

# **FINEMAKER**

**DC-01CANBM**  
**Wall Mount Dust Collector**

**FINEMAKER AUTOMATION CORP.**

623 VINELAND AVE, LA PUENTE, CA91746, U.S.A.

TEL:1-626-346-3025

Mail: [info@finemakerusa.com](mailto:info@finemakerusa.com) Web: [www.finemakerusa.com](http://www.finemakerusa.com)

# Wall Mounted 1HP DUST COLLECTOR



## Operator's Manual

## TABLE OF CONTENTS

Specifications .....	1
Safety Rules .....	2
Grounding .....	3
Contents of Package .....	4
Assembly .....	5 - 7
Operation .....	7
Parts Diagram .....	8
Parts List .....	9
Wiring Diagram.....	10

## SPECIFICATIONS

Motor .....	1HP, TEFC
Motor Speed (no load).....	3,450 RPM
Volts .....	120 V / 240 V
Amps, Hertz, Phase .....	7 A / 3.5 A, 60 Hz, 1 Ph
Dust Collection Velocity CFM .....	750 CFM
Max. Static Pressure (at 0 CFM) .....	7.2"
Blower Impeller .....	10" Diameter, Aluminum
Sound Rating @ 6 Feet .....	<86.375 dB
Canister Filtration Rating .....	1 Micron
Canister Pleated Filter Size .....	370(mm) *400(mm)
Dust Ports / Hose Connections .....	4"
Overall Size (LxWxH) .....	600*530*1170(mm)
Net Weight .....	30KGS

# SAFETY RULES

---

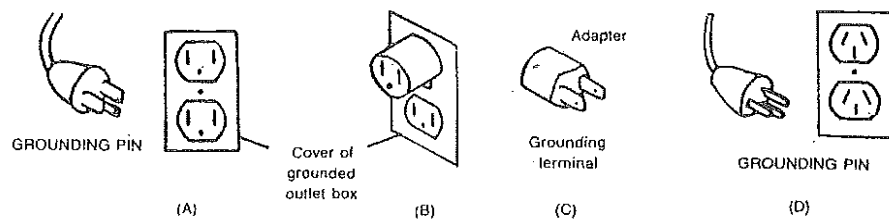
1. **READ AND BECOME FAMILIAR** with the entire operating manual.
2. **KEEP GUARDS AND COVER** in place and in working order.
3. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operations is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **DON'T FORCE TOOL.** It will do a better and safer job at the rate for which it was designed.
6. **AVOID ACCIDENTAL STARTING.** Make sure switch is in "OFF" position before plugging in cord.
7. **DISCONNECT TOOLS BEFORE SERVICING** and when changing accessories such as blades, bits, cutters.
8. **DON'T OVERREACH.** Keep your proper footing and balance at all times. For best footing wear rubber soled footwear. Keep floor clear of oil, scrap wood, etc.
9. **WEAR PROPER APPAREL.** Loose clothing or jewelry may get caught in moving parts. Wear protective hair covering to contain long hair.
10. **MAKE WORKSHOP KIDPROOF.** Place a padlock on the switch when blade saw is not in use and store the key in a safe location.
11. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
12. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations. Keep your work area well illuminated *DO NOT USE* in explosive atmosphere (around paint, flammable liquids, etc.)
13. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from work area, especially while operating unit.
14. **USE THE PROPER TOOL.** Don't force tool or attachment to do a job for which it was not designed.
15. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **SECURE WORK.** Use clamps or a vise to hold work, when practical. It's safer than using your hand and prevents round or irregularly shaped pieces from turning.
17. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be checked to assure that it will operate properly and perform its intended function—check for alignment of moving parts, breakage of parts, mounting, any other conditions that may affect its operations. A guard or other part that is damaged should be properly repaired or replaced.
18. **USE RECOMMENDED ACCESSORIES—**Consult Owner's Manual. Use of improper accessories could be hazardous.
19. **NEVER STAND ON TOOL.** Injury could occur from a fall.
20. **NEVER LEAVE TOOL RUNNING AND UNATTENDED.**
21. **ALWAYS REMOVE CORD PLUG** from electrical outlet when adjusting, changing parts or working on tool.

