

Mechanical Parts List

To order parts, please have the following information ready:

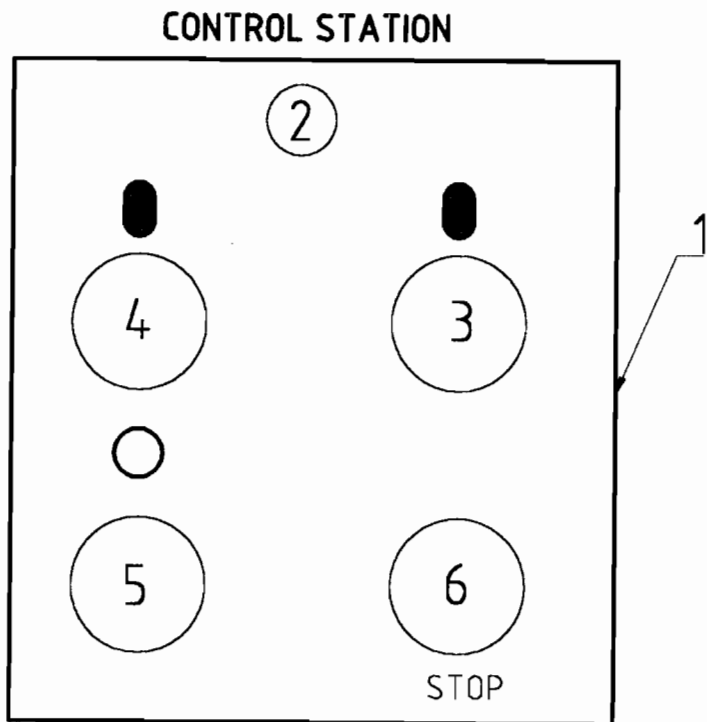
- 1. Year of production**
- 2. Model and serial number**
- 3. Item number and description**
- 4. Quantity**

11. FUNCTIONS OF OPERATION SWITCH

Supra 618II Control Panel and Its Parts List

Description table in motors:

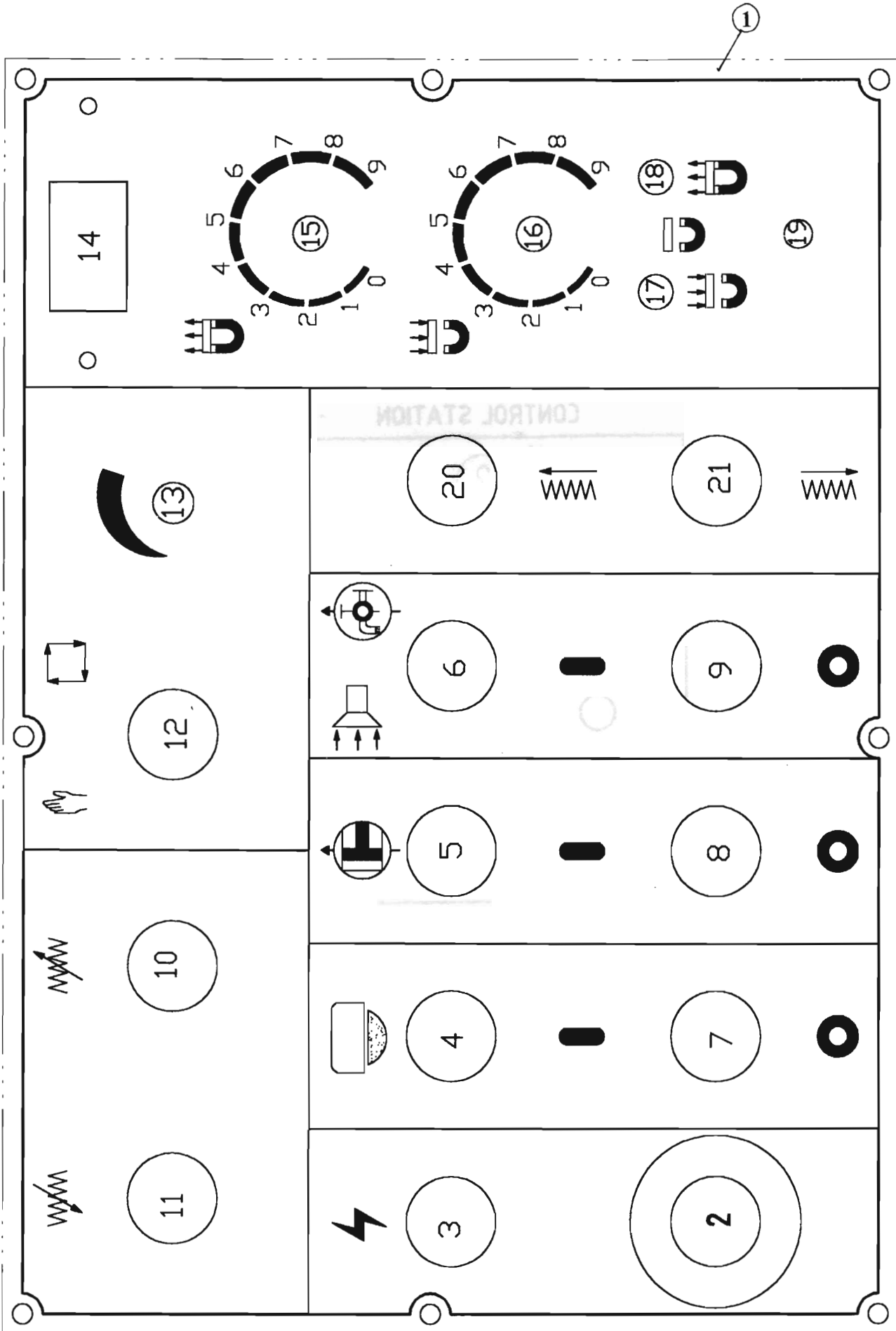
1. 1MTR – Spindle (Wheel head) motor: 2.2KW, 3-phase, AC motor.
2. 3MTR – Coolant pump motor: 0.2KW , 3-phase, AC motor.
3. 3MTR – Vacuum/Dust - exhaust motor: 0.4KW , 3-phase, AC motor.
4. 8MTR – Lubrication motor: 10W , 1-phase, 110VAC motor.



Control station:

No.	Description	Parts NO.	Type reference	Supplier
1.	Control station panel	GPE-618-E-001	Acer-618 panel	ACER
2.	Power On indicator	GPE-618-E-002	TPN-127R	Tend
3.	Spindle On	GPE-618-E-003	MK/ABLFC-22G/24V	Mark
4.	Coolant/Dust. On	GPE-618-E-004	MK/ABLFC-22G/24V	Mark
5.	Stop	GPE-618-E-005	MK/ABFP-22R	Mark
6.	Emergency Stop	GPE-618-E-006	AE-22 (Lock)	Mark

Supra 618AHIII Control Panel and Its Parts List



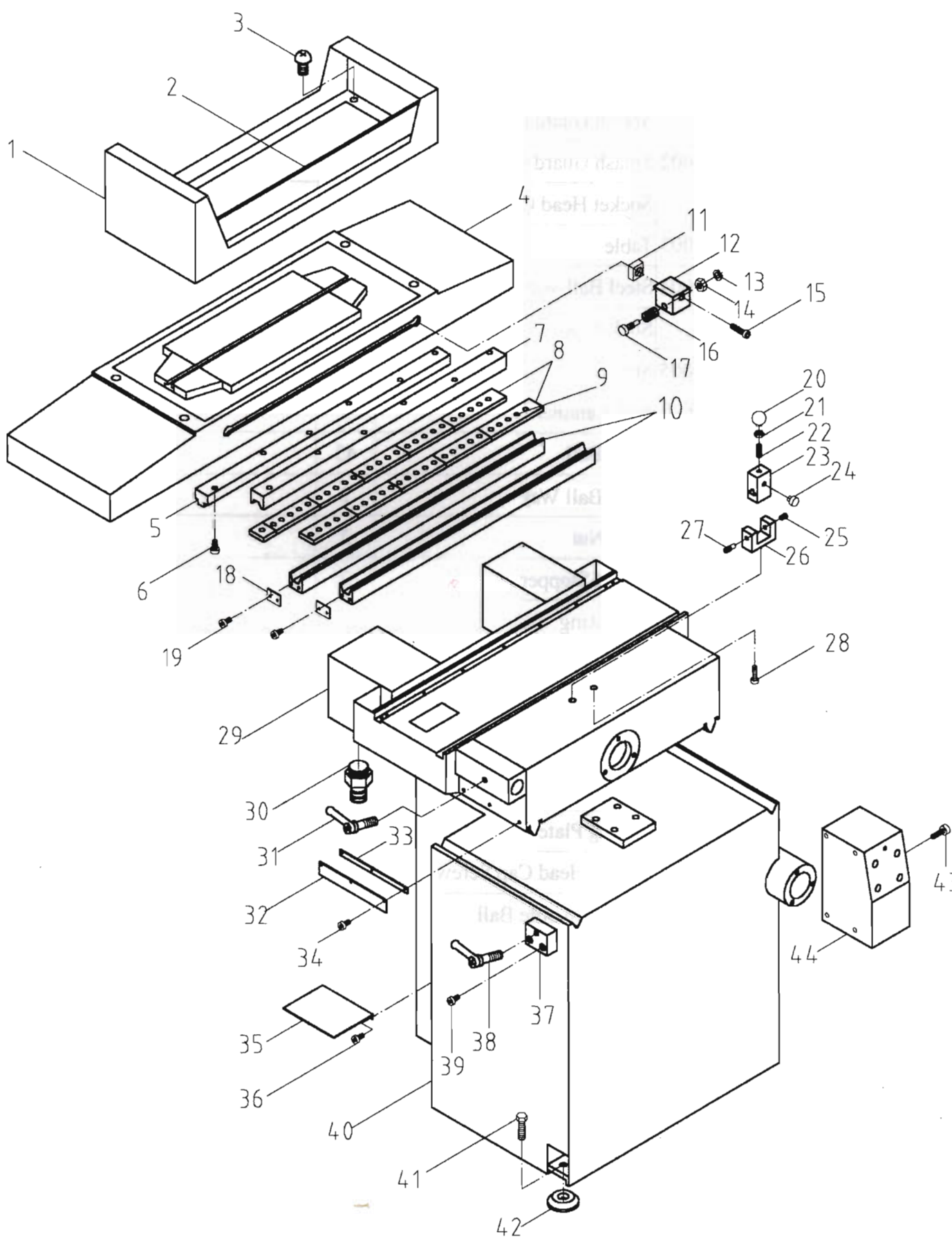
DESCRIPTION OF CONTROL PANEL FOR 618AHII

