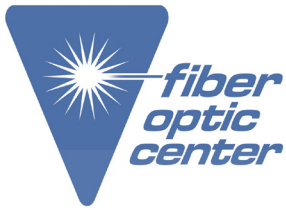


MANUAL

**Manufacturer:**

Seikoh Giken

Product Name:

Seikoh Giken SFP-550C High Duty Cycle Fiber Optic Polishing Machine

Manufacturer Part Number:

SFP-550C

▶ [Click here for more details on the Seikoh Giken SFP-550C High Duty Cycle Fiber Optic Polishing Machine](#)

Click the thumbnail below to navigate to the Manual



[SFP-550C
Operating Manual](#)



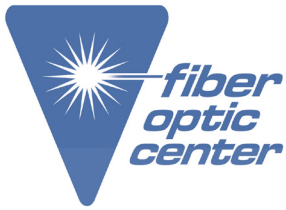
[SFP-550C
Maintenance Manual](#)

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SFP-550C

Operating Manual



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Safety Precautions

This manual shows the following symbols for proper and safety operation of SFP-550C polishing machine and for prevention of damages to the polishing machine.

Below explains meanings of each symbol. Please read and have your understanding and follow the instructions indicated by the markings.

	Warning	Improper handling with negligence of this precaution may result in death or serious injury
	Caution	Improper handling with negligence of this precaution may result in injury or material

Examples of Symbols



This symbol refers to any caution (including danger and warning). Example in the left shows “Warning or Precaution” for safety.



This symbol refers to any prohibition. Example in the left shows “No disassembly.”



This symbol refers “Unplug the power cable from the outlet.”

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Warning



Never touch or gain access to moving parts, the arm of the fiber holder with your hand or finger during operation. Otherwise, you may injure.



- Do not touch the polishing machine during operation.
- Do not replace polishing holder during operation.
- Please unplug power cable after work.



- Do not touch the operation panel or the switch with wet hand or
- Do not connect or disconnect the power cable with wet hand.
- Otherwise, you may get electric shock, accident or failure may occur.



- Be sure to use specified voltage and connect grounding terminal (Class 3 grounding or greater). Otherwise, fire, electric shock, accident or failure may occur



- Turn off the power and unplug the cable from the outlet for the following cases. Otherwise, fire, electric shock, or accident may occur.
- When fuse is replaced (use 2A).
- When any abnormalities such as abnormal odor, smoke or abnormal noise are occurred.

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Caution



Never perform the following actions. Otherwise, fire, electric shock, accident or failure may occur.

- Wear proper uniform and safety shoes when you work
- Place the polishing machine on flat and rigid work table.
- Do not place any object on the polishing machine
- Do not place or leave the polishing machine outdoor or at the place where the polishing machine is exposed to water.
- Be careful not to fall the polishing machine in transport condition.
- Do not apply shock or drop the polishing machine.
- Do not place any objects on the power cable.
- Do not twist or pull the cable strongly.
- Do not operate the polishing machine in unmanned.
- Turn off the switch when leaving from the polishing machine.
- Keep away any flammable substances or explosives from the polishing machine.
- Do not place any objects within 30cm from the cooling fan.
- Do not put anything inside the polishing machine. This may cause accident or failure.
- To prevent corrosion, please remove any liquid completely from the polishing machine and avoid using and keeping the polishing machine in humid condition.
- Do not disassemble the polishing machine more than described in the manual.



Seikoh Giken does not assume any responsibility for products manufactured with the polishing machine.

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Introduction

- Thank you for purchasing SFP-550C Polishing Machine -

This operating manual covers operating procedures for SFP-550C Polishing Machine in depth. Before use, read this manual carefully and familiarize yourself with the various features and functions of this machine.

Features of SFP-550C

SFP-550C is designed to polish ferrule endface of fiber-optic connectors and offers the following features:

High-Yield Operation

Capable of quick polishing of multiple ferrules at once (*number of ferrules to be polished is varied by types of connectors).

Easy Operation

Both maintenance and operation are remarkably easy and require no special skills.

Wide Range of Application

Applicable to FC, SC, and various other connector types in high-physical contact, angled physical contact or flat contact, simply by changing the polishing holder.

