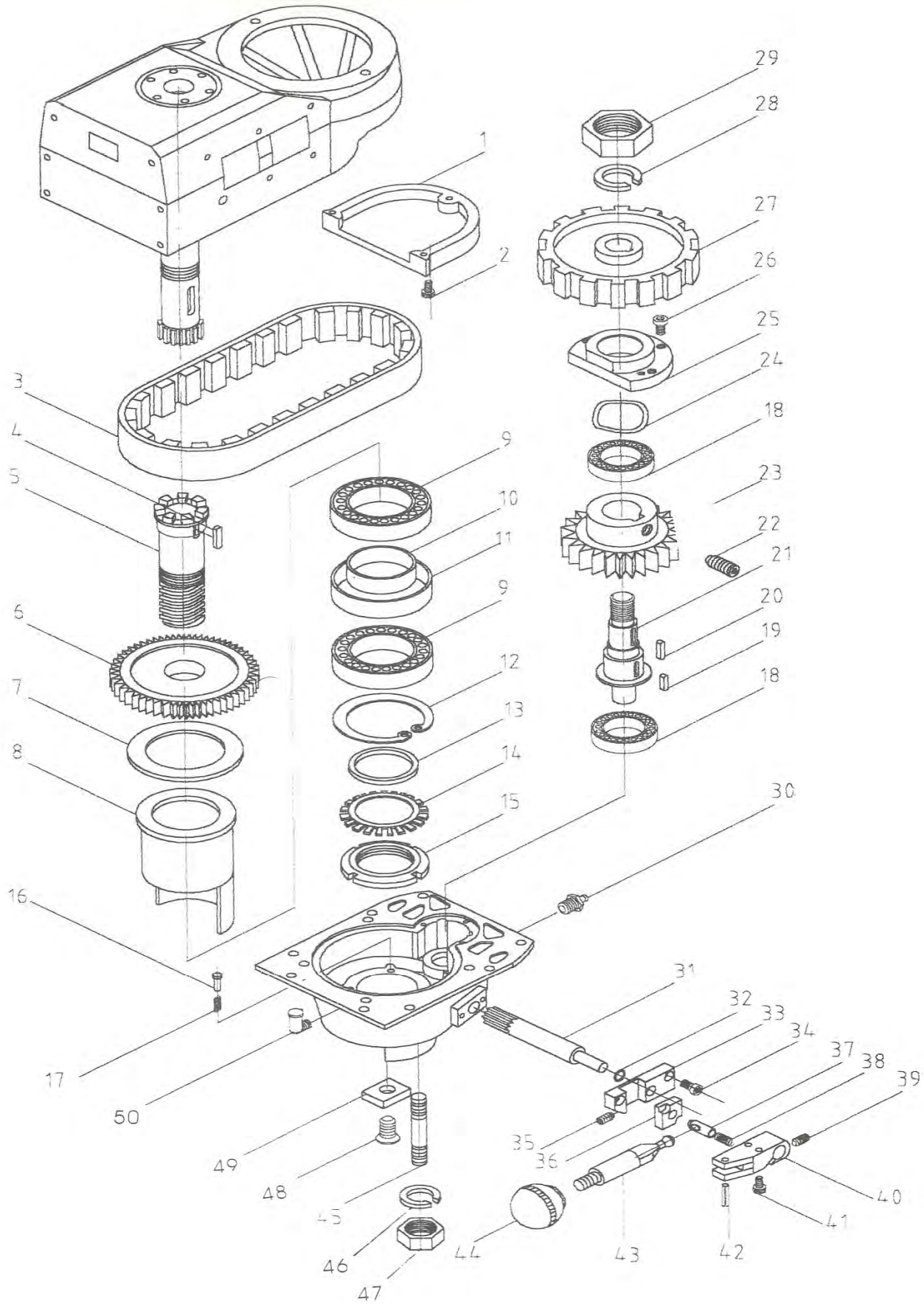


12. Mechanical Drawings & Parts Breakdown List

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

12-1. 5HP e-Mill HEAD TOP HOUSING



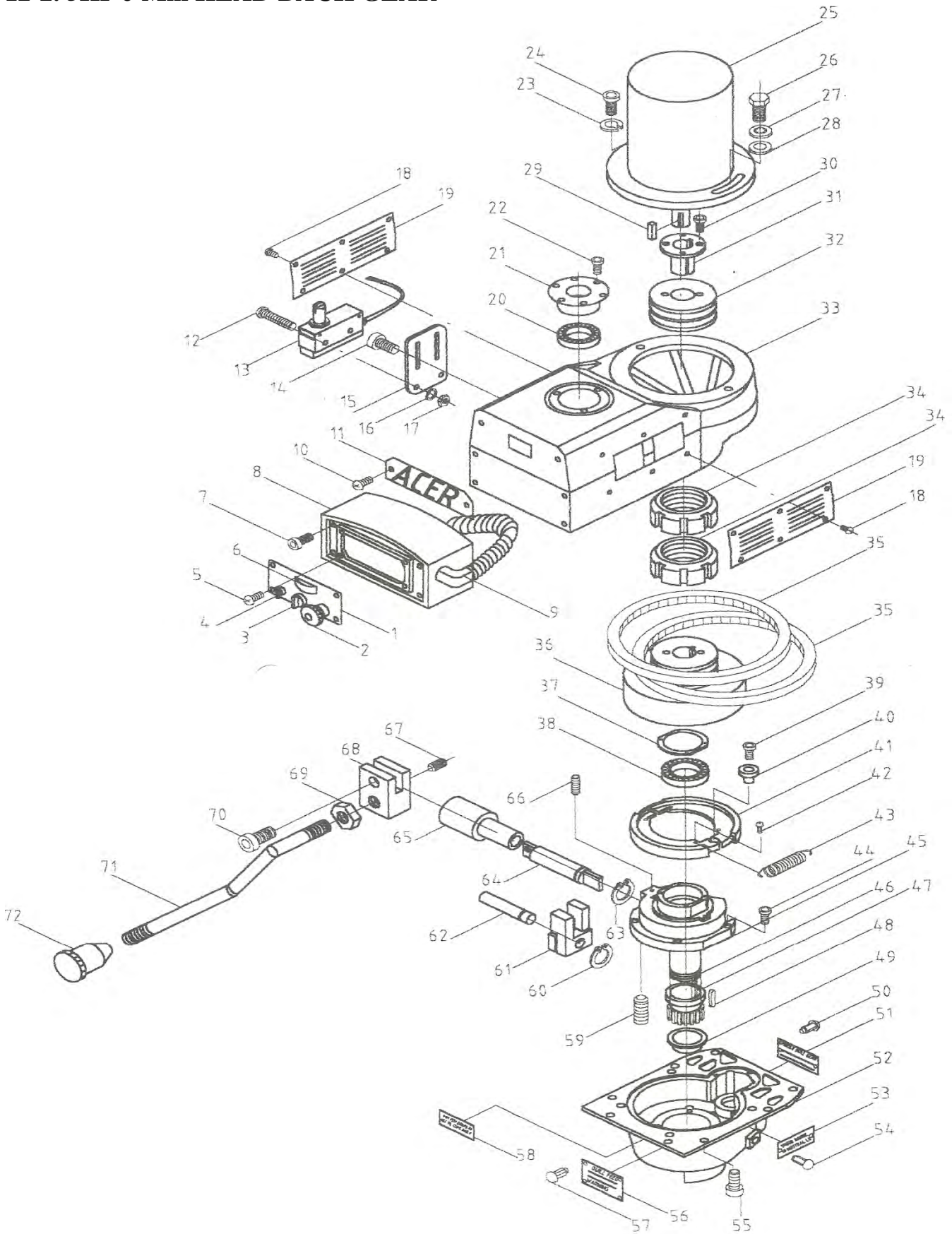
5HP E-mill HEAD TOP HOUSING

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
1	8054	VS11	Motor Pulley Cover	1
2	8055	VS12	Socket HD Cap Screw	3
3	5E7036	FVS63	Timing Belt	1
4	5E7081	FVS72	Key	1
5	5E7039	FVS73	Splined Gear Hub	1
6	5E7040	FVS74	Spindle Bull Gear	1
7	5E7057-2	FVS100	Bull Gear Washer	1
8	5E7048	FVS75	Ball Bearing Gear Sleeve	1
9	5E7041	FVS77	Bearing—6910VV	2
10	5E7043	FVS78	Bull Gear Bearing Spacer	1
11	5E7057	FVS79	Bearing Sleeve Spacer	1
12	5E7042	FVS80	Snap Ring	1
13	5E7039-1	FVS	Gear Hub Spacer	1
14	5E7058	FVS73-1	Wave Spring Washer	1
15	5E7056	FVS81	Bearing Lock Nut	1
16	7055-1	VS102	T-Tip Pin	3
17	7055	VS84	Compression Spring	3
18	7079	VS65	Ball Bearing-6203ZZ	2
19	7078	VS69	Key	1
20	7078	VS69	Key	1
21	7080	VS67	Bull Gear Pinion Counter Shaft	1
22	7077	VS03	Socket Set Screw	1
23	7083	VS66	Bull Gear Pinion	1
24	7082	VS64-1	Wave Spring Washer	1
25	7084	VS64	Bull Gear Pinion Bearing Cap	1
26	7085	VS12	Socket HD Cap Screw	3
27	5E7086	FVS62	Timing Belt Pulley	1
28	5E7087-1	FVS	Spring Washer	1
29	7087	VS61	Jam Nut	1
30	8063-3	VS82-4	Grease Nibble	1
31	5E7059	FVS87	Bull Gear Shift Pinion Shaft	1
32	5E7059-1	VS	Wave Spring Washer	1
33	7060	VS89	Hi-Low Detent Plate	1
34	7068	VS12	Socket HD Cap Screw	2
35	7064	VS	Socket Set Screw	1
36	7065	VS89-1	Adjustable Plate	1
37	7066	VS90	Hi-Low Detent Plunger	1
38	7067	VS91	Spring	1
39	5E7071-1	VS	Socket Set Screw	1
40	7071	VS92	Hi-Low Pinion Block	1

5HP E-mill HEAD TOP HOUSING

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
41	7072-1	VS92-1	Socket HD Cap Screw	2
42	7072	VS88	Spring Pin	1
43	7070	VS94	Hi-Low Shift Crank	1
44	7069	B24	Bakelite Ball	1
45	5E7063	FVS85	Stud	3
46	5E7062	FVS85-1	Spring Washer	3
47	5E7061	FVS85-2	Hex Nut	3
48	5E7049-1	FVS83-1	Flat HD Cap Screw	2
49	5E7049-2	FVS83-2	Brass Locating Plate	2
50	7054	VS82-1	Oil Cup	1