Item #	Description	Parts Number	Name on Circuit
1.	Control Panel Plate	GPE618AH-001	
2.	Emergency Push Button	GPE618AH-002	PB1
3.	Power on Button with Light	GPE618AH-003	PB2
4.	Spindle on Button	GPE618AH-004	PB3
5.	Hydraulic on Button	GPE618AH-004	PB5
6.	Coolant/Dust on Button	GPE618AH-004	PB7
7.	Spindle off Button	GPE618AH-007	PB4
8.	Hydraulic off Button	GPE618AH-007	PB6
9.	Coolant/Dust off Button	GPE618AH-007	PB8
10.	Crossfeed Inward	GPE618AH-004	PB11
11.	Crossfeed Outward	GPE618AH-004	PB12
12.	Rapid/Step Selector	GPE618AH-012	SS1
13.	Step Adjustment VR	GPE618AH-013	POT1
13-1.	Step Adjustment Knob	GPE618AH-013K	
14.	LED Display(Opt)	GPE618AH-014	DVM1
15.	Demagnetizer Timer(Opt)	GPE618AH-015	DEMAG.
16.	Magnetizer VR(Opt)	GPE618AH-015	MAG.
17.	Demag. Indicator Light(Opt)	GPE618AH-017	
18.	Mag. Indicator Light(Opt)	GPE618AH-018	
19.	Mag./Demag. Selector(Opt)	GPE618AH-019	
20.	Power up Button (Opt.)	GPE618AH-020	
21.	Power down Button(Opt.)	GPE618AH-020	
22.	Chuck Controller (Opt.)	GPE-CMR5G	

ELECTRIC PARTS OF CONTROL PANEL FOR 618AHIII

Item #	Description	Type Reference	Supplier
1.	Control Panel Plate	ACER 618AH Panel	ACER
2.	Emergency Push Button	MK/AE-22 (Lock)	Mark
3.	Power on Button with Light	MK/ABLFC-22W/24V	Mark
4.	Spindle on Button	MK/ABLFC-22G/24V	Mark
5.	Hydraulic on Button	MK/ABLFC-22G/24V	Mark
6.	Coolant/Dust on Button	MK/ABLFC-22G/24V	Mark
7.	Spindle off Button	MK/ABFP-22R	Mark
8.	Hydraulic off Button	MK/ABFP-22R	Mark
9.	Coolant/Dust off Button	MK/ABFP-22R	Mark
10.	Crossfeed Inward	MK/ABLFC-22G/24V	Mark
11.	Crossfeed Outward	MK/ABLFC-22G/24V	Mark
12.	Rapid/Step Selector	MK/AC-22B	Mark
13.	Step Adjustment VR	RV24YN 20S, B502	COSMOS
13-1	Step Adjustment Knob	#596B	Wafer
14.	LED Display(Opt)	DVM1 Card	Maytronics
15.	Demagnetizer Timer(Opt)	503B, d24	
16.	Magnetizer VR(Opt)	503B, d24	
17.	Demag. Indicator Light(Opt)	Red, d8	
18.	Mag. Indicator Light(Opt)	Green, d8	
19.	Mag./Demag. Selector(Opt)	3B, d7	Alpus
20.	Power up Button(Opt.)	MK/ABLFC-22B/24V	Mark
21.	Power down Button(Opt.)	MK/ABLFC-22B/24V	Mark
22.	Chuck Controller(Opt)	CMR-5G	Maytronics

TABLE, SADDLE, BASE ASS'Y



TABLE, SADDLE AND BASE ASS'Y

(618-01)

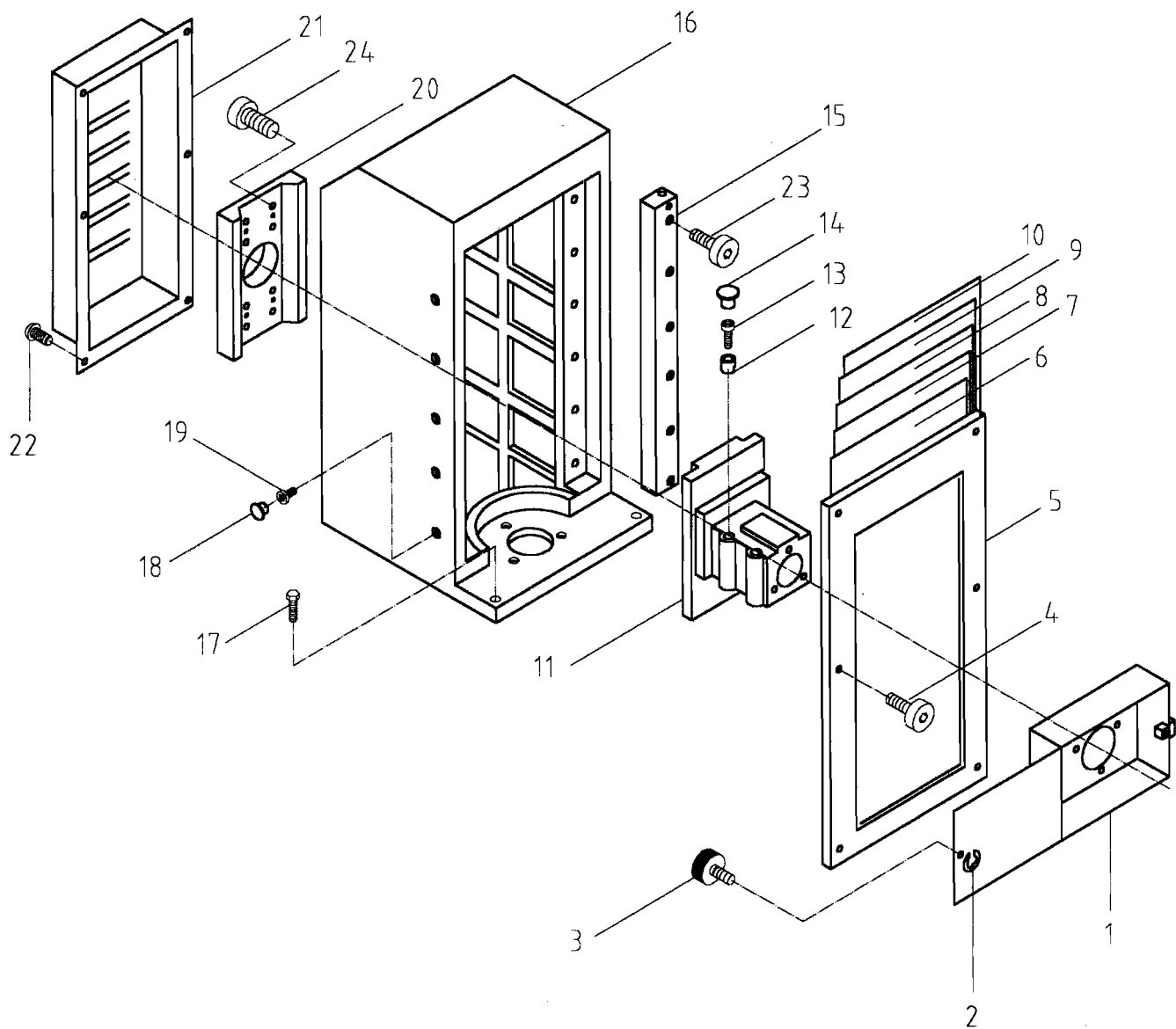
Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-01-001	Splash Guard (Frame)	1	
2	618-01-002	Splash Guard (Plate)	3	
3		Socket Head Cap Screw	4	M6*10L
4	618-01-003	Table	1	
5	618-01-004	Steel Ball Way	1	
6		Socket Head Cap Screw	12	M6*25L
7	618-01-005	Steel Ball Way	1	
8	618-01-006	Ball Retainer	9	
9	618-01-017	Steel Ball	43	
10	618-01-007	Steel Ball Way	2	
11		Hex. Nut	2	
12	618-01-020	Travel Stopper	2	
13		Snap Ring	2	$\phi 6$
14		Hex. Nut	2	M8
15		Socket Head Cap Screw	2	M8*30L
16	618-01-018	Spring	2	
17	618-01-019	Stopper Screw	2	
18	618-01-009	Setting Plate	4	
19		Socket Head Cap Screw	8	M5*10L
20	618-01-021	Black Bakelite Ball	1	
21		Hex Nut	1	M6
22		Set Screw	1	M6*20L
23	618-01-022	Table Bracket Base	1	
24	618-01-023	Rubber Spacer	1	
25		Set Screw	1	M8*20L
26	618-01-024	Table Bracket Base	1	