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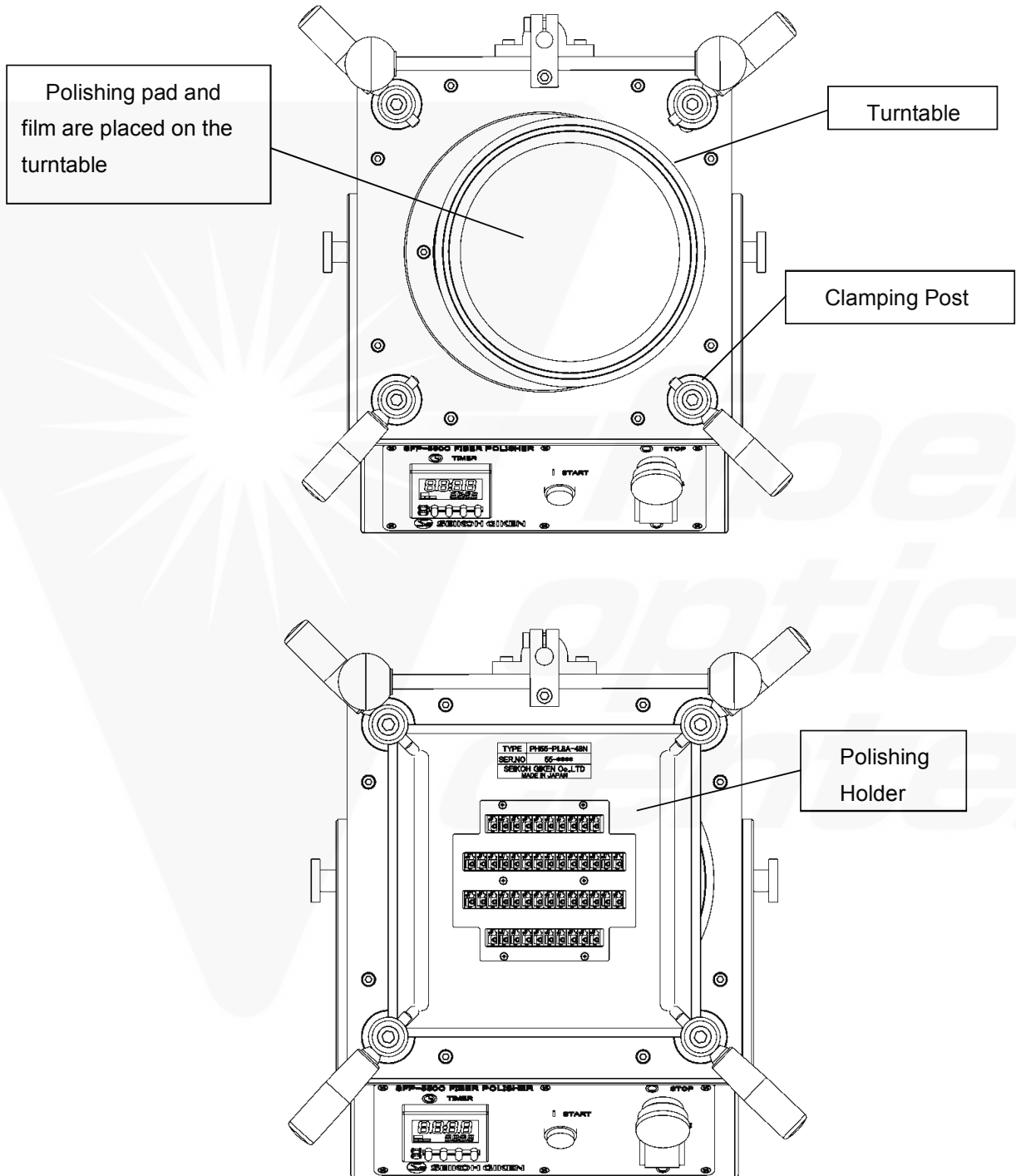
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1. Specifications

1-1 Structure and Parts

1-1-1 Digital Timer Type

Polishing Machine Top View



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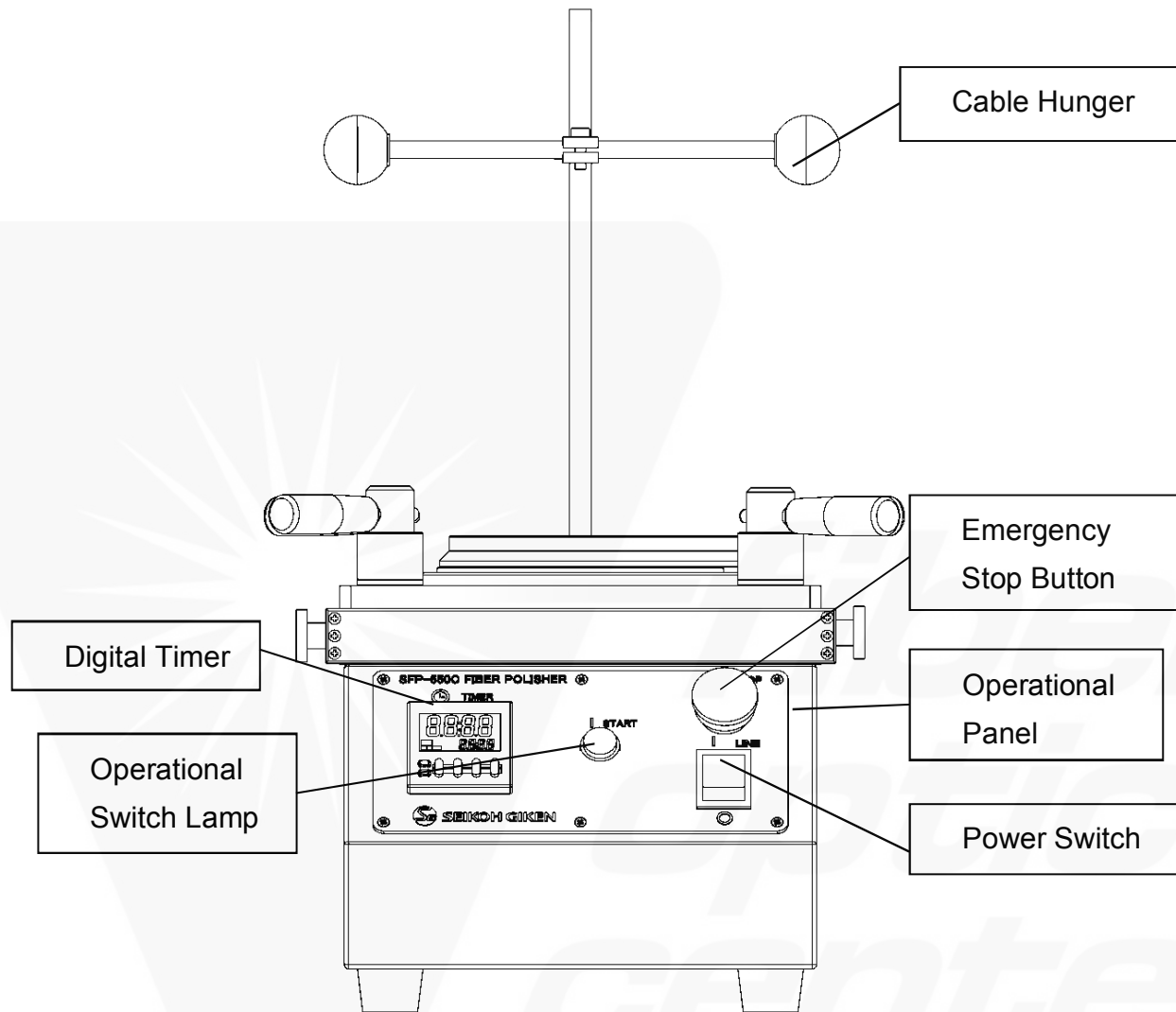
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Polishing Machine Front View



