

OPERATION MANUAL AND PARTS LIST

7660.002

ROUND ROD MILLING MACHINE



WARNING: 1.Read this operation manual carefully before operation
2.Keep this manual for future reference

**WOOD RATTAN WORKING MACHINE
AUTOMATIC ROUND RATTAN
AND ROUND ROD MILLING MACHINE**

7660.002

The is a precise WOOD RATTAN WORKING MACHINE AUTOMATIC ROUND RATTAN AND ROUND ROD MILLING MACHINE. We believe that if you operate it normally and make a good maintenance periodically, the machine will stay in a perfect condition. Before operating the machine, please read the INSTRUCTION-HANDBOOK.

SPECIFICATIONS :

TYPE	7660.002
Work area diameter.	3/8"-2-3/8"
Minimum workable length (mm)	300
Main shaft motor (HP)	3-5
Feed motor (HP)	1-2
R.P.M. of main shaft	3000
Feeding speed (m/min)	6 , 9 , 13 , 16
Size of machine (cm)	92x68x100
Packing size (cm)	105x75x110
Net weight (kg)	300
Gross weight (kg)	340

FEATURES :

1. This unit is ideally suited for the rod milling jobs for flag rod, especially with materials like rattan, molded board, acrylics, carbon, bakelite, bamboo and wood.

2. The cutter head is equipped with a stabilizer featuring no chips blocking in stabilizer guide way and effectively reduces the noise level of this machine during operation.
3. There are four rollers for input and output, therefore, any material can be conveyed smoothly. The processing speed can be changed 4 speed by transmission.
4. The conveyance unit can be adjusted in speed or replacement for clockwise or counter clockwise revolution.
- 5 The retain roller for processed materials is made in ball type. As the center point is adjusted, for any kind of outside diameter of processed material, the width of the roller can be easily adjusted by the handle. Besides, it can function to control the center point between roller with the tension of the spring, consequently, it keeps the material in the center although there is difference in distorter, rough and fine angles.

OPERATION STEPS :

1. Put machine in a steady position , and then check whether the power is suitable for the motor voltage. Turn on the electricity supply and examine whether the revolution of main shaft follows the arrows. If not , turn off the power and switch the two wire lines.

2. Before operation, please check and adjust positions of support bracket for work-piece. When height of work-piece support is inappropriate, loose the handle and fix the support bracket. Fig 1 shown after adjustment is completed.



Fig 1

3. To select the correct feed wheel to install and fix: loose the nuts and wind-up after completed changing of feed wheel.
(for the switch side with nuts of left-clockwise & right-counter clockwise thread) Fig 2.



Fig 2

4. Even edge tool correct regulation means that as shown in Figure 3.



Fig 3

5. To adjust hand wheel according to sizes of work-piece: adjust spring nuts.

See Fig 4.

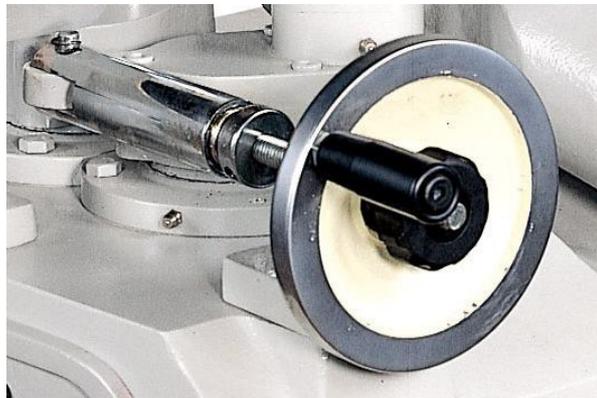


Fig 4

6. There are 4 variable speeds, to select the correct speed , depends on the quality, hard or soft and sizes of work-piece.



Fig 5

7. To adjust the machine to meet requirements, the power needs to be turned off.

8. How to the select feed wheel for according to work-piece.

WORKPIECE SIZE	FEED WHEEL SIZE
8-12 m/m	6 m/m
12-18 m/m	10 m/m
18-28 m/m	16 m/m
28-36 m/m	26 m/m
36-60 m/m	34 m/m

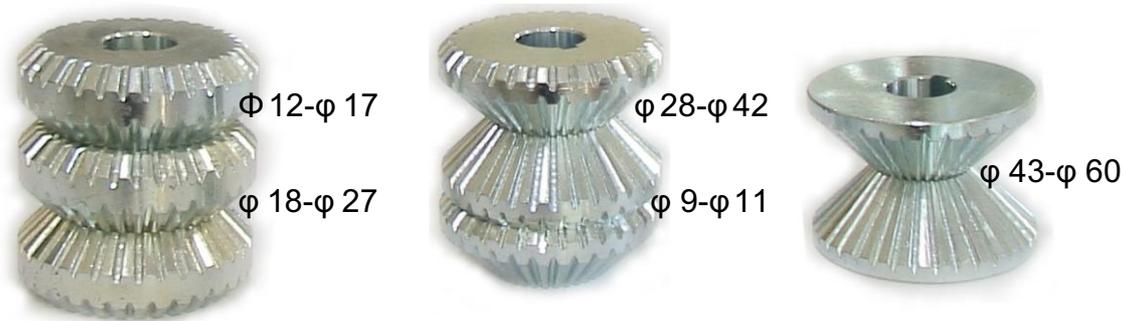


Fig 6 (圖 6)

MAINTENANCE:

1. Do not open the tool guard or put in anything while the machine is in operation. Always keep away from the dust exhaust port. Do not put in band or open the tool guard when machine in operating , to keep away from Dust Exhaust port.
2. Lubrication should be done in daily basis before operation.
3. Machine and its surface should be cleaned daily.
4. Gearbox should be lubricated and replaced periodically. S.A.E. #30 lubricant is suggested for the gearbox.
5. When work piece is jammed during operation, stop the feed wheel and withdraw the work-piece.