# GROUNDING

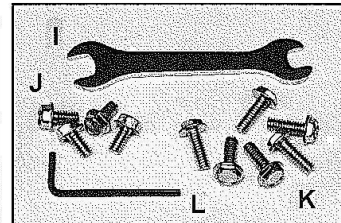
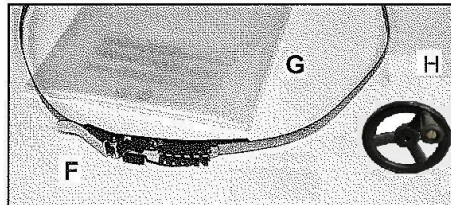
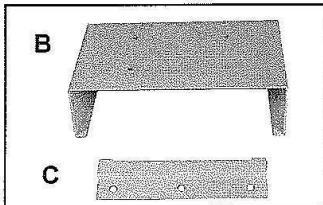
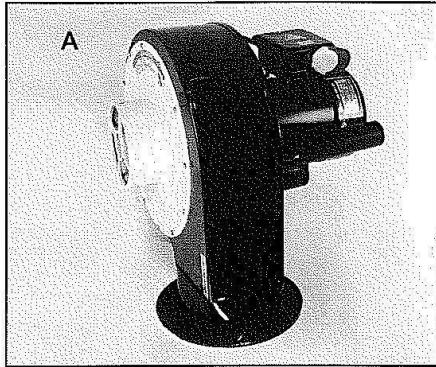
1. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.
2. Do not modify the plug provided it will not fit the outlet, have the proper outlet installed by a qualified electrician.
3. Improper connection of the equipment grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripe is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
4. Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
5. Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.
6. Repair or replace damaged or worn cord immediately.
7. This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch A. The tool has a grounding plug that looks like the plug illustrated in sketch A. A temporary adapter, which looks like the adapter illustrated in sketches B and C, may be used to connect his plug to a 1-pole receptable as shown in sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, etc. extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

NOTE: The type of electrical plug and receptacle differs from country to country.  
**Caution:** In Canada only the grounding shown in figure (A) is acceptable. The extension cords should be CSA certified S.J.T. type or something better.

**Caution:** In Australia only the grounding shown in figure (D) is acceptable. The extension cords should be SAA certified.



## CONTENTS OF PACKAGE



- Box 1 of 2
- A Motor & Fan Assembly
  - B Wall Mounting Bracket
  - C Motor Plate
  - D Manual ( not shown )

Parts Diagram and  
Parts List are listed  
on Pages 8 and 9 .

- Box 2 of 2
- E Filter Canister
  - F Bag Strap Clamp
  - G Plastic Collection Bag
  - H Filter Cleaning Handle
  - Hardware Pack:
    - I Wrench 10/12mm
    - J Motor Mount Bolts 1/4-20x1/2" (4)
    - K Flange Bolts 1/4-20x3/4" (6)
    - L Hex Wrench 3mm

### Needed For Setup

- Tape Measure
- Drill & Drill Bits
- Phillips Screwdriver
- Level
- Fasteners
- Safety Glasses & Respirator
- 4" Dust Hose
- Hose Clamps

Wall Mounted 1HP Portable Dust Collector is shipped complete in two boxes.

### Unpacking and Clean-up

1. Carefully remove all contents from the shipping carton. Compare the contents with the list of contents to make sure that all of the items are accounted for, before discarding any packing material. Place parts on a protected surface for easy identification and assembly. **DO NOT** turn your machine **ON** if any of these items are missing. You may cause injury to yourself or damage to the machine.
2. Report any shipping damage to your local distributor. Take photographs for any possible insurance claims.
3. Clean any rust protected surfaces with ordinary house hold type grease or spot remover. Do not use; gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
4. Set packing material and shipping carton aside. Do not discard until the machine has been set up and is running properly.

## ASSEMBLY

**NOTE:** The parts listed in the instructions refer to either the Contents of Package on page 4, or the Parts Diagram & Parts List on pages 8 & 9.

**WARNING** THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ASSEMBLY IS COMPLETE.

### INSTALL THE MOTOR PLATE TO THE MOTOR BRACKET

Locate the following parts:

- Motor & Fan Assembly (A, Parts Diagram #34)
- Motor Plate (C, #11)
- 4 Motor Mount Bolts 1/4-20x1/2" (K, #25)
- Wrench 10/12mm (J)

**NOTE:** Before assembly, screw the bolts into the threaded holes in the motor plate. This will 'clean out' any paint that may be left on the threads from the painting process, and will make the final assembly of parts easier.

1. Assemble the Motor Plate (A) to the Motor Bracket (C) with the 4 Bolts (K). Figure 1.

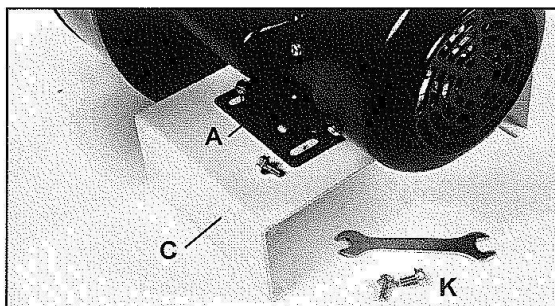


FIG. 1

### INSTALL THE FILTER CANISTER TO THE MOTOR ASSEMBLY

Locate the following parts:

- Motor & Fan Assembly (A, Parts List #34)
- Filter Canister (E, #1)
- 6 Flange Bolts 1/4-20x3/4" (L, #27)
- Wrench 10/12mm (J)

1. Position the Motor & Fan Assembly (A) onto the Filter Canister (E). Figure 2.

**NOTE:** The motor assembly is heavy and tilts easily, so a second set of hands is recommended to help hold the motor during its assembly to the canister.