12-2. 5HP e-Mill HEAD BACK GEAR



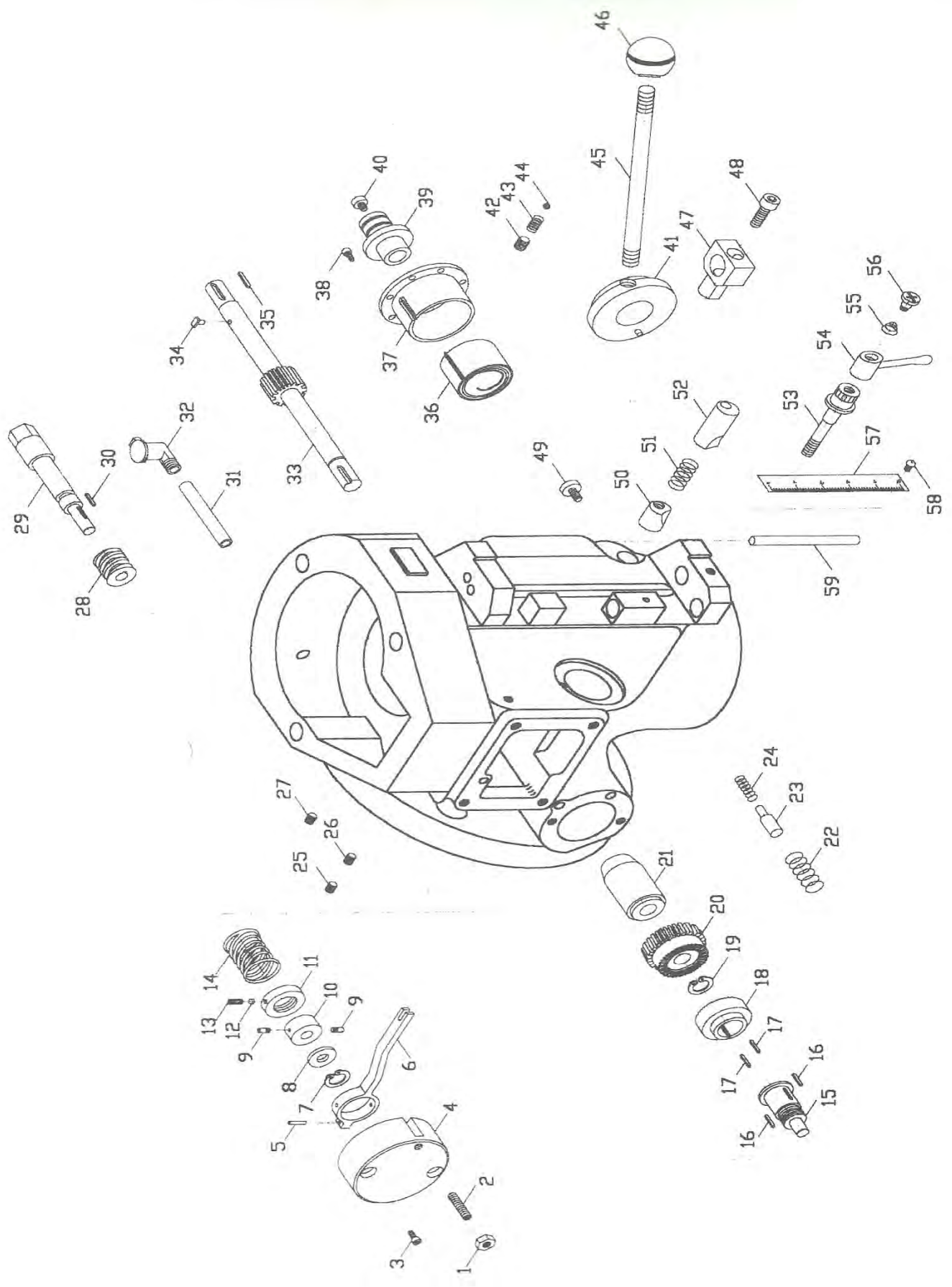
5HP E-mill HEAD BACK GEAR

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
1	5EH7023-1	FVS16-5	Chrome Face Plate	1
2	9500	VS	Emergency Switch	1
3	9501	VS	F/R Switch	1
4	9502	VS	Variable Resistor	1
5	7022-1	VS17-1	Round Socket Cap Screw	4
6	5E9503	VS	RPM Meter	1
7	H7025	VS17	Socket HD Cap Screw	4
8	H7005-1	VS16-6	Speed Changer Housing	1
9	9504	VS	Control Wire Cable	1
10	H8010-3	VS1-6	Round Socket Cap Screw	2
11	H8010-1	VS1-4	ACER Name Plate	1
12	7022-2	VS	Round Socket Cap Screw	2
13	9505	VS	Limit Switch w/Cable	1
14	7022-5	VS	Socket HD Cap Screw	2
15	H8010-2	VS1-5	Limit Switch Bracket Plate	1
16	7022-3	VS	Spring Washer	2
17	7022-4	VS	Hex Nut	2
18	H7088-1	VS101-1	Round Cap Wooden Screw	12
19	H7088	VS101	Ventilator	2
20	5E8004	FVS15	Ball Bearing—6209ZZ	1
21	5E7013	FVS13	Top Bearing Cap	1
22	8001	VS14	Socket HD Cap Screw	3
23	8009-3	VS	Wave Lock Washer	1
24	8009	VS	Socket HD Cap Screw	1
25	5E8008-1	VS	5 HP Spindle Motor	1
26	8009	VS	Socket HD Cap Screw	1
27	8009-3	VS	Wave Lock Washer	1
28	8009-2	VS	Washer	1
29	8039-1	VS06-1	Key	1
30	8040-3	VS02-3	Hex HD Screw	2
31	8040-2	VS02-2	V-Belt Pulley Sleeve	1
32	5E8040-1	FVS02-1	3V Belt Pulley	1
33	5E8010	FVS01	Belt Housing	1
34	5E8034-1	FVS70-2	Spindle Hub Lock Nut	2
35	5E8027-1	FVS04-1	3V Belt	2
36	5E8028-1	FVS45-1	Stationary Driven Pulley	1
37	5EH8053-3	FVS50-3	Brake Shoe Lock Plate	1
38	5E8023	FVS43	Ball Bearing—6013VV	1
39	8035	VS14	Round Socket Cap Screw	1
40	8036	VS48	Brake Shoe Pivot Sleeve	1

5HP E-mill HEAD BACK GEAR

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
41	5E8032	FVS47	Brake Shoe Assembly	1
42	8032-1	VS47-1	Round Cap Screw	4
43	8031	VS49	Brake Spring	2
44	H8064	VS51	Socket HD Cap Screw	4
45	5EH8053-2	FVS50-2	Belt Housing Base	1
46	5E8034-5	FVS70-1	Spindle Pulley Hub	1
47	5E8033	FVS98	Spindle Pulley Spacer	1
48	5E8049-1	FVS71-1	Key	1
49	5E7038	FVS105	Timing Pulley Clutch Sleeve	1
50	8059	VS	Drive Screw	2
51	8063-2	VS01-1	Grease Add Name Plate	1
52	5EH8063	FVS82	Gear Housing	1
53	8058	VS82-2	Hi-Low Range Name Plate	1
54	8059	VS	Drive Screw	2
55	8055	VS12	Socket HD Cap Screw	8
56	8061	VS82-1	Quill Feed Name Plate	1
57	8059	VS	Drive Screw	4
58	H8063-1	VS82-3	Oil Add Name Plate	1
59	H8077	VS99	Socket Set Screw	1
60	8066	VS60	Snap Ring	1
61	8067	VS59	Brake Operating Finger	2
62	8068	VS58	Brake Finger Pivot Stud	1
63	8066-1	VS60-1	Snap Ring	1
64	H8074	VS53	Brake Lock Shaft	1
65	H8073	VS52	Sleeve for Brake Lock Shaft	1
66	H8077	VS99	Socket Set Screw	1
67	8072	VS54-1	Socket Set Screw	1
68	8070-2	VS54	Brake Handle Block	1
69	8070-1	VS56-1	Hex Nut	1
70	8071-1	VS55-1	Socket HD Cap Screw	1
71	5E8070	FVS56	Brake Lock Handle	1
72	8069	VS57	Bakelite Ball Handle	1
73	5EH8053-4		Round Socket Cap Screw	4

12-3. (MILLING HEAD) HAND FEED ASSEMBLY



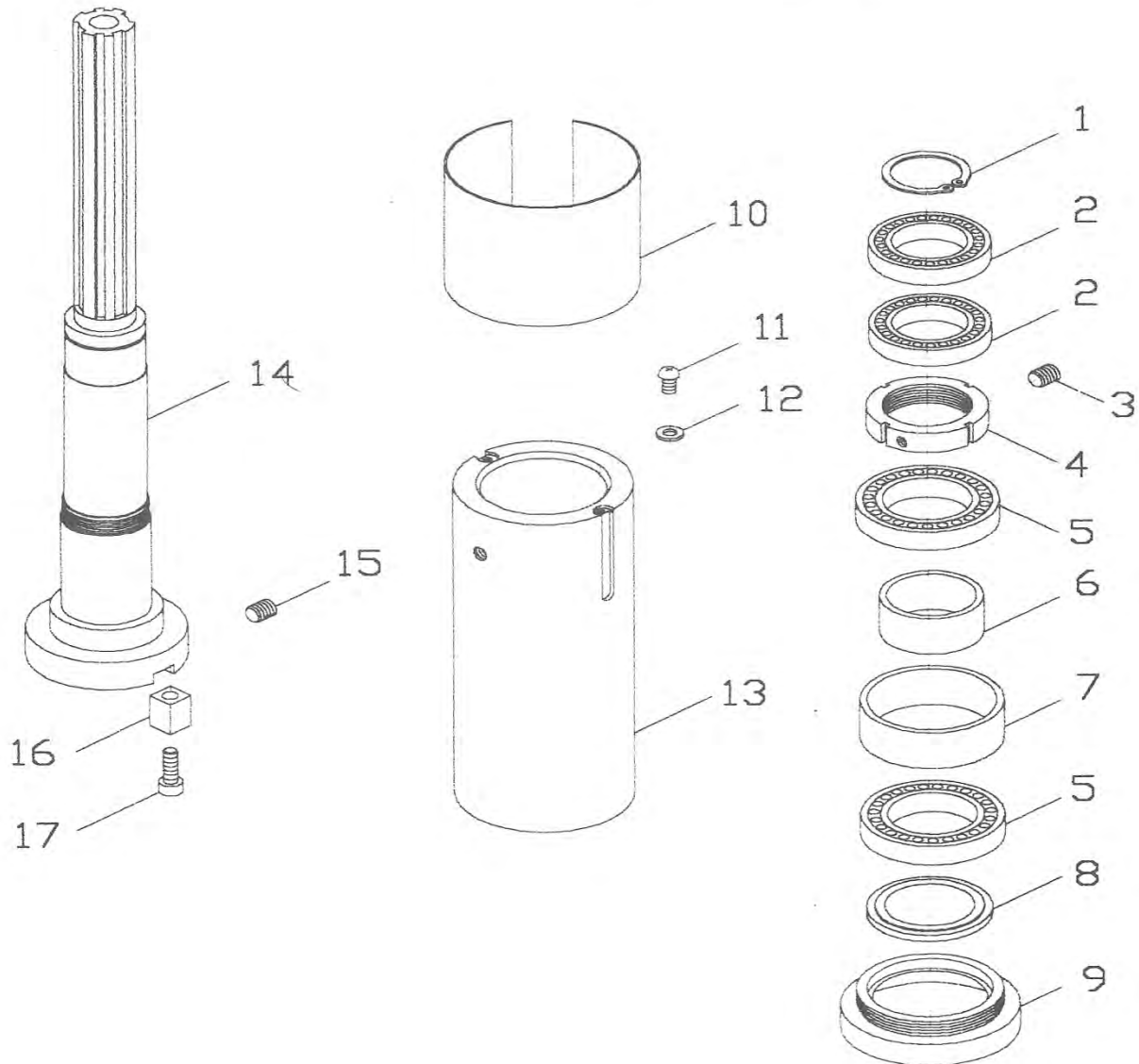
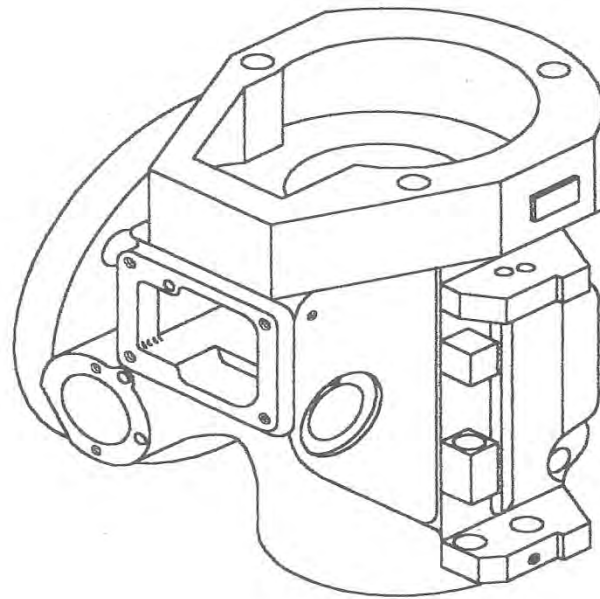
5HP (MILLING HEAD) HAND FEED ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
1	5K-6208	M6	Hex Nut	1
2	5K-6207	M6x16	Socket Set Screw	1
3	5K-6206	M5x35	Socket HD Cap Screw	2
4	5K-6205	B99	Clutch Arm Cover	1
5	5K-6204	5x20	Roll Pin	1
6	5K-6203	FB96	Overload Clutch Trip Lever	1
7	5K-6195-1	C10	Snap Ring	1
8	5K-6201	B97	Overload Clutch Washer	1
9	5K-6202	B74	Clutch Ring Pin	2
10	5K-6200	B75	Clutch Ring	1
11	5K-6198	B78	Overload Clutch Lock nut	1
12	5K-6199-1		Brass Plug	1
13	5K-6199	M6x6	Socket Set Screw	1
14	5K-6197	FB79	Safety Clutch Spring	1
15	5K-6195	FB81	Overload Clutch Sleeve	1
16	5K-6196	5x20	Key	2
17	5K-6196	5x25	Key	2
18	5K-6194	FB80	Overload Clutch	1
19	5K-6188-1	C16	Snap Ring	1
20	5K-6187+88	FB92+93	Overload Clutch Worm Gear and Ring	1
21	5K-6186	FB90+91	Quill Pinion Shaft Bushing	1
22	5K-6192	B88-1	Compression Spring	1
23	5K-6193	B89	Overload Clutch Lever Spring Plunger	1
24	5K-6191	FB88	Compression Spring	1
25	5K-6246-1	M6x6	Socket Set Screw	1
26	5K-6246	M6x16	Lock Screw	1
27	5K-5042		Set Screw Plunger	1
28	5K-5039	B186	Worm Gear	1
29	5K-5040	FB189	ADJ Worm Shaft	1
30	5K-5041	4x20	Key	1
31	5K-6133-1		Bronze Tubing	1
32	5K-6133		Oil Cup	1
33	5K-6172	FB166	Quill Pinion Shaft	1
34	5K-6172-1	B168	Cap Tip- T shape	1
35	5K-6184	3x20	Key	1
36	5K-6181	FB178	Clock Spring	1
37	5K-6180	FB177	Spring Cover	1
38	5K-6180-1	M5x12	Socket HD Cap Screw	2
39	5K-6182	B176	Pinion Shaft Hub Sleeve	1
40	5K-6183	B172	Pinion Shaft Hub Screw	1

