

OPERATOR'S MANUAL

VM32(L)



**Keep Read and Understand the Operation Manual and Safety Information
Before Operated!**

NOTE

The information contained in this handbook is intended as a guide to the operation of these machines and does not form part of any contract. The data it contains has been obtained from the machine manufacturer and from other sources. Whilst every effort has been made to ensure the accuracy of these transcriptions it would be impracticable to verify each and every item. Furthermore, development of the machine may mean that the equipment supplied may differ in detail from the descriptions herein. The responsibility therefore lies with the user to satisfy himself that the equipment or process described is suitable for the purpose intended.

LIMITED WARRANTY

We Make every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: **ONE YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE.** This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and tear, repair or alterations outside our facilities, or to a lack of maintenance.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, the product or part must be returned to us for examination, postage prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at our expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of our's warranty, then the user must bear the cost of storing and returning the product.

The manufacturers reserve the right to change specifications at any time as they continually strive to achieve better quality equipment.

Copyright. The copyright of this instruction book is the property of us and may not be reproduced or copied without prior consent of us.

WARNING!

Read and understand the entire instruction manual before attempting set-up or operation of this mill/drill

1. **This machine is designed and intended for use by properly trained and experienced personnel only.** If you are not familiar with the proper safe use of mill/drills, do not use this machine until proper Training and knowledge has been obtained.
2. **Keep guards in place.** Safety guards must be kept in place and in working order.
3. **Remove adjusting keys and wrenches.** Before turning on machine, check to see that any adjusting wrenches are removed from the tool.
4. **Reduce the risk of unintentional starting.** Make sure switch is in the OFF position before plugging in the tool.
5. **Do not force tools.** Always use a tool at the rate for which it was designed.
6. **Use the right tool.** Do not force a tool or attachment do a job for which it was not designed.
7. **Maintain tools with care.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubrication and changing accessories.
8. **Always disconnect the tools from the power Source before adjusting or servicing.**
9. **Check for damaged parts.** Check for alignment of moving parts, breakage of parts, mounting, and any Other condition that may affect the tools operation.
10. **Turn power off. Never leave a tool unattended.** Do not leave a tool until it comes to a complete stop.
11. **Keep work area clean.** Cluttered areas and bench Invite accidents.
12. **Do not use in a dangerous environment.** Do not Use power tools in damp or wet locations, or expose Them to rain. Keep work area well lighted.
13. **Keep children and visitors away.** All visitors should be kept a safe distance from the work area
14. **Make the workshop child proof.** Use padlocks, . master switches and remove starter keys.
15. **Wear proper apparel.** Loose clothing, gloves, neckties, rings, bracelets, or other jewelry may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Do not wear any glove.
16. **Always use safety glasses.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are not safety glasses. accessories may be hazardous.
17. **Do not overreach.** Keep proper footing and balance at all times.
18. **Do not place hands near the cutterhead** while the machine is operating.
19. **Do not perform any set-up work while machine is operating.**
20. **Read and understand all warnings posted on the machine.**
21. **This manual is intended to familiarize you with the technical aspects of this mill/drill.** It is not, nor was it intended to be, a training manual.
22. **Failure to comply with all of theses warnings may result in serious injury.**
23. **Some dust created** by power sanding, sawing, grinding, drilling and other construction activites contains chemicals known to cause cancer, birth defects or other reproductive harm.
24. **Your risk from those exposures** varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well ventilated are, and work with approved safety equipment

MAIN TECHNICAL SPECIFICATION

Model	VM32L	
Max. Drilling Capacity	1-3/16"	30mm
Max. End Milling Capacity	25/32"	20mm
Max. Face Milling Capacity	3"	76mm
T-Slot Size	3 @ 35/64" slots	3 @ 14mm slots
T-Slot Centers	2-1/2"	63mm
Table Size	33-5/64" × 8-17/64"	840 × 210mm
Table Travel (X, Y)	22-53/64" × 8-5/64"	580 × 205mm
X/Y-Axis Travel per Handwheel Revolution	0.1"	
Spindle Stroke	2-3/4"	70mm
Distance from Spindle to Column	8-17/64"	210mm
Distance from Spindle nose to table	18-1/2"	470mm
Drawbar Thread Size	7/16"	
Drawbar Length	12-1/2"	318mm
Head Tilt (Left/Right)	90 Deg.	
Spindle Taper	R8	
Number of Spindle Speeds	Variable	
Vertical Spindle Speeds	100 - 2250 RPM	
Motor Type	Brushless 2HP	
Power Requirement	Single Phase 110V 60Hz	
Rated Current	10A	
Packing Size	39-5/8" × 28-3/4" × 46"	
Net Weight	445.4 lbs.	
Gross Weight	551.3 lbs.	

The specifications in this manual are given as general information and are not binding. WEISS reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fitting and accessory equipment deemed necessary for any reason whatsoever.

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WARNING

**Read and understand the entire contents of this Manual before attempting set-up or operation!
Failure to comply may cause serious injury!**

CONTENTS OF SHIPPING CONTAINER

- 1 VM32L Milling & Drilling Machine
- 1 7/16" Drawbar (installed on the machine)
- 1 Digital Scale & Speed Readout
- 1 Test Flow Chart
- 1 Operator manual
- 1 Toolbox & Tools

Toolbox Contents (Fig. 01)

- 1 Oil Gun
- 1 R8 Arbor
- 2 Double End Spanner (17-19, 12-14mm)
- 6 Hex Socket Wrench (2.5,3,4,5,6mm)
- 1 Flat Blade Screwdriver
- 1 Cross Blade Screwdriver
- 4 Handle
- 2 M12 "T" Screw
- 2 M12 Washer
- 2 M12 Nut



Fig. 01

Unpacking and Clean-up

- 1. Finish removing the wooden crate from around the mill/drill.
- 2. Unbolt the machine from the crate bottom.
- 3. Sling mill/drill with the proper equipment.
- 4. Clean all rust protected surfaces using a mild commercial solvent, kerosene or diesel fuel. Do not use paint thinner, gasoline, or lacquer thinner. These will damage painted surfaces. Cover all cleaned surfaces with a light film of machine oil.

Assembly

1. Screw handles (A, Fig.02) onto handwheel (B, Fig.3) and tighten.
2. Repeat for remaining handles of table.

Installation



WARNING!

Machine is heavy! Use an appropriate lifting device and use extreme caution when moving the machine to its final location. Failure to comply may cause serious injury!

