x4.76x40mm	Key	1
28	M5x0.8x4	Set Screw	1
29	M5x0.8x6	Set Screw	1

Item#	Part #	Description	Quantity
30	ACER-B1-A038	Timing Belt for 750W(5Mx400)	1
	ACER-B1-A038-1K	Timing Belt for 1KW	1
	ACER-B1-A038-F	Timing Belt for Fagor Servo Motor	1
31	M5x0.8x8	Set Screw	2
32	M6	Washer	4
33	M6x1	Hex Nut	4
34	ACER-B1-A016	X, Y Ball Screw Nut	1
35	M6x1x25	Socket Hd Cap Screw	3
36	M3x3x25	Key	1
37	M5x5x30	Key	1

11-13. ACER-B1-B01 COLUMN ASSEMBLY-BALANCING BLOCK TYPE

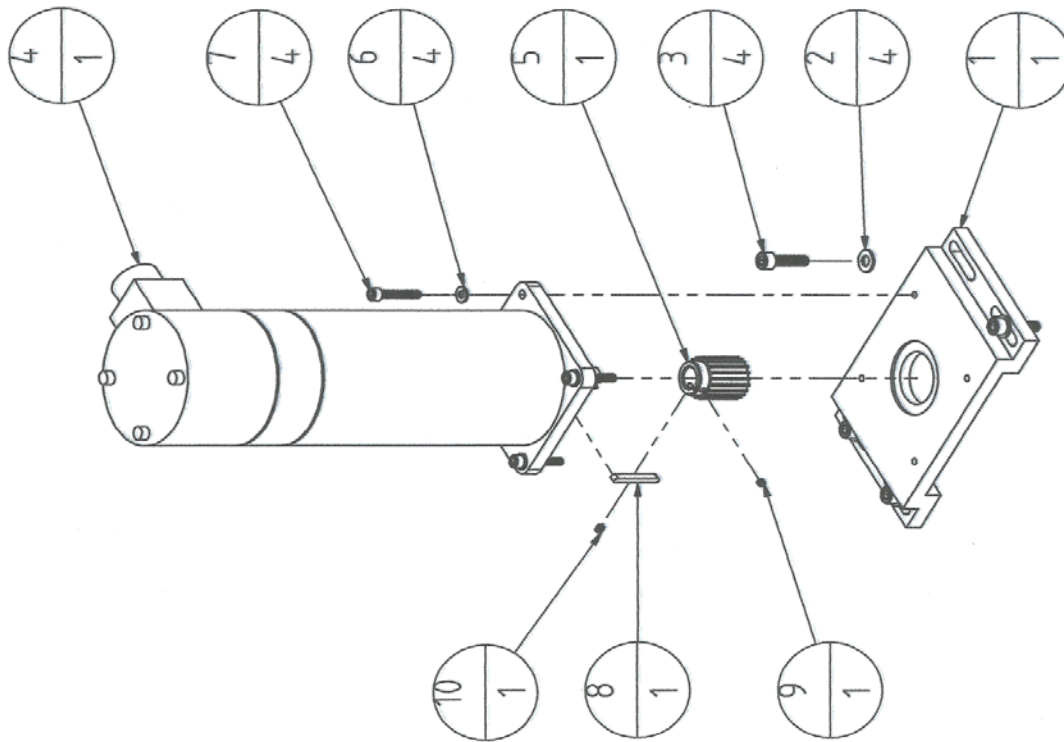
項次編號	零件名稱	數量
1	ACER-B1-B001立柱	1
2	ACER-B1(鏈輪型)(page6)0410	1
3	ACER-B1-B007Z軸滾珠螺帽	1
4	M6X1X20 內六角螺絲	3
5	ACER-B1-B007Z軸滾珠螺桿	1
6	ACER-B1-B03Z軸上軸承座	1
7	ACER-B1-B04Z軸下軸承座	1
8	ACER-B1-B010大傘齒輪間隔環	1
9	5X5X20	1
10	5X5X25	1
11	ACER-B1-B011昇降傳動大傘齒輪(市購)	1
12	ACER-B1-B012大傘齒輪鎖緊墊圈	1
13	M8X1.25X16 內六角螺絲	1
14	M22彈簧墊圈	6
15	M22X2.5X75 內六角螺絲	6
16	ACER-B1-E01鍊輪座	1
17	ACER-B1-A019皮帶輪間隔環	1
18	ACER-B1-E014滾珠螺桿皮帶輪	1
19	ACER-B1-E04Z軸電機	1
20	M5X0.8X8止付螺絲	2
21	M20X1.5軸承螺帽-1	1
22	ACER-B1-E016Z軸皮帶5M-500(市購)	1
23	M12X1.75X40 內六角螺絲	6
24	M12彈簧墊圈	6
25	ACER-B1-B029Z軸行程定位塊固定板	1
26	ACER-B1-A047行程定位塊	1
27	吊臂	1
28	ACER-B1-E03配重塊	1
29	ACER-B1-E009Z軸上波浪蓋板上固定板	1
30	ACER-B1-E012配重塊導桿下固定板	1
31	ACER-B1-E008配重塊導桿	1
32	ACER-B1-001Z軸上波浪蓋板(鏈輪型)	1
33	M6X1X12 內六角螺絲	1
34	M6X1X16平頭 內六角螺釘	2
35	M8X1.25X20 內六角螺絲	1