5HP (MILLING HEAD) HAND FEED ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
41	5K-6178	B175	Rack Feed Handle Hub	1
42	5K-6177	M8x6	Socket Set Screw	1
43	5K-6175		Compression Spring	1
44	5K-6176		Steel Ball	1
45	5K-6174	B190	Pinion Shaft Hub Handle	1
46	5K-6173	B191	Black Plastic Ball	1
47	5K-6105	FB164	Quill Stop Knob	1
48	5K-6106	3/8x5/8x24T	Socket HD Cap Screw	1
49	5K-6253	B154	Cap Screw	1
50	5K-6116B	B148	Quill Lock Sleeve Tapped	1
51	5K-6116-1	B152-1	Compression Spring	1
52	5K-6116A	FB153	Quill Lock Sleeve	1
53	5K-6117	FB152	Quill Lock Bolt	1
54	5K-6119	FB149	Lock Handle	1
55	5K-6117-1		Spring	1
56	5K-6117-2		Spring Screw	1
57	5K-6243	B159	Micrometer Scale	1
58	5K-6244	M4x8	Round HD Cap Screw	2
59	5K-6251	B147	Set Bar	1

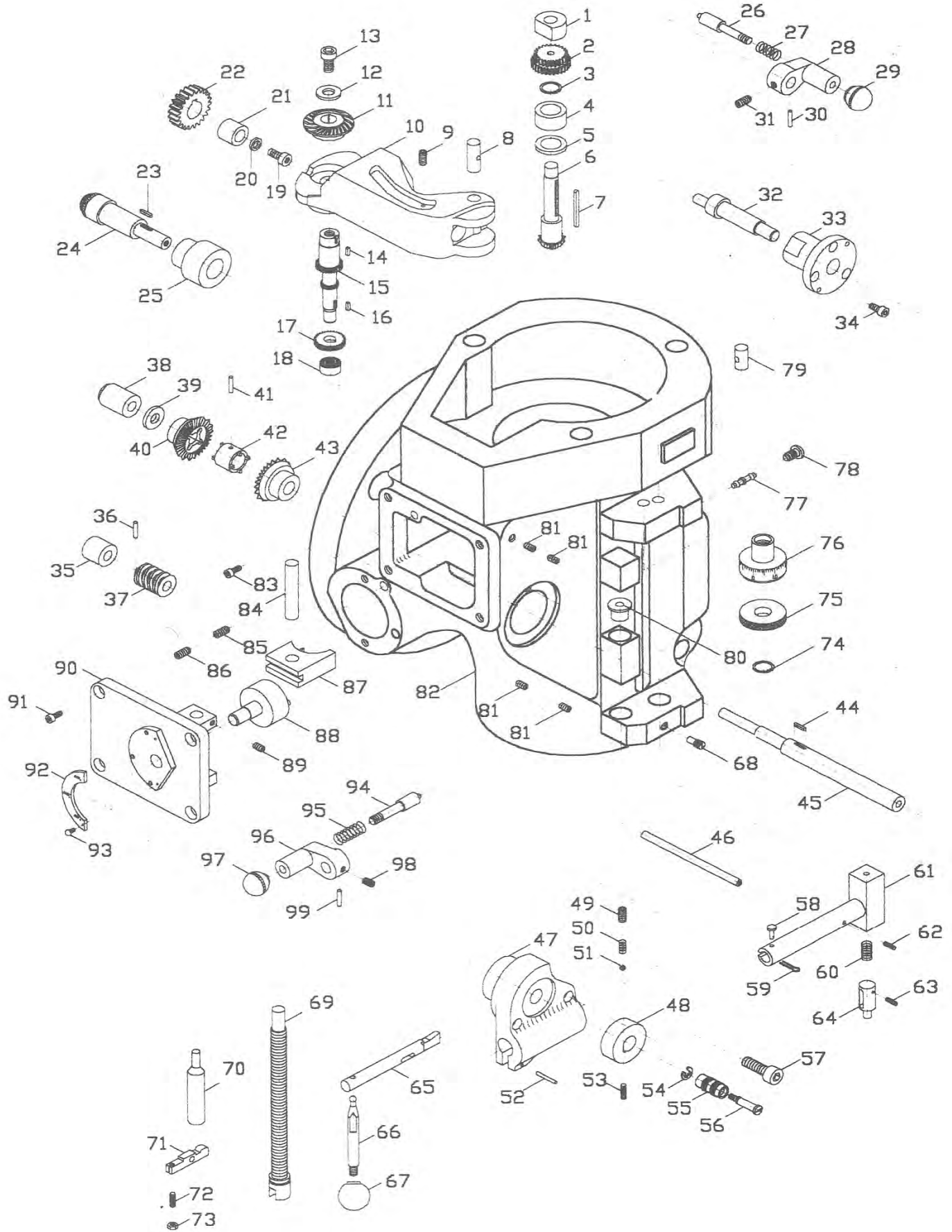
12-4. (MILLING HEAD) SPINDLE ASSEMBLY



5HP (MILLING HEAD) SPINDLE ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
1	5K-6090	C40	Snap Ring	1
2	5K-6092		Ball Bearing- 6008LLB	2
3	5K-6094-1	M8x6	Socket Set Screw	2
4	5K-6094	FB129	Lock Nut	1
5	5K-6093		Ball Bearing- 7010	2
6	5K-6096	FB137	Bearing Spacer- Small	1
7	5K-6095	FB136	Bearing Spacer- Large	1
8	5K-6097	FB134	Spindle Dirt Shield	1
9	5K-6098	FB133	Nose Piece	1
10	5K-6086	FB128	Quill Skirt	1
11	5K-6088-1	M5x8	Felt Washer Screw	2
12	5K-6088-2	M5	Washer	2
13	5K-6085	FB142	Quill	1
14	5K-6084	FB127	Spindle #40	1
15	5K-6085-1	M5x8	Socket Set Screw	1
16	5K-6099	FB127-1	Keeper Key	2
17	5K-6100	M8x25	Socket HD Cap Screw	2
18	5K-8014		Drawbar	1
19	5K-8020		Drawbar Washer	1

12-5. (MILLING HEAD) AUTO FEED ASSEMBLY



5HP (MILLING HEAD) AUTO FEED ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
1	5K-6157	B27	Cluster Gear Shaft Upper Bearing	1
2	5K-6153	FB28	Cluster Gear Assembly	1
3	5K-6158	C16	Snap Ring	1
4	5K-6156	FB33	Bevel Gear Bearing	1
5	5K-6159	FB34	Bevel Gear Thrust Spacer	1
6	5K-6151	FB31+35	Cluster Gear Shaft	1
7	5K-6160	M3x35	Cluster Gear Key	1
8	5K-6122	B16	Feed Engage Pin	1
9	5K-6123	M6x6	Socket Set Screw	1
10	5K-6121	FB17	Worm Gear Cradle	1
11	5K-6148	FB15	Feed Reverse Bevel Gear	1
12	5K-6149	FB13, 3/8"	Washer	1
13	5K-6150	3/8x1/4	Socket HD Cap Screw	1
14	5K-6147	3x8	Key	1
15	5K-6143	FB36	Feed Driving Gear Shaft	1
16	5K-6145	3x10	Key	1
17	5K-6144	FB40	Feed Drive Gear	1
18	5K-6252	BA66	Needle Bearing	1
19	5K-6124	M6x12	Socket HD Cap Screw	1
20	5K-6140	M6	Washer	1
21	5K-6136-1		Worm Gear Bushing	1
22	5K-6134		Feed Drive Worm Gear	1
23	5K-6135	3x12	Key	1
24	5K-6139		Feed Bevel Pinion	1
25	5K-6136+37		Worm Gear Cradle Bushing	1
26	5K-6169	B20	Gear Shift Plunger	1
27	5K-6170	B21	Compression Spring	1
28	5K-6168	B23	Shift Crank	1
29	5K-6131	B24	Black Plastic Ball	1
30	5K-6128	3x20	Spring Pin	1
31	5K-6168-1	M5x5	Socket Set Screw	1
32	5K-6126	B18	Worm Gear Cradle Throw-out	1
33	5K-6125	B19	Shift Sleeve	1
34	5K-6132	M5x12	Socket HD Cap Screw	3
35	5K-6227	B42	Bushing	1
36	5K-6226	3x10	Spring Pin	1
37	5K-6225	B43	Worm	1
38	5K-6224	FB44	Feed Worm Shaft Bushing	1
39	5K-6223	B47	Feed Worm Shaft Thrust Washer	1
40	5K-6220	B48+49	Feed Reverse Bevel Gear	1

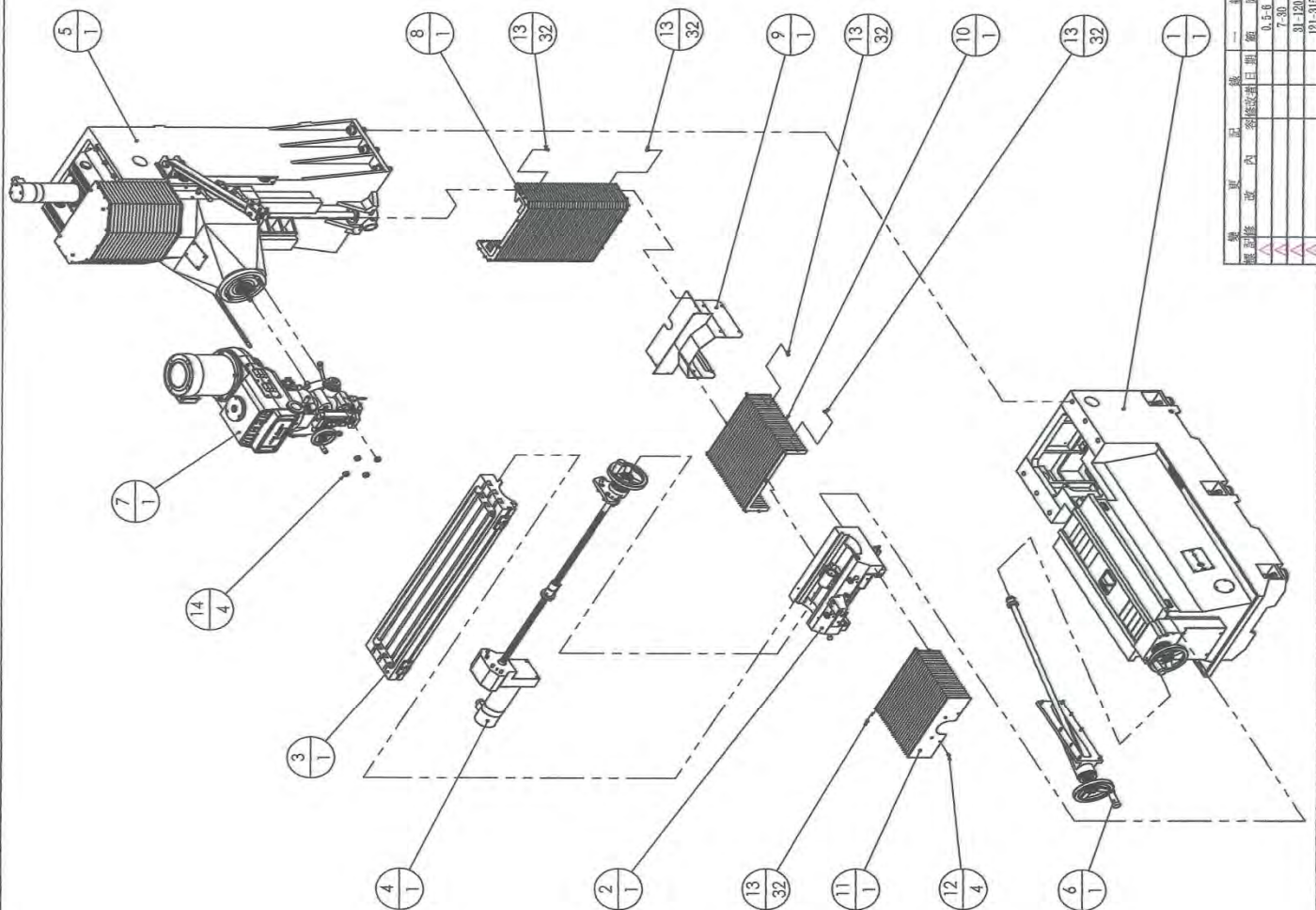
5HP (MILLING HEAD) AUTO FEED ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
41	5K-6217	3x20	Spring Pin	1
42	5K-6222	B50	Feed Reverse Clutch	1
43	5K-6220	B48+49	Feed Reverse Bevel Gear	1
44	5K-6230	3x15	Key	1
45	5K-6209	FB57	Feed Worm Shaft	1
46	5K-6216	FB55	Reverse Clutch Rod	1
47	5K-6231	FB106	Feed Trip Bracket	1
48	5K-6218	B113	Handwheel Clutch	1
49	5K-6219-1	M8x6	Socket Set Screw	1
50	5K-6219-2	B115	Compression Spring	1
51	5K-6255	B114	Steel Ball	1
52	5K-6231-1	5x20	Dowel Pin	1
53	5K-6219	M6x6	Socket Set Screw	1
54	5K-6215	B112, E5	Snap Ring	1
55	5K-6213	B111	Reverse Knob	1
56	5K-6214	B110	Feed Reverse Knob Stud	1
57	5K-6232	M6x25	Socket HD Cap Screw	2
58	5K-6236-1		Dowel Pin	1
59	5K-6241-1	#2	Y Pin	1
60	5K-6242	B120	Compression Spring	1
61	5K-6236	FB118	Cam Rod Sleeve Assembly	1
62	5K-6237	3x16	Spring Pin	1
63	5K-6241	3x12	Spring Pin	1
64	5K-6240	B121	Trip Plunger	1
65	5K-6239	FB103	Cam Rod	1
66	5K-6234	FB104	Trip Handle	1
67	5K-6131	B24	Black Plastic Ball	1
68	5K-6112		Trip Lever Pin	1
69	5K-6104	B164	Quill Stop Micro-Screw	1
70	5K-6118	B124	Feed Trip Plunger	1
71	5K-6111	B145	Feed Trip Lever	1
72	5K-6113	B146, M4x20	Socket Set Screw	1
73	5K-6113-1	M4	Hex Nut	1
74	5K-6115	C16	Snap Ring	1
75	5K-6108	B161	Quill Micro-Stop Nut	1
76	5K-6107	B162	Micrometer Nut	1
77	5K-6110	B183	Reverse Trip Ball Lever	1
78	5K-6114	B185	Reverse Trip Ball Lever Screw	1
79	5K-6109	B184	Feed Reverse Trip Plunger	1
80	5K-6118-1	B123	Trip Plunger Bushing	1