2. Align the Canister so that the Spindle (#4) to mount the Filter Cleaning Handle (G, #13) is positioned to the right, near the motor area. This will position the handle away from the walls for unrestricted operation.

3. Align the 6 holes in the motor assembly's bottom flange with the 6 holes in the top of the canister and assemble the parts together with the 6 Bolts (L, #27). Figure 2.

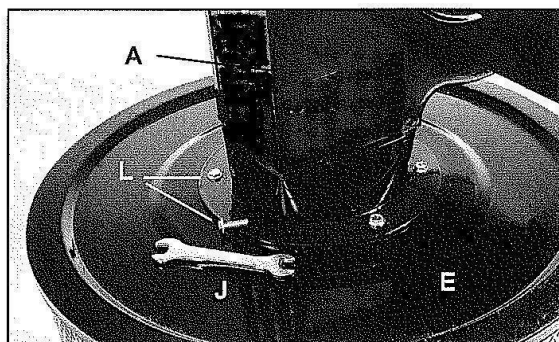


FIG. 2

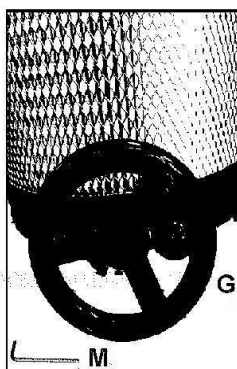


FIG. 3

### INSTALL THE FILTER CANISTER HANDLE

Locate the following parts:

- Filter Cleaning Handle (G, Parts List #13)
- Hex Wrench 3mm (M)

1. Assemble the Filter Cleaning Handle (G) onto the canister's Spindle (#4) and secure it in place with the Hex Bolt (#20) using the 3mm hex wrench provided. Figure 3.

## ASSEMBLY

### INSTALL THE WALL MOUNTING BRACKET

Locate the following parts:

- Wall Mounting Bracket (B, Parts List #12)
- Lag bolts, screws, molleys & tools (not included)
- Level, pencil, drill, wrenches or screwdriver

1. Position the Mounting Bracket (#12) on a sturdy wall at a height for the dust collector's bag to freely hang down without harm, about 50-65" from the floor. Also position the bracket ample room away from any side walls so that there is plenty of room for operating the canister handle or dealing with the dust hoses.

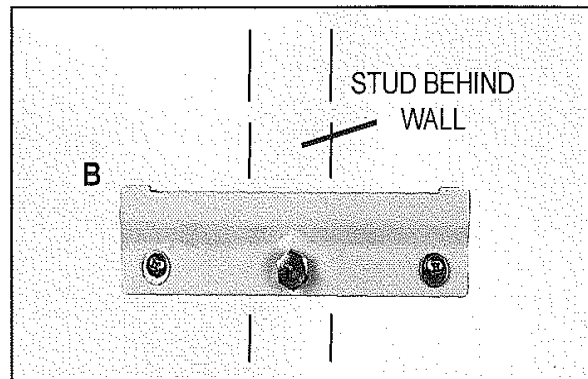


FIG. 4

The Dust Collector should be near an electrical outlet so an extension cord is not used, and near a machine(s) so a long dust hose is not needed, which can reduce the suction efficiency of the dust collector.

2. Once the position of the bracket on a wall is determined, use a pencil to mark the wall with the locations of the 3 holes in the mounting plate. If possible, locate the center hole where there is a stud. Mount the bracket. Figure 4.

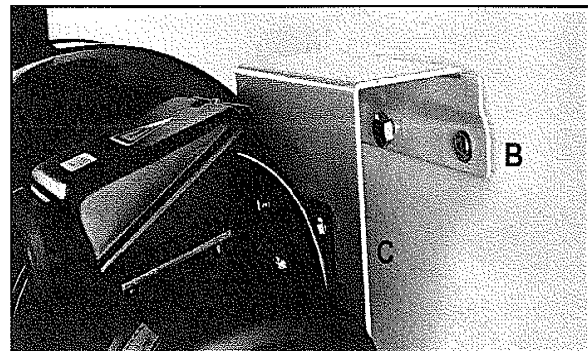


FIG. 5

**NOTE:** For solid, plywood or masonry walls, fasteners can be used to directly attach the plate to the wall. For wallboard, the use of molleys are recommended.