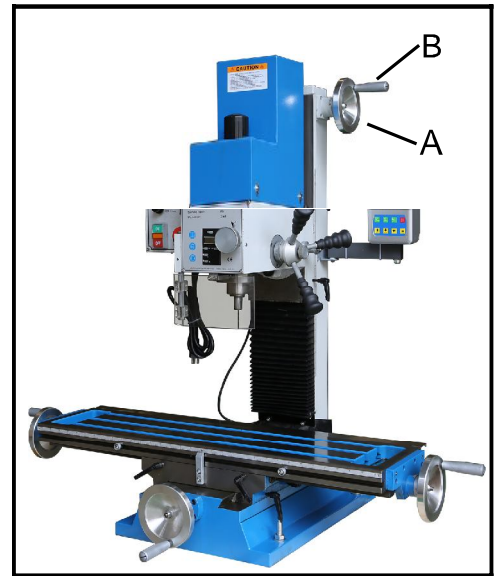


Fig. 02

1. The location for the mill/drill should be well lit, dry, and have room enough to allow the head to rotate 360°.
2. Carefully lift the mill/drill with properly rated equipment to a sturdy stand or working bench. For best performance, through bolt the mill/drill to a stand.
We do not recommend that unattached machines be operated, as the machine will move during operation!
3. Before bolting the mill/drill to a bench or stand, the unit must be level in both directions. Place a level on the table in both directions.
4. If the table of mill is not to level, shim under the low corner(s) until level. Tighten the fastening bolts. Check for level again. Adjust as necessary until the mill/drill is level. Check again when securing bolts are tightened.

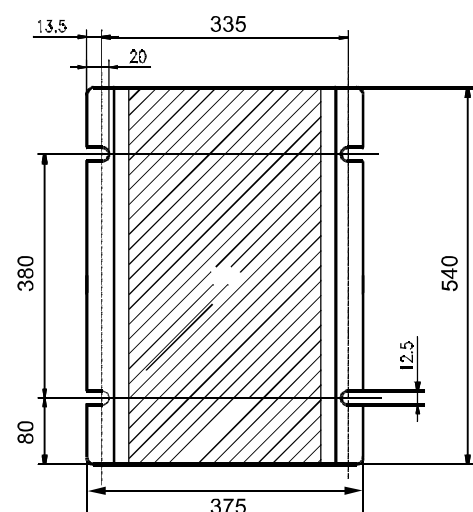
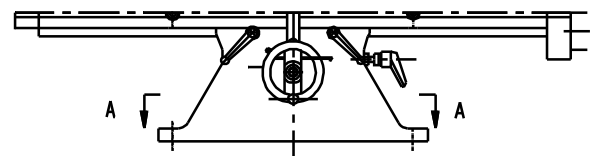


Fig. 03

Installation Drawing (Fig. 03)

The installation drawing described below may differ from the real dimensions. The tolerances are in the range of the general tolerances according to DIN 7168.

CONTROL

Longitudinal Handwheel (A, Fig. 04)

Located on two side of the table. Moves table side to side.

Cross Feed Handwheel (B, Fig. 04)

Located on the front of the base. Moves table toward, or away from the column.

Head Elevating handwheel (C, Fig.05),

Locate on the right of column. The head can be adjusted up or down to suit height requirements for different workpieces. Turn it clockwise to up head on the column and counter-clockwise to down. **When the head is at the desired height, lock in place with the locks.**

Caution: Have to loosen the locks for the slideways before above operation!

Adjustable Table Stops (D, Fig.06)

Located on table front. Adjust to stop table at any setting along the longitudinal axis.

Table locks

Longitudinal table locks (E, Fig. 06) are located on front of the table. Cross-feed table locks (F, Fig.05) are located on the right side under the table. Turn clockwise to lock the slideways.

Mill Head locks (G, Fig.07)

Located on the right of column. Turn clockwise to lock the mill head.

Quill Lock Lever (H, Fig. 07)

Located on the left of the mill head. The height of the spindle can be locked with the quill lock lever. Set the desired height with the quill lever and turn the lever down. Turn clockwise to lock the quill, reverse to loosen.

Caution: For best results. All milling operations should be done with the quill/spindle as close to the head assembly as possible. Lock spindle, table and mill head in place before starting milling operations!

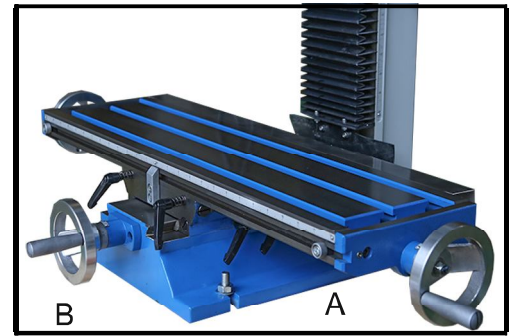


Fig. 04



Fig. 05

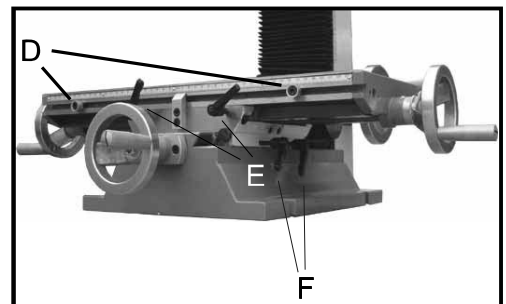


Fig. 06



Fig. 07

Down feed Handles: (J, Fig. 08):

Located on the right side of the head casting. Counter-clockwise movement advances the quill toward the table. Return spring retracts the handles. **The knob (K, Fig. 08) must be loose before the operating the handles.** The graduated dials (L, Fig. 08) on the handle base can be indexed or “zeroed” to help make accurate and convenient movements.

Fine Down Feed

Turn counter-clockwise the knob (K, Fig. 08) to engage the fine down feed knob (M, Fig. 08) what located on the front of the head. Turn it according to you want to move downward, Clockwise turn the hand wheel to down feed the spindle, reverse to retract it.

