

OPERATION MANUAL AND PARTS LIST

*DOWEL CUT AND CHAMFERING
MACHINE*
WINTER FS 36



WARNING!

*The operator must thoroughly read this manual before operation.
Keep this manual for future reference.*

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This is a precise DOWEL GROSS-CUT AND CHAMFERING MACHINE, we believe that if you operate it normally and make a good maintenance on time, the machine will stay in perfect condition. Before operating the machine, please read the INSTRUCTION-HANDBOOK.

Specifications:

Work Area Diameter C6-C18 mm

Minimum Workpiece 20 mm

Maximum Workpiece Length 150 mm

House Power Used ½ HP

Cut Across Speed 36 piece/min

Size of Machine 560 x 500 x 330 mm

Packing Size 640 x 550 x 730 mm

Net Weight 80Kg

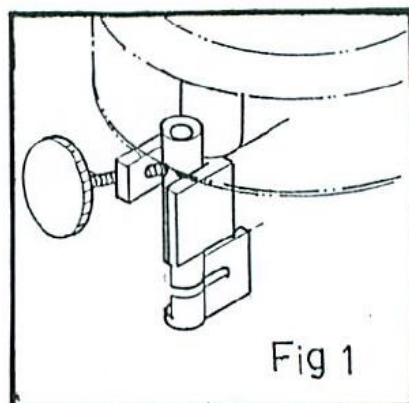
Exported Packing Weight 100 Kg

Features:

(The machine is fitted to use in any length and surface of martise- tenor such as helical groove, cross slot, longitudinal slot and smooth surface also fitted to that of diameter C6-C18M/M and length 20-150 M/M by adjusting the horizontal position. Chamfer also can be adjusted optionally up to the required)

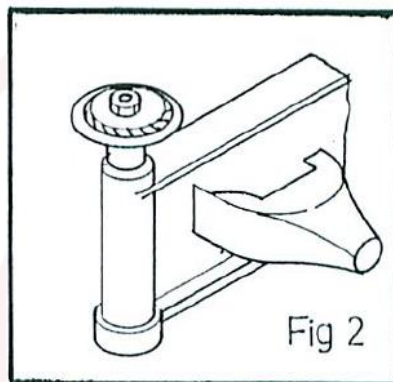
Operation Steps:

- 1.To select the correct Guide Tube to install and fix, before operating.

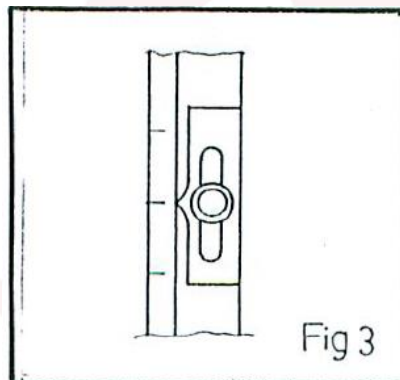


2. Before supplying electric, please check whether the electric power is the same as the voltage of motor and then turn on the electric, turn off the electric and switch the two wire lines.

3. To replace Vertical Shaft Knife, take out Guard and loose than tight up the nut for hanging.



4. To have the Driving Rubber Cam connect with outer rim of workpiece, so that the workpiece will be rotate properly in tune with the rotation of the cam, it is correctly for adjustment, connection can not be too tight or loose, adjusting control gage of product length.



5. To adjusting handle of chamfer large & small depends upon amount of chamfer.

6. To check size, outlook of the first workpiece when completed, if it's conform to requirement, otherwise, re-adjust after turn-off power source.

Maintenance:

- 1.To clean dust and remains on the machine, after finished daily operation.
- 2.To keep tools in sharp condition at all time.
- 3.Do not use metallic materials manufacture.
- 4.When machine in operation, do not Lake off the guard.
- 5.In operation, operator shall stand away from the saw & cutter line, for fear that dust might get into eyes.

Parts list

| PART No | PART NAME | PART NAME | UNIT REQD |
|---------|-----------|----------------------------------|-----------|
| 1 | | Body | 1 |
| 2 | | Movable Bracket of Cutter | 1 |
| | | Tool | |
| 3 | | Nut | 1 |
| 4 | | Washer | 1 |
| 5 | | Pulley | 1 |
| 6 | | Socket Set | 6 |
| 7 | | Ball Bearing | 2 |
| 8 | | Cutter Tool Shaft | 1 |
| 9 | | Sunk Key | 2 |
| 10 | | Bushing | 1 |
| 11 | | Upper & Lower Cutter | 1 |
| 12 | | Circular Saw | 1 |
| 13 | | Flat Washer | 1 |
| 14 | | Nut | 3 |
| 15 | | Pulley Guard | 1 |
| 16 | | Round Head Screw | 11 |
| 17 | | Cutter Tool Guard | 1 |
| 18 | | Adjusting Nut | 2 |
| 19 | | Handle | 2 |
| 20 | | Grease Nipple (P.T) | 7 |
| 21 | | Setting Screw of Spring | 3 |
| 22 | | "I" Movable Arm | 1 |
| 23 | | Hexagon Screw | 2 |
| 24 | | Ball Bearing | 2 |
| 25 | | Bearing Bolt | 2 |
| 26 | | Put Material Wheel Disk Shaft | 1 |