### MOUNTING THE COLLECTOR ON THE WALL

Once the mounting bracket (B) is installed, the dust collector can be hung on the bracket. The base of the Motor Plate (C, #11) will fit into the recess on the bracket to secure the collector in place. Figure 5 & 6.

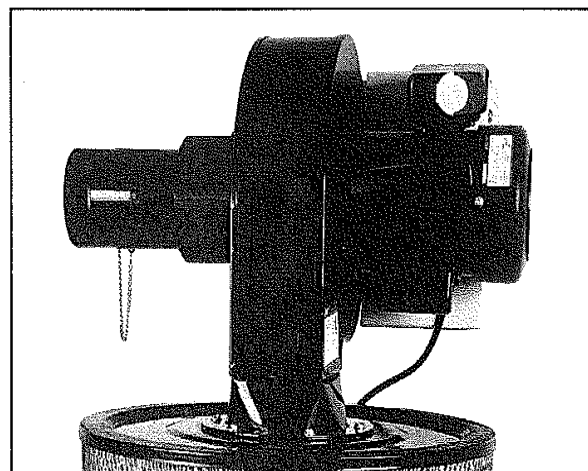


FIG. 6



## ASSEMBLY

### INSTALL THE PLASTIC DUST BAG

1. Install the lower, clear plastic collection bag (#29) onto the bottom rim of the Filter Canister. Temporarily secure it in place with some adhesive tape (masking, duct, etc), magnets or small binder clips.
2. Install the Strap Clamp (#16) around the canister and over the plastic bag. Lock it in place with the strap clamp. Engage the catch end of the strap with the clasp in the appropriate slot to ensure a tight fit, and press the lever with the palm of your hand to lock the clamp. Figure 7.

**NOTE:** To release the clamp, lift up on the lever. If the lever is hard to disengage, simply use a flat head screwdriver to pry the lever upwards.

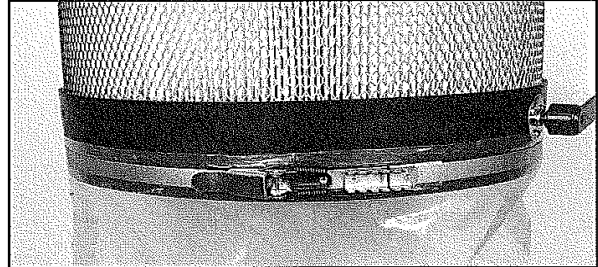


FIG. 7

**WARNING** THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ASSEMBLY IS COMPLETE.

### INSTALL THE DUST HOSE

**NOTE:** Dust hoses and hose clamps are NOT included with the machine. Obtaining these accessories are the responsibility of the user. Please visit your local machine dealer for dust collection supplies.

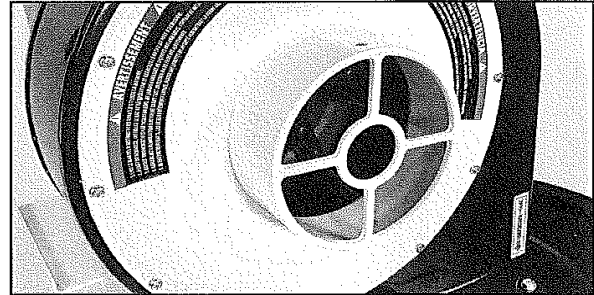


FIG. 8

## OPERATION

### ON/OFF LOCKING SAFETY SWITCH

**CAUTION:** Make sure that the On/Off locking switch is in the “Off” position before plugging the dust collector into a power source.

The On/Off Locking Switch has a center Safety Key (A) that can be used to prevent unauthorized use of the dust collector. The switch needs to have the center key inserted before the machine can be used. Figure 9.