Drawing #: ACER-B1-B01			
Item #	Part #	Description	Quantity
1	ACER-B1-B001	Column	1
2	ACER-B1-0410	Spindle Housing Assembly	1
3	ACER-B1-B007	Ball Screw Nut	1
4	M6x1x20	Socket HD Cap Screw	4
5	ACER-B1-B007	Z Axis Ball Screw	1
6	ACER-B1-B03	Z Axis Upper Bearing Seat Assembly	1
7	ACER-B1-B04	Z Axis Lower Bearing Seat Assembly	1
8	ACER-B1-B010	Spacer-long	1
9	M5x5x20	Key	1
10	M5x5x25	Key	1
11	ACER-B1-B011	Bevel Gear (4019)	1
12	ACER-B1-B012	Washer	1
13	M8x1.25x16	Socket HD Cap Screw	1
14	M24	Spring Washer	6
15	M24x2.5x75	Socket HD Cap Screw	6
16	ACER-B1-E	Roller Chain Assembly	1
17	ACER-B1-A019	Pulley Spacer	1
18	ACER-B1-A020	Ball Screw Pulley	1
19	ACER-B1-B05	Servo Motor Assembly	1
20	M5x0.8x8	Set Screw	2
21	M20x1.5	Precision Lock Nut	1
22	ACER-B1-E016	Timing Belt 5mx500	1
	ACER-B1-E016F	Timing Belt for Fagor Servo Motor	1
23	M12X1.75X40	Socket HD Cap Screw	6
24	M12	Spring Washer	6
25	ACER-B1-B029	Z Axis Travel Locating Plate	1
26	ACER-B1-A047	Axis Positioning Block	2
27	ACER_B--F01	Control Arm Assembly	1
28	ACER-B1-E006	Balancing Block	1
29	ACER-B1-E009	Top Cover Locating Plate	1
30	ACER-B1-E012	Balancing Block Shaft Guiding Plate	1
31	ACER-B1-E008	Block Guiding Rod	1
32	ACER-B1-001	Z Axis Upper Accordion Cover	1
33	M6x1.0x12	Socket HD Cap Screw	4
34	M6x1.0x16	Round HD Cap Screw	18
35	M8x1.25x20	Socket HD Cap Screw	2

11-14. ACER-B1-B05 SERVO MOTOR ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-A022馬達法蘭座(YZ軸GM4000M1)	1
2	M8平墊圈	4
3	M8X1.25X30內六角螺絲	4
4	ACER-B1-A023GM4000M1伺服馬達(市購)	1
5	ACER-B1-A024GM4000M1馬達皮帶輪	1
6	M6彈簧墊圈	4
7	M6X1X35內六角螺絲	4
8	4.76X4.76平行鍵	1
9	M5X0.8X4止付螺絲	1
10	M5X0.8X6止付螺絲	1



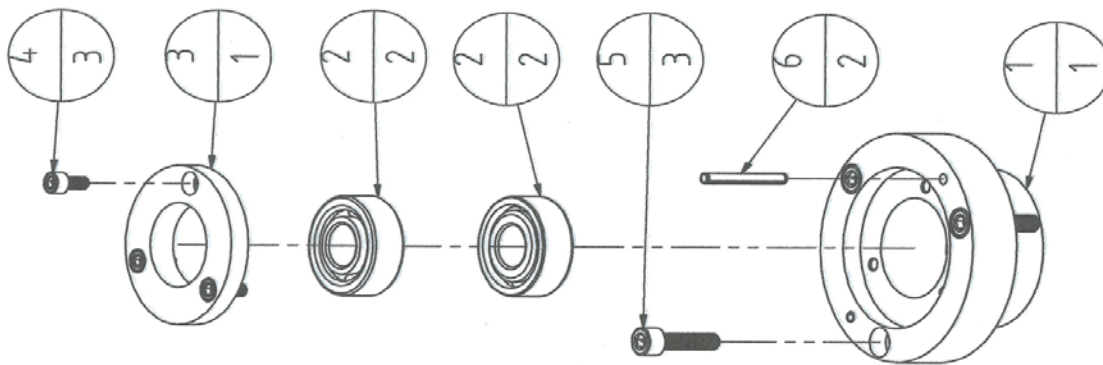
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△	日期	張政龍	mm	
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△	範圍	張政龍	材質	
△	公差	張政龍	設計	
△	範圍	張政龍	繪圖	
△	公差	張政龍	校對	
△	範圍	張政龍	核准	

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Drawing #: ACER-B1-B05			
Item #	Part #	Description	Quantity
1	ACER-B1-A022	Motor Plate	1
	ACER-B1-A022-F	Motor Plate for Fagor Servo Motor	1
2	M8	Washer	4
3	M8x1.25x30	Socket Hd Cap Screw	4
4	ACER-B1-A023	Z Axis Servo Motor	1
	ACER-B1-A023-F	Z Axis Fagor Servo Motor	1
5	ACER-B1-A024	Motor Pulley	1
	ACER-B1-A024-F	Motor Pulley for Fagor Servo Motor	1
6	M6	Spring Washer	4
7	M6x1x35	Socket Hd Cap Screw	4
8	M4.76x4.76x40	Key	1
9	M5x0.8x4	Set Screw	1
10	M5x0.8x6	Set Screw	1

11-15. ACER-B1-B03 Z AXIS UPPER BEARING SEAT ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-B008Z軸上軸承座	1
2	20TAC47B(20X47X15)	2
3	ACER-B1-A018軸承蓋(市購)	1
4	M6X1X12內六角螺絲	3
5	M8X1.25X30內六角螺絲	3
6	5X40	2



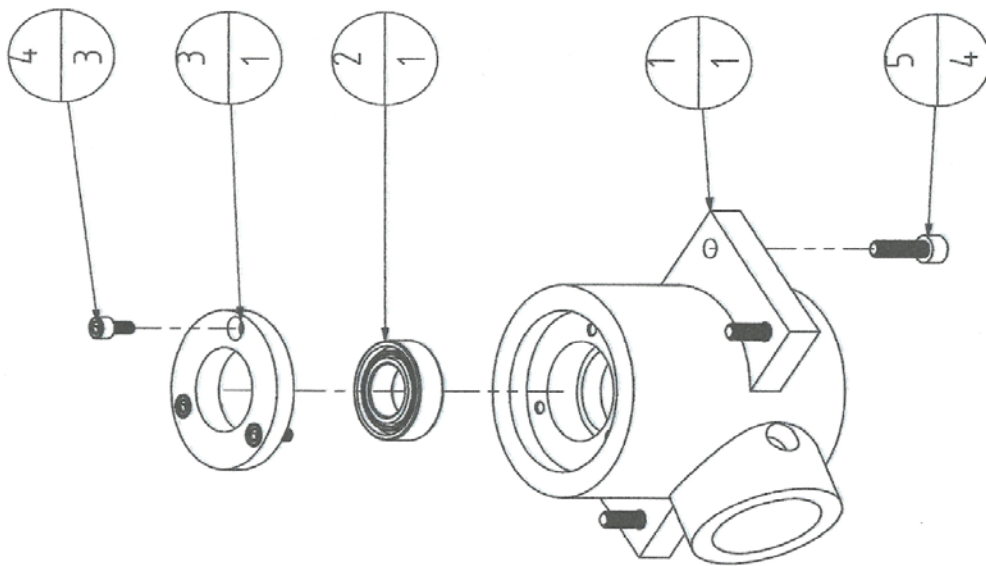
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					範圍	公差								
△					0.5-6	±0.05	設計	張	政龍	100.07.30	100.07.30	1:2	ACER-B1-B03	Z軸上軸承座爆炸圖
△					7-30	±0.1	繪圖	張	政龍	100.07.30	100.07.30	投		
△					31-120	±0.15	校對					影		
△					121-315	±0.2	核准							