| | | |
|----|----------------------------|---|
| 27 | Put Material Wheel disk | 1 |
| | Seat | 1 |
| 28 | Put Material Wheel Disk | 1 |
| | Seat Plate | |
| 29 | PBR | 1 |
| 30 | Disk | 1 |
| 31 | Transmission Material | 1 |
| | plate | |
| 32 | Washer | 2 |
| 33 | Hexagon Screw | 1 |
| 34 | Driver Cam Movable | 1 |
| | Bracket | |
| 35 | Chain Drum | 1 |
| 36 | Driver Cam Shaft | 1 |
| 37 | Sunk Key | 1 |
| 38 | Sunk Key | 1 |
| 39 | Flat Washer | 1 |
| 40 | Rubber Driver Cam Seat | 1 |
| 41 | Pie | 2 |
| 42 | Rubber Driver Cam | 1 |
| 43 | Chain drum | 1 |
| 44 | Pie | 1 |
| 45 | Hexagon Bolt | 1 |
| 46 | Setting Shaft | 1 |
| 47 | Lower Chain Drum Guard | 1 |
| 48 | Screw Seat of Pully Spring | 1 |
| 49 | Spring Washer | 3 |
| 50 | Extensioin Spring | 1 |
| 51 | Extensioin Spring | 1 |
| 52 | Setting Gage Angle Seat | 1 |

| | | |
|----|--------------------------|----|
| 53 | Setting gage | 1 |
| 54 | Washer | 2 |
| 55 | Socket Head Screw | 1 |
| 56 | Pie | 1 |
| 57 | Rule | 1 |
| 58 | Guide Tube | 1 |
| 59 | Handle | 1 |
| 60 | Chain Drum | 1 |
| 61 | Sunk Key | 1 |
| 62 | Wheel Disk Driver Shaft | 1 |
| 63 | Wheel Disk Driver | 1 |
| 64 | Wheel disk Driver Rubber | 1 |
| 65 | Wheel Disk Driver Iron | 1 |
| | Plate | |
| 66 | Socket Head Screw | 1 |
| 67 | Bushing | 1 |
| 68 | Hexagon Screw | 1 |
| 69 | Oval Sphere | 1 |
| 70 | Discontinuous Bracket | 1 |
| | Yoke Axis | |
| 71 | Discontinuous Bracket | 1 |
| | Yoke | |
| 72 | Discontinuous Bracket | 1 |
| | Yoke Spring | |
| 73 | Bushing | 1 |
| 74 | Hexagon Screw | 2 |
| 75 | Nut | 13 |
| 76 | Upper Chain Drum Guard | 1 |
| 77 | "L" Movable Arm | 1 |
| 78 | Reducer Gear Box | 1 |

| | | |
|-----|--------------------------|----|
| 79 | Hexagon Screw | 4 |
| 80 | Socket Head Screw | 18 |
| 81 | Shaft Cover | 4 |
| 82 | Ball Bearing | 5 |
| 83 | Vertical Worm | 1 |
| 84 | Sunk Key | 4 |
| 85 | Worm Gear | 2 |
| 86 | Neddle Roller Bearing | 1 |
| 87 | Shaft cover | 1 |
| 88 | Clutch Chain Drum Shaft | 1 |
| 89 | Steel Ball | 3 |
| 90 | Clutch Chain Drum | 1 |
| 91 | Clutch Chain Drum Spring | 1 |
| 92 | Spring cap | 1 |
| 93 | Vertical Worm | 1 |
| 94 | Shaft Cover | 1 |
| 95 | Pulley | 1 |
| 96 | Gear Box Cover | 1 |
| 97 | Socket Head Screw | 6 |
| 98 | All Thread Screw | 4 |
| 99 | Motor | 1 |
| 100 | Sunk Key | 1 |
| 101 | Socket Set | 2 |
| 102 | Pulley | 1 |
| 103 | Hexagon Screw | 4 |
| 104 | Nut | 4 |
| 105 | Flat Head Screw | 3 |

