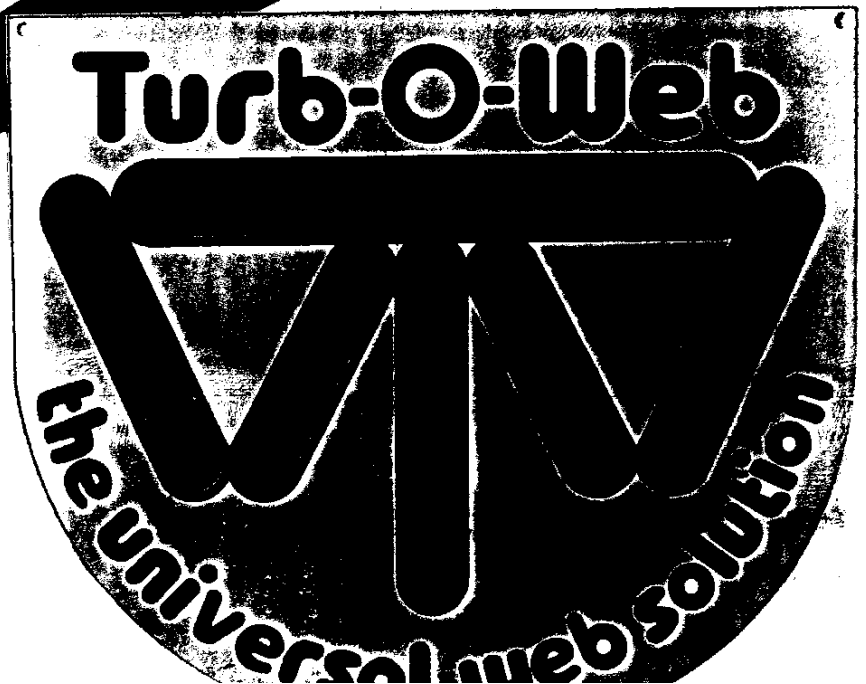
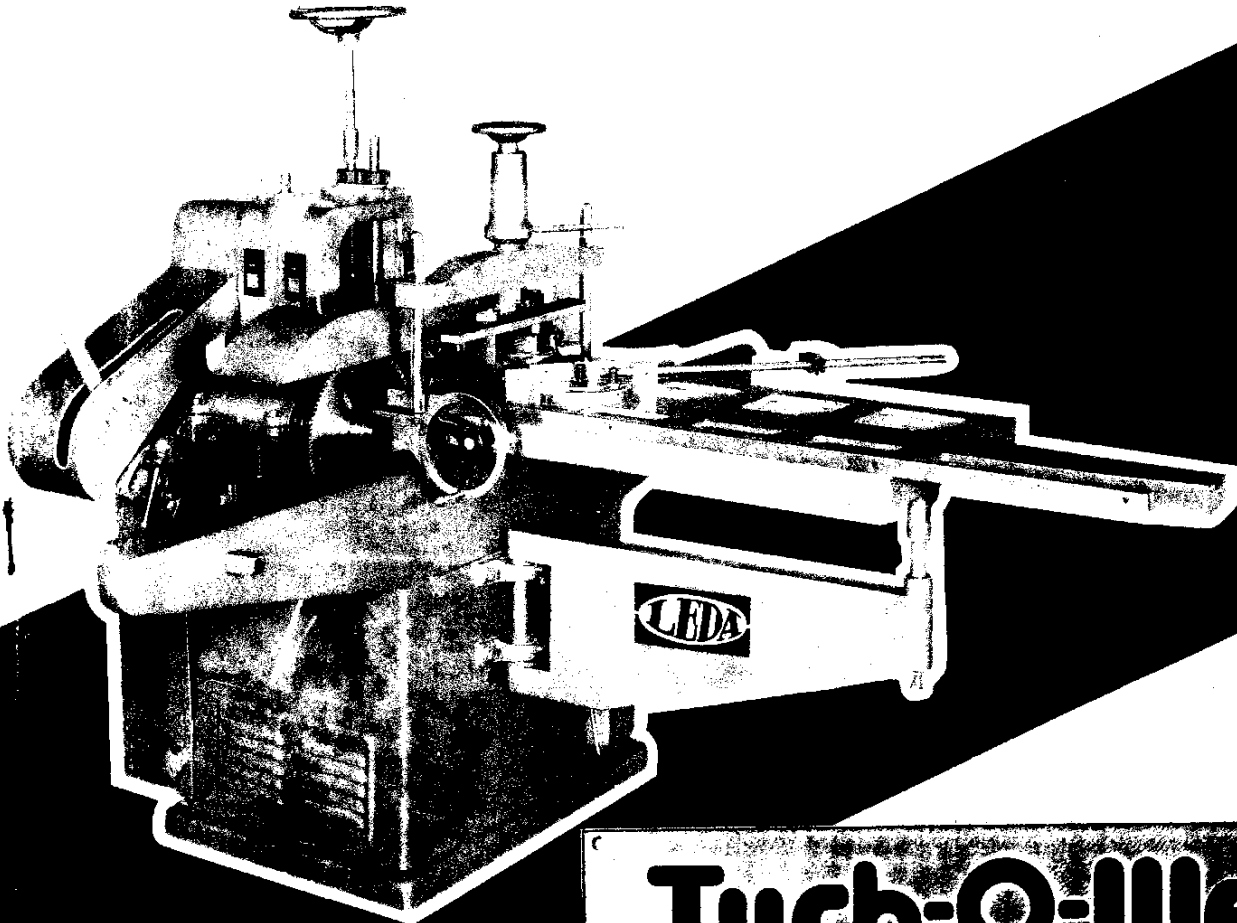