Polishing Machine Rear View

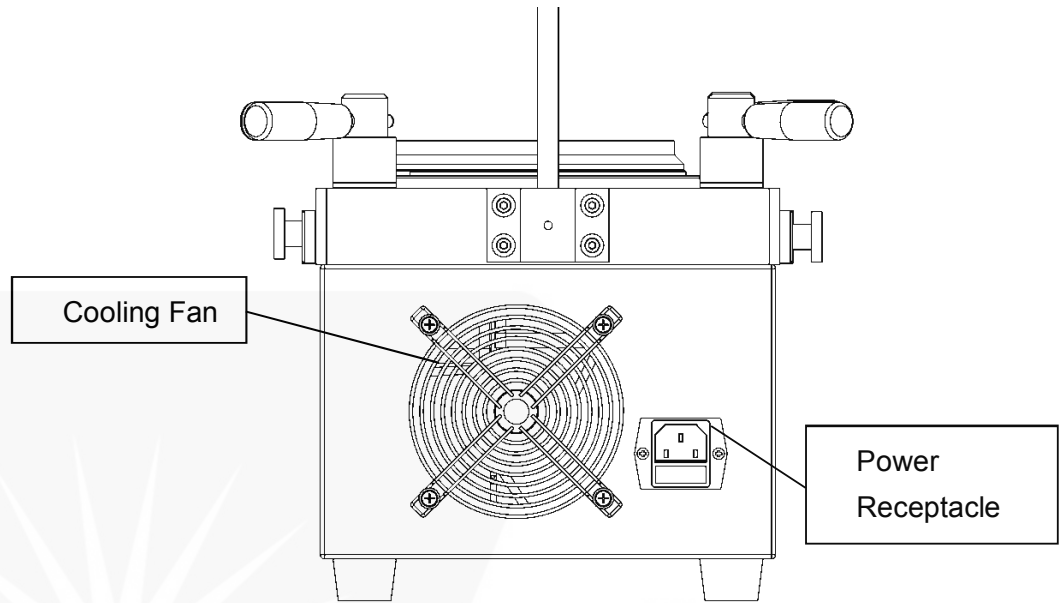
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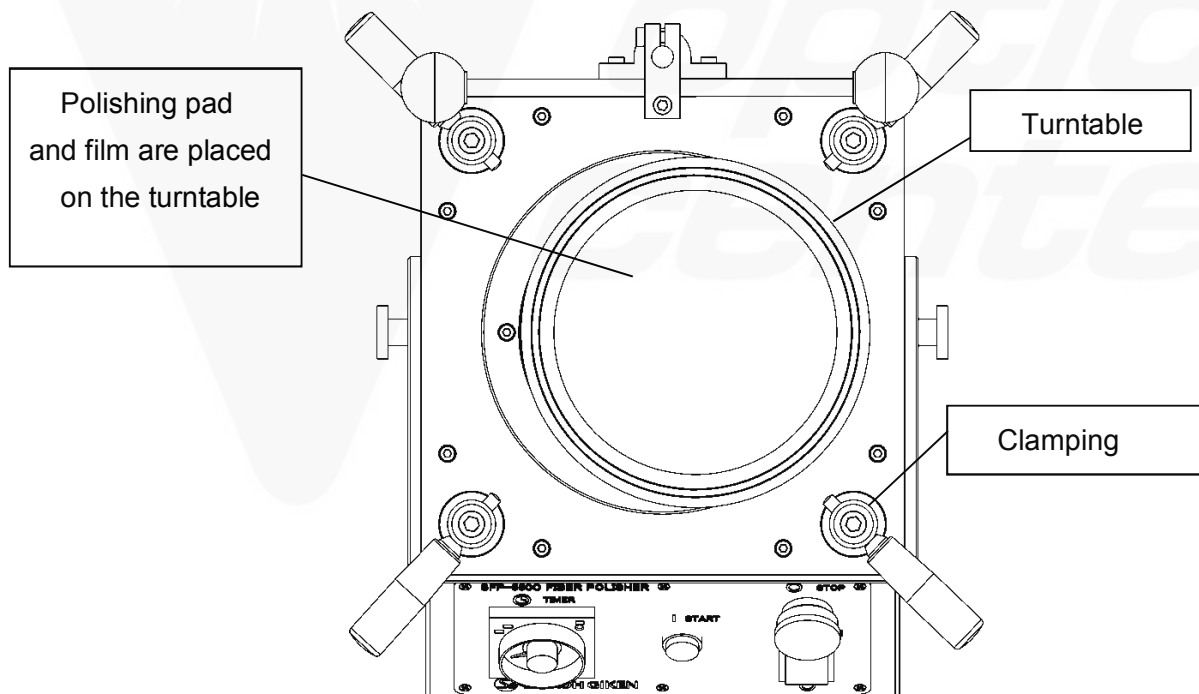
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1.1.2 Analogue Timer Type