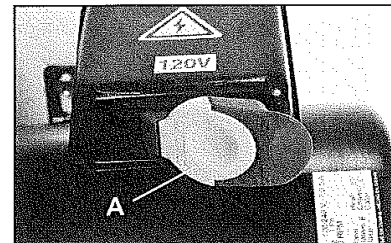
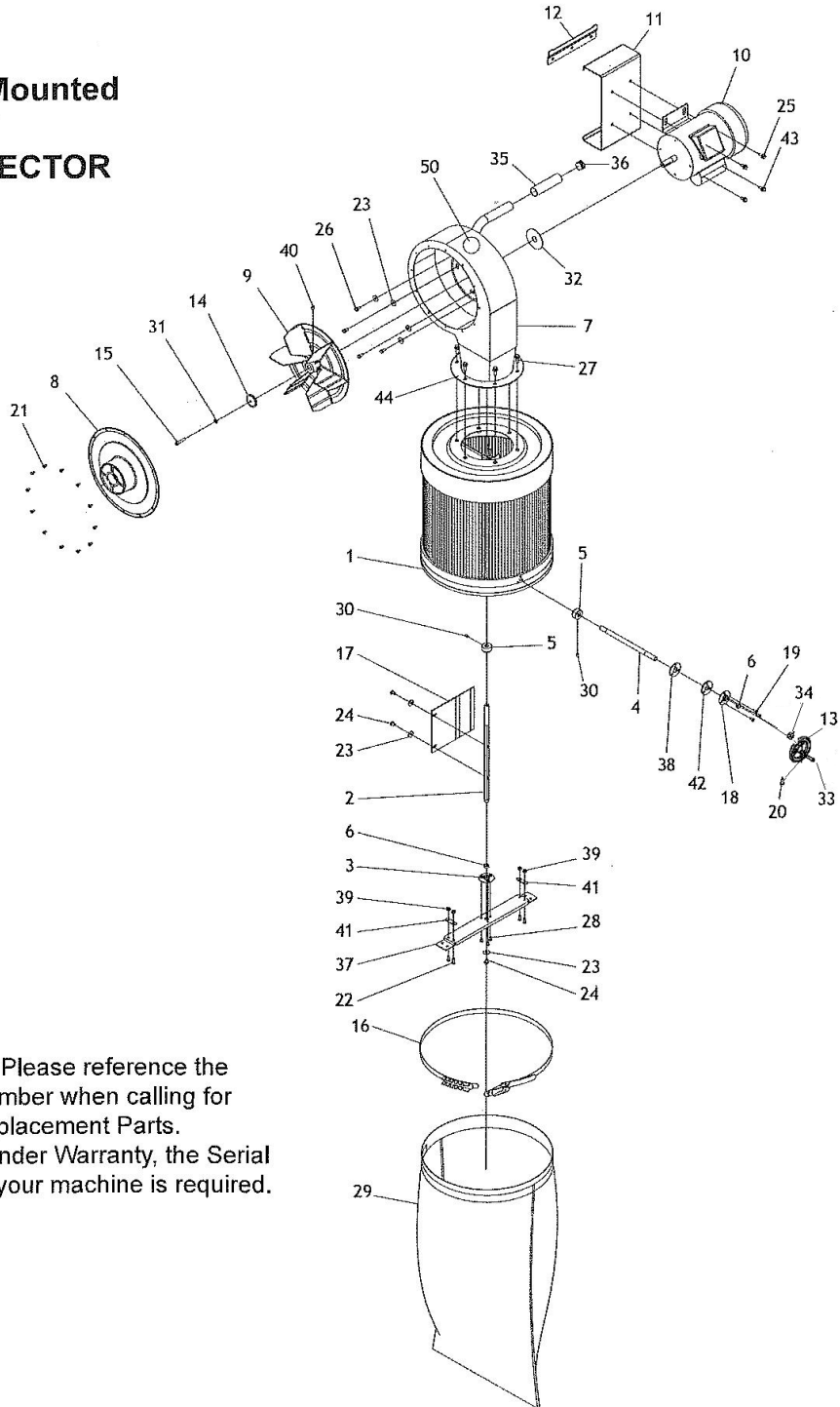


FIG. 9

# PARTS DIAGRAM

## Wall Mounted DUST COLLECTOR



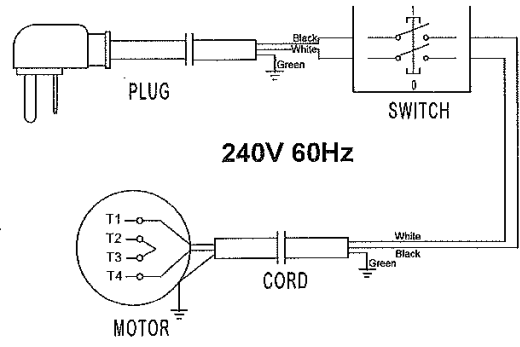
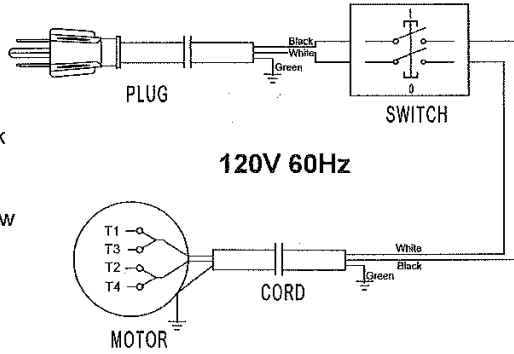
**NOTE:** Please reference the Part Number when calling for Replacement Parts.  
For Parts under Warranty, the Serial Number of your machine is required.