# ST-120/ST-152

OPERATION INSTRUCTIONS



## 一、平板調整 FIG1 FIG2 FIG3

1. 調整滑輪支軸 A、B、使其平板表面，與軌道平行。(FIG. 1)
2. 放鬆螺帽 C 調整螺絲 D 使整塊平板成水平之後鎖緊螺帽 C。(FIG. 2)
3. 放鬆螺帽 E 調整螺絲 F 使平板與軌道密切配合之後，鎖緊螺帽 E (FIG. 3)

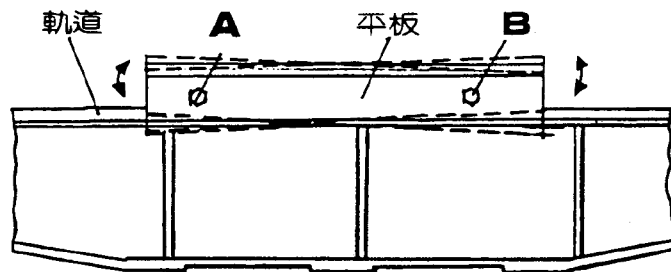


FIG1

### I. Adjustment of Slab. (FIG1, FIG2, FIG3)

1. Adjust Pulley Axle A, B to make the surface of the slab parallel with the track. (FIG 1)
2. Loosen Nut C and adjust Screw D to make the slab level, and then, lock nut C tightly. (FIG. 2)
3. Loosen Nut E and adjust Screw F to make the slab perfectly match with the track, and then, lock nut E tightly. (FIG. 3)

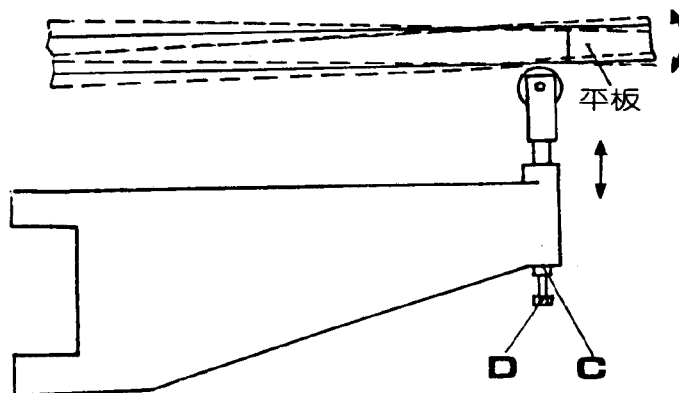


FIG2

## 二、鉤刀上、下、橫軸調整 FIG4

1. 上下位置調整：FIG4
  - a. 將齒輪 B 移至上方位置使其與齒輪 A 分開。
  - b. 轉動昇降軸 C 調整上橫軸至適當位置。
  - c. 轉動昇降軸 D，調整下橫軸至適當位置
  - d. 將齒輪 B 放下與齒輪 A 齒合（齒輪 B 上有三個鍵槽，可任意選擇其中最適合之鍵槽放下），此後只要任意轉動昇降軸 C 或昇降軸 D 即可同時帶動上、下橫軸做上、下位置之移動，而並不改變上、下橫軸間之中心距離。
2. 前後位置調整：FIG4
  - a. 轉動螺桿 E 可調整上橫軸之前後位置。（其調整量為 16mm）
  - b. 轉動螺桿 F 可調整下橫軸之前後位置。（其調整量為 16mm）

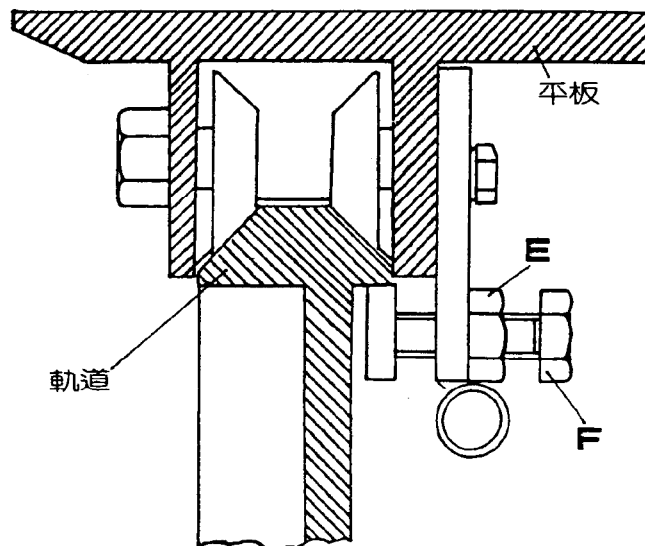


FIG3

## II. Adjustment of Upper & Lower Cross Axles of Plane Iron: (FIG4)

### 1. Adjustment of Upper and Lower Position (FIG. 4)

- a. Move the Gear B to the upper position to make it separate from Gear A.
- b. Turn the Lifting Axle C to adjust the upper cross axle to the proper position.
- c. Turn the Lifting Axle D to adjust the lower cross axle to the proper position.
- d. Put Gear B down to tally with Gear A. (There are three key slots on Gear B, which are to be selected to put down optionally as it is appropriate.) Since then, as long as optionally turning the Lifting Axles C or D, the upper and lower cross axles could be moved up and down but the central distance between the upper and lower cross axles won't be changed.