Polishing Machine Top View



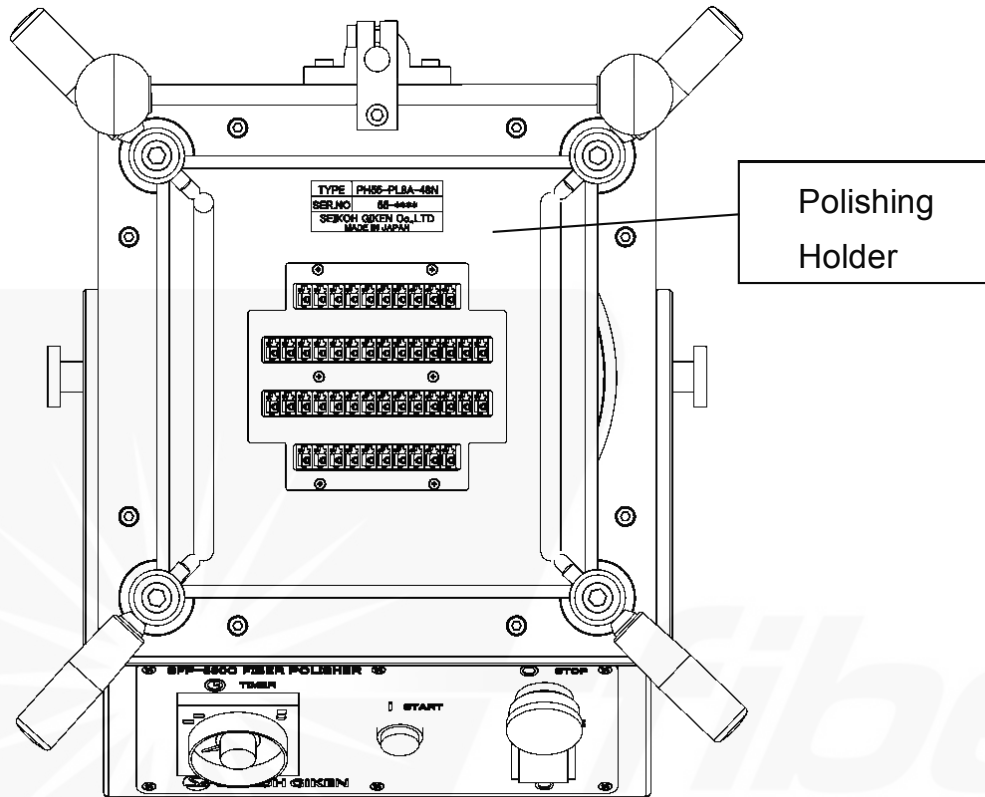
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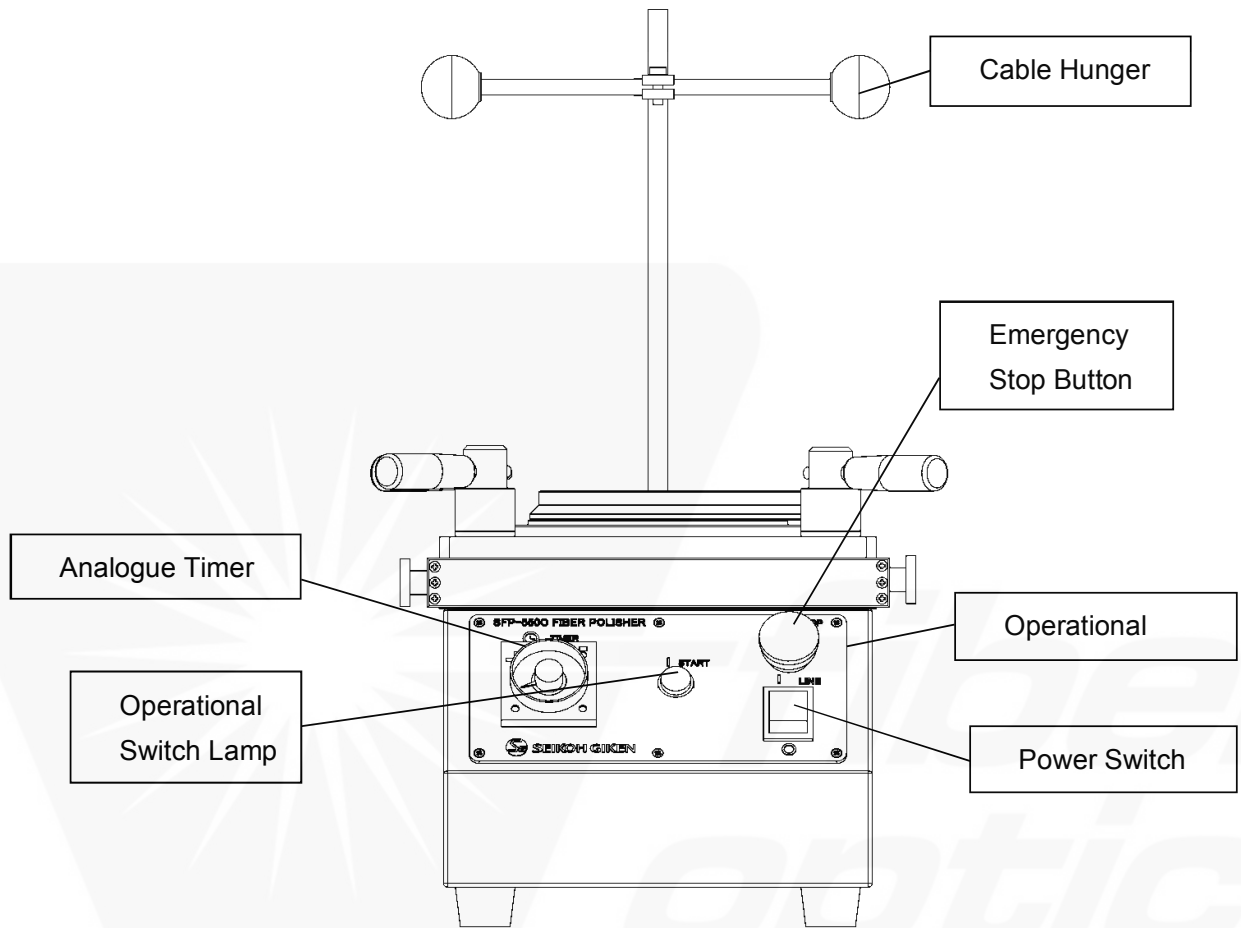
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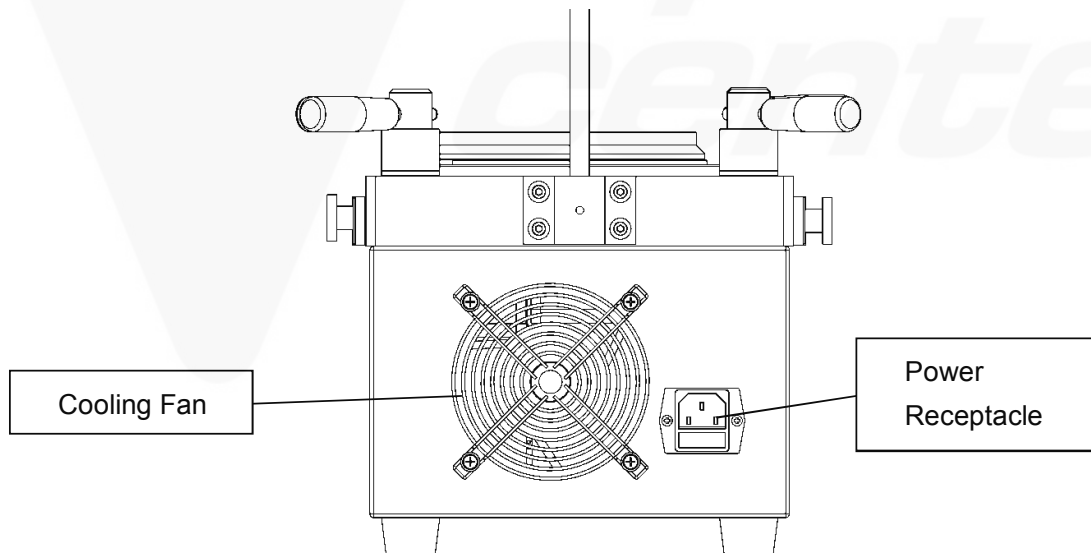
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Polishing Machine Front View