## PARTS LIST

KEY NO.	DESCRIPTION	QTY.
1	Canister Filter	1
2	Main Spindle	1
3	Bearing Fixing Plate	1
4	Connecting Spindle	1
5	Bevel Gears	2
6	Self-lubricating Bearings	3
7	Main Housing	1
8	Inlet Cover	1
9	Aluminum Impeller 10"	1
10	Motor	1
11	Motor Plate	1
12	Wall Mount Bracket	1
13	Hand Wheel	1
14	Impeller Washer 6 mm	1
15	Cap Screw M6×30 LH	1
16	Belt Clamp	1
17	Flapper	1
18	Bearing Fixing Plate	1
19	Phillip HD Screws M5×10 mm	3
20	Hex Bolt M6×16 mm	1
21	Phillip HD Screws M5×10 mm	12
22	Phillip HD Screws M5×15 mm	4
23	Flat Washers 1/4"×18	4
24	Phillip HD Screws M6×12 mm	4
25	Flange Screws 1/4-20×1/2"	4
26	Hex Bolts 1/4-20×1/2"	4
27	Flange Screws 1/4-20×3/4"	6
28	Phillip HD Screws M5×8 mm	3
29	Plastic Dust Bag 58cm×76cm flat	1
30	Set Screws 1/4-20×5/16"	2
31	Spring Washer 1/4"	1
32	Motor Gasket	1
33	Hand Wheel M10×14	1
34	Locking Nut M10	1
35	Handle Cover 1"×4"	1
36	End Cap 1"	1
37	Spindle Plate	1
38	Bearing Fixing Plate (Special)	1
39	Hex Nuts M5	4
40	Set Screw 5/16-18×5/16"	1
41	Mounting Plates	2
42	Rubber Gaskets	2
43	Flange Bolts 1/4"×1/2"	4
44	Canister Gasket	1

## WIRING DIAGRAM

T1 = Black  
 T2 = Gray  
 T3 = Red  
 T4 = Yellow



**⚠ WARNING:**

This machine must be grounded. Replacement of the power supply cable should only be done by a qualified electrician.

# Maintenance and Lubrication information

## MAINTENANCE INFORMATION

For your own safety, before maintenance your machine; please turns off the power switch, and unplug the power.

1. Please read carefully operating manual before operating the machine to understand the limits and potential damages of machine.
2. When operate the machine, make sure every safety cover has positioned.
3. For safety, machine with ground wirings is required.
4. It is not allowed putting tools/things on the machine when operating.
5. Make sure the power off when replaced the saw blade or maintained.
6. Always keeping machine and working surrounding area clean.
7. Please remember to turn off the machine before your leaving.
8. Do not maintain the electrical control box unless doing by an electrical specialist.
9. Do not stand on the dust cover when adjust the machine.
10. When move the machine, please raise up the horizontal screws.
11. Please follow the manual to maintain the machine regularly.
12. Keeping clean of the dust vent.
13. When execute different jobs, please adjust related parts.
14. Before turn ON the machine every day, please check all parts of the lubricator's oil, if there has manual lubricator device, please oiling manually before start running machine.
15. Check the lubrication oil regular in the air unite weekly, and drain the filtered water in the air unite before finished work every day.
16. Every thirty days, filling grease at each designated point.
17. Daily completed work, remove residual glue on the glue comb and conveyor.
18. Keep table and lubricated device clean, lubricating and dry.
19. Always keep circular saw web and tools sharp and dry.
20. Regularly inspect oil hydraulic pump tank and make sure circulating oil is enough every month (check oil meter).
21. Service life of tools is short, so please exchange or grinding them about every 30~45 hours in normal use.



**Note: Most of emphasis of maintenance is cleaning and oiling. If you surely do as required the quality of mechanical manufacturing shall be better and replacement rate of parts shall be decreased. Please make your own regular maintenance records manual, regular maintenance is accurately documented to avoid future disputes arising due to damaged parts.**

### Consumables:

**The machine has many expendables which need changing regularly. Such as: Belt; conveyor belt; tools; wind pressure pipe; hair brush and cloth rubber wheel. Please pay attention to these items in the maintenance state, and in accordance with the state as a regular replacement, ensuring machining quality.**

The maintenance of any machine is a vital ingredient to ensuring the longevity and performance of the machine. A maintenance schedule should be developed and followed by a qualified person, or someone who has been trained to perform such tasks. The maintenance schedule should include the following aspects;

- Clean machine at regular intervals and keep as free from dust as possible.
- Check cutter drive chain and replace when required - removing links is not good practice as sprockets will be subject to increased wear.
- Check motor drive belts regularly and tension if squealing noises are heard during startup.
- Keep electrical cabinet door closed and free from dust.
- Check and clean, if required, any dusts build up on sensors.