### 2. Adjustment of Front & Rear Positions: (FIG. 4)

- a. The position of front and rear of the upper cross axle can be adjusted by means of turning Screw E. (The adjusting distance is 16mm.)
- b. The position of front and rear of the lower cross axle can be adjusted by means of turning Screw F. (The adjusting distance is 16mm.)

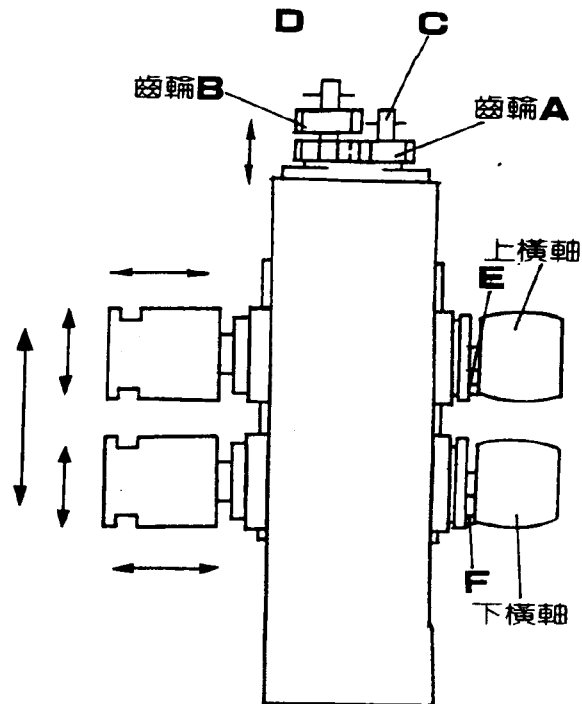


FIG4

## 三、圓鋸刀橫軸調整 FIG5

1. 轉動昇降軸 A 可調整橫鋸刀橫軸之上下位置。
2. 轉動螺桿 B 可調整圓鋸刀橫軸之前後位置(其調整量為 16mm )

## III. Adjustment of Cross Axle of Disc Saw (FIG5)

1. The position of up and down of the cross axle, disc saw can be adjusted by means of turning Lifting Axle A.
2. The position of front and rear of the cross axle, disc saw can be adjusted by means of turning Screw B. (The adjusting distance is 16mm.)

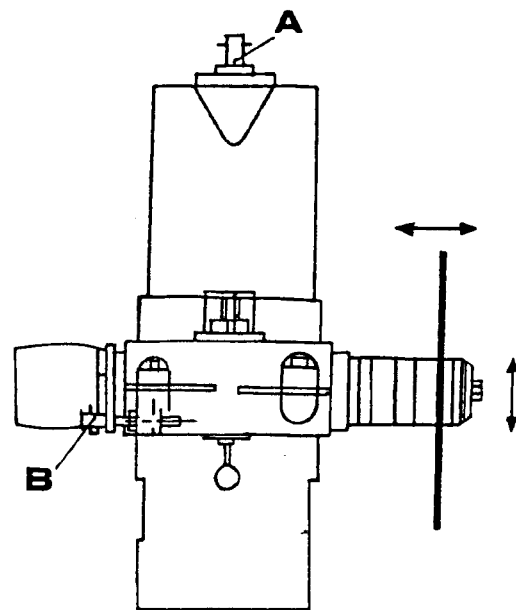


FIG5

## 四、皮帶調整 FIG6

1. 調整皮帶中心位置：
  - a. 少許放鬆把柄 A 及調整桿 B
  - b. 調整 C、D、E、F 四個螺帽至適當位置
  - c. 恢復把柄 A 及調整桿 B 至適當位置。
2. 調整皮帶鬆緊及更換皮帶
  - a. 放鬆調整桿 B 移動把柄 A 使皮帶放鬆並取下舊皮帶。
  - b. 依原來皮帶之裝置位置換上新皮帶
  - c. 移動把柄 A 調整皮帶至適當鬆緊度。
  - d. 鎖緊調整桿 B