ROD MILLING MACHINE

NO	Description	QUANTITY
1	Lower Base	1
2	Support of Motor Seat	2
3	Net	4
4	Hexagon Screw	4
5	Flat Washer	4
6	Hexagon screw	4
7	Seat of Motor & Transmission	1
8	Seat of Motor	1
9	Hexagon screw	2
10	Set plate	1
11	Hexagon Screw	2
12	Hexagon Screw	4
13	Flat Washer	2
14	Nut	2
15	Left Column	1
16	Hexagon screw	4
17	Flat Washer	4
18	Hexagon screw	4
19	Flat Washer	4
20	Pulley	1
20-1	A-Belt	1
21	Hexagon screw	1
22	Square Key	1
23	Motor 5HP	1
24	Motor 2HP	1
25	Pulley	1
25-1	B-Belt	2
26	Socket Set	2
27	Hexagon screw	4
28	Spring Washer	4
29	Transmission	1
30	Net	4
31	Spring Washer	4
32	Pulley	1

32-1	Pulley	2
33	Spring Washer	1
34	Net	1
35	Hexagon screw	1
36	Transmission Rod Head	1
37	Transmission Rod	1
38	Handle	1
39	Hexagon screw	4
40	Seat of Reducer	1
41	Reducer	1
42	Spring Washer	4
43	Hexagon screw	4
44	Pulley	1
45	Round Head Screw	1
46	Hexagon screw	3
47	Guard	2
48	Round Head Screw	16

ROD MILLING MACHINE

49	Upper Base	1
50	Gear	4
51	Gear	2
52	Gear	2
53	Socket Head Screw	12
54	Chain Drum	1
55	Socket Head Screw	3
56	Flat Washer	4
57	Hexagon screw	4
58	Hexagon screw	4
59	Chain Drum	1
60	Gear Coupler	1
61	Hexagon screw	2
62	Chain Drum	1
63	Snap Ring	1
64	Idle Gear Shaft	1
65	Idle Gear Support	1
66	Flat Washer	1
67	Flat Washer	2
68	Nut	1
69	Hexagon screw	2
70	Support of Hanging Hook	2
71	Socket Head Screw	2
72	Work-piece Support	2
73	Hexagon screw	4
74	Work-piece Support Seat	2
75	Locking Handle	2
76	Name Plate	2
77	Round Head Screw	4
78	Spring Sleeve	2
79	Spring Screw	2
80	Spring	2
81	Nuts of Spring Sleeve	2
82	Snap Ring	2

83	Hand Wheel Seat	2
84	Bushing	2
85	Hexagon screw	2
86	Handle wheel	2
87	Movable Handle	2
88	Gear Box Seat	4
89	Hexagon screw	1
90	Bearing	4
91	Dual Needle Roller Bearing	4
92	Gear Box Bottom	4
93	Bearing	4
94	Lower Gear Shaft	2
95	Upper Gear Shaft	2
96	Bearing	4
97	Bearing Bushing	4
98	Gear Box Covet	2
99	Bearing	4
100	Socket Head Screw	1
101	Bearing Locking Cover	4
102	Bushing	4
103	Feet Wheel of R-Shape	2
104	Nut	4
105	Feed Wheel of Gear Shape	2
106	Feed Wheel of Gear Shape	2
107	Gear Box Covet with Lug	2
108	Grease Nipple	6
109	Gear Box Cover with Lug	2
110	Sunk Key	2
111	Sunk Key	2

ROD MILLING MACHINE

112	Spindle Seat	1
113	Spindle Cover	1
114	Spindle	1
115	Bearing	1
116	Bearing Locking Ring	1
117	Spindle Read Cover	1
118	Hexagon screw	3
119	Guide Tube Bushing	1
120	Steady Controller Guide Tube	1
121	Hexagon screw	3
122	Grease Nipple	2
123	Socket Head Screw	4
124	Hexagon screw	4
125	Flat Washer	4
126	Bearing	1
127	Spindle Front Cover	1
128	Flat Knife	1
129	Flat Washer	1
130	Hexagon screw	1
131	Hexagon screw	3
132	Knife Block Coupler	1
133	Knife Block	1
134	Flat Knife	1
135	Hexagon screw	1
136	Hexagon screw	2
137	Locking Handle	1
138	Set Bolt	
139	Spring Washer	2
140	Hexagon screw	2
141	Movable Handle	1
142	Nut	1
143	Dust Catcher Tube Cover	1
144	Spring Pie	1
145	Dust Catcher Tube Seat	1
146	Bearing	1