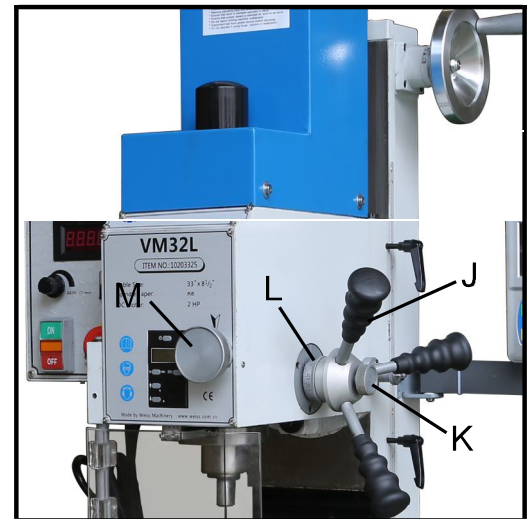


Fig. 08

Mill Head Rotation

The head is designed to tilt 90° either left or right, enabling it to perform task such as angle drilling or horizontal slotting. Loosen the lock nuts (N, Fig. 09) under the head. Rotate the head to its desired position, using the reference guide (O, Fig.09). Once in place, re-tighten the lock nuts.

Note: make sure to provide support for the head so it doesn't unexpectedly rotate on its own. Always maintain control of the head.

Keep in mind that the head must be dialed in when it's returned to the “zero” position if high levels of accuracy are required. If you are able to use an angle vise to accomplish your milling operation without tilting the mill head, you will save yourself a good amount of set-up time.

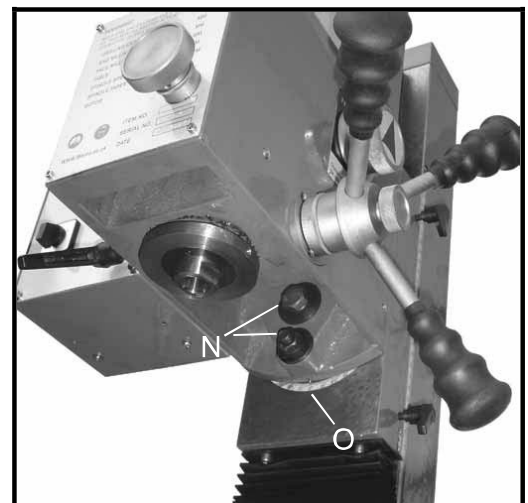


Fig. 09

ELECTRICAL CONNECTIONS

WARNING!

A qualified electrician must make all electrical connections!

Failure to do so may cause serious injury!

Before connecting the machine to the mains, make sure that the electrical values of the mains supply are the same as those for the machine's electrical components. Use the wiring diagram (Fig. 11) for connecting the lathe to the mains supply.

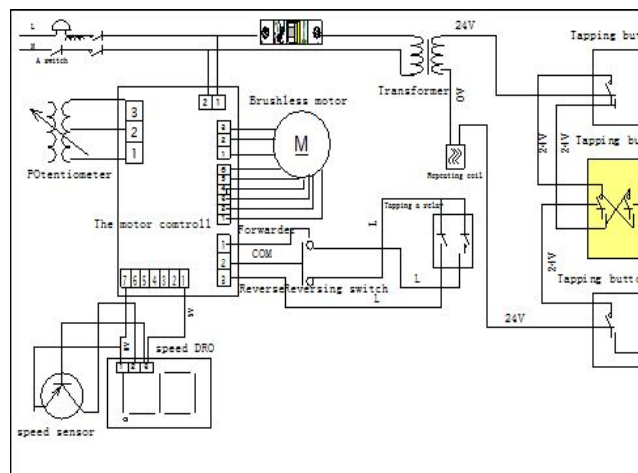


Fig.11

WARNING!

Make sure the machine is properly ground!

Failure to do so may cause serious injury and damage to user!

Brushless Motor

its type is 94BL-1145S 110V 2HP

Make sure that all 2 phase (L, N) are connected. Defective or incorrect connection will render the guarantee null and void.

Indicators are:

Motor runs hot immediately (3-4 minutes).

Motor doesn't run silently and has no power.

Magnetic Switch (A, Fig.12) has the function of emergency stopping and the protective function to the machine and electric components. Green push button marked "I" to start the motor, Red push button marked "O" to switch the motor off.

Speed Control Knob (B, Fig. 12) turn it clockwise to increase the spindle speed, reverse to decrease. The knob should be turned to zero each time the machine is stopped. Always start the machine with the knob set at zero.

F/R switch (C, Fig.12) changing the position of switch will reverse the direction of the motor. F-forward direction, R- reverse direction.

Fuse Base (D, Fig. 13) located on the back plate of electrical box. Fuse what rate is 15A is put in the base. Turn counter-clockwise the button to open and change the fuse, reverse to retighten.

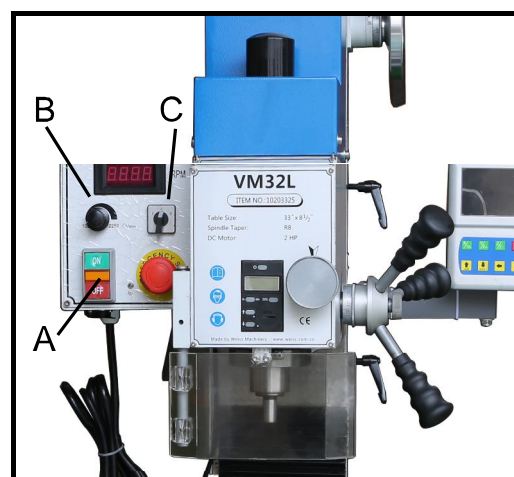


Fig.12

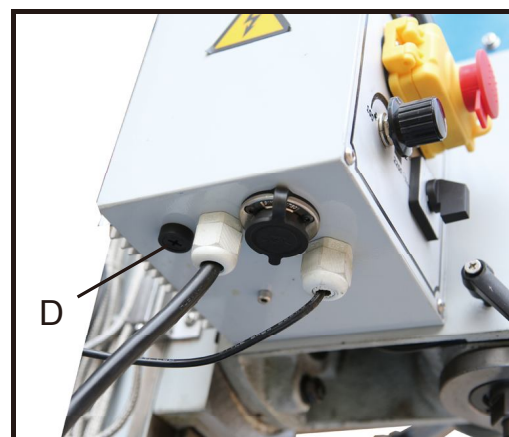


Fig.13

⚠ WARNING!