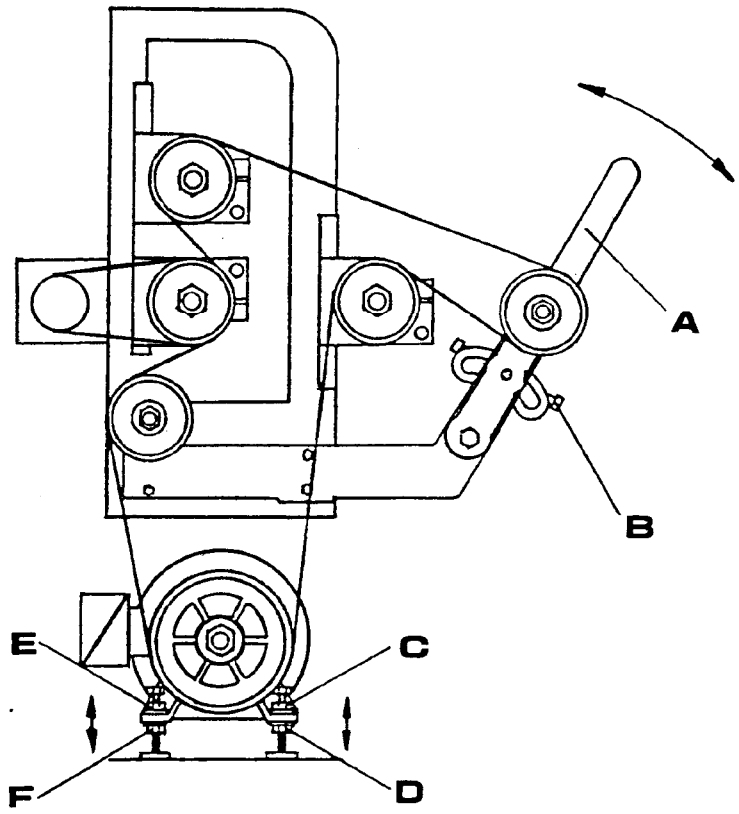


FIG6

## IV. Adjustment of Belt: (FIG6)

1. Adjustment of Belt Center:
  - a. Slightly loosen Handle A and adjust Screw B.
  - b. Adjust Nuts C, D, E, F to the proper position.
  - c. Reset the Handle A and adjust Screw B to the proper position.
2. Adjustment of Belt Tightness & Change of Belt:
  - a. Loosen Adjusting Screw B and move Handle A to loosen the belt and take off the old belt.
  - b. Assemble the new belt at the position of the old belt.
  - c. Move Handle A and adjust the belt to the proper tightness.
  - d. Lock Adjusting Screw B tightly.

## 五、立軸調整 FIG7

1. 欲調整上、下時可轉動昇降軸 A
2. 欲調整前後時，可轉動昇降軸 B

## V. Adjustment of Vertical Axle. (FIG7)

1. Up and down adjustment is by means of turning Lifting Axle A.
2. Front and rear adjustment is by means of turning Lifting Axle B.

\* 注意事項：(1) 機器需定期保養擦拭  
(2) 15天至20天需定期上油潤滑

Note: (1) The machine must be maintained & wiped regularly.  
(2) It must fit to put on lubricating oil during 15 - 20 days.

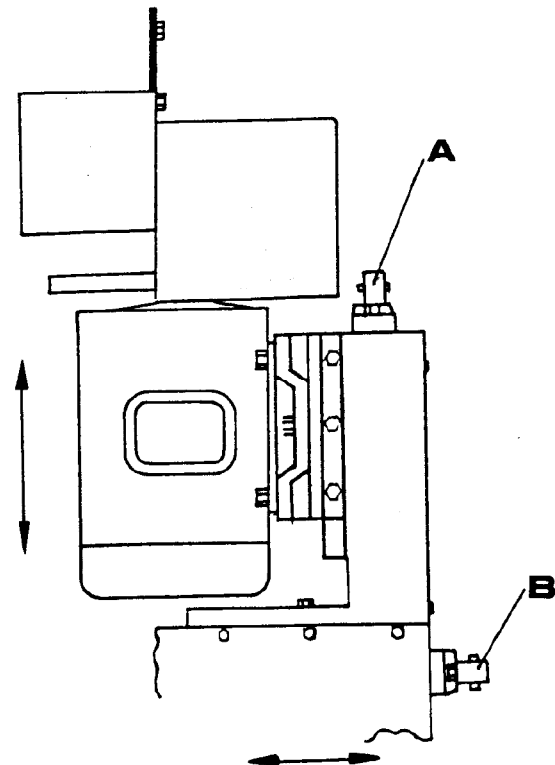
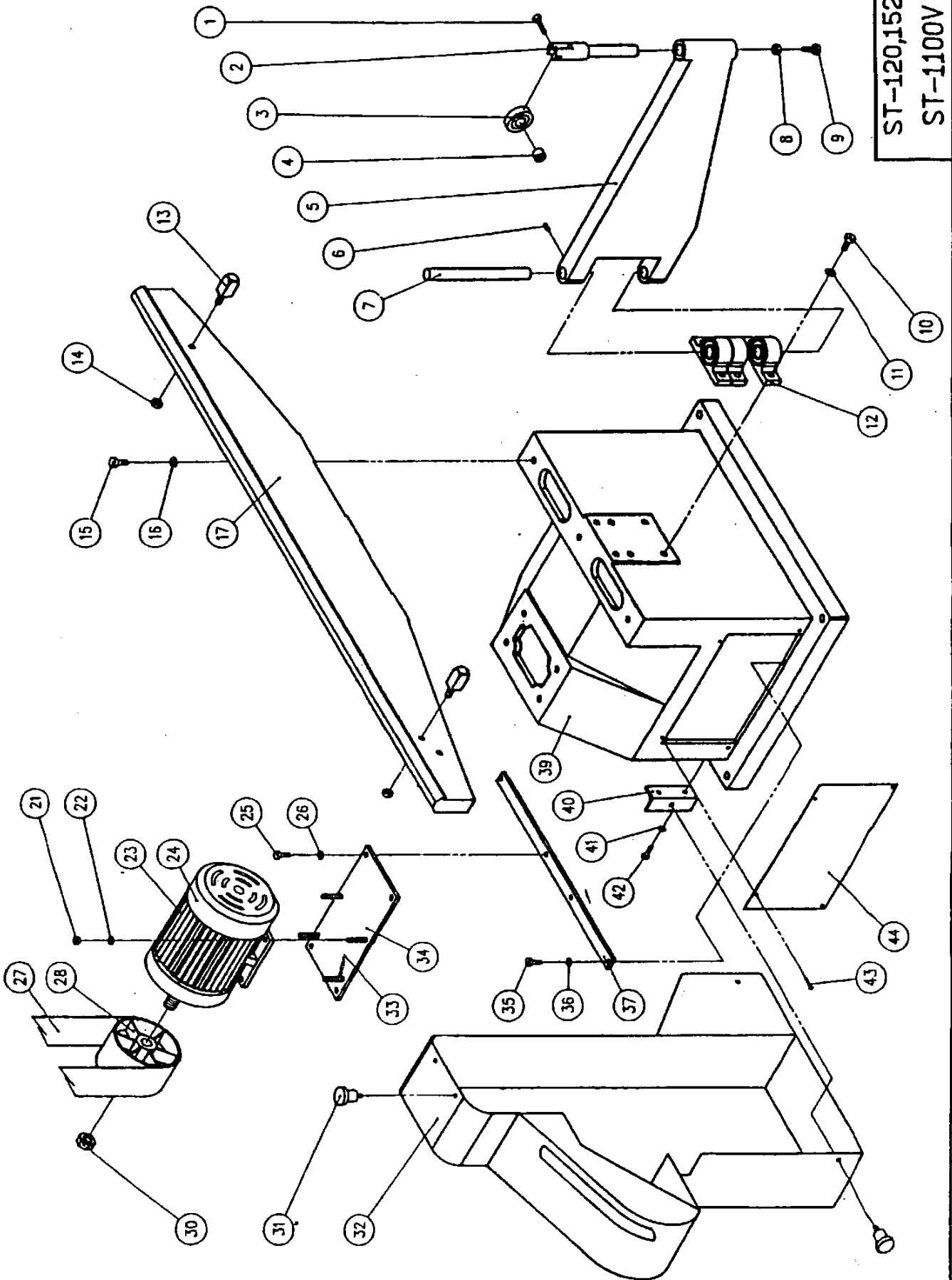