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Drawing #: ACER-B1-B03			
Item #	Part #	Description	Quantity
1	ACER-B1-B008	Z Axis Upper Bearing Seat	1
2	20TAC47B	Ball Screw Support Bearing	2
3	ACER-B1-A018	Bearing Retaining Cover	1
4	M6x1x12	Socket HD Cap Screw	3
5	M8x1.25x30	Socket HD Cap Screw	3
6	M5x40	Roll Pin	2

11-16. ACER-B1-B04 Z AXIS LOWER BEARING SEAT ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-B009Z軸下軸承座	1
2	6005(25X47X12)	1
3	ACER-B1-A018軸承蓋(市購)	1
4	M6X1X12內六角螺絲	3
5	M8X1.25X25內六角螺絲	4



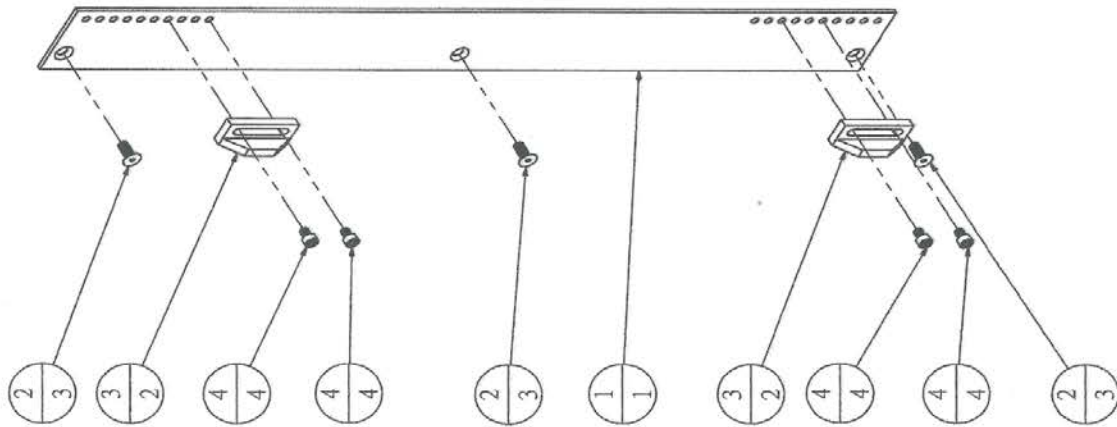
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				範圍	公差	範圍	公差	範圍	公差									
△1				0.5-6	±0.05	316-1000	±0.3	設計	張政龍	100.07.30	1:3	ACER-B1-B04	Z軸下軸承座爆炸圖					
△2				7-30	±0.1	1001-2000	±0.5	繪圖	張政龍	100.07.30	1:3	ACER-B1-B04	Z軸下軸承座爆炸圖					
△3				31-120	±0.15	2001-3000	±0.8	校對			1:3	ACER-B1-B04	Z軸下軸承座爆炸圖					
△4				121-315	±0.2	3001-6000	±1	核准			1:3	ACER-B1-B04	Z軸下軸承座爆炸圖					

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Drawing #: ACER-B1-B04			
Item #	Part #	Description	Quantity
1	ACER-B1-B009	Z Axis Lower Bearing Seat	1
2	6005ZZ	Ball Bearing (25x47x12)	1
3	ACER-B1-A018	Bear Retaining Cap	1
4	M6x1x12	Socket HD Cap Screw	3
5	M8x1.25x25	Socket HD Cap Screw	4

11-17. ACER-B1-B08 Z AXIS TRAVEL LIMIT ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-B029Z軸行程定位塊固定板	1
2	M6X1X12平頭內六角螺釘	3
3	ACER-B1-A047行程定位塊	2
4	M5X0.8X8內六角螺絲	4