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Arbor Replacement

1. Disconnect machine from the power source, unplug.
2. Remove the cover of drawbar onto the motor cover (A, Fig. 14).
3. Hold the flat of spindle (B, Fig.15) to keep it from moving while loosening the drawbar (C, Fig 16) with the 22-25 spanner in toolbox.
4. Loosen the drawbar approximately three to four full turns.
5. Tap the drawbar head with a rubber mallet to dislodge the arbor.
6. Grasp the arbor with one hand while loosening the drawbar with the other. Continue to loosen the drawbar until the arbor can be withdrawn from the spindle. Wipe out the spindle with a clean dry rag.
7. Wipe down the new arbor with a clean dry rag and place the arbor into the spindle. Thread the drawbar into the arbor. Tighten the drawbar with a spanner while holding the spindle.

WARNING!

Do not loosen the drawbar more than three or four turns before hitting with a rubber mallet. Damage to the drawbar threads may occur!

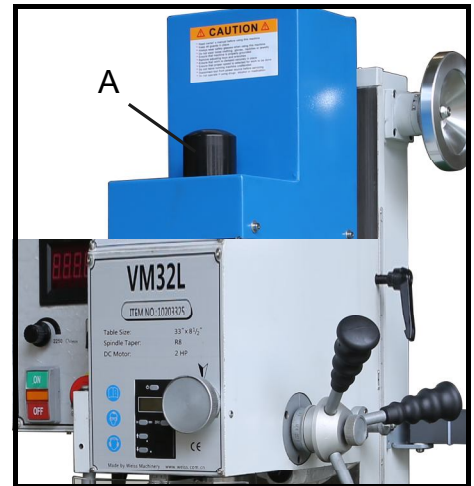


Fig. 14

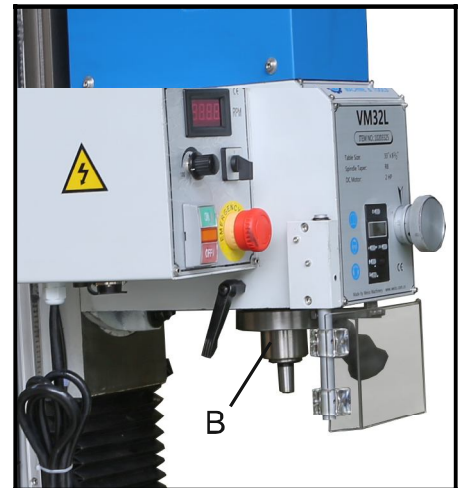


Fig. 15



Fig. 16

GIBS ADJUSTMENT

After a period of time, movement of the table over the ways will cause normal wear. Adjust the gibs to compensate for this wear.

1. The horizontal gib adjustment screw (A, Fig.17) is found to the rear right on table. The traverse gib adjustment screw (B, Fig.17) is found on the right side of saddle under the table. The vertical gib adjustment screw (C, Fig.18) is found onto the column.
2. Loose the screw from small taper end of gib. Turn the screw from large taper end of gib slightly clockwise to tighten. Turn the table handwheel and check the tension.
3. Re-adjust as required.

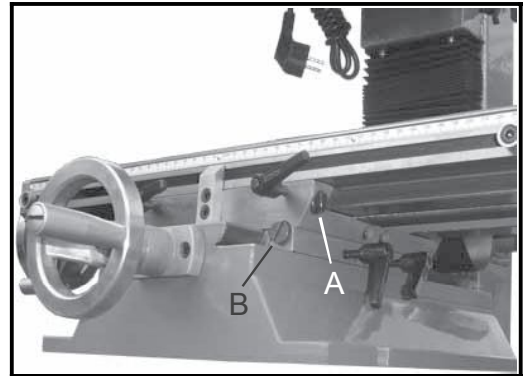


Fig. 17

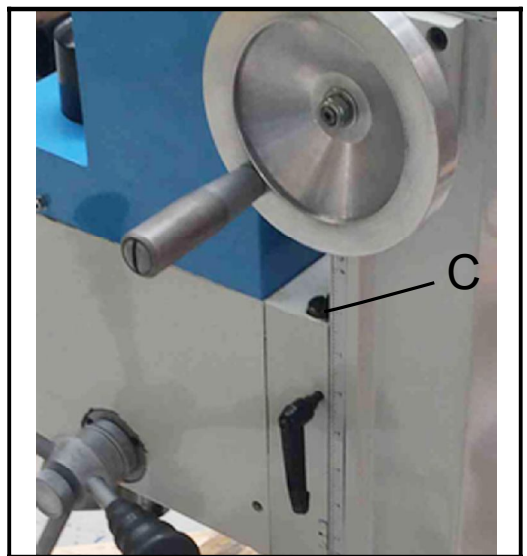


Fig. 18

Maintenance

Keep the maintenance of the machine tool during the operation to guarantee the accuracy and service life of the machine.

1. In order to retain the machine's precision and functionality, it is essential to treat it with care, keep it clean and grease and lubricate it regularly. Only through good care, you can be sure that the working quality of the machine will remain constant. **Disconnect the machine plug from the mains supply whenever you carry out cleaning, maintenance or repair work!**
2. Lubrication all slideways lightly before every use. The leadscrew must also be lightly lubricated with lithium base grease.
3. During the operation, the chips what falls onto the sliding surface should be cleaned timely, and the inspection should be often made to prevent chips falling into sliding ways. Asphalt felt should be cleaned at certain time. **Do not remove the chips with your bare hands. There is a risk of cuts due to sharp-edged chips.**
4. After the operation every day, eliminate all the chips and clean different part of the machine and apply machine oil to prevent rusting.
5. In order to maintain the machining accuracy, take care of the arbor, drawbar, the surface of the worktable and the guide way and avoid mechanical damage and the wear due to improper guide.
6. If the damage is found, the maintenance should be done immediately.