Polishing Machine Rear View



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1-2 Standard Specifications

Item	Specification
Power Supply Voltage, Frequency	AC110—120V: 50Hz/60Hz or AC220—240V: 50Hz/60Hz
Power Consumption	80VA
Drive Unit Revolution Motor (rpm) Rotation Motor (rpm) Cooling Fan	25W Motor with reduction gear (100rpm) 6W Motor with reduction gear (1.8rpm) φ90mm propeller fan
Operating Unit Control Timer Digital timer type Control Timer Analogue timer type Timer Switch	Setting increment: 1 sec. Maximum setting time: 9999 sec. Setting increment: 0.05 min. Maximum setting time: 3.0 min. Green-lamp button(on-off alternately)
Pressurizing Unit Pressurizing Method	By clamps on the four corner with coil spring
Polishing Plates Polishing Film Polishing Pad For Flat Polishing For PC Polishing	Outer diameter: 127mm, plastic base Outer diameter: 127mm Glass pad Synthetic rubber pad
Performance PC Polishing(Pre-radius ferrule) APC Polishing(Step ferrule)	4 processes, 120 sec. 5 processes, 200 sec.
Dimensions and Weight Dimensions Weight	W250 x D305 x H240 mm 16.0 kg

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1-3 Standard Accessories

Parts Name	P/N	Qty
Other Accessories		
Coil spring	RP55C-14	4
2A fuse	RP55-56	1
Hexagon wrench L	RP55C-71	1
Hexagon wrench S	RP55C-72	1
M5-45 bolt	RP55C-73	1
Power cable	RP55-30	1
Cable hanger	FP-CH	1
Manual		
Operation manual	FP-IM55C	1
Process manual	FP-PM55C	1
Maintenance manual	FP-MM55C	1