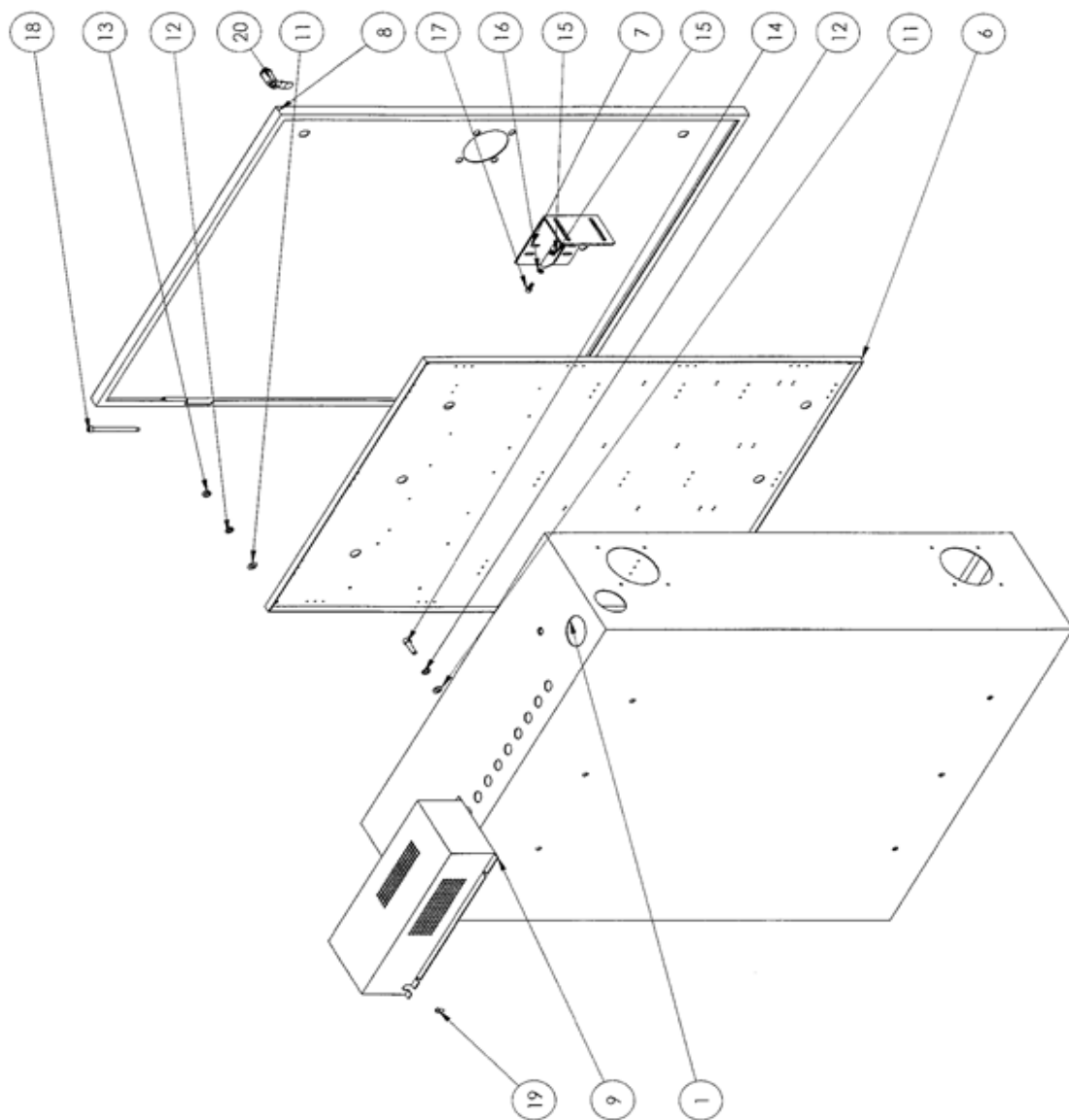
變更	標記	內容	日期	範圍	公差	尺寸	公差	單位	mm	數量	日期	比例	圖號	圖名
標記	△			0.5-5	±0.05	315-1000	±0.3	設計			100.07.30	1:3	ACER-B1-B08	Z軸行程定位塊固定板
修改	△			7-30	±0.1	1001-2000	±0.5	繪圖			100.07.30	投影		Z軸行程定位塊固定板 爆炸圖
	△			31-120	±0.15	2001-3000	±0.8	校對						
	△			121-315	±0.2	3001-4000	±1	核准						

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Drawing #: ACER-B1-B08			
Item #	Part #	Description	Quantity
1	ACER-B1-B029	Z Axis Traveling Locating Plate	1
2	M6x1x12F	Flat Hd Socket Cap Screw	3
3	ACER-B1-A047	Axis Positioning Block	2
4	M5x0.8x8	Socket HD Cap Screw	4

11-18. ELECTRIC CABINET ASSEMBLY—Taiwan Version Only!