Trouble Solution

Problem	Possible Cause	Solution
Too chatters	Gibs too loose on table, column Unused feeds not locked Mill head not locked Quill too loose Tool not on center Improper tool shape, tool dull	Readjust gibs Lock all axes but the one moving Lock mill head Tighten quill lock Center tool reshape, sharpen, or replace tool
Depth of cut is not consistent	Quill moving Setup wrong	Lock quill Make sure setup is parallel to table
Hole is off center or bit wanders	Bit dull Bit not mounted correctly in chuck Chuck loose in spindle Drawbar not secured Bearing loosen or worn Cutting too fast	Use sharp bits Remount tool Remount chuck on arbor Tighten drawbar Tighten or replace bearings Reduce speed
Bit turns erratically or stops	Bit fed into work too fast	Reduce feed rate
Chuck is difficult to tighten or loosen	Chuck sticking Debris in chuck	Apply lubricant Clean chuck
Chuck wobbles	Chuck loose on arbor Drawbar not tight	Clean arbor and remount Clean spindle and replace drawbar
Turn on machine and nothing happens	Machine unplugged Loose electrical connections	Plug in machine Tighten wiring connections

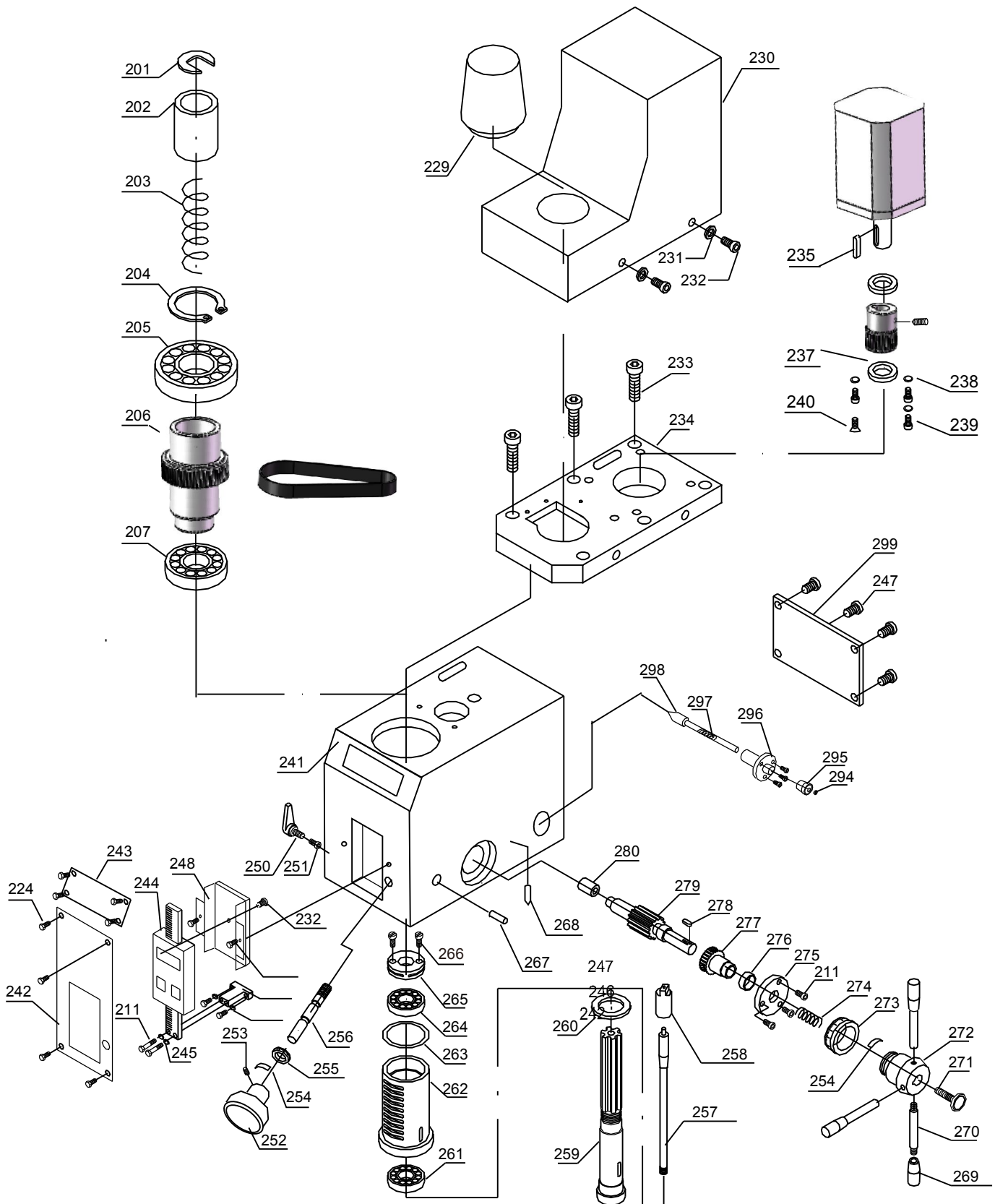
PARTS LIST FOR VM32L



Keep Read and Understand the Operation Manual and Safety Information
Before Operated!