5HP (MILLING HEAD) AUTO FEED ASS'Y

ITEM#	PART#	FACTORY#	DESCRIPTION	Q'TY
81	5K-6246	M6x8	Socket Set Screw	4
82	5K-6101	FB192	Quill Housing	1
83	5K-6101-1	M6x30	Socket HD Cap Screw	1
84	5K-6163	B60	Feed Shift Rod	1
85	5K-6228	M6x12	Mock-It Lock Screw	1
86	5K-6228-1	M6x8	Socket Set Screw	1
87	5K-6162	B63	Feed Gear Shift Fork	1
88	5K-6166	FB64	Cluster Gear Shift Crank	1
89	5K-6164	M5x5	Socket Set Screw	1
90	5K-6161	FB66	Cluster Gear Cover	1
91	5K-6165	M5x12	Socket HD Cap Screw	4
92	5K-6165-1	VS66-1	Feed Rate Plate	1
93	5K-6165-2		Drive Screw	2
94	5K-6169	B20	Gear Shift Plunger	1
95	5K-6170	B21	Compression Spring	1
96	5K-6168	B23	Shift Crank	1
97	5K-6171	B24	Black Plastic Ball	1
98	5K-6168-1	M5x5	Socket Set Screw	1
99	5K-6167	3x20	Spring Pin	1
100	5K-6210	B125	Handwheel	1
101	5K-6210-1	B126	Handle	1

12-6. ACER-B1 ASSEMBLY DRAWING



項次編號	零件檔案名稱	數量
1	ACER-B1-A01-0底座	1
2	ACER-B1-A02-0載座	1
3	ACER-B1-A04-0工作台10X50	1
4	ACER-B1-A04-1X軸滾珠螺桿(GM4000M1)	1
5	ACER-B1-B01立柱(鍵輪型)	1
6	ACER-B1-C01升降手柄座	1
7	ACER-B1-D頭部	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螺帽	4

圖號	比例	圖名
ACER-B1	1:1.5	ACER-B1
ACER-B1	1:1.5	ACER-B1

圖號	圖名	日期	數量
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1

圖號	圖名	日期	數量
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1
ACER-B1	ACER-B1	10/07/03	1

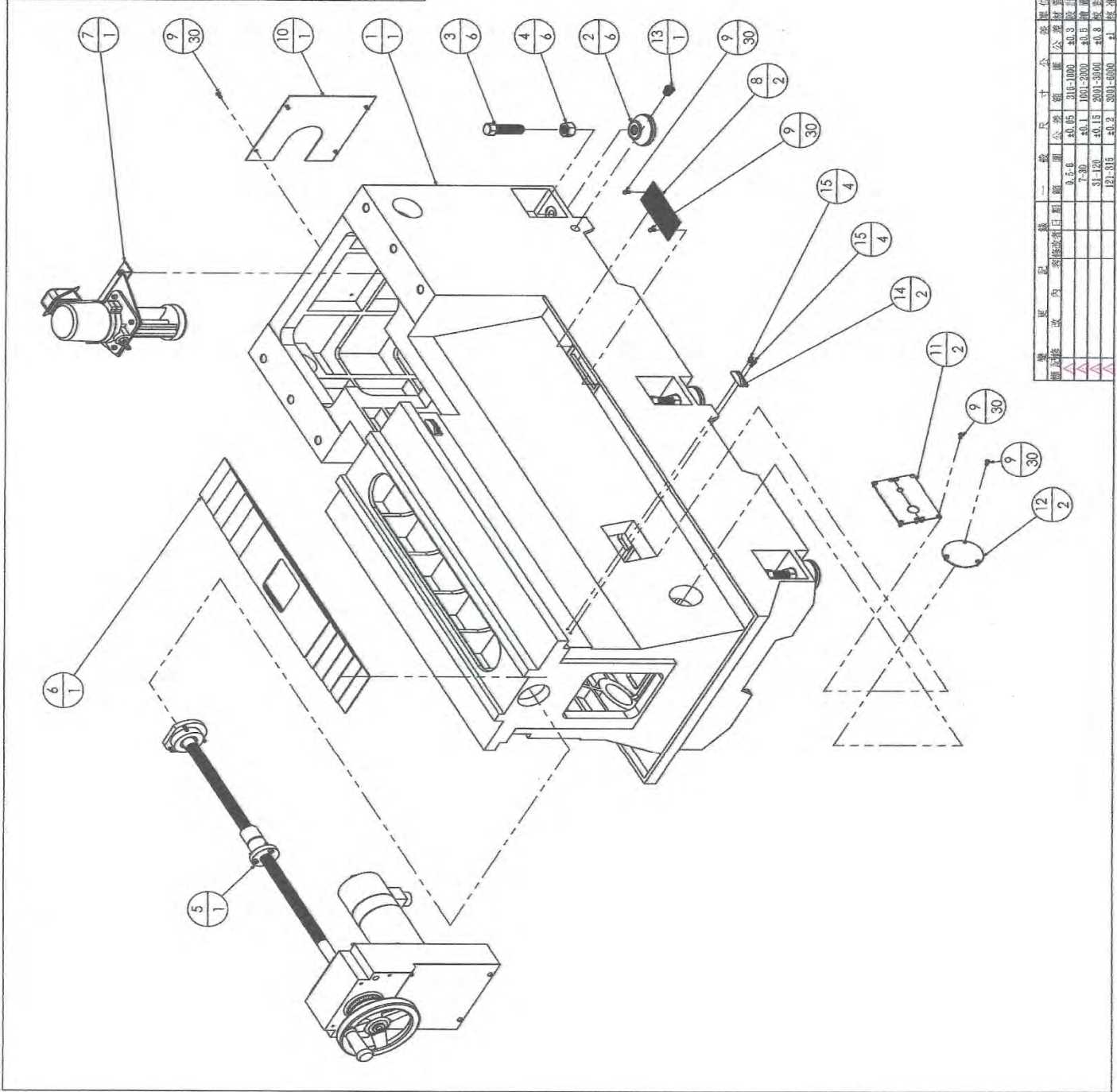
亞欽股份有限公司

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-D	Head 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
14	5"x12UNC	Hex Nut	4

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

12-8. ACER-B1-A01-0 MACHINE BASE ASSEMBLY

項次/圖號	零件名稱	數量
1	ACER-B1-A00 底座	1
2	ACER-B1-A02 基礎螺絲(右側)	6
3	ACER-B1-A03 基礎螺絲(左側)	6
4	ACER-B1-A04-075-90UNC 螺絲(右側)	6
5	ACER-B1-A05-075-90UNC 螺絲(左側)	1
6	ACER-B1-A01-1 防撞蓋板	1
7	ACER-B1-A06-0 命鎖蓋板	1
8	ACER-B1-A08-0 命鎖螺絲	2
9	ASDVBKT 螺絲十字螺釘	30
10	ACER-B1-A077 (ASDVBKT) 命鎖螺絲蓋板 (用於防止螺絲蓋板脫落)	1
11	ACER-B1-A066 螺絲刀孔蓋板	2
12	ACER-B1-A065 螺絲刀孔蓋板	2
13	PD3.514UNC 止震螺絲	1
14	ACER-B1-A007 行程定位塊	2
15	ASDVBKT2 六角螺絲	4



圖號	圖名	比例	日期	設計	校核	繪圖	審核
ACER-B1-A01-0	底座爆炸圖	1:6					
ACER-B1-A01-0	底座爆炸圖	1:6					

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Drawing #: ACER-B1-A01-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A001	Machine Base	1
2	ACER-B1-A002	Leveling Pad	6
3	ACER-B1-A003	Leveling Screw	6
4	ACER-B1-A004	Hex Nut	6
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

12-9. ACER-B1-A03-0 Y AXIS TRAVEL ASSEMBLY

零件編號	零件名稱	數量
1	ACER-B1-A01Y軸行輪軸系組(主動)	1
2	20T ACER 20X20X15	2
3	MIX1.5X20吋六角螺絲	4
4	5.5彈簧墊圈	2
5	ACER-B1-A01Y軸行輪系(主動)	3
6	M4X11吋六角螺絲	9
7	ACER-B1-A01Y軸行輪系(被動)	3
8	ACER-B1-A01Y軸行輪系(被動)	3
9	5X5平彈簧	1
10	ACER-B1-A02Y軸行輪系(被動)	2
11	M5X20X3吋六角螺絲	2
12	M20X1.5螺絲墊圈	1
13	ACER-B1-A02Y軸行輪系(被動)	2
14	ACER-B1-A02Y軸行輪系(被動)	2
15	ACER-B1-A02Y軸行輪系(被動)	2
16	ACER-B1-A02Y軸行輪系(被動)	2
17	M6X12X2吋六角螺絲	4
18	4.70X4.76吋彈簧	1
19	M5X20X3吋六角螺絲	1
20	M5X20X3吋六角螺絲	1
21	M5X20X3吋六角螺絲	1
22	M5X1.25X8吋六角螺絲	1
23	ACER-B1-A02Y軸行輪系(被動)	1
24	ACER-B1-A02Y軸行輪系(被動)	1
25	5X20X3吋六角螺絲	1
26	M5X1.25X20吋六角螺絲	3
27	ACER-B1-A02Y軸行輪系(被動)	1
28	5X20X3吋六角螺絲	1
29	M5X1.25X8吋六角螺絲	2
30	M5X1.25X20吋六角螺絲	2
31	ACER-B1-A02Y軸行輪系(被動)	1
32	M5X1.25X20吋六角螺絲	4
33	M5X1.25X20吋六角螺絲	2
34	M3X0.5X6平圓內六角螺絲	1
35	ACER-B1-A02Y軸行輪系(被動)	1
36	5X5平彈簧	1
37	ACER-B1-A02Y軸行輪系(被動)	1
38	ACER-B1-A02Y軸行輪系(被動)	1
39	ACER-B1-A03Y軸行輪系(被動)	1
40	ACER-B1-A03Y軸行輪系(被動)	1
41	ACER-B1-A03Y軸行輪系(被動)	1
42	M5X1.25X20吋六角螺絲	1
43	ACER-B1-A03Y軸行輪系(被動)	1

圖號		ACER-B1-A03-0	
圖名		Y軸行輪系組(被動)	
比例	1:8	日期	100.07.30
數量	1	設計	張政龍
單位	mm	繪圖	張政龍
公差	±0.3	校對	
圖差	±0.5	核准	
尺寸	315-1000		
範圍	±0.05		
圖差	±0.1		
範圍	7-30		
圖差	±0.15		
範圍	2001-3000		
圖差	±0.2		
範圍	3001-5000		

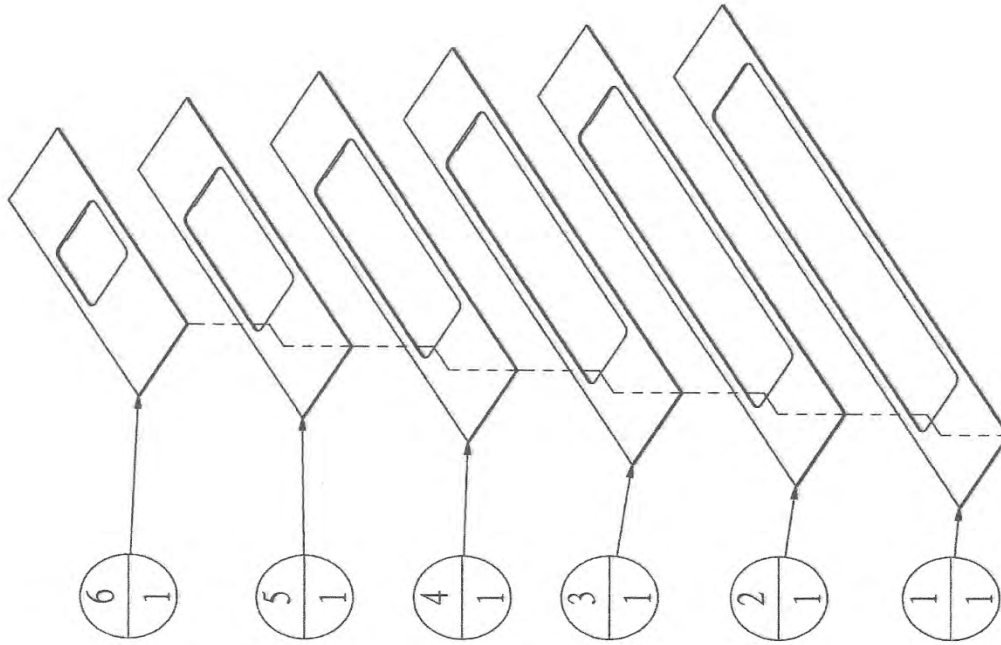
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Drawing #: ACER-B1-A03-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A017	Cross Feed Bearing Bracket (3005)	1
2	20TAC47B	Ball Screw Support Ball Bearing	2
3	M10x1.5x20	Socket Hd Cap Screw	4
4	Φ5	Roll Pin	2
5	ACER-B1-A018	Bearing Cap	3
6	M6x1x12	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	1
11	M5x0.8x8	Set Screw	2
12	M20x1.5	Precision Lock Nut	2
13	ACER-B1-A022	Motor Plate	1
14	ACER-B1-A023	Servo Motor	1
15	ACER-B1-A024	Motor Pulley	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 (5Mx550)	1
24	ACER-B1-A021	Ball Bearing Seat	1
25	6204ZZ	Ball Bearing (20x47x14)	1
26	M6x1x20	Socket Hd Cap Screw	3
27	ACER-B1-A026	Y Axis Front Cover Assembly	1
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