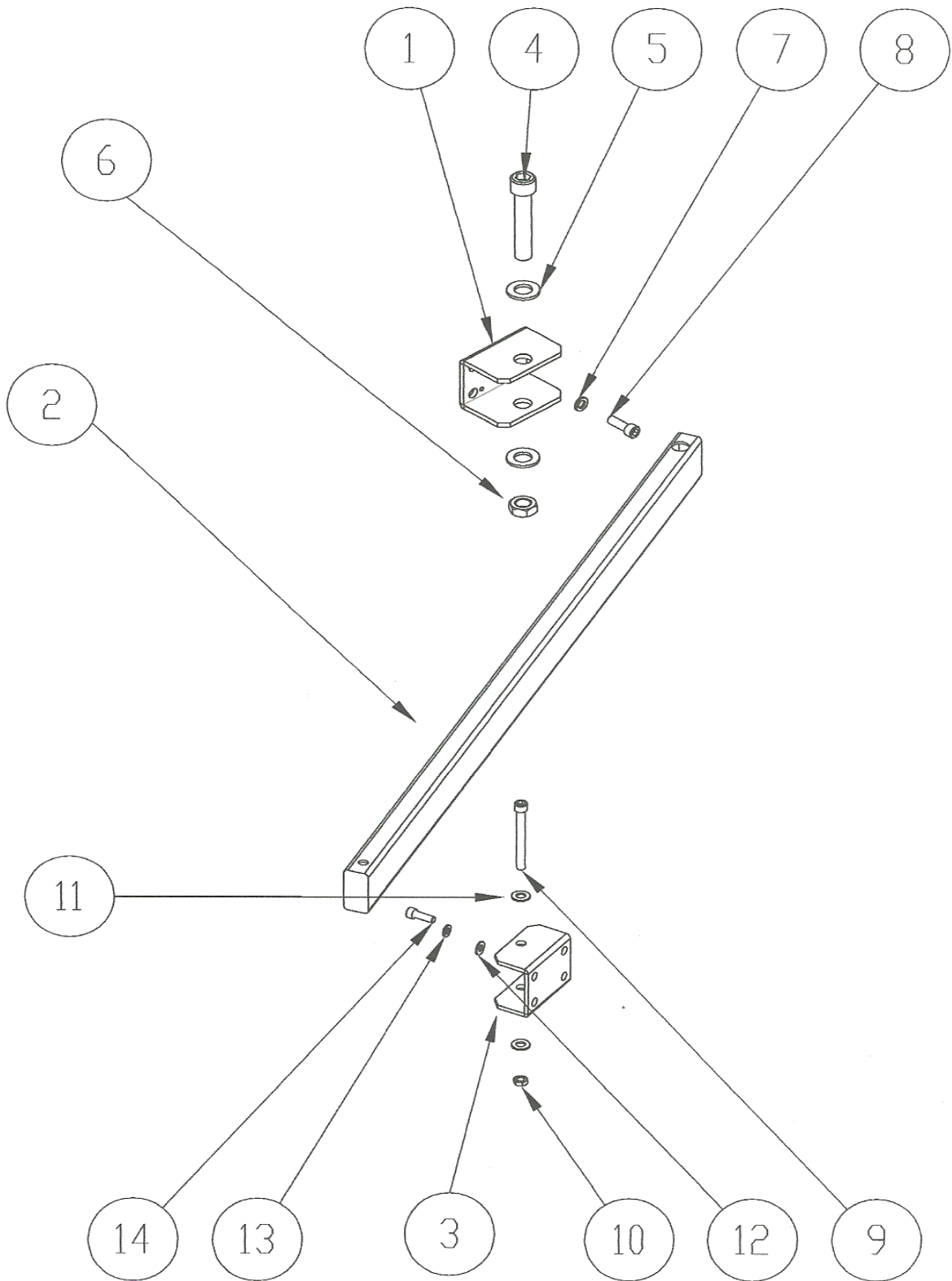
項次編號	零件名稱	數量
1	ACU-A01 電氣箱	1
2	ACU-B09 主軸線槽	1
3	圓管-B	1
4	圓管-A	1
5	ACU-B10 主軸線槽蓋板	1
6	ACU-A03-配電盤	1
7	ACU-A04-開關固定座	1
8	ACU-A02 電氣箱門	1
9	ACU-A14 取線電阻盒	1
10	B18.34M - 5 x 0.8 x 8 SBHCS --C	1
11	M8 彈簧墊圈	2
12	M8 彈簧墊圈	2
13	M8 彈簧	1
14	B18.31M - 8 x 1.25 x 30 Hex SHCS -- 30CHX	1
15	B18.22M - Plain washer, 6 mm, narrow	2
16	M6 彈簧墊圈	2
17	M6X1X15 內六角螺絲	2
18	100mm 長後管-B	1
19	B18.34M - 6 x 1.0 x 12 SBHCS --C	1
20	C-402	1



Item #	Part #	Description	Quantity
1	ACU-A01	Electric Cabinet-Main Body for Delta Servo Motor	1
	ACU-A01F	Electric Cabinet-Main Body for Fagor Servo Motor	1
2		NA	1
3		NA	2
4		NA	4
5		NA	1
6	ACU-A03	Electric Component Plate	1
	ACU-A03F	Electric Component Plate for Fagor Servo System	1
7	ACU-A04	Power Switch Locating Bracket	1
8	ACU-A02	Electric Cabinet-Cover	1
9	ACU-A14	Braking Resistor Cover	1
10		NA	4
11		M8 Flat Washer	10
12		M8 Spring Washer	10
13		M8 Hex Nut	4
14		M8x1.25x30 Socket Head Cap Screw	6
15		M6 Flat Thin Washer	4
16		M6 Spring Washer	4
17		M6x1x15 Socket Head Cap Screw	4
18	ACU-003	Hinge Roll Pin	2
19		M6x1.0x12 Round Head Socket Cap Screw	4
20	ACU-004	Door Lock Set	2

Note: For electric cabinet breakdown drawings on US installed machines, please refer to CNC controller's part list and operation manual.