TABLE, SADDLE AND BASE ASS'Y

(618-01)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
27	618-01-025	Round End Screw	1	
28		Socket Head Cap Screw	2	M6*20L
29	618-01-010	Saddle	1	
30	618-01-026	Coolant Hose Connector	1	
31	618-01-011	Handle (ADJUSTABLE)	1	
32	618-01-027	Crossfeed Stopping Plate	1	
33	618-01-028	Stopping Plate Spacer	1	
34		Socket Head Cap Screw	3	M5*16L
35	618-01-029	Lube Pump Cover Plate	1	
36		Socket Head Cap Screw	2	M5*8L
37	618-01-030	Crossfeed Locking Base	1	
38	618-01-011	Handle (Adjustable)	1	
39		Socket Head Cap Screw	2	M5*35L
40	618-01-013	Base	1	
41	618-01-014	Leveling Screw	3	
42	618-01-015	Leveling Block	3	M8*16
43		Socket Head Cap Screw	4	
44	618-01-031	Electrical Cabinet	1	M6*20L

COLUMN ASS'Y

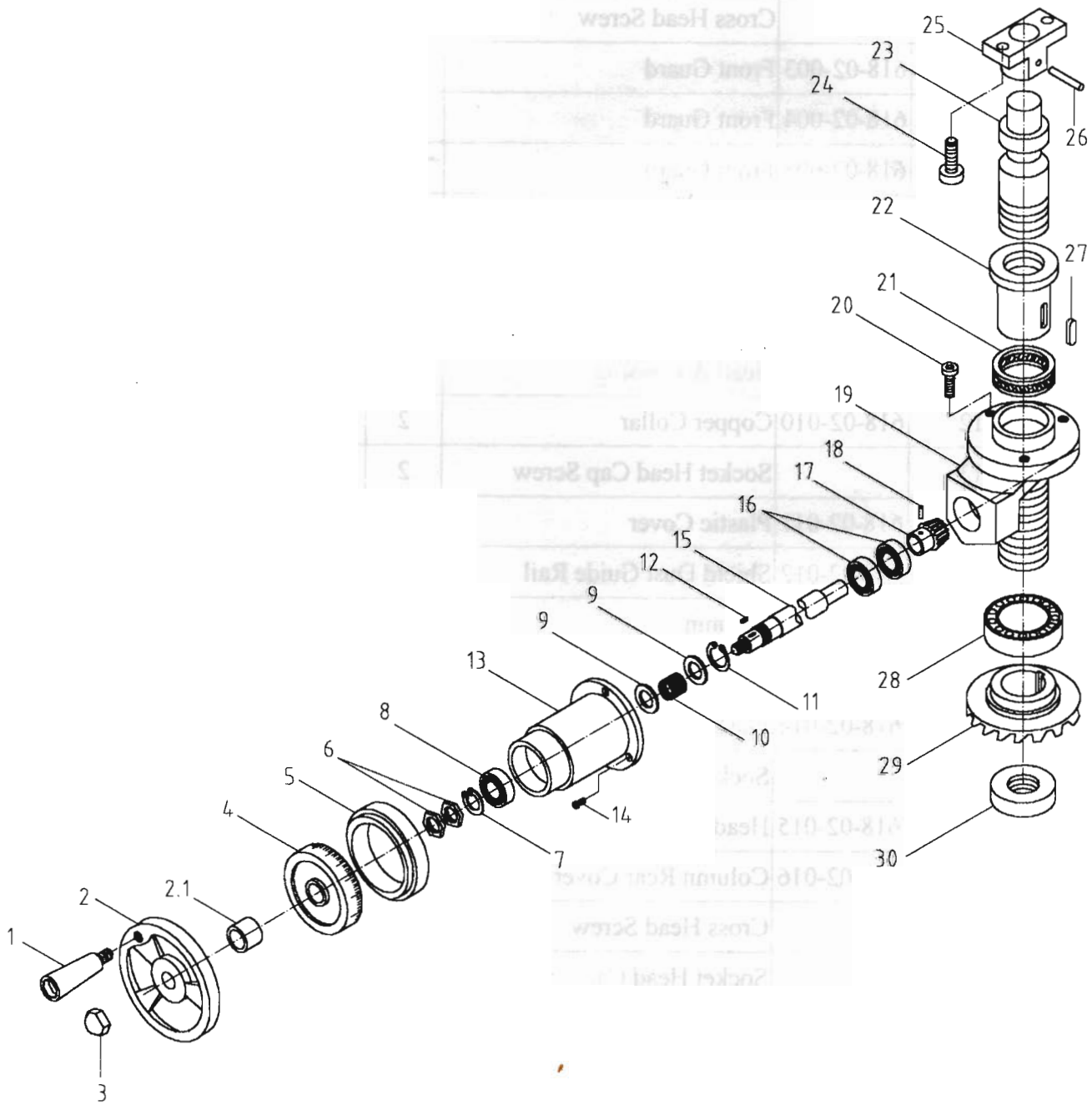


COLUMN ASS'Y

(618-02)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-02-001	Wheel Guard	1	
2		E-Snap Ring	1	$\phi 8$
3	618-02-002	Lock Screw	1	
4		Cross Head Screw	6	M5*10L
5	618-02-003	Front Guard	1	
6	618-02-004	Front Guard	1	
7	618-02-005	Front Guard	1	
8	618-02-006	Front Guard	1	
9	618-02-007	Front Guard	1	
10	618-02-008	Front Guard	1	
11	618-02-009	Head A Housing	1	
12	618-02-010	Copper Collar	2	
13		Socket Head Cap Screw	2	M10*40L
14	618-02-011	Plastic Cover	2	
15	618-02-012	Shield Dust Guide Rail	2	
16	618-02-013	Column	1	
17		Hexagonal Head Screw	3	3/4"*65L
18	618-02-014	Plastic Cover	12	
19		Socket Head Cap Screw	12	M10*16L
20	618-02-015	Head B Housing	1	
21	618-02-016	Column Rear Cover	1	
22		Cross Head Screw	6	M5*8L
23		Socket Head Cap Screw		M10*30L
24		Socket Head Cap Screw		M10*40L