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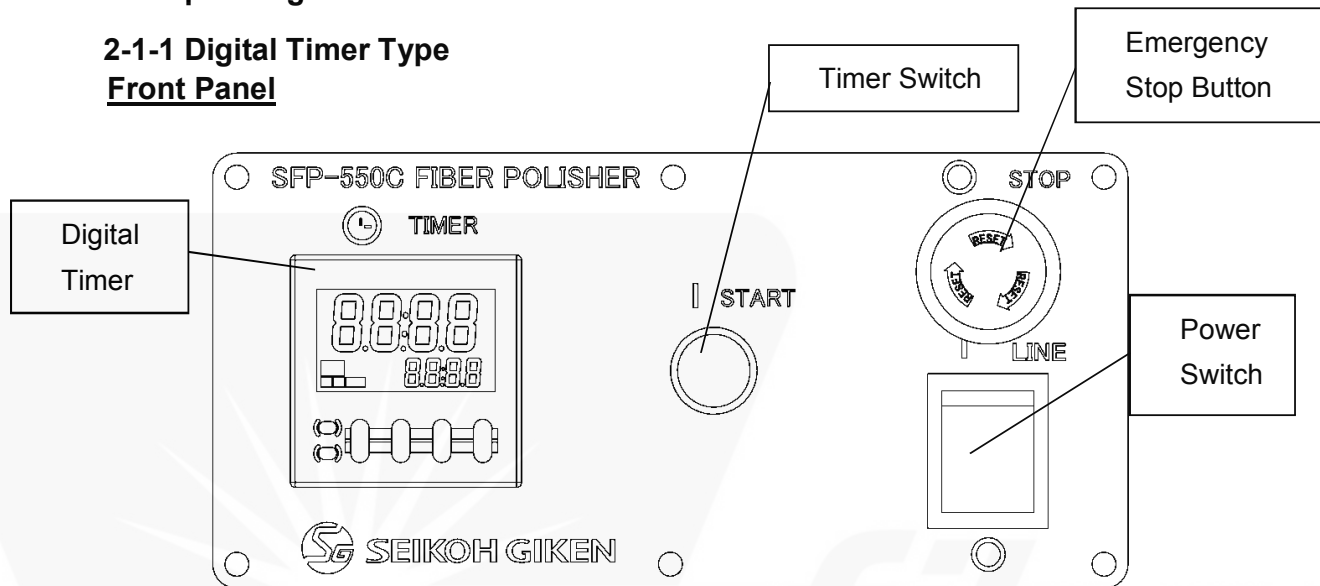
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2. Operating Procedures

2-1 Operating Panel

2-1-1 Digital Timer Type Front Panel



<Procedure>

1) Power Switch ON

Turn on the power switch. The green lamp will light up, and the cooling fan will start running.

2) Timer Switch ON

Turn on the timer switch. The green lamp will light up, and the polishing machine (turntable) will be operating while the timer is running.

After the set time elapses, the polishing machine (turntable) will stop automatically and the green lamp will be off.

3) Emergency Stop Button

Push the Emergency stop button to stop turntable during operation.

Turn the button to resume operation.

4) Power Switch OFF

Make sure you turn off the power switch when you stop or shut down the polishing machine. Check if all switch lamps are off. This power switch alternates ON-OFF functions by pushing.

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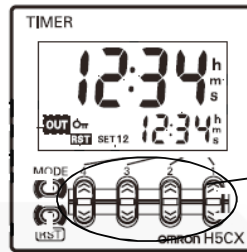
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Digital Timer

Timer setting function is preset as only available in sec (not in minute and hour) before shipment from our factory.

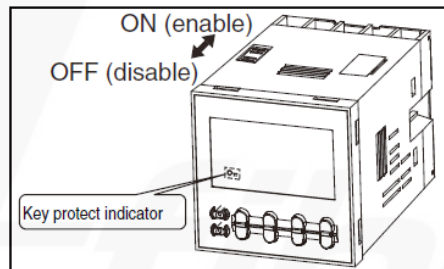


Time setting
1~4

Key-protect Switch Settings

When the key-protect switch is ON, individual key operations can be disabled to prevent setting errors according to the key protect levels (KP-1 to KP-7) shown in the following table.

* Key protect levels are set in function setting mode.



Level	Mode change*	Display switch in the run mode	Reset Key	Up/Down Key
KP-1 (default setting)	Invalid	Valid	Valid	Valid
KP-2	Invalid	Valid	Invalid	Valid
KP-3	Invalid	Valid	Valid	Invalid
KP-4	Invalid	Valid	Invalid	Invalid
KP-5	Invalid	Invalid	Invalid	Invalid
KP-6	Invalid	Invalid	Valid	Valid
KP-7	Invalid	Invalid	Invalid	Valid

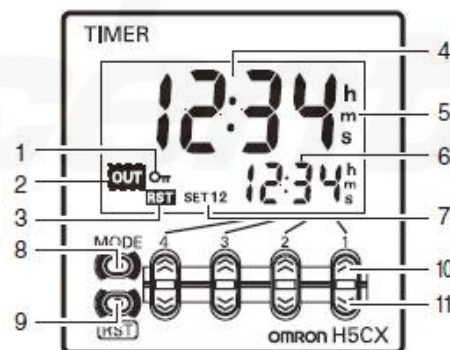
* Changing mode to Timer/Twin Timer selection mode or function setting mode.

● Display Section

1. Key Protect Indicator (orange)
2. Control Output Indicator (orange)
3. Reset Indicator (orange)
4. Present Value Display (Main Display)
(Character height: 12 mm, red*)
*Characters on models with terminal blocks can be switched between red, green, and orange.
5. Time Unit Indicators (If the time range is 0 min, 0.0 min, 0 h, 0.0 h, or 0 h 0 min, these indicators flash to indicate timing operation.)
6. Set Value Display (Sub-display)
(Character height: 6 mm, green)
7. Set Value 1, 2 Indicator

● Operation Key

8. Mode Key (Changes modes and setting items)
9. Reset Key (Resets present value and output)
10. Up Keys 1 to 4
11. Down Keys 1 to 4



Parameters are set with the operation keys on the front panel

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- Change from RUN Mode to Function Setting Mode.