FIG7

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ST-1100V



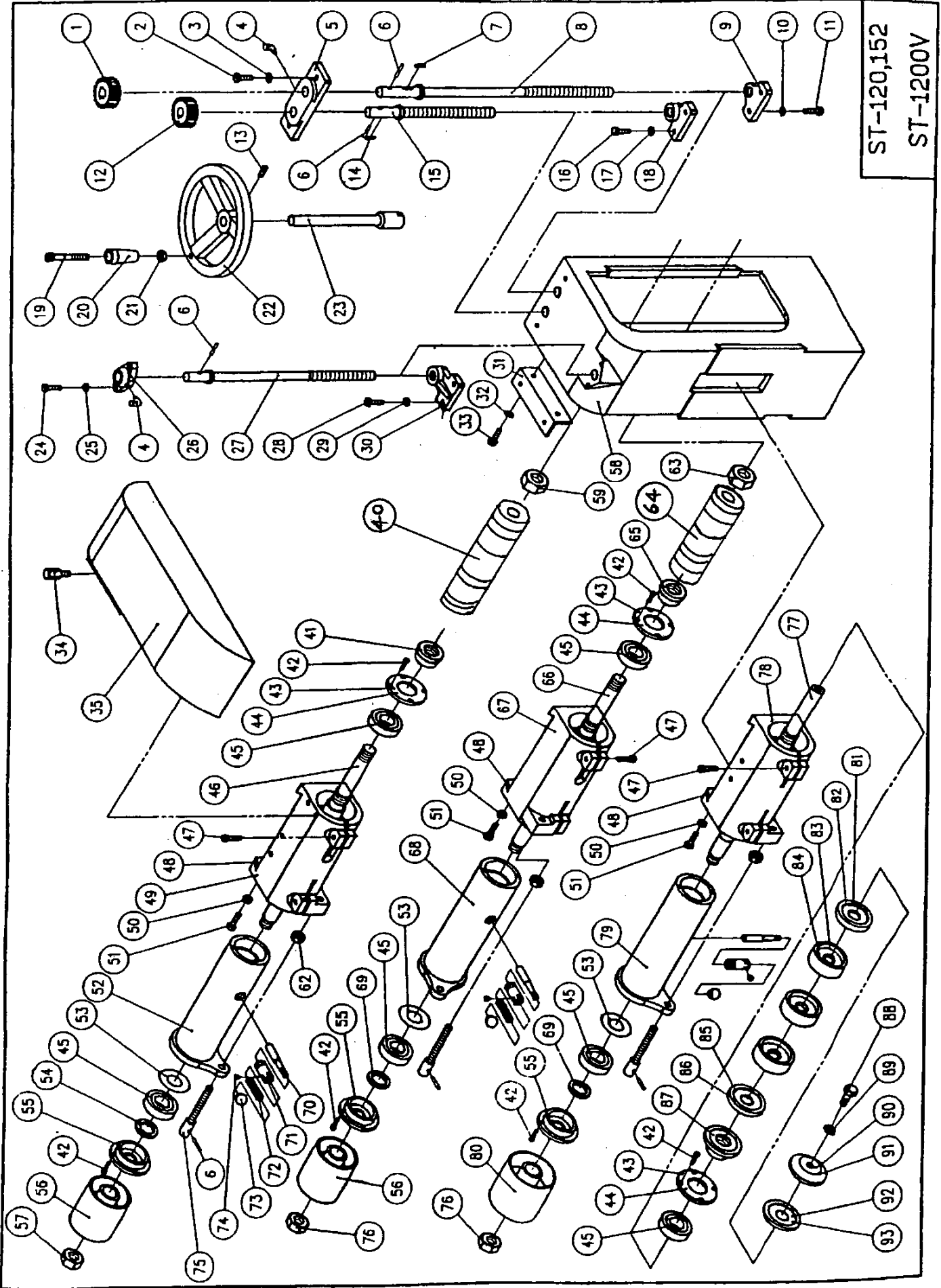
# **TURB-O-WEB CUTTING MACHINE / ST-152P**