MILLING & DRILLING MACHINE

Mill Head Assembly



MILL HEAD ASSEMBLY I

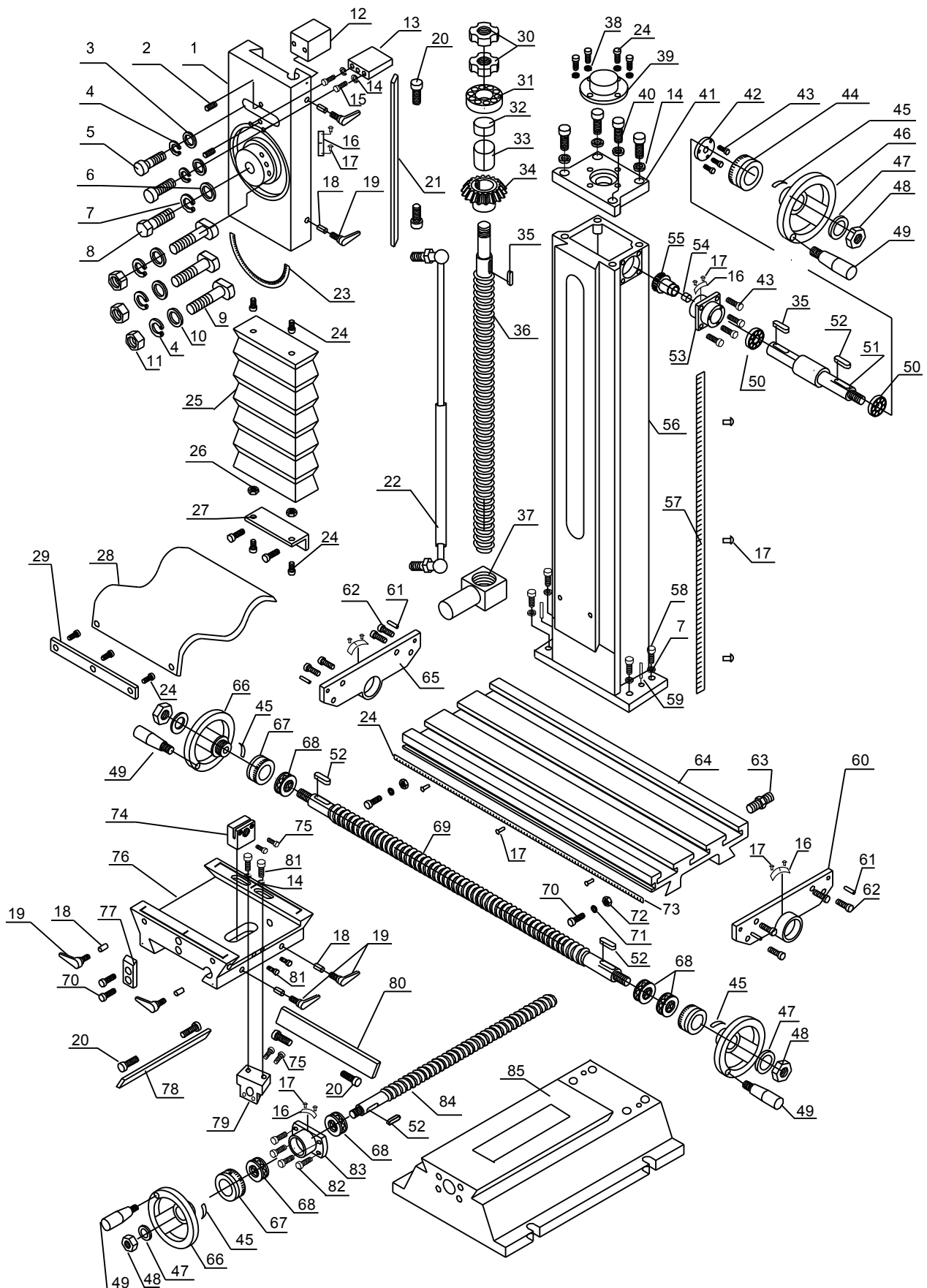
Parts No.	Description	Specification	Qty	Code NO.
201	Position Washer		1	30213101
202	Bush		1	30213102
203	Spring	3×Φ29×150	1	50670130
204	Snap Ring	Φ100	1	50640653
205	Bearing	6211-2RZ	1	50406211
206	Gears	39/64T	1	30213103
207	Bearing	6207-2RZ	1	50406207
208	Snap Ring	Φ72	1	50640644
209	Snap Ring	Φ15	1	50640813
210	Gears	39T	1	30213104
211	Hex Head Cap Srew	M4×10	2	50619042B
212	Guard		1	30213105
213	Snap Ring	Φ35	2	50640624
214	Bearing	6202-2RZ	2	50406202
215	Shafting Gear	31/56T	1	30213106
216	Shaft		1	30213107
217	Key	5×16	1	50644033
218	Key	6×50	1	50644058
219	Pin	2x10	2	50643310
220	Raster Ring	16Bore	1	30213108
221	Hex Head Cap Srew	M3×8	2	50619032B
222	Sensor		1	51809001
223	Bracket for finder		1	30213109
224	Hex Head Cap Srew	M3×6	12	50619031B
225	Washer	Φ3	2	50637903B
226	Nut	M3	2	50630203B
227	Screw	M4×16	1	50615154
228	Terminal		1	38140202
229	Drawbar Cover		1	30213110
230	Motor Cover		1	30213111
231	Washer	Φ4	4	50635804B
232	Hex Head Cap Srew	M4×8	7	50619041B
233	Hex Head Cap Srew	M6×30	6	50619065

Parts No.	Description	Specification	Qty	Code NO.
234	Motor Plate		1	30213112
235	Motor		1	38014240
236	Hex Head Cap Srew	M8×16	4	50619071
237	Spring Washer	8	4	50637808B
238	Key	5×20	1	50644035
239	Gear	20T	1	30213113
240	Snap Ring	Φ14	1	50640812
241	Mill Head		1	30213114
242	Label		1	39213100
243	Label		1	39213000
244	Digital Scale		1	23070100
245	Washer	Φ4	6	50637904B
246	Base		1	30213115
247	Screw	M4×8	8	50615251
248	Bracket		1	30213116
249	Plate			30213117
250	Locking Lever	M8×20	1	50661066
251	Brass Pin		1	30213118
252	Knob		1	30213119
253	Set Screw	M5×6	1	50618850A
254	Spring Piece		2	50674004
255	Dial		1	30213120
256	Worm Shaft		1	30213121
257	Drawbar		1	30213005
258	Retainer cup		1	30213122
259	Spindle		1	30213123
260	Ring		1	30213124
261	Bearing	32007	1	50432007
262	Sleeve		1	30213125
263	Rubber Ring	69×5.3	1	50650220
264	Bearing	32006	1	50432006
265	Adjusted Nut		1	30213126
266	Hex Head Cap Srew	M5×12	2	50619052
267	Pin	A6×35	1	50642306

Parts No.	Description	Specification	Qty	Code NO.
268	Pin	2×10	1	30213127
269	Handle		3	30213128
270	Handle Lever		3	30213129
271	Locking Knob	M8	1	30213130
272	Base		1	30213131
273	Dial		1	30213132
274	Spring	1.5×Φ15×29	1	50670115
275	Flange		1	30213133
276	Washer		1	30213134
277	Worm Gear	25T	1	30213135
278	Key	6×16	1	50644048
279	Gear Shaft		1	30213136
280	Block		1	30213137
281	H/L Speed Indication Label		1	30213901
282	Set Screw	M8×8	1	50618670
283	Spring	0.8×Φ5×25	1	50670080
284	Ball	Φ6.5	2	50650325
285	Knob		1	30213138
286	Set Screw	M5×10	2	50618852A
287	Rivet	2×3	4	50626720
288	H/L Speed Label		1	30213902
289	Flange		1	30213139
290	Fork Shaft		1	30213140
291	Set Screw	M5×8	1	50618851A
292	Fork Arm		1	30213141
293	Fork		1	30213142
294	Nut	M6	1	50634606
295	Knob		1	30213143
296	Bracket		1	30213144
297	Spring	0.9×Φ8×20	1	50670090
298	Pin		1	30213145
299	Rear Plate		1	30213146