12-10. 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



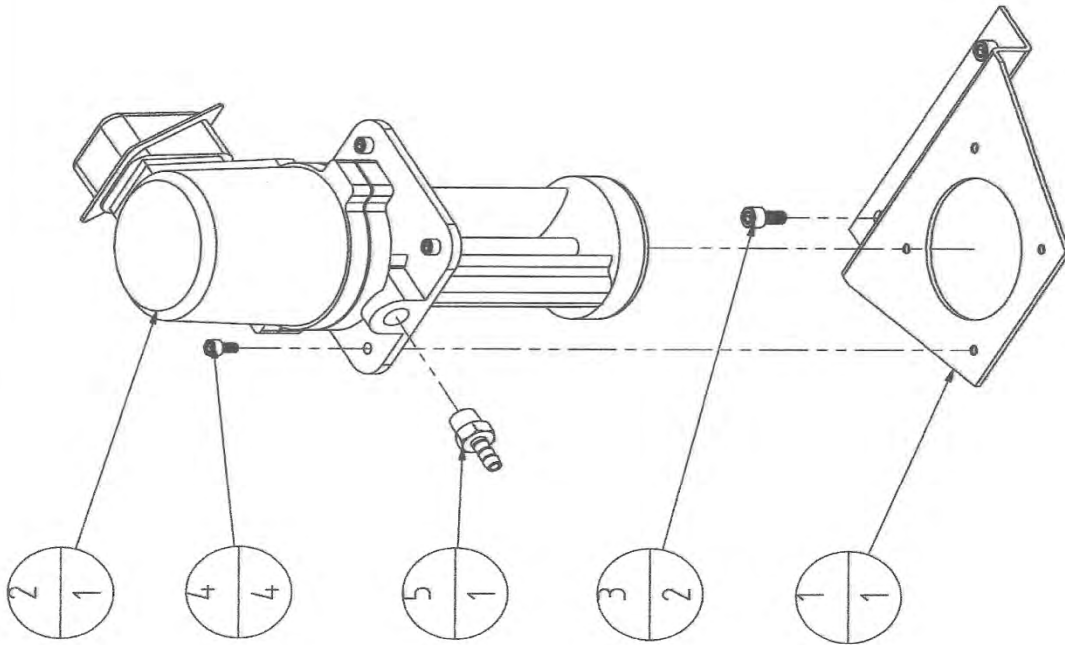
變更	標記	內容	日期	修改者	錄	一般	尺寸	公差	單位	mm	數量	日期	比例	圖號
1	△				範圍	公差	範圍	公差	材質		張	100.07.30	1:8	ACER-B1-A01-1
2	△				0.5-6	±0.05	316-1000	±0.3	設計		張	100.07.30	投影	防塵蓋板爆炸圖
3	△				7-30	±0.1	1001-2000	±0.5	繪圖		張	100.07.30		
4	△				31-120	±0.15	2001-3000	±0.8	校對					
					121-315	±0.2	3001-6000	±1	核准					

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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

12-11. 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



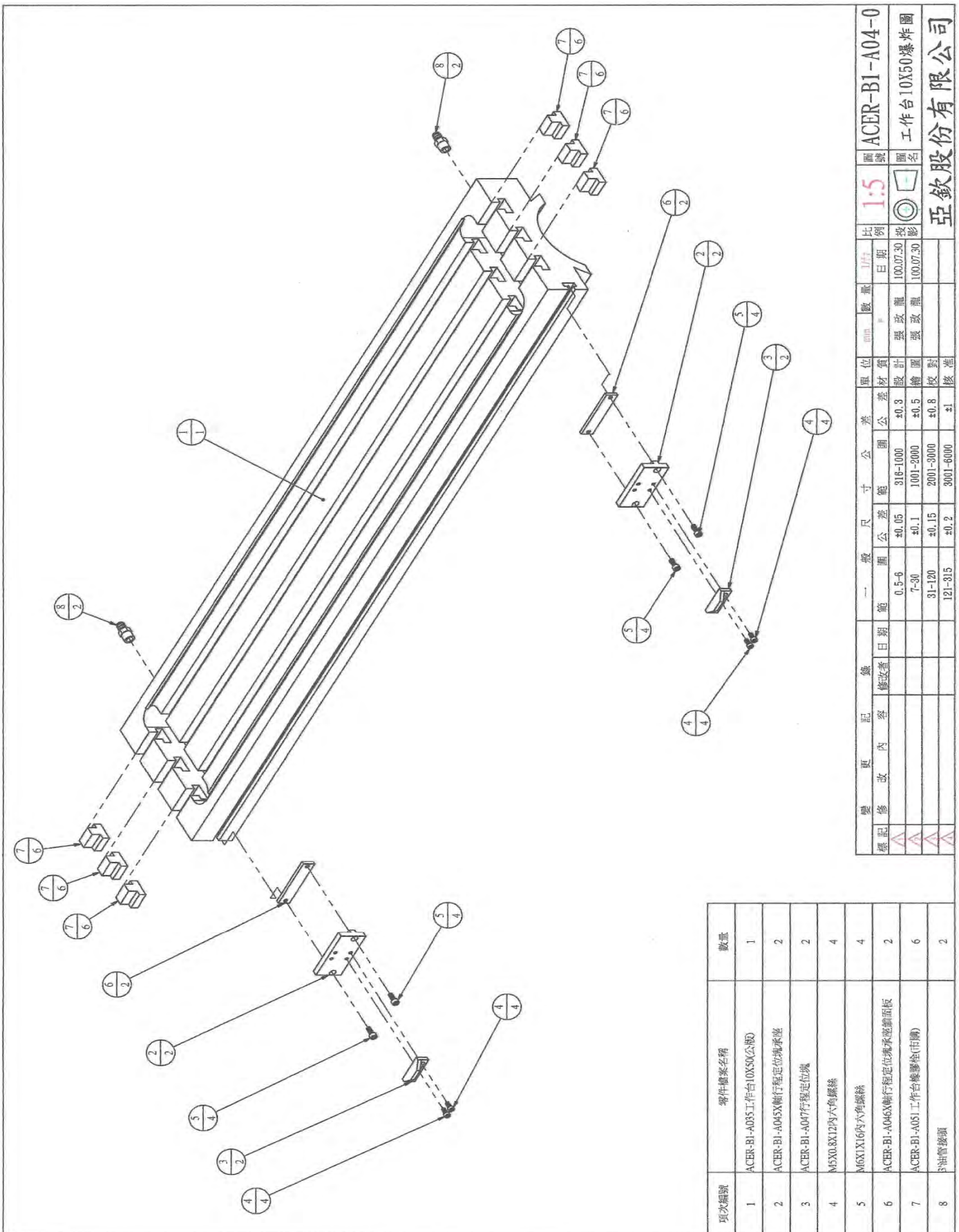
標記	變更內容	日期	修改者	一般尺寸公差		單位	數量	1/台	比例	圖號	圖名
				範圍	公差						
△1				0.5-6	±0.05	設計	張政龍	100.07.30	1:4	ACER-B1-A05-0	冷卻油泵爆炸圖
△2				7-30	±0.1	繪圖	張政龍	100.07.30			
△3				31-120	±0.15	校對					
△4				121-315	±0.2	核准					
				3001-6000	±1						

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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
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

12-13. ACER-B1-A04-0 TABLE ASSEMBLY



項次編號	零件權案名稱	數量
1	ACER-B1-A035工作台10X50(公版)	1
2	ACER-B1-A065X軸行程定位塊承座	2
3	ACER-B1-A047行程定位塊	2
4	M5X0.8X12內六角螺絲	4
5	M6X1X16內六角螺絲	4
6	ACER-B1-A066X軸行程定位塊承座副面板	2
7	ACER-B1-A051工作台橡膠墊(自備)	6
8	牛油管接頭	2

變更	記號	日期	內容	單位	數量	日期	比例	圖號
△				設計	張政龍	100.07.30	1:5	ACER-B1-A04-0
△				繪圖	張政龍	100.07.30	投影	圖名
△				校對				圖名
△				核准				圖名

圖號: ACER-B1-A04-0
 比例: 1:5
 圖名: 工作台10X50爆炸圖
 日期: 100.07.30
 設計: 張政龍
 繪圖: 張政龍
 校對:
 核准:
 亞欽股份有限公司

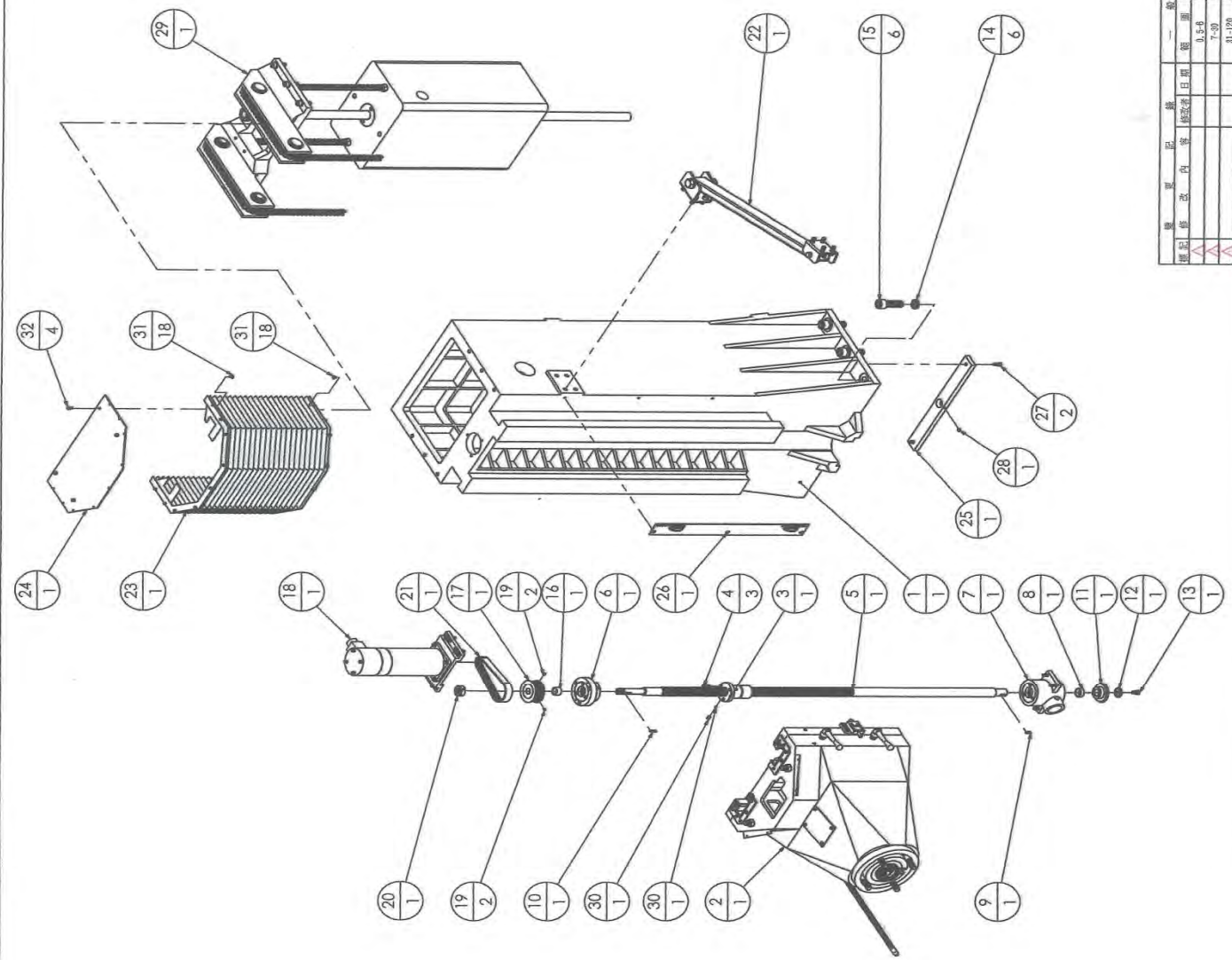
Drawing #: ACER-B1-A04-0			
Item #	Part #	Description	Quantity
1	ACER-B1-A035	Table (2001)	1
2	ACER-B1-A045	X Axis Travel Locating Plate	2
3	ACER-B1-A047	Axis Positioning Block	2
4	M5x0.8x12	Socket HD Cap Screw	4
5	M6x1x16	Socket HD Cap Screw	4
6	ACER-B1-A046	Traveling Locating Back Plate	2
7	ACER-B1-A051	Table End Rubber Stopper	6
8	1/2"PT	Coolant Plug	2