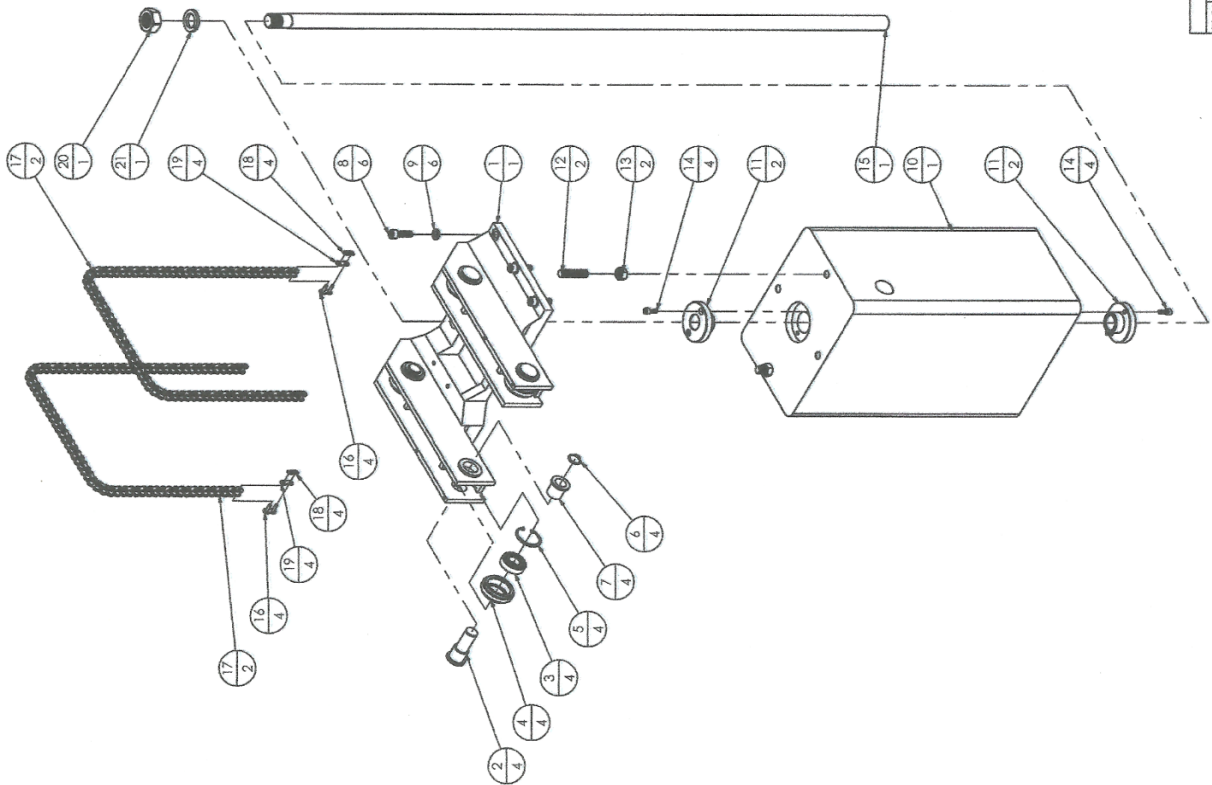
11-19. CONTROL BOX ASSEMBLY



Item #	Part #	Description	Quantity
1	ACER-B1-F001	Control Arm Locating Bracket-Column Side	1
2	ACER-B1-F002A	Control Arm for ATM 1054, 1050	1
3	ACER-B1-F003	Control Arm Locating Bracket-Panel Side	1
4		3/4"x 4" Socket Head Cap Screw	1
5		M20 Flat Washer	2
6		3/4" Hex Nut	
7		M10 Spring Washer	4
8		M10x1.5x30 Socket Head Cap Screw	4
9		3/8"x16UNCx88.9 Socket Head Cap Screw	1
10		3/8"x16UNC Hex Nut	1
11		M10 Flat Washer	4
12		M8 Spring Washer	4
13		M8 Flat Washer	4
14	ACER-B1-F004	M8x1.25x25 Socket Head Socket Cap Screw	1

11-20. ACER-B1-E ROLLER CHAIN ASSEMBLY

項次編號	零件檔案名稱	數量
1	ACER-B1-E001鍊輪座	1
2	ACER-B1-E003鍊輪軸	4
3	6205(25X52X15)	4
4	ACER-B1-E002鍊輪	4
5	R52孔用C型打環	4
6	S25軸用C型打環	4
7	ACER-B1-E004鍊輪軸套	4
8	M12X1.75X40內六角螺絲	6
9	M12彈簧墊圈	6
10	ACER-B1-E006配重塊	1
11	ACER-B1-E007配重塊導套	2
12	ACER-B1-E005鏈條連接螺絲	2
13	M16X2螺帽	2
14	M8X1.25X20內六角螺絲	4
15	ACER-B1-E008配重塊導料	1
16	15.875鏈條連接銷	4
17	5/8鏈條80節	2
18	15.875鏈條連接銷扣板	4
19	15.875銷鏈板	4
20	M30X2螺帽	1
21	M30彈簧墊圈	1