It is suggested that a regular maintenance check is carried out once a week. This is just a guide, and if excessive dust, water, or wear is present, the maintenance check should be carried out more regularly.

#### Preservation notes :

Check the oil gage before power on.

Operating this machine go by normal procedural.

Please be sure maintenance and shaving off the harden summing after finish.

The periods of general maintenance divided into daily, weekly, monthly and semiannually in order to diminish breakdown and elongate running life of machinery.

1. The oil in the hydraulic oil tank should be replaced for the first half year of operation. Then replace the hydraulic oil once a year.
2. In case any abnormal sound occurs on the hydraulic pump; first check if oil amount is sufficient or not. Then check if oil hoses loosened or not, and if filter jammed or not.
3. SPEED REDUCER: Replace oil after the first half year of operation. Afterwards, Replace oil once a year.
4. Please add grease in grease nipple quarterly.
5. Gas tank oil capacity on oil gage 90%

#### Selection and maintenance of hydraulic oil

1. Use abrasion resistance ISO VG32 ~ 68 hydraulic oil.

Recommended AW32 AW46 AW68

**R level circulating oil not applicable**

2. Hydraulic oil depending on the degree of deterioration it should be 1 to 3 years replacement, add new oil can not improve the oil quality, should be all new ones.
3. Oil filter should be cleaned once every 3 to 6 months or replaced.
4. The ideal oil temperature is 30°C ~ 50°C

# REGULAR MAINTENANCE TABLE

MAINTAIN SYSTEM	REGULATION ITEM	Daily	Weekly	Monthly	Quarterly	Half year	Yearly	Remarks
M/C BASE	Cleaning and lubricating the transmission lead screw.		★					Grease
	Lubricating the case of transmission lead screw.			★				Grease
	Cleaning and lubricating the precision linear guide ways.		★					Mobile oil
	Lubricating the gear reducer.						★	Gear oil
MOVABLE SIDE SYSTEM	Lubricating the case of precision linear guide ways.			★				Grease
FEEDING SYSTEM	Change the gear oil inside variable feed motor.					★		Gear oil
	Cleaning & lubricating the feeding transmission rod.	★						Mobile oil
	Lubricating the feeding transmission bearing.			★				Grease
	Lubricating the universal joint			★				Grease
	Lubricating the shafts of feed chain track.		★					Grease
GRAR BOX	Lubricating transmission shafts inside the gear box.			★				Grease
BOTTOM PRESSURE BEAM SYSTEM	Inspecting the tolerance of the spring of driver chain rollers.			★				
	Cleaning and lubricating the dogs on the feeding chain.		★					Mobile oil
	Angle balancing the dogs on the feeding chain.			★				
	Cleaning the feed driver rollers, and adjusting the tension of belts.			★				
COLUMN	Cleaning and lubricating the cases of slide lead screws on each column.		★					Mobile oil
AIR FILTER	Inspecting the air pressure and oil	★						Compress oil

P.S. NOTICE: / P.S .

1. The above mentioned maintenance methods are based on normal operation of the machines in 8 hours per day.
2. The gear reducer must be cleaned up and refilled with gear oil after initially 100 hours operation of machine. Then change the oil every 2500 hours. The lubricating oil Model: HD-320. (Common load, ambient temperature: 5°C ~ 40°C.)
3. Grease for bearings, Model: SKF-LGLT2 , others for grease NO. 3.
4. Mobil oil Model: CDC-R33, Compressor oil Model: R30.

# Maintenance Method

**Before use the machine, please check for the following conditions and repair or replace when necessary:**

- Loose mounting bolts.
- Worn switch.
- Worn or damaged cords and plugs.
- Damaged drive belt.
- Any other condition that could hamper the safe operation of this machine.
- Check the entire air system for leaks.

**Maintenance machine is important for best results, safe operation, and long service life.**

<b>Location</b>	<b>Inspection</b>	<b>Incidence</b>	<b>Activity</b>
sanding paper	Inspection	8 hours	if worn, please replace
Pad	Inspection	40 hours	if surface worn, please replace
Air unit	Cleaning	40 hours	release condensed water
Table lifting chain	Tension	300 hours	if needed, please tighten
All belts	tension	200 hours	if worn or loose, please replace or tighten
Conveyor belt	Tension	300 hours	if worn or loose, please replace or tighten
Table lifting bolt	Lubrication	40 hours, 1 year	Grease
Grease Nipples	Lubrication	1 month	Grease

## DAILY MAINTENANCE

1. Check the filter bowl on the filter / regulator / lubricator combination unit, and release the water inside the bowl.

The lubricator bowl should be kept at the proper quantity of lubrication oils.