Drawing #: ACER-B1-A04-1			
Item#	Part #	Description	Quantity
1	ACER-B1-A037	X Axis Servo Motor Bracket	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
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	1
11	6204ZZ	Ball Bearings (20x47x14)	2
12	ACER-B1-A019	Spacer	1
13	ACER-B1-A020	Ball Screw Pulley	1
14	M20x1.5	Precision Lock Nut	1
15	ACER-B1-A034	X Axis Ball Screw Assembly	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	1
24	ACER-B1-A024	Motor Pulley	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
30	ACER-B1-A038	Timing Belt (5Mx400)	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

12-15. ACER-B1-B01 COLUMN ASSEMBLY-BALANCING BLOCK TYPE

項次編號	零件檔案名稱	數量
1	ACER-B1-B001 立柱	1
2	ACER-B1-B02 1.8吋頭部底座	1
3	ACER-B1-B007Z軸滾珠螺帽	1
4	M6X120內六角螺絲	3
5	ACER-B1-B007Z軸滾珠螺帽	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大傘齒輪副膠環	1
9	5X5平行鍵	1
10	5X5平形鍵	1
11	ACER-B1-B011昇降電動大傘齒輪(市購)	1
12	ACER-B1-B012大傘齒輪緊壓圈	1
13	M8X1.25X16內六角螺絲	1
14	M22彈簧墊圈	6
15	M22X2.5X7.5內六角螺絲	6
16	ACER-B1-A019皮帶輪副膠環	1
17	ACER-B1-E014滾珠螺桿皮帶輪	1
18	ACER-B1-B05Z軸電機	1
19	M5X0.8X8止付螺絲	2
20	M20X1.5軸承螺帽-1	1
21	ACER-B1-E016Z軸皮帶5M-500(市購)	1
22	吊臂	1
23	ACER-B1-001Z軸上波浪蓋板(總輪型)	1
24	ACER-B1-E009Z軸上波浪蓋板上固定板	1
25	ACER-B1-E012配重塊滑桿下固定板	1
26	ACER-B1-B08Z軸行程定位塊固定板	1
27	M8X1.25X20內六角螺絲	2
28	M8X1.25X8止付螺絲	1
29	ACER-B1-E鐵輪座	1
30	M8X1油筒螺頭	1
31	M6X16平頭內六角螺釘	18
32	M6X1X12內六角螺絲	4

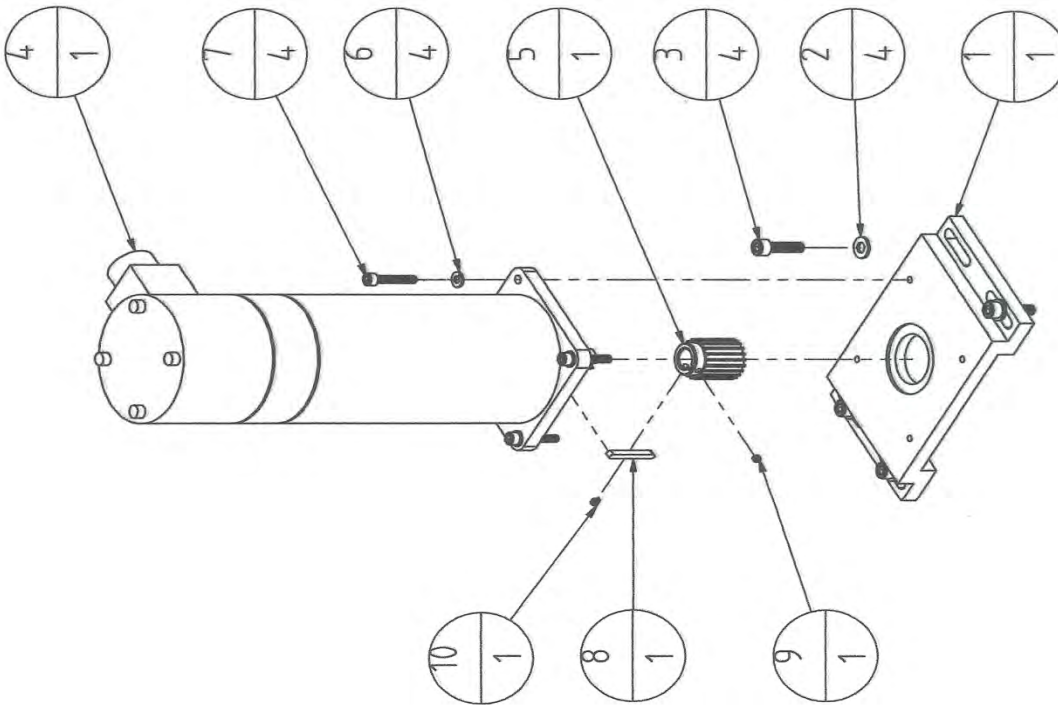


圖號	修改內容	日期	單位	公稱	材料	數量	日期	比例	圖名
ACER-B1-B01		100730	設計	11#-1000	軸	1	100730	1:10	ACER-B1-B01
		100730	校對	1001-2000	軸	1	100730		立柱(總輪型)爆炸圖
			校對	2001-3000	軸	1			亞欽股份有限公司
			校對	3001-5000	軸	1			

Drawing #: ACER-B1-B01			
Item #	Part #	Description	Quantity
1	ACER-B1-B001	Column	1
2	ACER-B1-B02	Head 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	M5x5x20	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-A019	Pulley Spacer	1
17	ACER-B1-A020	Ball Screw Pulley	1
18	ACER-B1-B05	Servo Motor Assembly	1
19	M5x0.8x8	Set Screw	2
20	M20x1.5	Precision Lock Nut	1
21	ACER-B1-E016	Timing Belt 5mx500	1
22		Control Arm Assembly	1
23	ACER-B1-001	Z Axis Upper Accordion Cover	1
24	ACER-B1-E009	Top Cover Locating Plate	1
25	ACER-B1-E012	Balancing Block Shaft Guiding Plate	1
26	ACER-B1-B08	Z Axis Travel Limit Assembly	1
27	M8x1.25x20	Socket HD Cap Screw	2
28	M8x1.25x8	Set Screw	1
29	ACER-B1-E	Roller Chain Assembly	1
30	M8x1	Oil Fitting	1
31	M6x1x6F	Flat Hd Socket Cap Screw	18
32	M6x1x12	Socket HD Cap Screw	4

12-16. 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



變更記錄		一般尺寸公差		單位		圖號		
標記	修改內容	修改日期	範圍	公差	材質	數量	比例	
△1			0.5-6	±0.05	設計	張	1:5	
△2			7-30	±0.1	繪圖	張	100.07.30	
△3			31-120	±0.15	校對	張	100.07.30	
△4			121-315	±0.2	核准			
							圖名	ACER-B1-B05
							圖號	Z軸電機爆炸圖

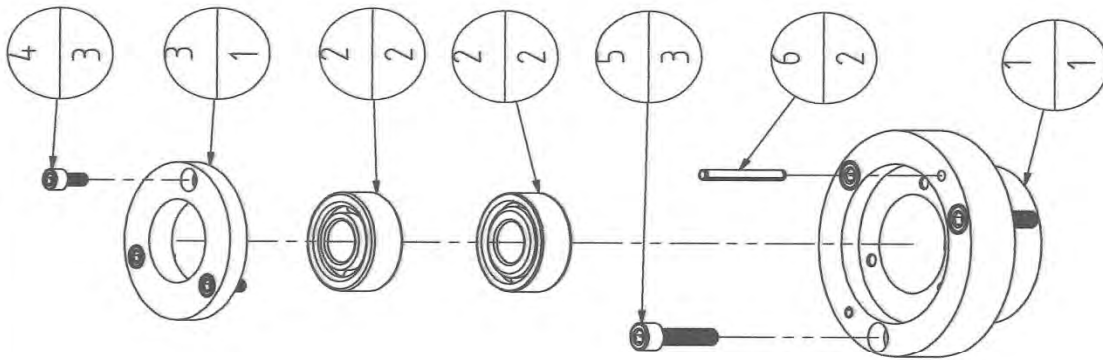
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Drawing #: ACER-B1-B05

Item #	Part #	Description	Quantity
1	ACER-B1-A022	Motor Plate	1
2	M8	Washer	4
3	M8x1.25x30	Socket Hd Cap Screw	4
4	ACER-B1-A023	Z Axis Servo Motor	1
5	ACER-B1-A024	Motor Pulley	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

12-17. 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



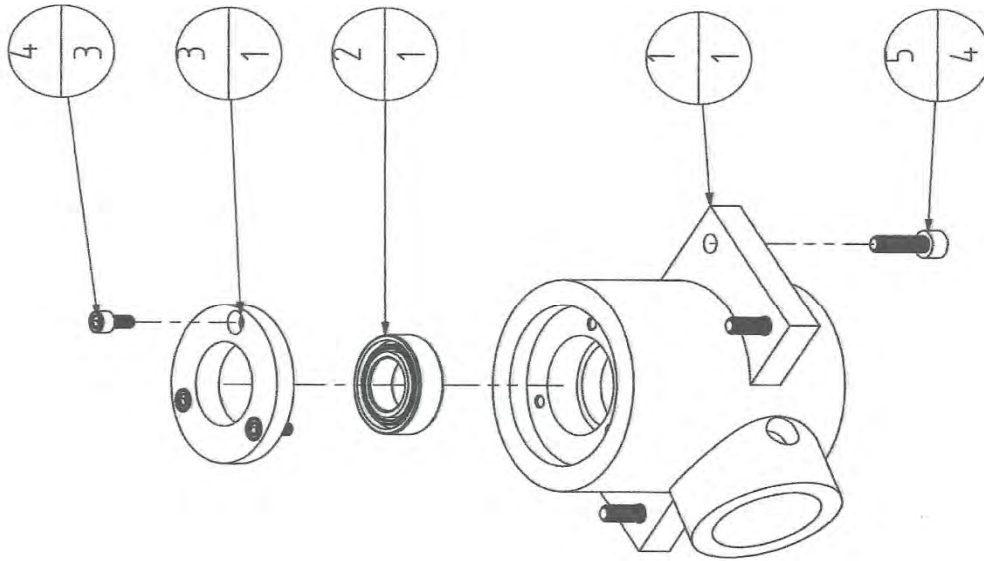
變更內容	日期	修改者	錄	一般尺寸公差		單位	mm	數量	I/台	日期	比例	圖號	圖名
				範圍	公差								
標記				0.5-6	±0.05	材質					1:2	ACER-B1-B03	Z軸上軸承座爆炸圖
△				7-30	±0.1	設計	張政龍	100.07.30			投		
△				31-120	±0.15	繪圖	張政龍	100.07.30			影		
△				121-315	±0.2	校對							
△				3001-6000	±1	核准							

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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

12-18. 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



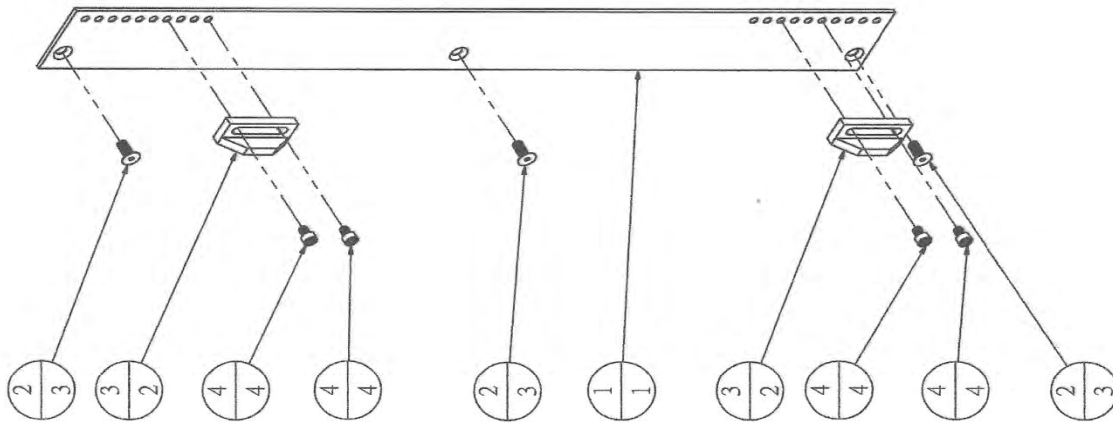
變更	標記	內容	修改者	日期	錄		一般		尺寸		公差	單位	mm	數量	I/台	日期	比例	圖號	圖名
					範圍	公差	範圍	公差	範圍	公差									
△1					0.5-6	±0.05	316-1000	±0.3	設計	張政龍	100.07.30	1:3	ACER-B1-B04	Z軸下軸承座爆炸圖					
△2					7-30	±0.1	1001-2000	±0.5	繪圖	張政龍	100.07.30	1:3							
△3					31-120	±0.15	2001-3000	±0.8	校對										
△4					121-315	±0.2	3001-6000	±1	核准										

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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