UPPER & LOWER TRANSMISSION ASS'Y

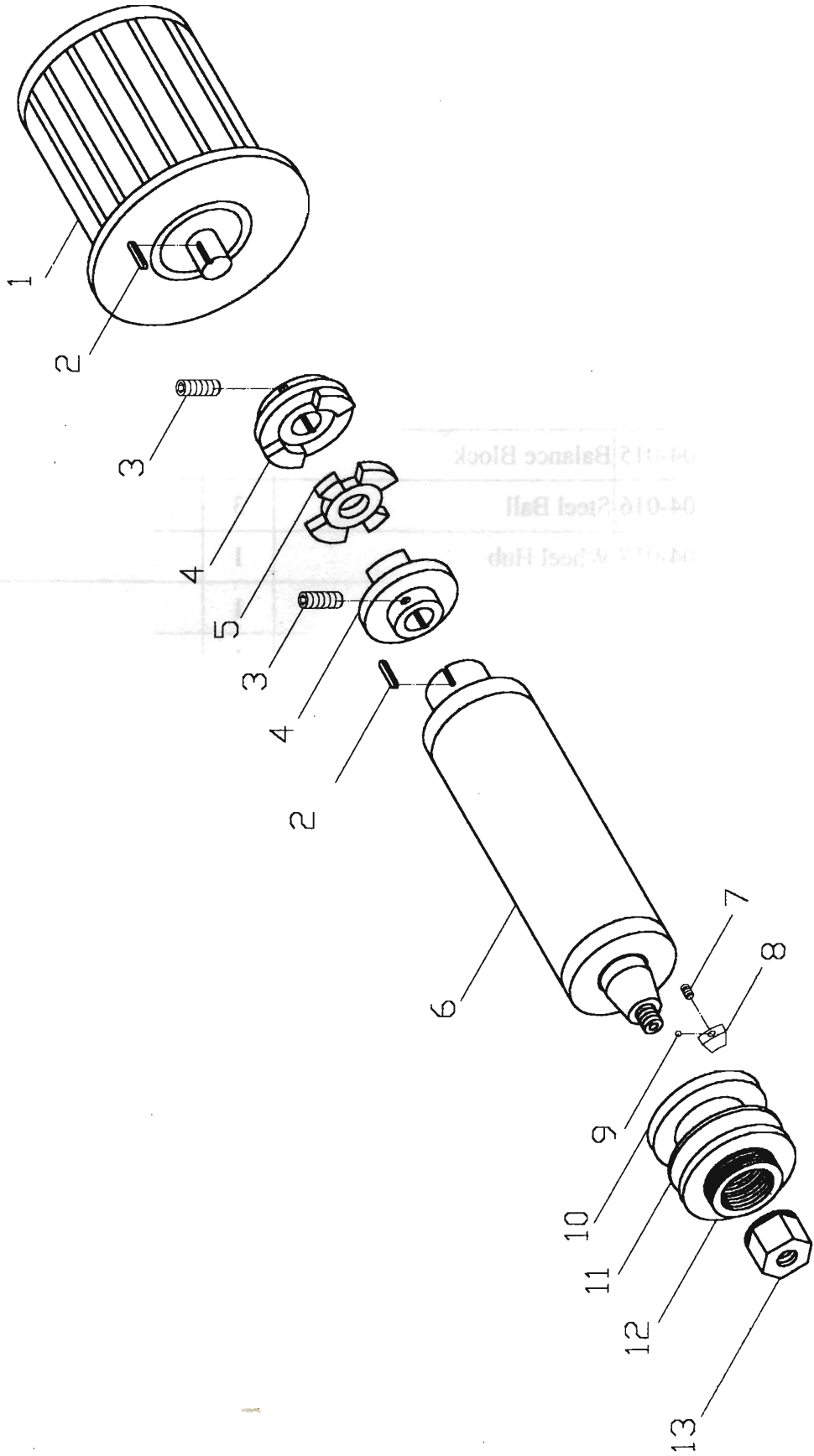


UPPER & LOWER TRANSMISSION ASS'Y

(618-03)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-03-001	Grip	1	
2	618-03-002	Handwheel	1	
2.1	618-03-016	Spacer	1	
3	618-03-003	Cap Nut	1	
4	618-03-004	Graduation Dial	1	
5	618-03-005	Graduation Dial Holder	1	
6	618-03-006	Hexagonal Nut	2	
7		Snap Ring	1	R52
8		Ball Bearing	1	1205
9		Washer	2	
10	618-03-016	Spring	1	
11	618-03-017	Snap Ring	1	
12		Key	1	5*5*20L
13	618-03-007	Bracket	1	
14		Socket Head Cap Screw	3	M8*20L
15	618-03-008	Transmission Shaft	1	
16		Ball Bearing	1	6204
17	618-03-009	Bevel Pinion	1	
18		Spring Pin	1	ϕ 6*30L
19	618-03-010	Gear Seat	1	
20		Socket Head Cap Screw	3	M12*60L
21		Ball Bearing	1	51108
22	618-03-011	Upper & Lower Lead Screw Socket	1	
23	618-03-012	Upper & Lower Lead Screw	1	
24		Socket Head Cap Screw	2	M8*16L
25	618-3-013	Connect Bracket	1	

SPINDLE ASS'Y

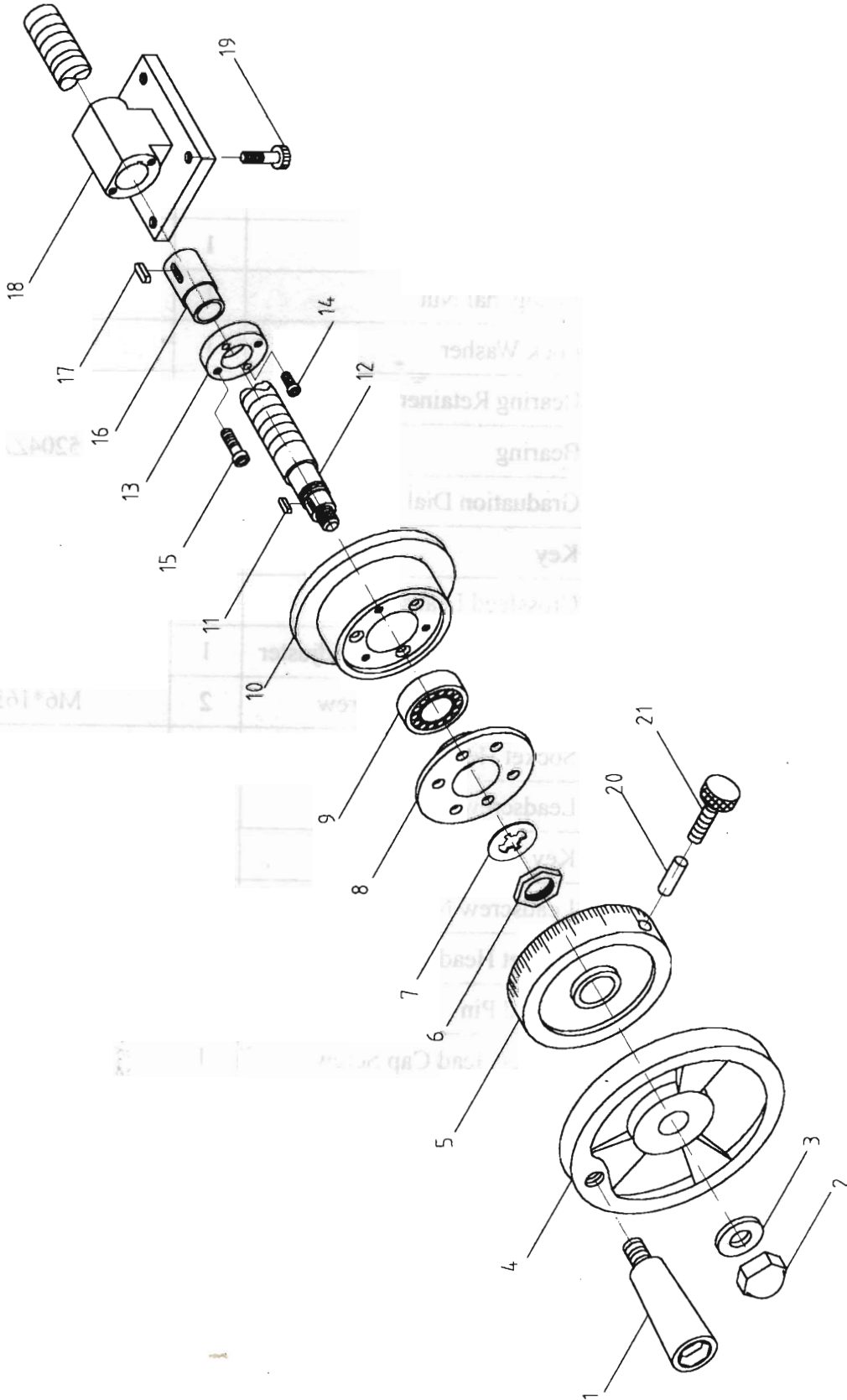


SPINDLE ASS'Y

(618-04)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-04-013	Spindle Motor	1	
2		Key	2	8*30L
3		Set Screw	2	M8*10
4	618-04-011	Coupling	2	
5	618-04-012	Rubber Coupling	1	
6	618-04-014	Spindle Assembly	1	
7		Set Screw	3	M4*5
8	618-04-015	Balance Block	3	
9	618-04-016	Steel Ball	3	$\phi 3$
10	618-04-017	Wheel Hub	1	
11	618-04-018	Washer	1	
12	618-04-019	Wheel Setting Nut	1	
13	618-04-020	Spindle Nut	1	

CROSS FEED ASS'Y



CROSS FEED ASS'Y

(618-05)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-05-001	Grip	1	
2	618-05-002	Cap Nut		
3		Washer	1	ϕ 10
4	618-05-003	Handwheel	1	
5	618-05-004	Graduation Dial	1	
6	618-05-005	Hexagonal Nut	1	
7		Lock Washer	1	
8	618-05-006	Bearing Retainer	1	
9		Bearing	1	5204ZZ
10	618-05-007	Graduation Dial Holder	1	
11		Key	1	5*5*30L
12	618-05-008	Crossfeed Leadscrew	1	
13	618-05-009	Leadscrew Backlash Adjuster	1	
14		Socket Head Cap Screw	2	M6*16L
15		Socket Head Cap Screw	2	M6*20L
16	618-05-010	Leadscrew Nut	1	
17		Key	1	5*5*20L
18	618-05-011	Leadscrew Nut Base	1	
19		Socket Head Cap Screw	4	M8*40L
20	618-05-012	Round Pin	1	ϕ 5*10L
21	618-05-013	Socket Head Cap Screw	1	
			1	