MILLING & DRILLING MACHINE

Column, Table, Base Assembly



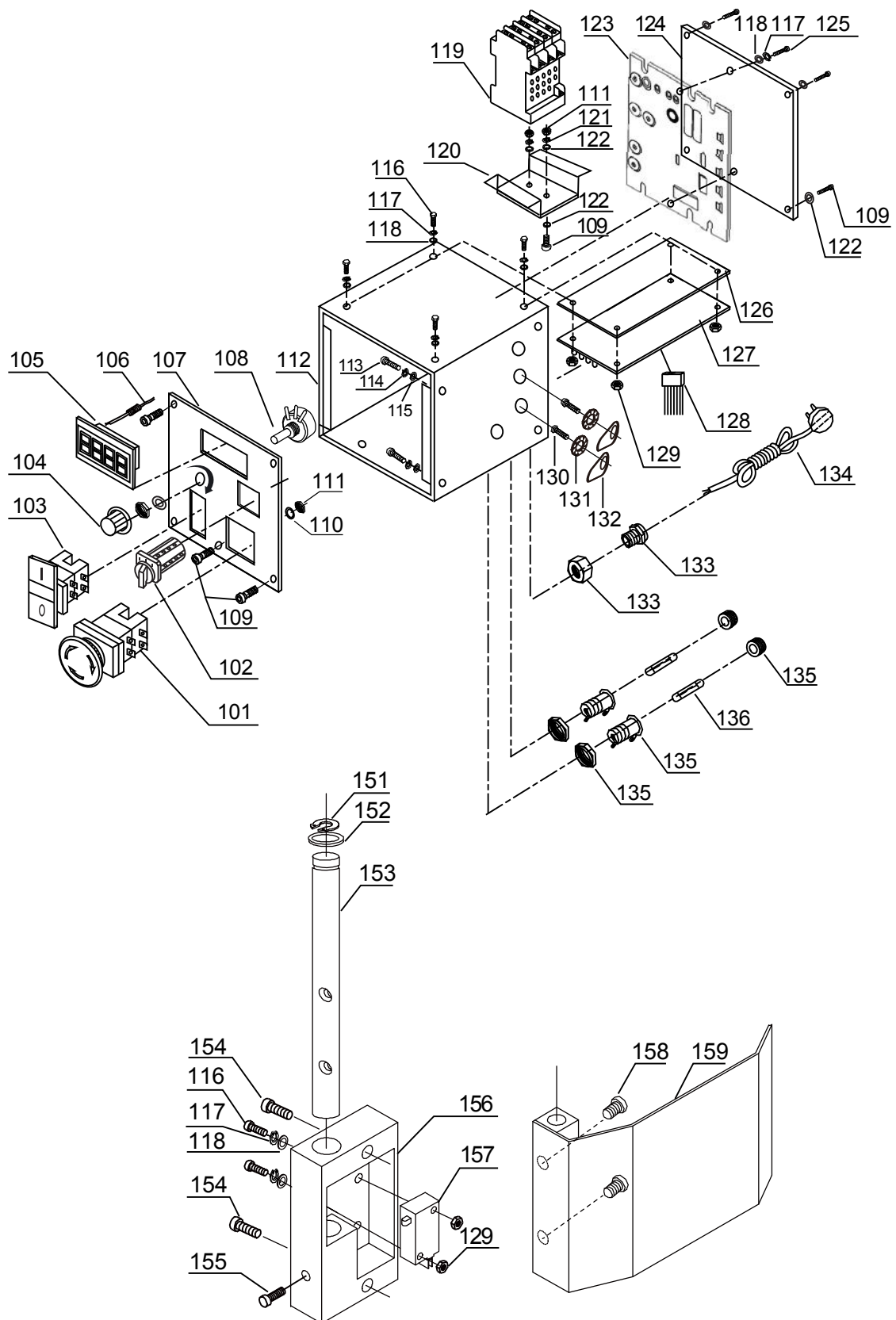
COLUMN, TABLE, BASE ASSEMBLY

Parts No.	Description	Specification	Qty	Code NO.
1	Vertical Slide		1	30213201
2	Set Screw	M6×16	2	50618864A
3	Washer	Φ10	2	50637910
4	Spring Washer	10	5	50637810
5	Hex Head Cap Srew	M10×35	2	50619085
6	Washer	Φ12	1	30213202
7	Spring Washer	12	5	50637812
8	Screw	M12×40	1	50612864
9	T-Bolt	M10×60	3	50611333
10	Washer	Φ10	3	30213203
11	Nut	M10	1	50630210
12	Block		1	30213204
13	Block		1	30213205
14	Spring Washer	8	8	50637808
15	Hex Head Cap Srew	M8×25	2	50619073
16	Postion label		5	3L922001
17	Rivet	2×3	16	50626720
18	Brass Pin		6	30213206
19	Locking Lever	M6×25	6	50661065
20	Gib Screw		6	30213207
21	Gib		1	30213208
22	Air spring		1	50675025
23	Angle Indication Label		1	30213903
24	Hex Head Cap Srew	M5×12	13	50619052B
25	Dust Cover	150mm	1	30213209
26	Nut	M5	2	50630205B
27	Connect Rib		1	30213210
28	Dust Cover		1	30213211
29	Connect Rib		1	30213212
30	Nut	M16×1.5	2	50632916
31	Bearing	51203	1	50451203
32	Brass spacer bush		1	30213213
33	Steel spacer bush		1	30213214
34	Gear	26T	1	30213215

Parts No.	Description	Specification	Qty	Code NO.
35	Key	4×16	2	50644023
36	Vertical Leadscrew		1	30213216
37	Nut		1	30213217
38	Washer	Φ5	4	50637905B
39	Cover		1	30213218
40	Hex Head Cap Srew	M8×20	4	50619072
41	Bracket		1	30213219
42	Flange		1	30213220
43	Hex Head Cap Srew	M5×12	7	50619052
44	Dial		1	30213221
45	Spring Piece		4	50674004
46	Handwheel		1	30213222
47	Washer	Φ8	4	50637908
48	Locking Nut	M8	4	50631708
49	Handle	M10×80	4	30213223
50	Bearing	6001-2RZ	2	50406001
51	Shaft		1	30213224
52	Key	4×10	4	50644020
53	Bearing Housing		1	30213225
54	Bush	Φ14 45#steel	1	30213226
55	Gear	26T	1	30213227
56	Column		1	30213228
57	Label		1	30213904
58	Hex Head Cap Srew	M12×65	4	50619097A
59	Pin	A6×50	2	50642308
60	Right Bracket		1	30213301
61	Pin	A6×25	4	50642304
62	Hex Head Cap Srew	M6×16	8	50619062
63	Plug		1	30213302
64	Working Table		1	30213303
	Working Table(L)		1	30213303L
65	Left Bracket		1	30213304
66	Handwheel		3	30213306
67	Dial		3	30213307
68	Bearing	51201	5	50451201