- Set the parameters using the Keys.

Display	Parameter name	Set value	Comments
Time range	Time range	*1	---
UP/DOWN mode	UP/DOWN mode	UP, down *2	---
Output mode	Output mode	A, A-1, A-2, A-3, b, b-1, d, E, F, z, S *2	
Output time	Output time	HOLD/0.01 to 99.99	(If the output time is set to 0.00, HOLD is displayed.) Displayed for modes A, A-1, A-2, A-3, b, b-1 and S only. Unit: second
Input signal width	Input signal width	20mS, 1mS *2	Displayed only for models other than H5CX-L8E□.
NPN/PNP input	NPN/PNP input	NPN, PNP *2	
Display color	Display color	Red, Green, Blue, r-G, G-r, r-B, B-r, G-B, B-G *2	Displayed only for models with terminal blocks.
Set value upper limit	Set value upper limit	1 to 9999	---
Key protect level	Key protect level	KP-1, KP-2, KP-3, KP-4, KP-5, KP-6, KP-7 *2	---
Output ON count alarm set value	Output ON count alarm set value	0 to 9999	× 1,000
Output ON count monitor value	Output ON count monitor value	---	The monitor value is only displayed. It cannot be set. × 1,000

*1 The set values for the time range are as follows:

Display	Set value
--.- s	0.01 s to 99.99 s (default setting)
---.- s	0.1 s to 999.9 s
---- s	1 s to 9999 s
--:-- ms	0 min 01 s to 99 min 59 s
---.- m	0.1 min to 999.9 min
---- m	1 min to 9999 min
--:-- hm	0 h 01 min to 99 h 59 min
---.- h	0.1 h to 999.9 h
---- h	1 h to 9999 h
-.--- s	0.001 s to 9.999 s

*2 After reaching the last set value, the Keys will return to the first set value.

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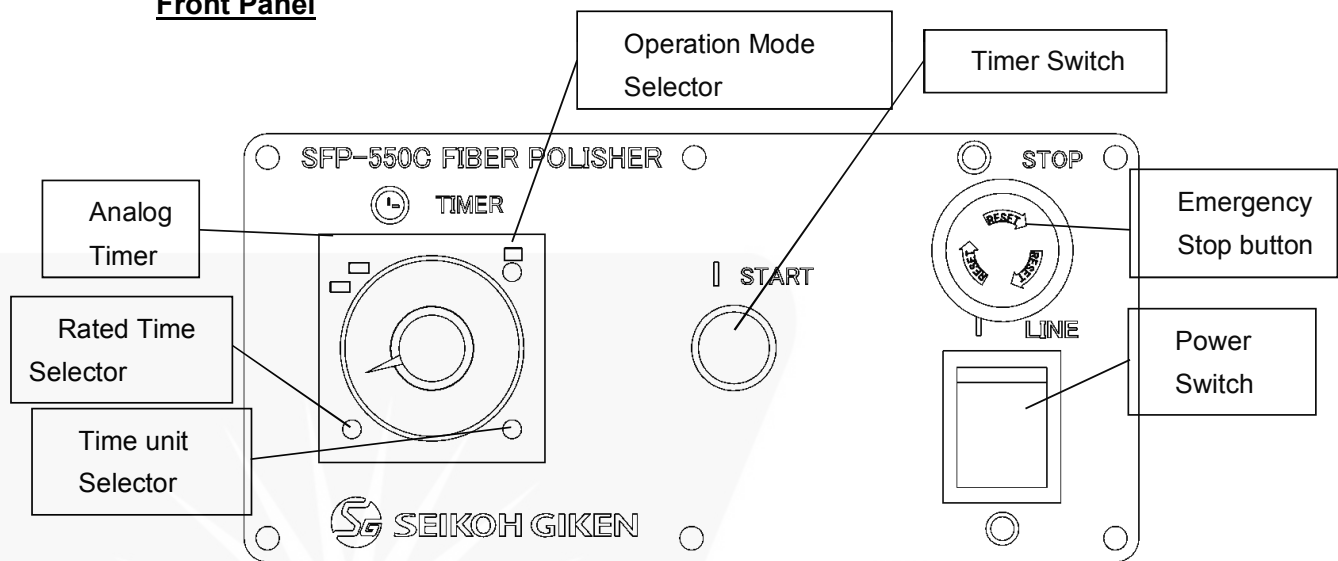
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2-1-2 Analogue Timer Type Front Panel



<Procedure>

1) Power Switch ON

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2) Timer Switch ON

Turn on the timer switch. The green lamp will light up, and the polishing machine (turntable) will be operating while the timer is running

After the set time elapses, the polishing machine (turntable) will stop automatically and the green lamp will be off.

3) Emergency Stop Button

Push the Emergency stop button to stop turntable during operation.

Turn the button to resume operation.

4) Power Switch OFF

Make sure you turn off the power switch when you stop or shut down the polishing machine. Check if all switch lamps are off. This power switch alternates ON-OFF functions by pushing.