TABLE HAND FEED ASS'Y

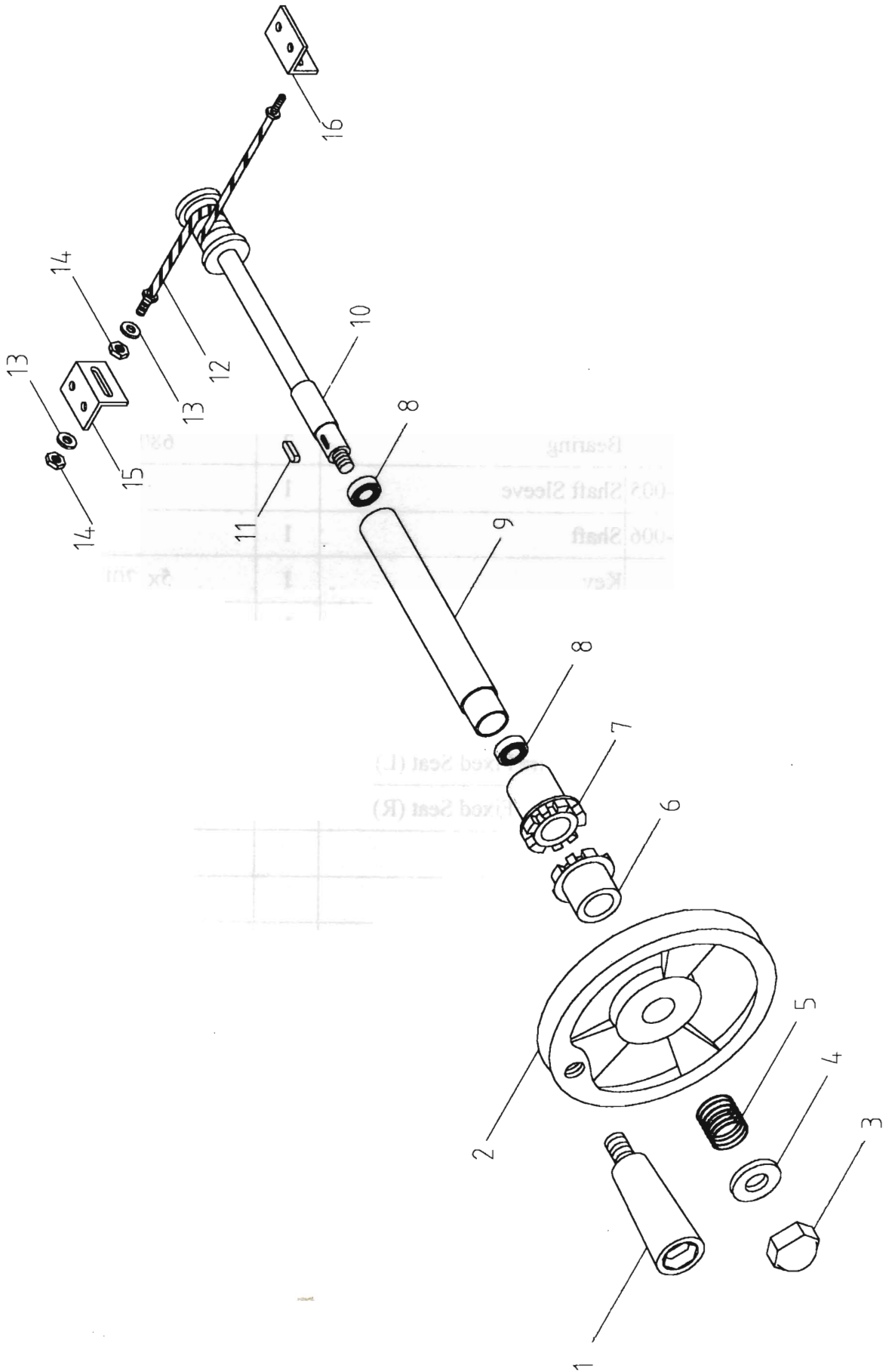
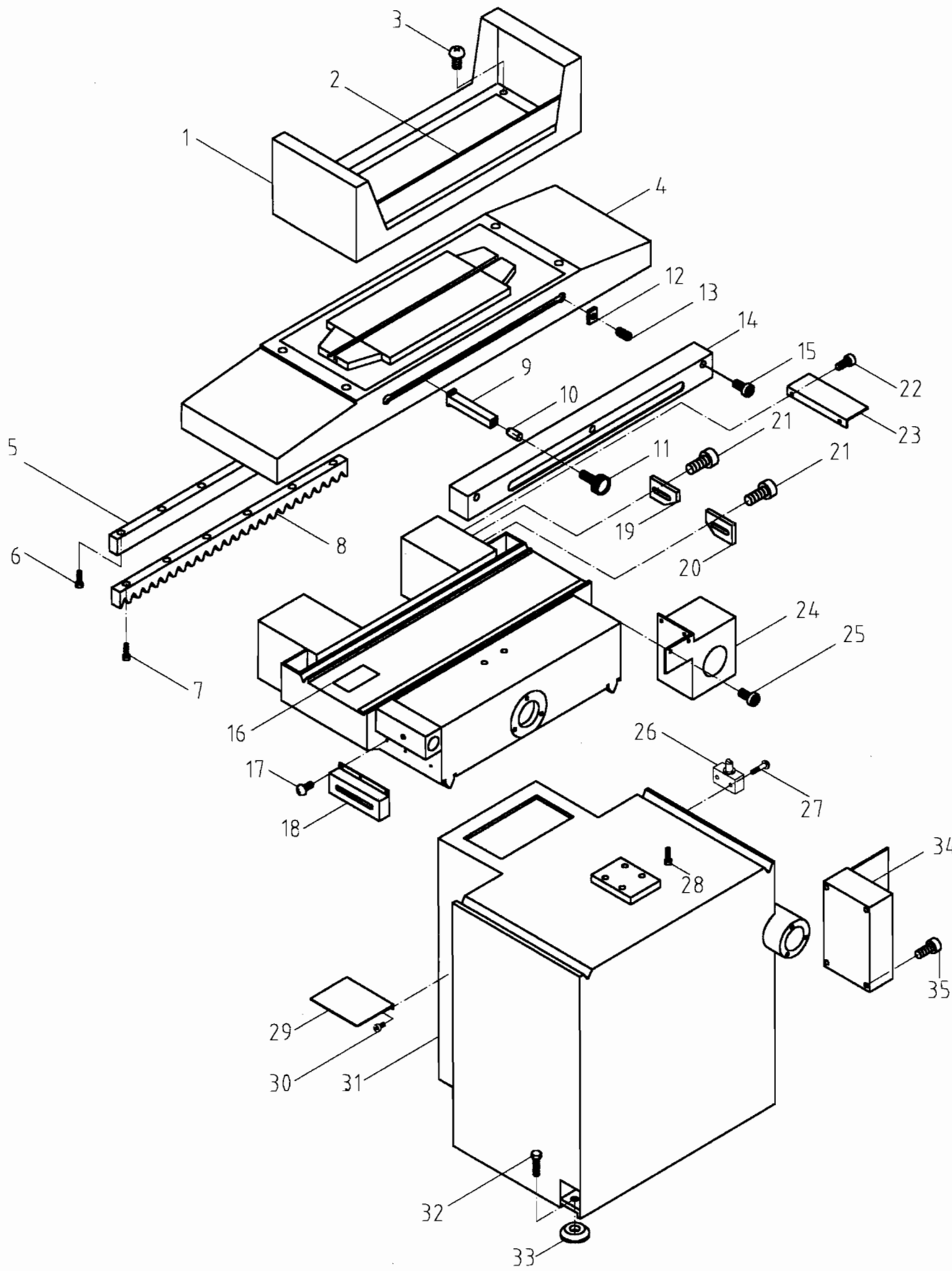


TABLE HAND FEED ASS'Y

(618-06)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-06-001	Grip	1	
2	618-06-002	Handwheel	1	
3		Cap Nut	1	M12
4		Washer	1	ϕ 12
5		Spring	1	
6	618-06-003	Gear Clutch	1	
7	618-06-004	Gear Clutch	1	
8		Bearing	2	6803ZZ
9	618-06-005	Shaft Sleeve	1	
10	618-06-006	Shaft	1	
11		Key	1	5x 20L
12	618-03-007	Steel Wire	1	
13		Washer	4	ϕ 8
14		Nut	4	M8
15	618-03-008	Steel Wire Fixed Seat (L)	1	
16	618-03-008	Steel Wire Fixed Seat (R)	1	

TABLE, SADDLE, BASE ASS'Y (FOR AH SERIES)