## **SPARE PARTS LIST**

### **Page ST-1100V**

1. Table Roller Bolt
2. Table Roller Support Bracket
3. Table Roller
4. Table Roller Nut
5. Table Support Arm
6. Locking Bolt
7. Arm Axle Shaft
8. Lock Nut
9. Lock Bolt
10. Bolt
11. Washer
12. Axle Plumber Block
13. Table Stop
14. Table Stop Nut
15. Bolt
16. Washer
17. Table Slide Way
21. Nut
22. Washer
23. Motor
24. Motor Fan Cover
25. Bolt
26. Washer
27. Flat Drive Belt
28. Flat Belt Motor Pulley
30. Pulley Nut
31. Plastic Knob
32. End Safety guard
33. Motor Mounting Bolt
34. Motor Mounting Plate
35. Bolt
36. Washer
37. Motor Support Strut
39. Machine Body
40. Guard Mounting Bracket
41. Washer
42. Bolt
43. Bolt
44. Front Cover Plate

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ST-1200V



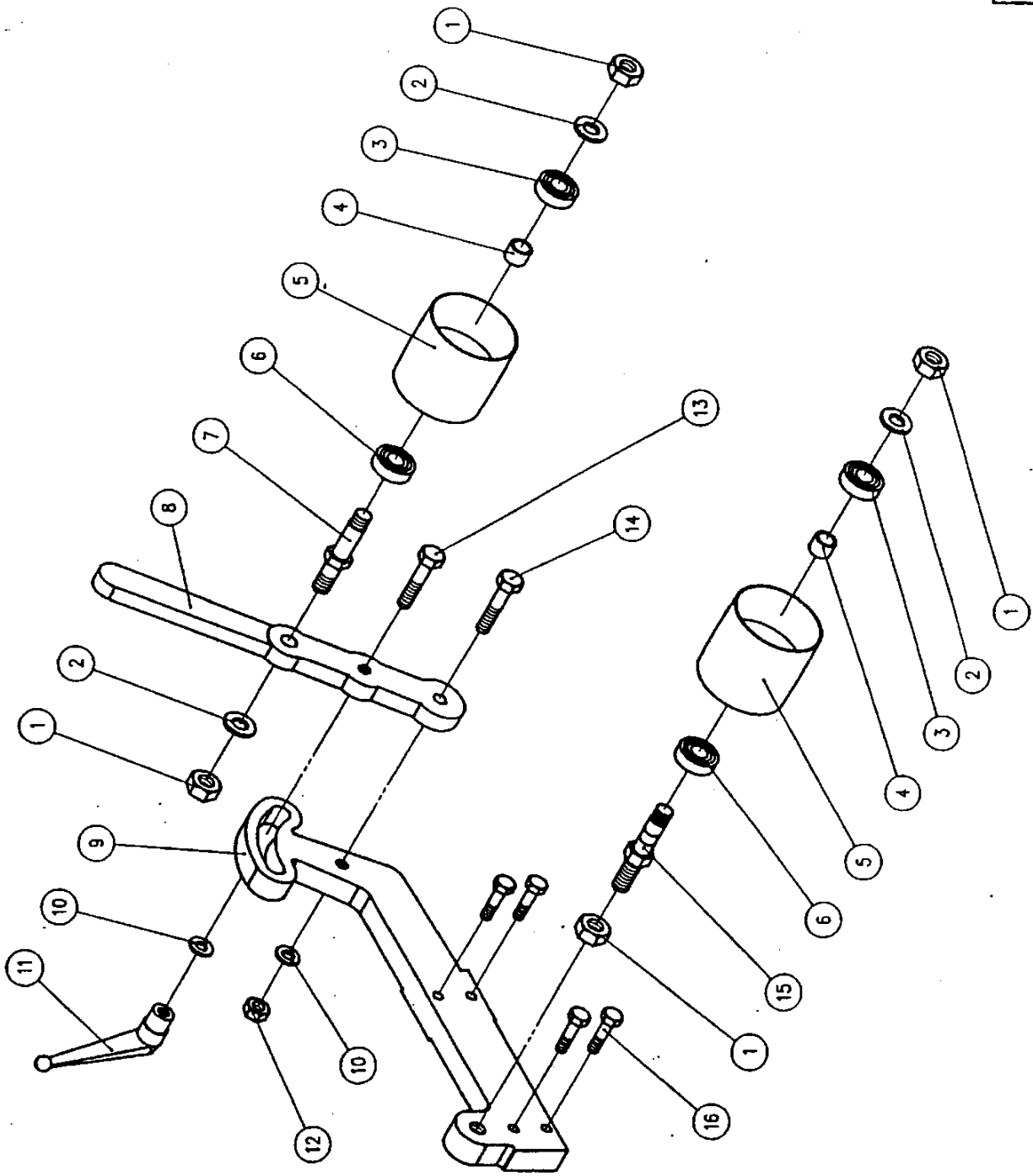
# **TURB-O-WEB CUTTING MACHINE / ST-152P**