12-19.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



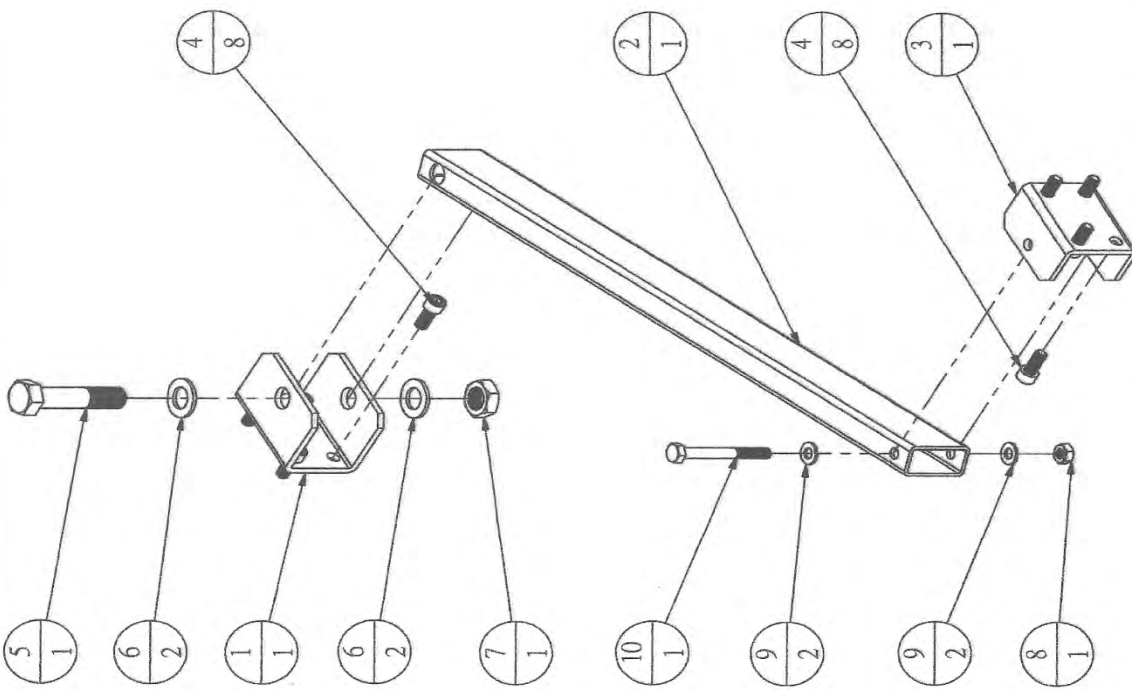
變更	標記	日期	修改者	一般	尺寸	公差	單位	數量	日期	比例	圖號	圖名
標記	△			0.5-6	±0.05	mm	mm	100.07.30	100.07.30	1:3	ACER-B1-B08	Z軸行程定位塊固定板
修	△			7-30	±0.1		張政龍	100.07.30	100.07.30			爆炸圖
改	△			31-120	±0.15		張政龍					
	△			121-315	±0.2		張政龍					

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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

12-20. ACER-B1-F01 CONTROL ARM ASSEMBLY

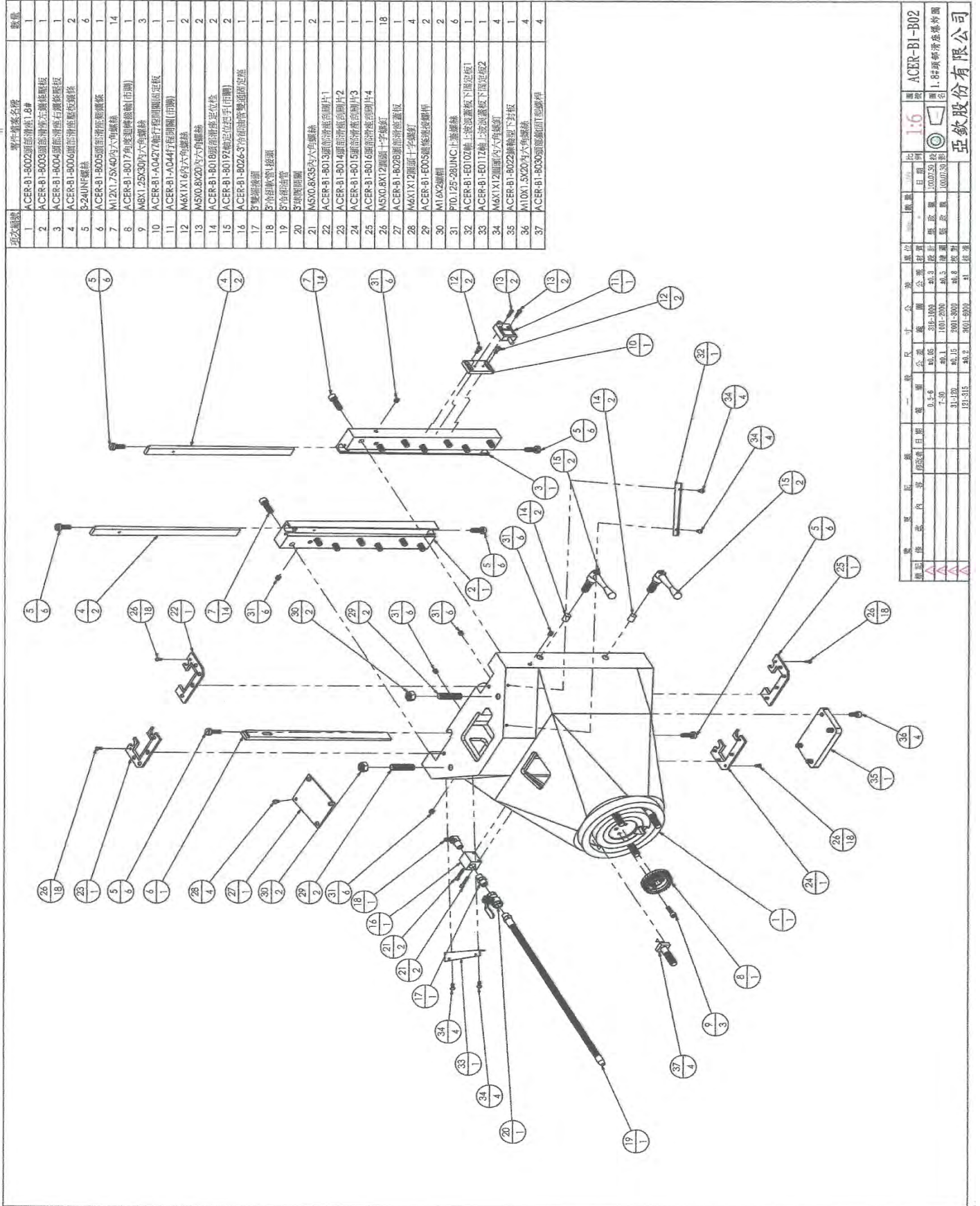
項次編號	零件權案名稱	數量
1	ACER-B1-F001吊臂固定板	1
2	ACER-B1-F002吊臂	1
3	ACER-B1-F003控制器固定板	1
4	M10X15X25內六角螺絲	8
5	M20X2.5X90外六角螺絲	1
6	M20平墊圈	2
7	M20X2.5螺帽	1
8	M10X1.5螺帽	1
9	M10平墊圈	2
10	M10X15X90外六角螺絲	1



圖號	圖名	比例	1/台	mm	數量	單位	公差	尺寸範圍	一般公差	日期	錄	變更內容	變更記錄				
													日期	修改者	日期	修改者	日期
ACER-B1-F01	吊臂爆炸圖	1:2		張	1	設計	±0.3	316-1000	±0.05	100.07.30							
				張	1	繪圖	±0.5	1001-2000	±0.1	100.07.30							
				張	1	校對	±0.8	2001-3000	±0.15								
						核准	±1	3001-6000	±0.2								

Drawing #: ACER-B1-F01			
Item #	Part #	Description	Quantity
1	ACER-B1-F001	Column Arm Bracket	1
2	ACER-B1-F002	Control Arm	1
3	ACER-B1-F003	Control Box Bracket	1
4	3/8"x3/4"	Socket HD Round Cap Screw	4
5	3/4"x3.5"UNF	Hex HD Cap Screw	1
6	M20	Washer	1
7	3/4"	Hex Nut	1
8	3/8"	Hex Nut	1
9	M10	Washer	2
10	3/8"x3.5"UNF	Hex HD Cap Screw	1

12-21. ACER-B1-B02 HEAD HOUSING ASSEMBLY



現貨編號	零件編號名稱	數量
1	ACER-B1-B002副面滑座1.8#	1
2	ACER-B1-B003副面滑座右蓋螺絲板	1
3	ACER-B1-B004副面滑座右蓋螺絲板	1
4	ACER-B1-B006副面滑座螺絲板接線	2
5	3-24UNF螺絲	6
6	ACER-B1-B005副面滑座螺絲板	1
7	M12X1.75X40內六角螺絲	14
8	ACER-B1-B017角感測磁鐵組(頂側)	1
9	M8X1.25X30內六角螺絲	3
10	ACER-B1-A0472軸子滑座副面固定板	1
11	ACER-B1-A044打有開關(頂側)	1
12	M6X1.6內六角螺絲	2
13	M5X0.8X20內六角螺絲	2
14	ACER-B1-B018副面滑座定位片	2
15	ACER-B1-B019Z軸定位片(頂側)	2
16	ACER-B1-B026-3常閉油壓電阻固定座	1
17	Z軸螺絲鎖	1
18	Z軸螺絲管 接頭	1
19	30角徑組管	1
20	3球閥開關	1
21	M5X0.8X35內六角螺絲	1
22	ACER-B1-B013副面滑座副面片1	2
23	ACER-B1-B014副面滑座副面片2	1
24	ACER-B1-B015副面滑座副面片3	1
25	ACER-B1-B016副面滑座副面片4	1
26	M5X0.8X12圓頭十字螺絲	18
27	ACER-B1-B028副面滑座蓋板	1
28	M6X1.2圓頭十字螺絲	4
29	ACER-B1-E005螺絲固定螺絲	2
30	M1.6X2螺絲	2
31	FD.125-28UNC上蓋螺絲	6
32	ACER-B1-E010Z軸上蓋蓋板下固定板1	1
33	ACER-B1-E011Z軸上蓋蓋板下固定板2	1
34	M6X1.2圓頭六角螺絲	4
35	ACER-B1-B022螺絲亞下字板	1
36	M10X1.5X20內六角螺絲	4
37	ACER-B1-B030副面磁鐵組(頂側)螺絲	4

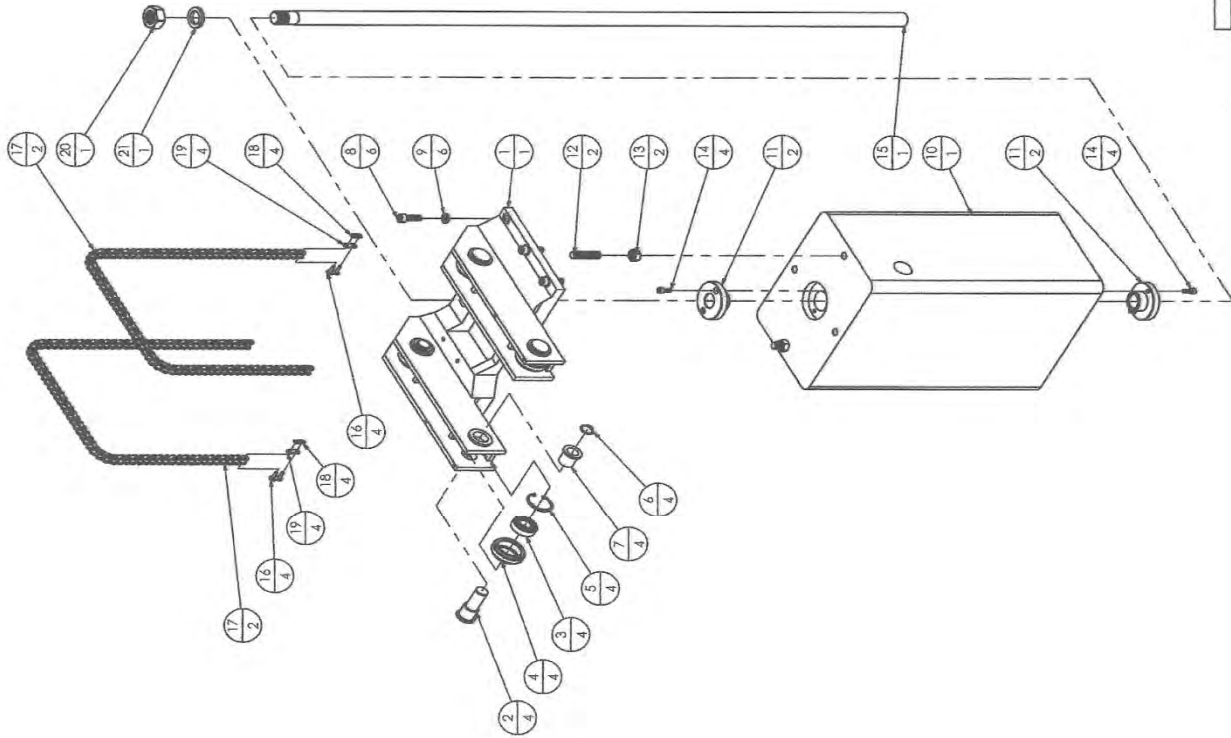
圖號	圖名	比例	日期	圖號	圖名	比例	日期
1:6	ACER-B1-B02	1:6		1:6	ACER-B1-B02	1:6	