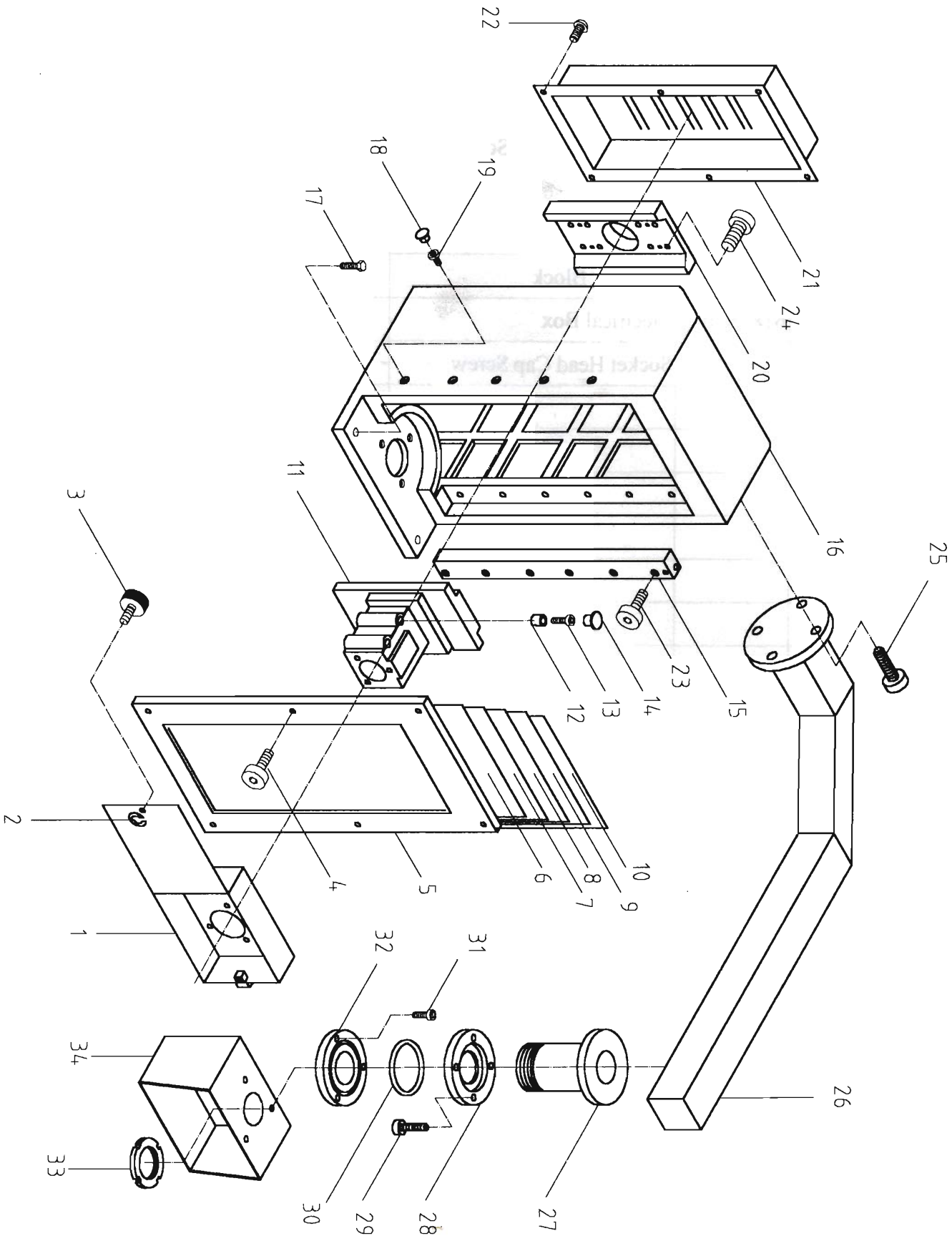


TABLE, SADDLE AND BASE ASS'Y (FOR AH SERIES

(618-01)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-01-001	Splash Guard (Frame)	1	
2	618-01-002	Splash Guard (Plate)	3	
3		Socket Head Cap Screw	4	M6*10L
4	618-01-003	Table	1	
5	618-01-032	Rack Gear Seat	1	
6		Socket Head Cap Screw	6	M6*20L
7		Socket Head Cap Screw	6	M5*10L
8	618-01-033	Rack Gear	1	
9	618-01-034	Adjusting Block	2	
10		Pin	2	ϕ 6*30L
11		Head Screw	2	M8*25L
12		Nut	2	M8
13		Headless Screw	2	M8*8L
14	618-01-035	Switch Cover	1	
15		Socket Head Cap Screw	3	M5*10L
16	618-01-010	Saddle	1	
17		Socket Head Cap Screw	3	M5*8L
18	618-01-036	Adjust Limit Switch Cover	1	
19	618-01-037	Rear Limit Block	1	
20	618-01-038	Front Limit Block	1	
21		Socket Head Cap Screw	2	M6*20L
22		Socket Head Cap Screw	2	M5*8L
23	618-01-039	Limit Switch Cover	1	
24	618-01-040	Throttling Valve Seat	1	
25		Socket Head Cap Screw	2	M8*16L
26	618-01-041	Limit Switch	1	
27		Cross Head Cap Screw	2	M4*30L
28		Socket Head Cap Screw	4	M10*50L

COLUMN ASS'Y (FOR AH SERIES)



COLUMN ASS'Y (FOR AH SERIES)

(618-02)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-02-001	Wheel Guard	1	
2		E-Snap Ring	1	
3	618-02-002	Lock Screw	1	
4		Cross Head Screw	6	M5*10L
5	618-02-003	Front Guard	1	
6	618-02-004	Front Guard	1	
7	618-02-005	Front Guard	1	
8	618-02-006	Front Guard	1	
9	618-02-007	Front Guard	1	
10	618-02-008	Front Guard	1	
11	618-02-009	Head A HOUSING	1	
12	618-02-010	Copper Collar	2	
13		Socket Head Cap Screw	2	M10*40L
14	618-02-011	Plastic Cover	2	
15	618-02-012	Shield Dust Guide Rail	2	
16	618-02-013	Column	1	
17		Hexagonal Head Screw	4	3/4" * 65L
18	618-02-014	Plastic Cover	12	
19		Socket Head Cap Screw	12	M10*16L
20	618-02-015	Head B HOUSING	1	
21	618-02-016	Column Rear Cover	1	
22		Cross Head Screw	6	M5*8L
23		Socket Head Cap Screw	12	M10*30L
24		Socket Head Cap Screw	12	M10*40L
25		Socket Head Cap Screw	4	M6*20L
26	618-02-017	Control Arm	1	

UPPER & LOWER TRANSMISSION ASS'Y

(618-03)

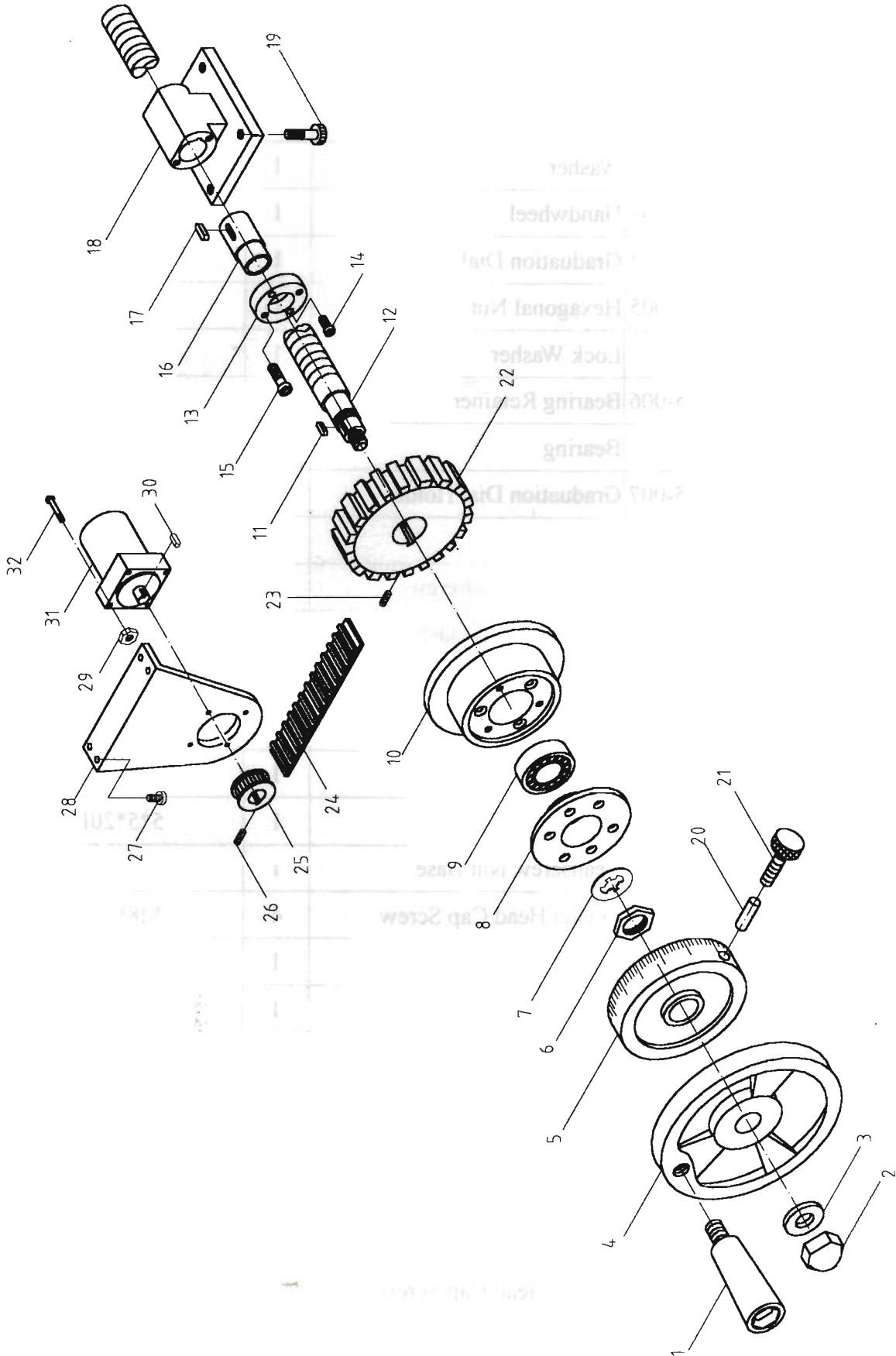
Index No.	Parts No.	Parts Name	Q'ty	Spec.
26		Spring Pin	1	φ 6*30L
27		Key	1	7*5*25
28		Ball Bearing	1	6011Z
29	618-03-014	Bevel Gear	1	
30	618-03-015	Lock Nut	1	

COLUMN ASS'Y (FOR AH SERIES)

(618-02)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
27	618-02-018	Control Cylinder Base	1	
28	618-02-019	Cylinder Fixing Plate	1	
29		Socket Head Cap Screw	4	M5*10
30		O-Ring	1	P44
31		Socket Head Cap Screw	3	M5*10L
32	618-02-020	Control Fixing Plate	1	
33	618-02-021	Lock Nut	1	
34	618-02-022	Control Box	1	

CROSS FEED ASS'Y (FOR AH SERIES)



CROSS FEED ASS'Y (FOR AH SERIES)

(618-05)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-05-001	Grip	1	
2	618-05-002	Cap Nut	1	
3		Washer	1	ϕ 10
4	618-05-003	Handwheel	1	
5	618-05-004	Graduation Dial	1	
6	618-05-005	Hexagonal Nut	1	
7		Lock Washer	1	ϕ 20
8	618-05-006	Bearing Retainer	1	
9		Bearing	1	5204ZZ
10	618-05-007	Graduation Dial Holder	1	
11		Key	1	5*5*30L
12	618-05-008	Crossfeed Leadscrew	1	
13	618-05-009	Leadscrew Backlash Adjuster	1	
14		Socket Head Cap Screw	2	M6*16L
15		Socket Head Cap Screw	2	M6*20L
16	618-05-010	Leadscrew Nut	1	
17		Key	1	5*5*20L
18	618-05-011	Leadscrew Nut Base	1	
19		Socket Head Cap Screw	4	M8*40L
20	618-05-012	Round Pin	1	ϕ 5*10L
21	618-05-013	Socket Head Cap Screw	1	
22	618-05-014	LEADSCREW Pulley	1	
23		Set Screw	1	M6*8L
24	618-05-015	Timing Belt	1	160XL
25	618-05-016	Motor Pulley	1	
26		Set Screw	1	M5*5L
27		Socket Head Cap Screw	4	M6*16L
28	618-05-017	Motor Fixing Plate	1	