## **SPARE PARTS LIST**

### **Page ST-1200V**

- |     |                        |       |                              |
|-----|------------------------|-------|------------------------------|
| 1.  | Gear                   | 45.   | Bearing                      |
| 2.  | Bolt                   | 46.   | Cutter Shaft, 40mm diameter  |
| 3.  | Washer                 | 47.   | Clevice Bolt                 |
| 4.  | Grease Cap             | 48.   | Adjustable Gib               |
| 5.  | Mounting Bracket       | 49.   | Cutter Shaft Housing Casting |
| 6.  | Pin                    | 50.   | Washer                       |
| 7.  | Key                    | 51.   | Bolt                         |
| 8.  | Rise & Fall Screw      | 52.   | Cutter Shaft Mounting Sleeve |
| 9.  | Rise & Fall Nut        | 53.   | Shim Spacer                  |
| 10. | Washer                 | 54.   | Oil Seal                     |
| 11. | Bolt                   | 55.   | Cover Plate                  |
| 12. | Gear                   | 56.   | Flat Belt Pulley             |
| 13. | Pin                    | 57.   | Pulley Nut                   |
| 14. | Pin                    | 58.   | Machine Column               |
| 15. | Rise & Fall Screw      | 59.   | Cutter Shaft Nut             |
| 16. | Bolt                   | 62.   | Nut                          |
| 17. | Washer                 | 63.   | Cutter Shaft Nut             |
| 18. | Rise & Fall Nut        | 64.   | Spacer Rings                 |
| 19. | Handle Bolt            | 65.   | Retaining Nut                |
| 20. | Handle                 | 66.   | Cutter Shaft, 40mm diameter  |
| 21. | Nut                    | 67.   | Cutter Shaft Housing Casting |
| 22. | Handwheel              | 68.   | Cutter Shaft Mounting Sleeve |
| 23. | Handwheel Shaft        | 69.   | Oil Seal                     |
| 24. | Bolt                   | 70.   | Cutter Shaft Locking Pin     |
| 25. | Washer                 | 71.   | Locking Pin sleeve           |
| 26. | Mounting Bracket       | 72.   | Spring                       |
| 27. | Saw Rise & Fall Screw  | 73.   | Plastic Knob                 |
| 28. | Bolt                   | 74.   | Bolt                         |
| 29. | Washer                 | 75.   | Adjustment Screw – Horiz.    |
| 30. | Saw Rise & Fall Nut    | 76.   | Pulley Nut                   |
| 31. | Guard Mounting Bracket | 77.   | Saw Shaft, 1¼" diameter      |
| 32. | Washer                 | 78.   | Saw Shaft Housing Cast       |
| 33. | Bolt                   | 79.   | Saw Shaft Housing Sleeve     |
| 35. | Safety Guard           | 80.   | Flat Belt Pulley             |
| 40. | Spacer Rings           | 81-86 | Saw Spacer Collars           |
| 41. | Retaining Nut          | 87.   | Inside Spacer Collar         |
| 42. | Bolt                   | 88.   | Saw Locking Bolt             |
| 43. | Cover Plate            | 89.   | Washer                       |
| 44. | Seal                   | 90-93 | Saw Spacer Collars           |