Parts No.	Description	Specification	Qty	Code NO.
69	Longitudinal Leadscrew		1	30213308
	Longitudinal Leadscrew(L)		1	30213308L
70	Hex Head Cap Srew	M6×10	4	50619058B
71	Bush	45#steel	2	30213309
72	Nut		2	30213310
73	Scale		1	30213905
74	Longitudinal Nut		1	30213311
75	Adjusted Screw	M4×14	4	50619044
76	Coross Slide		1	30213312
77	Position Block		1	30213313
78	Cross Gib		1	30213314
79	Cross Nut		1	30213315
80	Longitudinal Gib		1	30213316
81	Hex Head Cap Srew	M8×30	4	50619074
82	Hex Head Cap Srew	M6×20	4	50619063
83	Bearing Housing		1	30213317
84	Cross Leadscrew		1	30213318
85	Base		1	30213319

ELECTRICAL ASSEMBLY



ELECTRICAL ASSEMBLY

Parts No.	Description	Specification	Qty	Code NO.
101	Emergency Switch	YW1B-V4E01R	1	38053001
102	F/R Switch	ZH-DC-3-06 240~400V 3PH	1	38062053
103	ON/OFF Switch	TN2 BTY-1AB	1	38056201
104	Timing Knob		1	51820901
105	Speed Display		1	38150001
106	Cable		1	38141002
107	Electrical Plate		1	30213910
108	Potentiometer	WX14-12 4k7	1	51820047
109	Hex Head Cap Srew	M4×8	11	50619041B
110	Tooth Washer	4	1	50636704
111	Nut	M4	2	50630204B
112	Electrical Box		1	30213950
113	Hex Head Cap Srew	M5×8	4	50619050B
114	Spring Washer	5	4	50637805B
115	Washer	Φ5	4	50637905B
116	Hex Head Cap Srew	M3×18	6	50619036B
117	Spring Washer	3	8	50637803B
118	Washer	Φ3	8	50637903B
119	AC Contactor	S-P06	1	38021006
120	Bracket For AC Contactor		1	30213952
121	Spring Washer	4	2	50637804B
122	Washer	Φ4	8	50637904B
123	Speed Control	JYMC-220B-I	1	38080004
124	Cover		1	30213951
125	Hex Head Cap Srew	M3×8	2	50619032B
126	Bracket For Filter		1	51852902
127	Filter		1	51852004
128	Detect Cable		1	38141001
129	Nut	M3	6	50630203B
130	Hex Head Cap Srew	M5×12	2	50619052B
131	Tooth Washer	5	2	50636705
132	Ground Label	1	2	3L911001
133	Strand Relief		1	38109101
134	Plug		1	38100131
135	Fuse Holder		2	38131520
136	Fuse	10A	2	38130020

Parts No.	Description	Specification	Qty	Code NO.
151	Snap Ring	Φ12	1	50640810
152	Washer	Φ12	1	50637712
153	Rod		1	30213960
154	Hex Head Cap Srew	M5x16	2	50619053B
155	Set Screw	M5×10	1	50618852A
156	Bracket		1	30213961
157	Micro Switch		1	38060101
158	Screw	M4×10	2	50615253
159	Protective Cover		1	30213962

VM32(L)

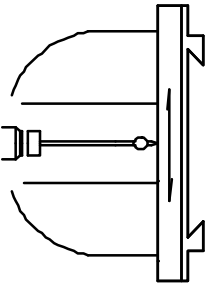
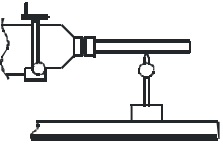
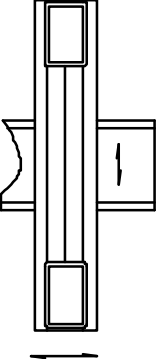
1. Visual Inspection	OK	4. Electrical Inspection	OK
a. Correct label	☐	a. CE electrical units	☐
b. Painting damage	☐	b. Function of source switch	☐
c. Corrosion damage	☐	c. High/low speed switch	☐
d. Screw tightened	☐	d. Emergency stop button	☐
2. Mechanical Inspection	OK	e. Function of power lighting	☐
a. Spindle up and down	☐	f. Function of forward button	☐
b. Spindle fine down feed	☐	g. Function of reverse button	☐
c. Mill head up and down	☐	h. Function of stop button	☐
d. Table move left and right	☐	i. Function of elevating switch	☐
e. Clearance of longitudinal leadscrew	☐	j. Function of tapping switch	☐
f. Saddle move front and back	☐	k. Function of safety cover	☐
g. Clearance of cross leadscrew	☐	l. Function of power feed	☐
h. Locks for spindle,table ,mill heac	☐	m.Function of motors	☐
g. Correct dials	☐	n. Function of SINO DOR	☐
3. Active Inspection	OK	5. Final Inspection	OK
a. Function of mill head	☐	a. Correct accessories	☐
b. Function of selecting speed levers	☐	b. Correct documents	☐
c. Running test	☐	c. Machine cleanness	☐
d. Noise test	☐	d. Credibility antitrust	☐
e. Leaky test	☐	e. Correct mark	☐
Remark:			

Test Record

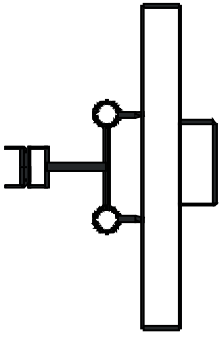
VM32(L)

Serial No.	
Date	
Inspector	

VM32(L)

NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
1	Flatness of table		0.04/500	
2	Parallelism of T slot to table movement		0.05 / 500	
3	Parallelism of table to table movement a in longitudinal b in cross		a 0.025/200 b 0.025/200	
4	Runout of spindle hole a at spindle nose b 300 distance		a 0.01 b 0.02/150	
5	Squareness of table longitudinal and cross movement		0.025/200	

VM32(L)

NO.	INSPECTION ITEM	DIAGRAM	TOLERANCE(mm)	
			PERMISSIBLE	ACTUAL
6	Squareness of spindle axis to table a right & left b forward & backward		a 0.05/200 b 0.05/200	