2. Clean the pressure beam slide and lubricate it.
3. Clean the saw carriage.
4. Check the driving belt tension and adjust if necessary.
5. Remove the chips and dust inside the dust collection chute.
6. Clean the guide rods and lubricate them.



# Hydraulic machine maintenance and troubleshooting

## Hydraulic machine regularly check essentials

Check place	Check items	Check period	Inspection methods
Tank (Including working oil)	Oil leak	Weekly	Visually
	Oil capacity	Weekly	Visually
Pump	Oil cleanliness and traits	Three months	Dependency analysis
	Oil Temperature	Weekly	Oil temperature gauge or touch
	Excretion	Three months	Drive speed measurement, test station
	Pressure	Three months	pressure gauge
	Noise	Three months	Sense of hearing or noise meter
	Surface temperature	Three months	Thermometer or touch
	Seal, packing, oil leak or inhaled air	Three months	Visually or Check the fuel tank inside the bubble, noise
Pressure control valve	Setting value and action status	Three months	Manometer or operating status of the actuator
Flow control valve	Setting value and action status	Three months	Drive speed measurement
Directional control valve	Action status	Three months	Operation check of drive
	Inhaled oil leak	A year	Operation of the actuator in neutrally or measured in the test station
	Coil insulation resistance	A year	Determined by 500MV
Filter	Cleanliness	Month	Visually
	Cleanliness	Three months	Clean
Coolers	Cooling capacity	Three months	Oil temperature gauge or touch
	Leak water	Three months	Reference values of working oil analysis
Piping and Pipe Clamp (Including rubber tube)	Oil leak	Weekly	Visually
	Loosen, vibration	Weekly	Visually · Touch or vibration meter

## Proper oil temperature / critical oil schematic

100°C   80°C	Dangerous temperature	Absolutely not be used.
80°C   55°C	Critical temperature / caution temperature	Shorten the life of the oil of the actuator, use an oil cooler. Oil temperature over 60 degrees, each degree increase 8 in the service life of the sequence halved.
55°C   30°C	Safe temperature / ideal temperature	The most appropriate temperature, highest performance, longest life expectancy °
30°C	Room temperature	No danger when you start, but the efficiency of the low long-term operation °
20°C	Hypothermia	Start should pay attention, the high-viscosity oil · Often caused by idling status

### Hydraulic oil maintenance / management strategies

1. Use temperature below 70 °C, if possible, preferably below 60 °C. Especially in the case of a high pressure from the relief valve back into the working oil temperature is high or use a heater for some parts heating must pay great attention. That will accelerate the oxidation at high temperatures.
2. Required pollution control. Oil pollutants because of work sometimes becomes the catalyst accelerated oxidation.
3. Avoid water mixed with oil inside. Water will make oil deterioration, too much water will make the work of oil emulsion °
4. Different manufacturers of working oil cannot be mixed ° Same-manufacturers, but the name and a different grading of oil but also to avoid mix that will cause deterioration of the oil additives
5. Control of hydraulic machinery and piping have oil leak situation, temporarily discharge volume to a minimum.
6. Periodic inspections of oil. (※Oil has started to deteriorate, should be change a new oil · only add new oil does not prolong life ° )

## LUBRICATION

To machine the best performance and extend the life of this machine a periodically lubrication for this machine is very important. Use recommends lubricant only.

### (1) Automatic lubricator:

Recommended lubricant oil #32.

This automatic lubricator is mounted at right side front of the machine. It automatically supply oil to spindle quill on both side and auxiliary drum shaft.

### (2)

	Lubrication point	Recommended oil	Frequency
1	Front center shaft	Grease	Once per 30 days
2	real center shaft	Grease	Once per 30 days
3	Pulley inside left cover	Grease	Once per 30 days
4	Pulley drive shaft inside cover	Grease	Once per 30 days
5	Oscillation shaft	Grease	Once per 30 days
6	Real center oil inlet	Oil #32	Once per 4 hours

The machine needs periodical lubrication on the parts as shown in the below diagram, to ensure normal performance.

Neglected lubrication can cause serious problems for machine operation.

LUBRICATION POINTS DESCRIPTION	LUBRICATION METHOD
Pressure beam slide	Directly lubricate the rod surfaces.(ISO VG #68)
Connection rod pivot	Directly lubricate the rod surfaces.( ISO VG #68)
Guide rods	Directly lubricate the rod surfaces.(ISO VG #68)
Filter / regulator / lubricator Combination unit	Fill the lubricator bowl with oil.(ISO VG #10)
Bearings of scoring saw-blade	Greasing (GREASE NO.2)
Bearings of main saw-blade	Greasing (GREASE NO.2)
Bearings of guide wheel	Greasing (GREASE NO.2)
Bearings of pulley	Greasing (GREASE NO.2)