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ST-1280V



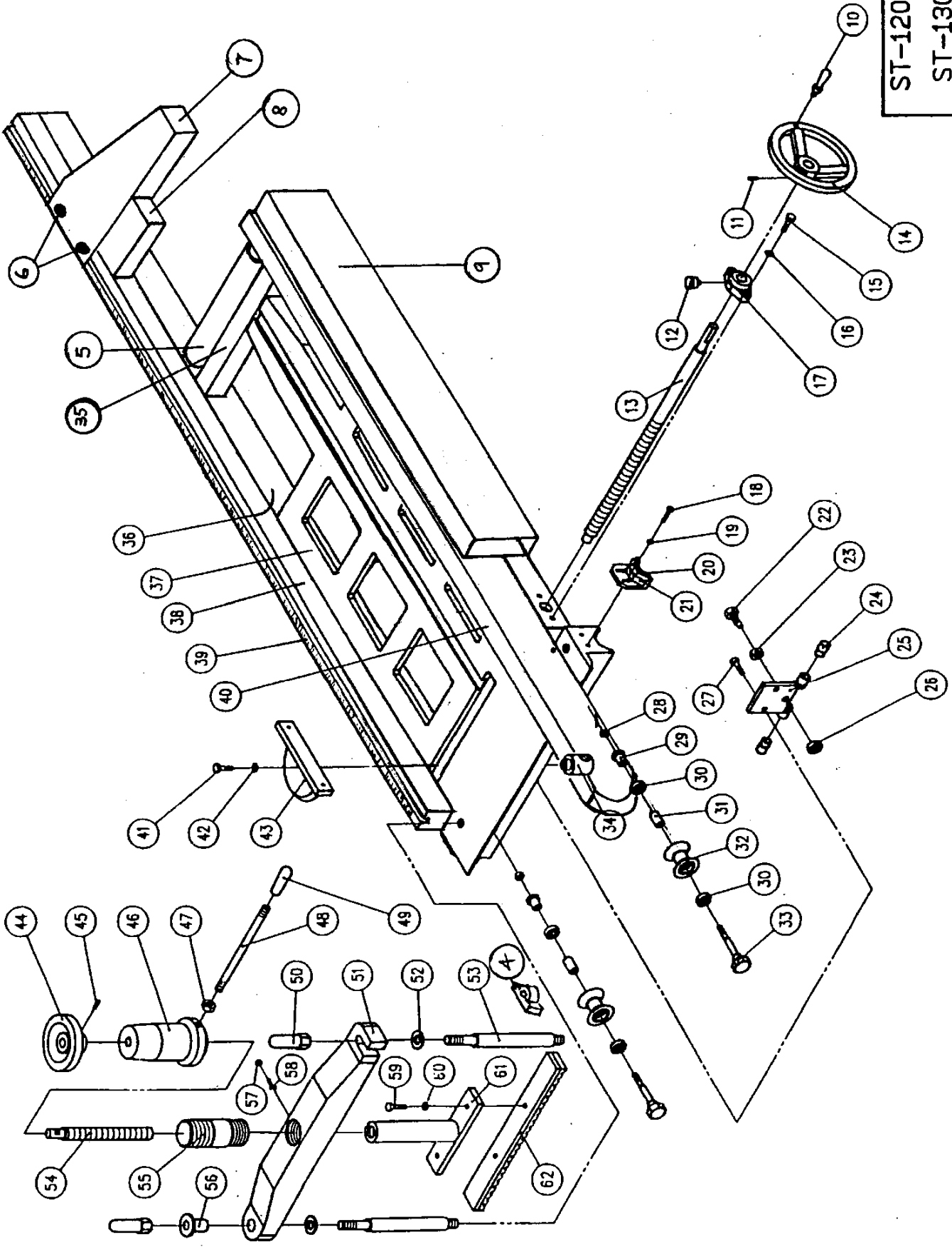
# **TURB-O-WEB CUTTING MACHINE / ST-152P**

## **SPARE PARTS LIST**

### **Page ST-1280V**

1. Nut
2. Washer
3. Bearing
4. Spacer Ring
5. Flat Belt Pulley
6. Bearing
7. Threaded Shaft
8. Belt Tightening Handle
9. Support Casting
10. Washer
11. Kipp Lever
12. Nut
13. Bolt
14. Bolt
15. Threaded Shaft
16. Bolt

ST-120,152  
ST-1300V



# **TURB-O-WEB CUTTING MACHINE / ST-152P**

## **SPARE PARTS LIST**

### **Page ST-1300V**

- |     |                        |     |                       |
|-----|------------------------|-----|-----------------------|
| 4.  | Fence Bracket          | 34. | Double Nut for Clamp  |
| 5.  | Loading Roller         | 35. | Aluminium Frame       |
| 6.  | Plastic Knob           | 36. | Aluminium Frame       |
| 7.  | Length Stop Slide      | 37. | Cast Iron Table       |
| 8.  | Length Stop Block      | 38. | Aluminium Fence       |
| 9.  | Aluminium Frame        | 39. | Measuring Tape        |
| 10. | Handwheel Handle       | 40. | Wooden Fence          |
| 11. | Locking Pin            | 41. | Bolt                  |
| 12. | Oiler with Cap         | 42. | Washer                |
| 13. | Horizontal Clamp Screw | 43. | Horizontal Work Clamp |
| 14. | Handwheel              | 44. | Handwheel             |
| 15. | Bolt                   | 45. | Locking Pin           |
| 16. | Washer                 | 46. | Clamp Boss            |
| 17. | Mounting Bracket       | 47. | Nut                   |
| 18. | Bolt                   | 48. | Clamp Lever           |
| 19. | Washer                 | 49. | Clamp Lever Grip      |
| 20. | Felt Oiler/Cleaner     | 50. | Domed Nut             |
| 21. | Holding Bracket        | 51. | Main Clamp Casting    |
| 22. | Eccentric Bolt         | 52. | Washer                |
| 23. | Locking Nut            | 53. | Clamp Post            |
| 24. | Rubber Stop            | 54. | Vertical Clamp Screw  |
| 25. | Stop Bracket           | 55. | Vertical Clamp Sleeve |
| 26. | Bearing                | 56. | T-Washer              |
| 27. | Bolt                   | 57. | Nut                   |
| 28. | Lock Nut               | 58. | Bolt                  |
| 29. | Nut                    | 59. | Bolt                  |
| 30. | Bearing                | 60. | Washer                |
| 31. | Shaft                  | 61. | Clamp Bracket         |
| 32. | Roller                 | 62. | Top Clamp             |
| 33. | Bolt                   |     |                       |