CROSS FEED ASS'Y (FOR AH SERIES)

(618-05)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
29		Nut	4	M5
30		Key	1	4*4*24L
31	618-05-018	Dc Gear Motor	1	4IK-25GNS 4GN3K
32		Cross Head Screw	4	M5*58L

TABLE HAND FEED ASS'Y (FOR AH SERIES

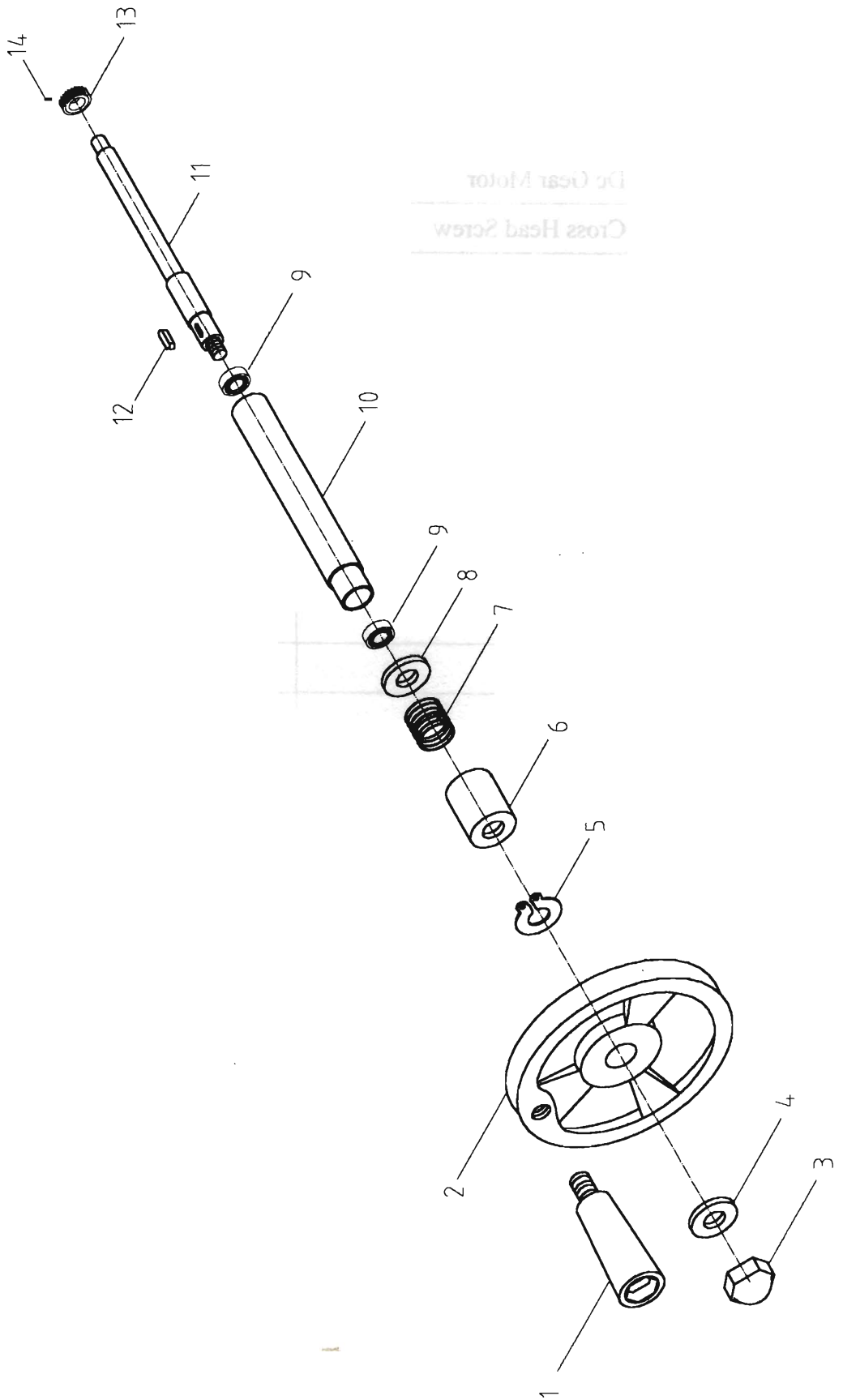
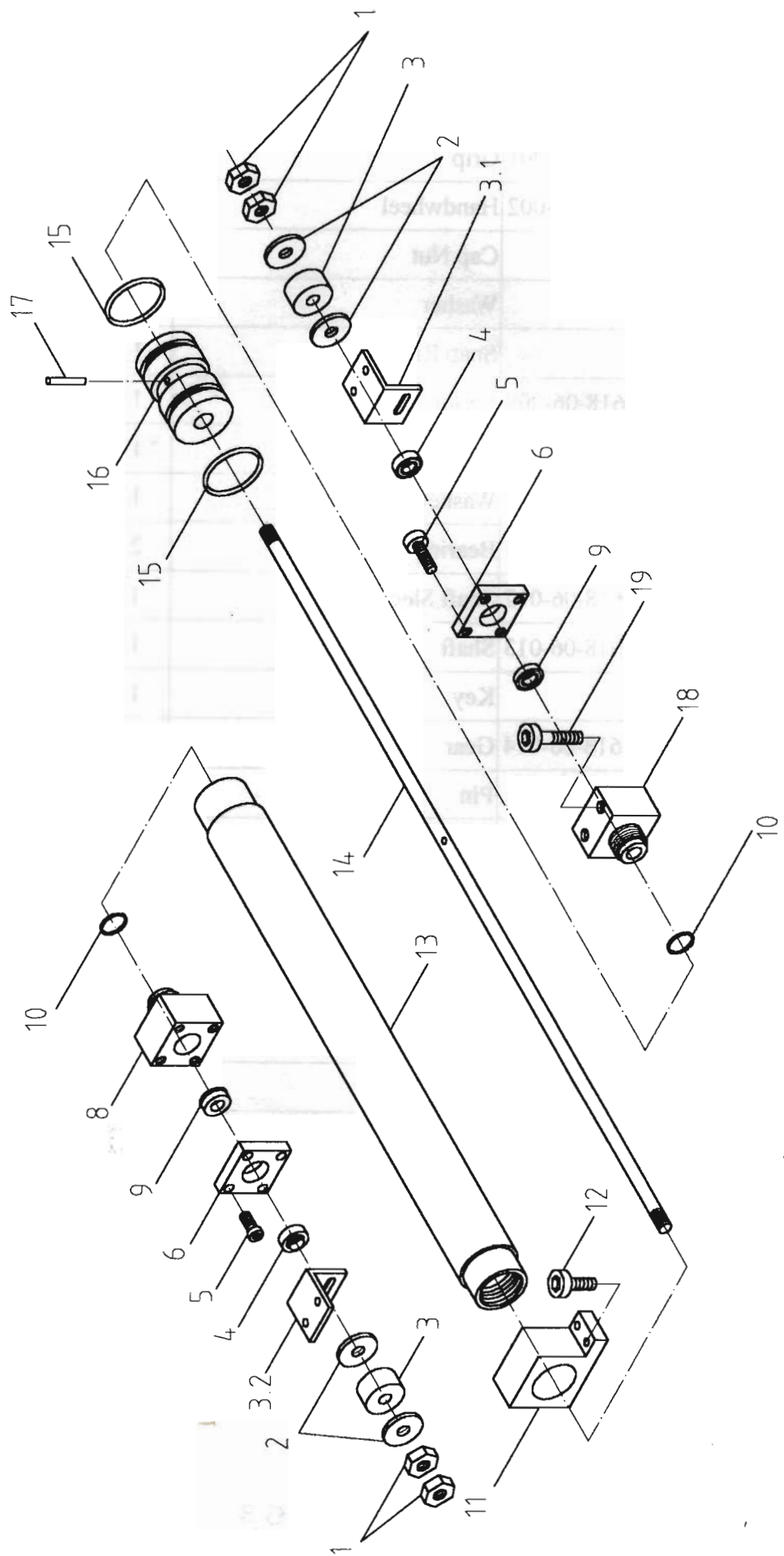


TABLE HAND FEED ASS'Y(FOR AH SERIES)

(618-06)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1	618-06-001	Grip	1	
2	618-06-002	Handwheel	1	
3		Cap Nut	1	M12
4		Washer	1	ϕ 12
5		Snap Ring	1	ϕ 16
6	618-06-009	Spring Seat	1	
7	618-06-010	Spring	1	
8	618-06-011	Washer	1	
9		Bearing	2	6803ZZ
10	618-06-012	Shaft Sleeve	1	
11	618-06-013	Shaft	1	
12		Key	1	5x 20L
13	618-06-014	Gear	1	
14		Pin	1	

LONGITUDINAL HYDRAULIC CYLINDER ASS'Y (FOR AH SERIES)