Drawing #: ACER-B1-B02			
Item #	Part #	Description	Quantity
1	ACER-B1-B002	Head Housing	1
2	ACER-B1-B003	Gib Plate-left	1
3	ACER-B1-B004	Gib Plate-right	1
4	ACER-B1-B006	Gib	2
5	3-24UNF	Gib Screw (3028)	6
6	ACER-B1-B005	Gib	1
7	M12x1.75x40	Socket Hd Cap Screw	14
8	ACER-B1-B017	Quill Housing ADJ Gear (5033)	1
9	M8x1.25x30	Socket Hd Cap Screw	3
10	ACER-B1-B042	X, Y Limit Switch Locating Plate	1
11	ACER-B1-B044	Limit Switch	1
12	M6x1x16	Socket Hd Cap Screw	2
13	M5x0.8x20	Socket Hd Cap Screw	2
14	ACER-B1-B018	Head Housing Plunger	2
15	ACER-B1-B019	Housing Lock Assembly	2
16	ACER-B1-B026	Coolant Nozzle Locating Block	1
17		Double-end Threaded Pipe Fitting	1
18		Single-end Thread Coolant Fitting	1
19	30"	Coolant Nozzle	1
20	1/2"	Ball Valve Assembly	1
21	M5x0.8x35	Socket Hd Cap Screw	2
22	ACER-B1-B013	Way Wiper-Right Top	1
23	ACER-B1-B014	Way Wiper-Left Top	1
24	ACER-B1-B015	Way Wiper-Left Bottom	1
25	ACER-B1-B016	Way Wiper-Right Bottom	1
26	M5x0.8x12R	Round HD Cap + Screw	18
27	ACER-B1-B028	Cover Plate	1
28	M6x1x12R	Round HD Cap + Screw	4
29	ACER-B1-E005	Chain Connecting Screw	2
30	M16x2	Hex Nut	4
31	PTO125'-28UNC	Set End Screw	6
32	ACER-B1-E010	Way Cover Locating Plate-right	1
33	ACER-B1-E011	Way Cover Locating Plate-left	1
34	M6x1x12R	Socket HD Round Cap Screw	4

35	ACER-B1-B022	Lower Housing Cover	1
36	M10x1.5x20R	Socket HD Round Cap Screw	4
37	ACER-B1-B030	T Bolt (5K-5036)	4

12-22. ACER-B1-E ROLLER CHAIN ASSEMBLY

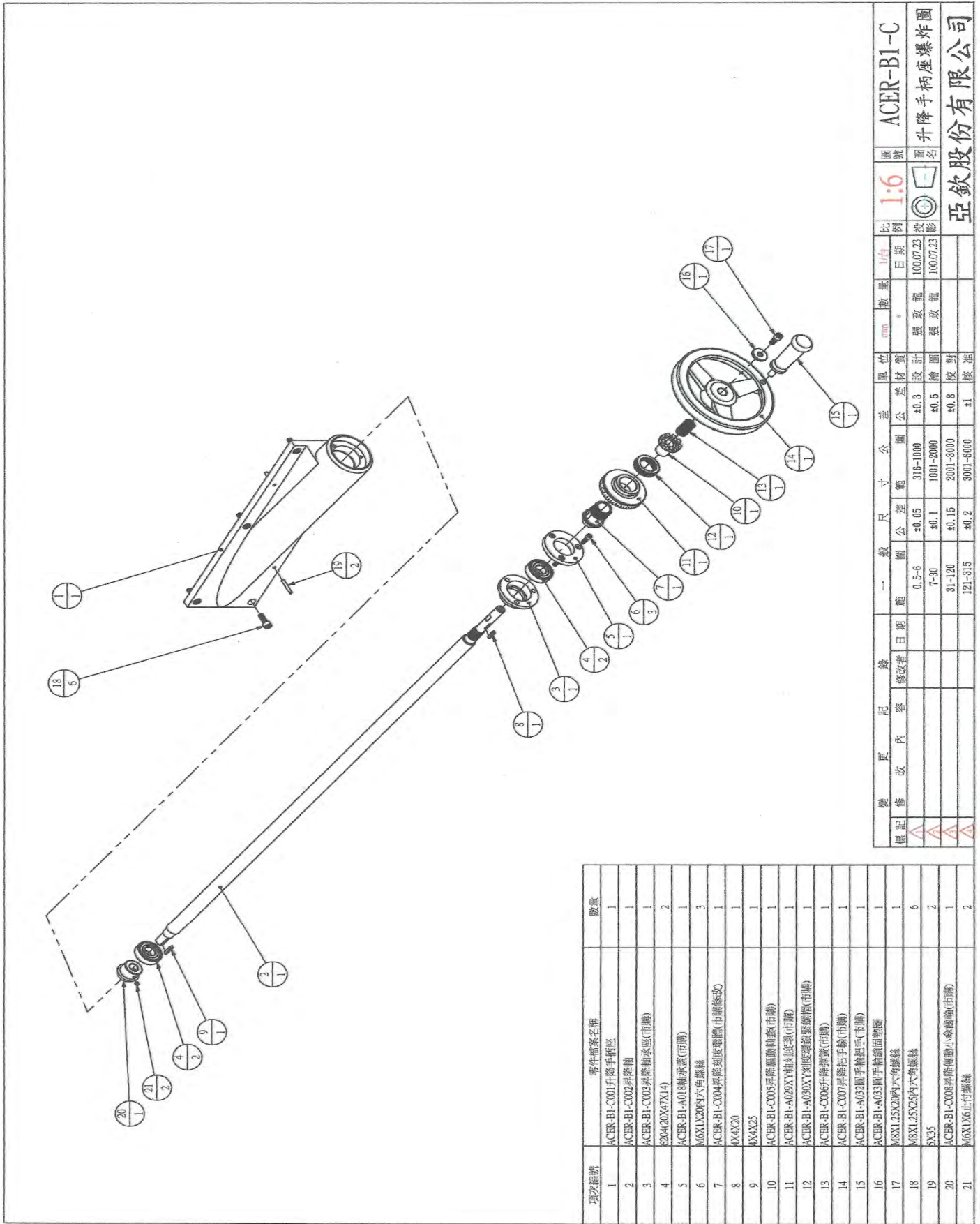
項次編號	零件描述名稱	數量
1	ACER-B1-E001鍍輪座	1
2	ACER-B1-E003鍍輪軸	4
3	620S(25X52X15)	4
4	ACER-B1-E002鍍輪	4
5	R32孔用C型打環	4
6	S2S軸用C型打環	4
7	ACER-B1-E004鍍輪軸套	4
8	M12X1.75X40內六角螺絲	6
9	M12彈簧墊圈	6
10	ACER-B1-E006配重塊	1
11	ACER-B1-E007配重塊專套	2
12	ACER-B1-E005鏈條連接螺桿	2
13	M16X2螺帽	2
14	M8X1.25X20內六角螺絲	4
15	ACER-B1-E008配重塊專料	1
16	15.875鏈條連接銷	4
17	5/8鏈條80節	2
18	15.875鏈條連接銷打板	4
19	15.875銷鏈板	4
20	M30X2螺帽	1
21	M30彈簧墊圈	1



圖號	ACER-B1-E
圖名	鏈輪座爆炸圖
比例	1:1
日期	103.07.05
繪圖	廖家龍
校核	廖家龍
審核	廖家龍
繪圖	廖家龍
校核	廖家龍
審核	廖家龍
繪圖	廖家龍
校核	廖家龍
審核	廖家龍
繪圖	廖家龍
校核	廖家龍
審核	廖家龍

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

12-23. ACER-B1-C ELEVATION CRANK ASSEMBLY



項次編號	零件編號名稱	數量
1	ACER-B1-C001升降手柄座	1
2	ACER-B1-C002升降軸	1
3	ACER-B1-C003升降軸承壓(市購)	1
4	5204(20X47X14)	2
5	ACER-B1-A018軸承蓋(市購)	1
6	M6X12內六角螺絲	3
7	ACER-B1-C004升降軸固定環(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輪軸套(市購)	1
12	ACER-B1-A030XY刻度環螺絲帽(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圓手柄扣手(市購)	1
16	ACER-B1-A033圓手柄鎖固墊圈	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升降輔助小傘齒輪(市購)	1
21	M6X16正付螺絲	2

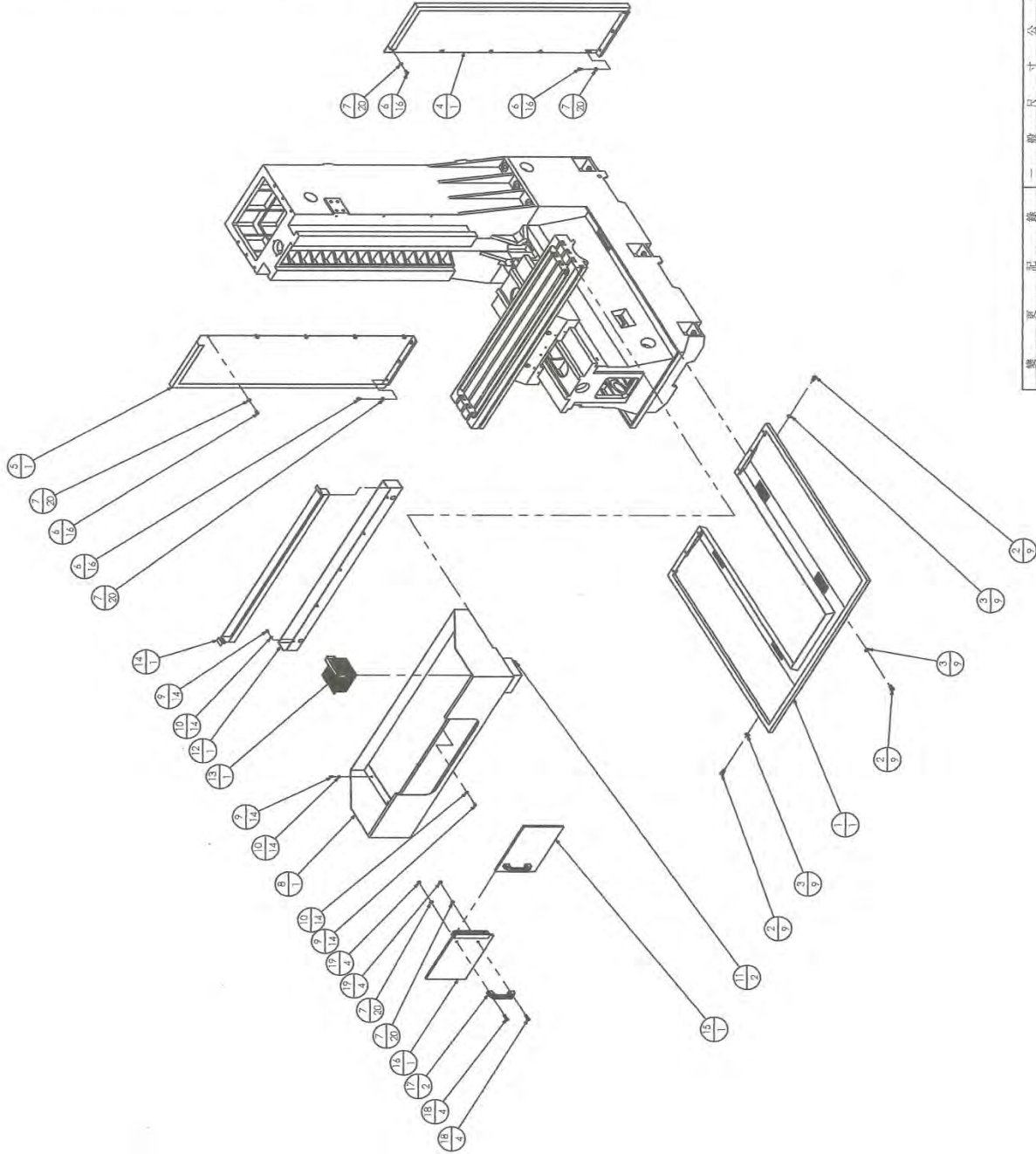
變更紀錄			公差			單位			圖號		
標記	修改內容	修改者	日期	公差	範圍	單位	材料	公差	圖號	圖名	圖號
△				0.5-6	0.5-6	mm	設計	±0.3	100.07.23	升降手柄座爆炸圖	ACER-B1-C
△				7-30	1001-2000	mm	繪圖	±0.5	100.07.23		
△				31-315	2001-3000	mm	校對	±0.8			
△				121-315	3001-5000	mm	核准	±1			

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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

12-24. ACER-B1 SHOWN WITH OPTIONAL ACCESSORIES

項次編號	零件檔案名稱	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圓頭內六角螺絲	16
7	M8平墊圈	20
8	ACER-B1-010工作台面水罩	1
9	M6X1X12圓頭內六角螺絲	14
10	M6平墊圈	14
11	ACER-B1-015-4分軟管伴接頭	2
12	ACER-B1-011工作台面接水槽	1
13	ACER-B1-016工作台面水罩槽	1
14	ACER-B1-017工作台面接水槽護槽	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螺絲	4



圖號	變更	說明	日期	圖號	變更	說明	日期
	1	新增	1/15	ACER-B1			
圖號		變更	說明	圖號		變更	說明
1	0.5-B	316-1000	100.07.30	1	0.5-B	316-1000	100.07.30
2	7-30	40.1	100.07.30	2	7-30	40.1	100.07.30
3	31-120	40.15	2001-30.00	3	31-120	40.15	2001-30.00
4	121-315	40.2	3001-30.00	4	121-315	40.2	3001-30.00

圖號: ACER-B1
圖名: 外板金爆炸圖
圖號: 1:15
圖名: 亞欽股份有限公司

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	Table Splash Guard	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	Splash Guard Door-Right	1
16	ACER-B1-013	Splash Guard Door-Left	1
17	ACER-B1-014	Door Handle	2
18	M8x1.25x30	Socket HD Cap Screw	4
19	M8x1.25	Hex Nut	4