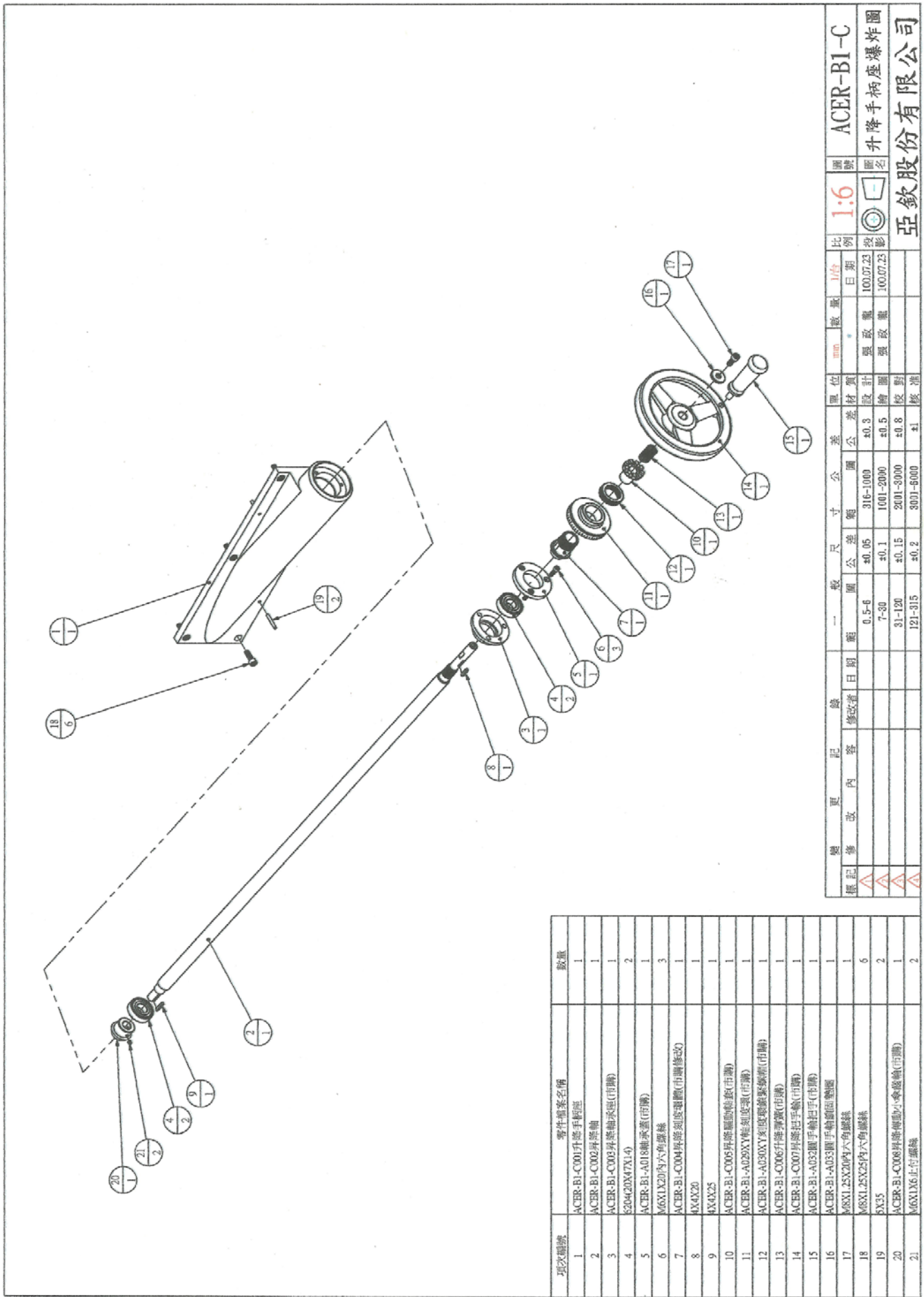


圖號	圖名	比例	日期	設計	校對	核准
ACER-B1-E	鍊輪座爆炸圖	1:1	100.07.08			
			100.07.08			

單位	數量	單位	數量
公	316-1000	公	0.3
英	100-2000	英	0.5
公	200-5000	公	0.8
英	300-6000	英	1.1

Drawing #: ACER-B1-E			
Item #	Part #	Description	Quantity
1	ACER-B1-E001	Chain Roller Seat	1
2	ACER-B1-E003	Roller Shaft	4
3	6205ZZ	Ball Bearings (25x52x15)	4
4	ACER-B1-E002	Roller Wheel	4
5	R52	C Type Snap Ring	4
6	S25	C Type Snap Ring	4
7	ACER-B1-E004	Roller Shaft Sleeve	4
8	M12x1.75x40	Socket Hd Cap Screw	6
9	M12	Spring Washer	6
10	ACER-B1-E006	Balancing Block	1
11	ACER-B1-E007	Shaft Sleeve	2
12	ACER-B1-E005	Chain Connecting Screw	2
13	M16x2	Hex Nut	2
14	M8x1.25x20	Socket Hd Cap Screw	4
15	ACER-B1-E008	Block Guiding Rod	1
16	15.875	Chain Dowel Pin	4
17	5/8"	Chain with 70 sections plus two halves	2
18	15.875	Chain Connecting Plate	4
19	15.875	Chain Slip Plate	4
20	M30x2	Hex Nut	1
21	M30	Spring Washer	1

11-21. ACER-B1-C ELEVATION CRANK ASSEMBLY



項次	零件名稱	數量
1	ACER-B1-C001升降手柄座	1
2	ACER-B1-C002升降軸	1
3	ACER-B1-C003升降軸承蓋(市購)	1
4	520420X47X1.4	2
5	ACER-B1-A018軸承蓋(市購)	1
6	M6X1X20內六角螺絲	3
7	ACER-B1-C004升降刻度環(市購修改)	1
8	4X4X20	1
9	4X4X25	1
10	ACER-B1-C005升降驅動軸套(市購)	1
11	ACER-B1-A029XY輕刻度環(市購)	1
12	ACER-B1-A030XY刻度環緊鎖螺絲(市購)	1
13	ACER-B1-C006升降彈簧(市購)	1
14	ACER-B1-C007升降把手輪(市購)	1
15	ACER-B1-A032圓手輪把手(市購)	1
16	ACER-B1-A033圓手輪鎖面墊圈	1
17	M8X1.25X20內六角螺絲	1
18	M8X1.25X25內六角螺絲	6
19	5X35	2
20	ACER-B1-C008升降傳動小傘齒輪(市購)	1
21	M6X1X6上行螺絲	2

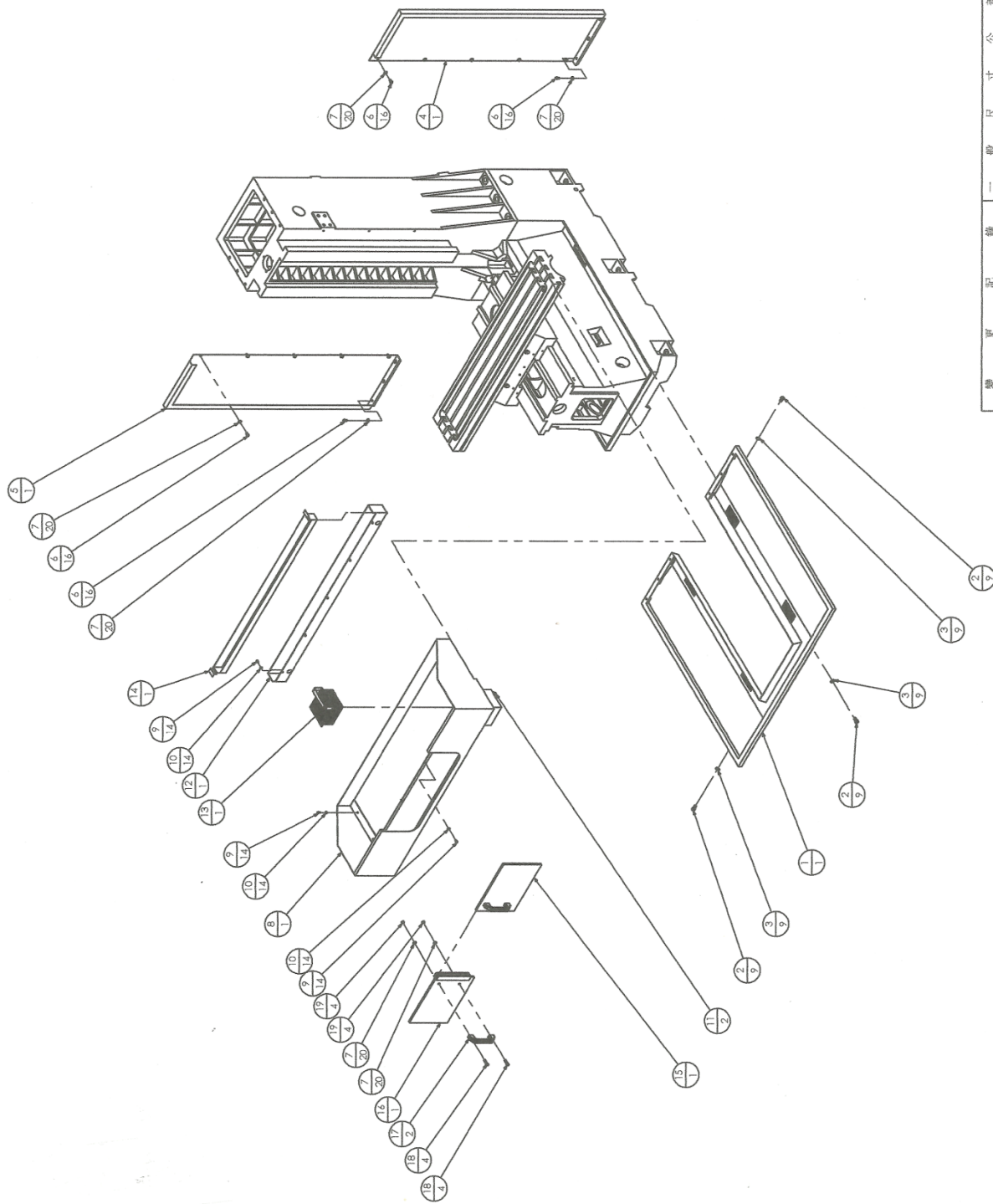
圖號	比例	日期	數量	單位	公差	圖號	圖名
ACER-B1-C	1:6	100.07.23	1份	mm	±0.05	316-1000	ACER-B1-C
▲	▲	▲	▲	▲	±0.3	1001-2000	升降手柄座爆炸圖
▲	▲	▲	▲	▲	±0.5	2001-3000	
▲	▲	▲	▲	▲	±0.8	3001-6000	