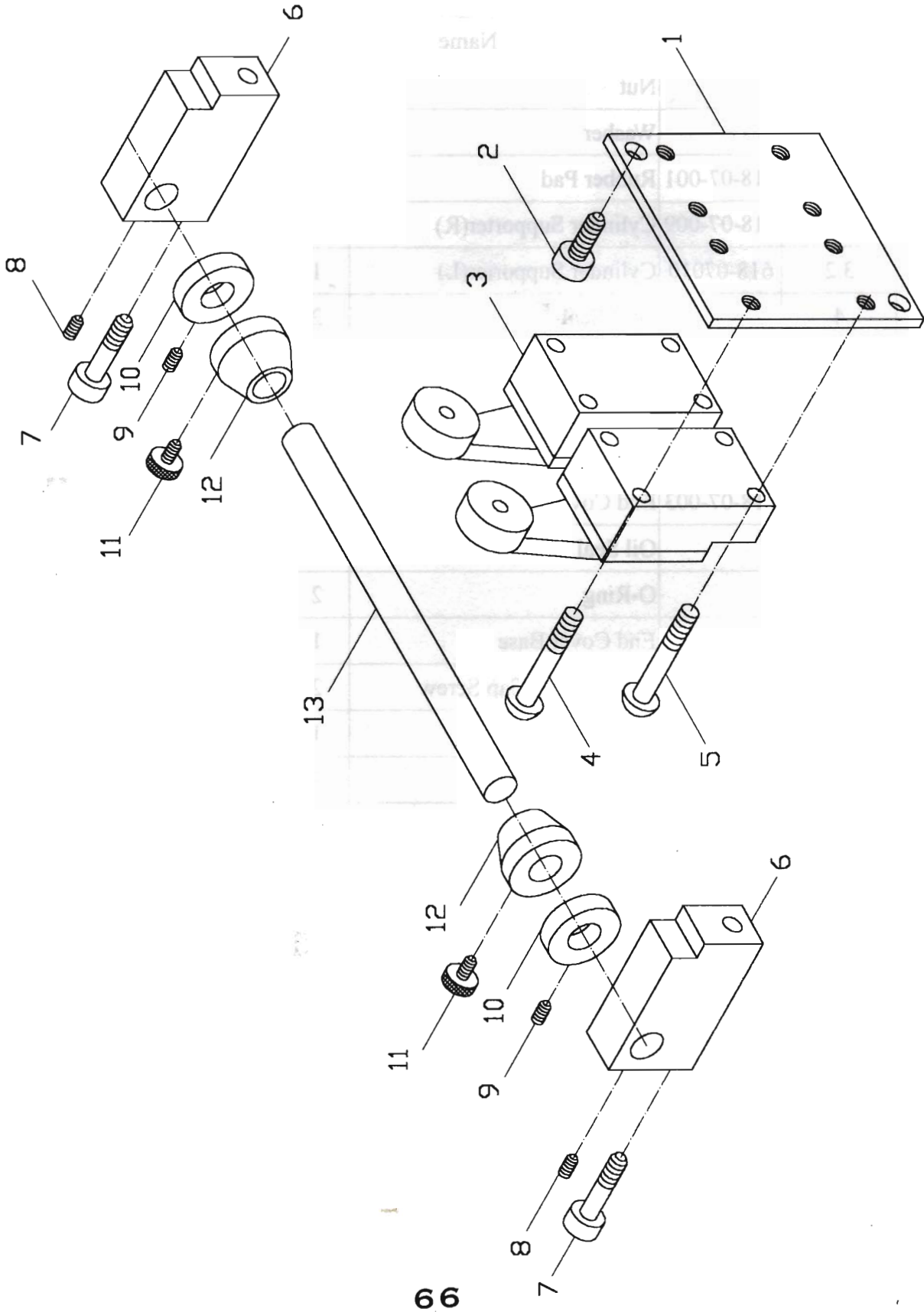
LONGITUDINAL HYDRAULIC CYLINDER ASS'Y

(FOR AH SERIES)

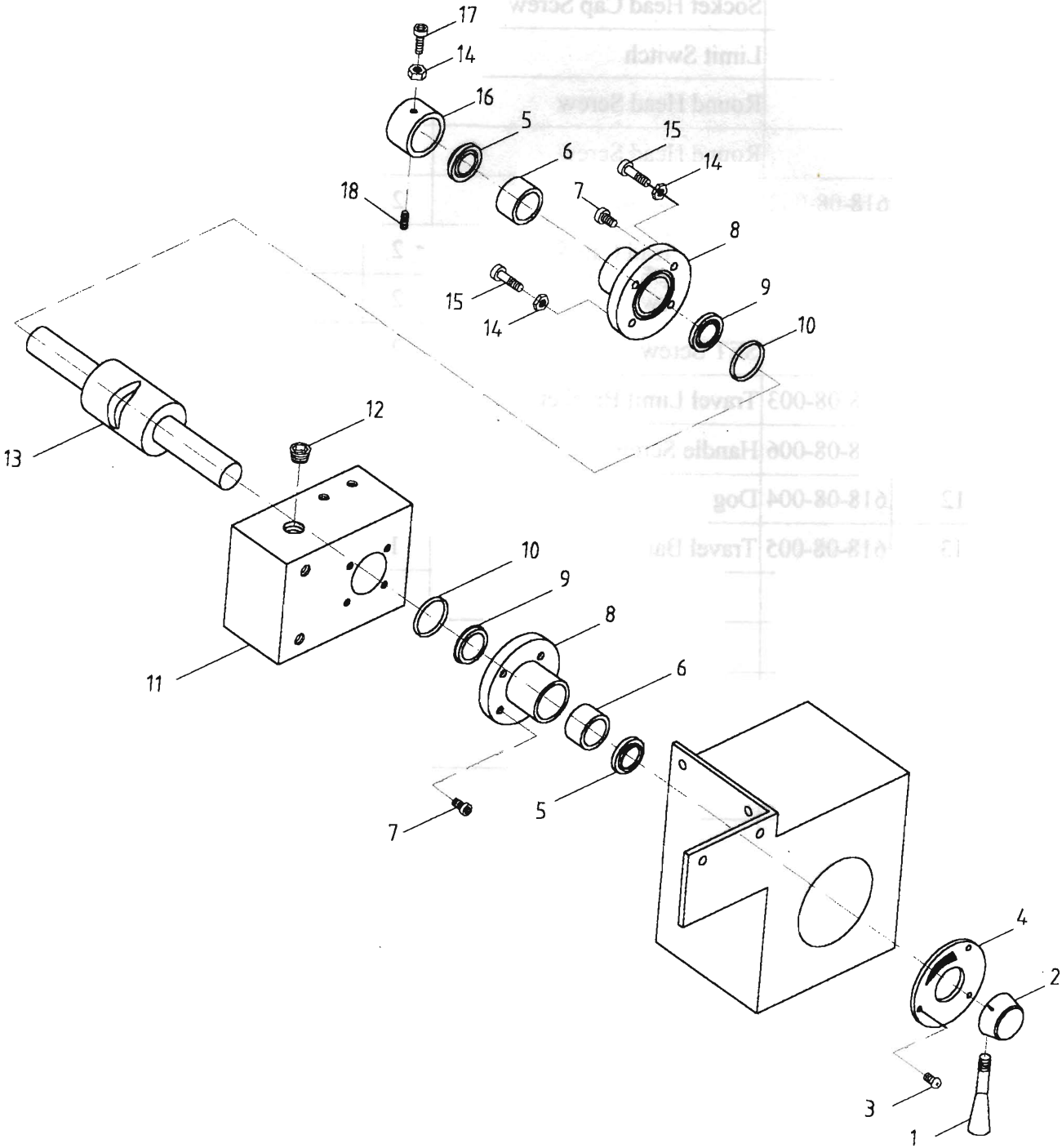
(618-07)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1		Nut	4	M8
2		Washer	4	ϕ 10
3	618-07-001	Rubber Pad	2	
3.1	618-07-009	Cylinder Supporter(R)	1	
3.2	618-07010	Cylinder Supporter(L)	1	
4		Dust Seal	2	DR10
5		Socket Head Cap Screw	8	M5*10L
6	618-07-002	Fixed Plate	2	
8	618-07-003	End Cover	1	
9		Oil Seal	2	UN10
10		O-Ring	2	P21
11	618-07-004	End Cover Base	1	
12		Socket Head Cap Screw	2	M5*16L
13	618-07-005	Cylinder Pipe	1	
14	618-07-006	Piston Rod	1	
15		O-Ring	2	P21
16	618-07-007	Piston	1	
17		Taper Pi N	1	#2*20L
18	618-07-008	End Cover	1	
19		Socket Head Cap Screw	2	M6*40L

CROSSFEED SWITCH ASS'Y (FOR AH SERIES)



VALVE ASS'Y



VALVE ASS'Y (FOR AH SERIES)

(618-09)

Index No.	Parts No.	Parts Name	Q'ty	Spec.
1.	618-09-01	Control Lever	1	
2.	618-09-02	Handle Boss	1	
3.		Cross Head Cap Screw	3	M4*5L
4.	618-09-03	Control Valve Plate	1	
5.	618-09-04	Dust Shield	2	DH-14
6.	618-09-05	Brass Bearing	2	1512
7.		Socket Head Cap Screw	8	3/16"*1-1/4"L
8.	618-09-06	Control Shaft Cover	2	
9.	618-09-07	U-Packing	2	UN-15
10.	618-09-08	O-Ring	2	28.5mm*2.62mm
11.	618-09-09	Valve Body	1	
12.		End Plug	1	1/2"PT
13.	618-09-10	Flow Control Shaft	1	
14.		Nut	3	M5
15.		Socket Head Cap Screw	2	M6*40L
16.	618-09-11	Fixed Ring	1	
17.		Socket Head Cap Screw	1	M6*20L
18.		Set Screw	1	M5*5L