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Drawing #: ACER-B1-C			
Item #	Part #	Description	Quantity
1	ACER-B1-C001	Elevation Handle Bracket	1
2	ACER-B1-C002	Elevation Shaft	1
3	ACER-B1-C003	Bearing Cap (4006)	1
4	6204ZZ	Ball Bearing (20x47x14)	2
5	ACER-B1-A018	Bearing Retaining Ring (2011)	1
6	M6x1x20	Socket HD Cap Screw	3
7	ACER-B1-C004	Dial Holder (4011)	1
8	M4x4x20	Key	1
9	M4x4x25	Key	1
10	ACER-B1-C005	Gear Shaft Clutch Insert (4013)	1
11	ACER-B1-A029	Dial (4010)	1
12	ACER-B1-A030	Dial Lock Nut (2016)	1
13	ACER-B1-C006	Spring	1
14	ACER-B1-C007	Handwheel	1
15	ACER-B1-A032	Handle	1
16	ACER-B1-A033	Washer	1
17	M8x1.25x20	Socket HD Cap Screw	1
18	M8x1.25x25	Socket HD Cap Screw	6
19	M5x35	Roll Pin	2
20	ACER-B1-C008	Bevel Gear (4014)	1
21	M6x1x6	Set Screw	2

11-22. ACER-B1 SHOWN WITH OPTIONAL ACCESSORIES

項次編號	零件描述名稱	數量
1	ACER-B1-007 底座水蓋	1
2	M10X1.5X20內六角螺絲	9
3	M10平墊圈	9
4	ACER-B1-008 機台右板金	1
5	ACER-B1-009 機台左板金	1
6	M8X1.25X16圓頭內六角螺釘	16
7	M8平墊圈	20
8	ACER-B1-010 工作台面水罩	1
9	M6X1X12圓頭內六角螺釘	14
10	M6平墊圈	14
11	ACER-B1-015-4分吹管母接頭	2
12	ACER-B1-011 工作台面後接水槽	1
13	ACER-B1-016 工作台面水罩濾槽	1
14	ACER-B1-017 工作台面後接水罩濾槽	1
15	ACER-B1-012 工作台面水罩右門板	1
16	ACER-B1-013 工作台面水罩左門板	1
17	ACER-B1-014 工作台面水罩門板把手	2
18	M8X1.25X30內六角螺絲	4
19	M8X1.25螺帽	4



變更紀錄		一般尺寸		公差		單位		圖例		比例		圖號	
日期	內容	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
	機台改裝	315-1000	12.4-39.4	±0.3	±0.012	100.07	3.937	1:1.5	ACER-B1				
	機台改裝	1001-2000	39.4-78.7	±0.5	±0.020	100.07	3.937		外板金爆炸圖				
	機台改裝	2001-3000	78.7-118.0	±0.8	±0.031	100.07	3.937						
	機台改裝	3001-6000	118.0-236.0	±1.0	±0.039	100.07	3.937						

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Drawing #: ACER-B1 with Optional Accessories			
Item #	Part #	Description	Quantity
1	ACER-B1-007	Chip & Coolant Pan	1
2	M10x1.5x20	Socket HD Cap Screw	9
3	M10	Washer	9
4	ACER-B1-008	Column Side Splash Guard-Right	1
5	ACER-B1-009	Column Side Splash Guard-Left	1
6	M8x1.25x16R	Socket HD Round Cap Screw	16
7	M8	Washer	20
8	ACER-B1-010-54	Table Splash Guard for 54" Table	1
	ACER-B1-010-50	Table Splash Guard for 50" Table	1
9	M6x1.25x16R	Socket HD Round Cap Screw	14
10	M6	Washer	14
11	ACER-B1-015	1/2" Nozzle Fitting	2
12	ACER-B1-011	Table Splash Guard Back Reservoir	1
13	ACER-B1-016	Chip Collecting Pan	1
14	ACER-B1-017	Table Splash Guard Collecting Pan	1
15	ACER-B1-012-54	Splash Guard Door-Right for 54" Table	1
	ACER-B1-012-50	Splash Guard Door-Right for 50" Table	1
16	ACER-B1-013-54	Splash Guard Door-Left for 54" Table	1
	ACER-B1-013-50	Splash Guard Door-Left for 50" Table	1
17	ACER-B1-014	Door Handle	2
18	M8x1.25x30	Socket HD Cap Screw	4
19	M8x1.25	Hex Nut	4