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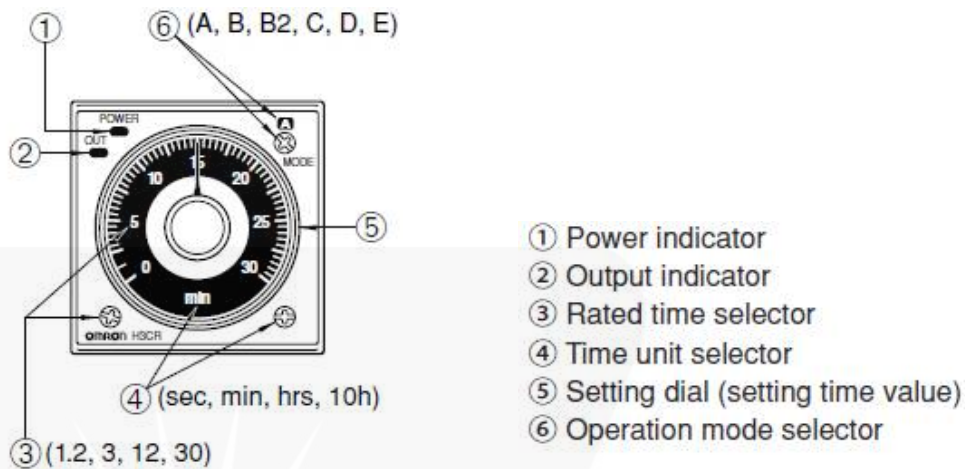
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Analogue Timer



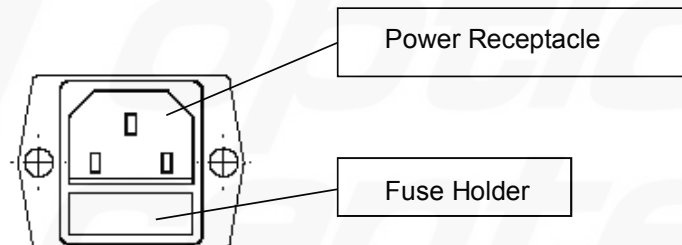
1. Rated time selector: Turning this selector changes the scale as follows.
 (1, 2, 3, 12, 30)

*Select [min] unless otherwise specified.

2. Time unit selector: Turning this selector changes timing range as follows.
 (sec, min, hrs, 10h)

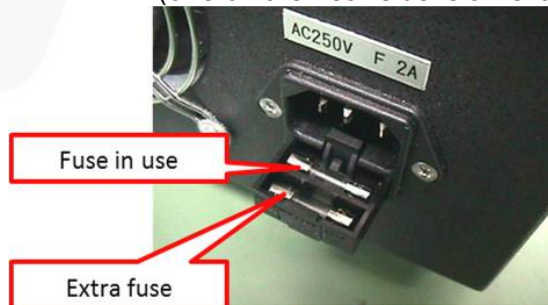
3. Operation mode selector: Select MODE A

Rear Panel



Power Receptacle : Insert the power plug into this receptacle.

Fuse Holder : To change fuse, pull out the fuse holder.
 (one on the near side is an extra fuse)



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2-2 Polishing Materials

Polishing Film

Use correct polishing films. Polishing films can be easily distinguished by color or label. Service life is varied by type of films. For more information, please refer the Polishing Process Manual. Service life is also varied by polishing process and operating & storage conditions. Store the polishing film in a dry and clean environment. After use, wipe the film and store in dry and clean environment.

Polishing Film	Identification	Service Life
GA5D	Green	1~10
DA5D-30u EDA5D-30U	Green	15~30
DR5D-9u EDR5D-9U	Pink	15~30
DH5D-3u EDH5D-3U	Light green	15~30
DJ5D-1u EDJ5D-1U	Lavender	15~30
XF5D	Translucent	5~10

Note

- EDA5D-30U is fully compatibility with DA5D-30u.
- EDR5D-9U is fully compatibility with DR5D-9u.
- EDH5D-3U is fully compatibility with DH5D-3u.
- EDJ5D-1U is fully compatibility with DJ5D-1u.

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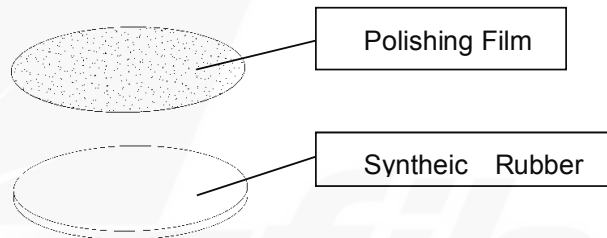
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Polishing Pad

Several polishing pad types are available for various uses. Use only the pad specified for each purpose. The identification mark of each pad is on the center of its reverse side. Attach a polishing film on top of the polishing pad as shown below. Replace the polishing pad with new one regularly as the lifetime of one year. Also replace pad with new one when the pad is damaged or deformed.

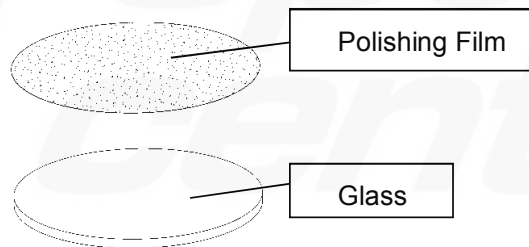
a. Pad for Convex Polishing

Made of synthetic rubber, this pad has an identification mark at the center of its reverse side. Make sure the top surface of the pad is clean when attaching a polishing film. Please refer Polishing Process Manual for how to attach polishing film. Do not use thinner, acetone, or other solvents, since such solvents will affect to the quality of the pad.



b. Pad for Flat Polishing

Made of glass with antiskid rubber film on the reverse (bottom) side. This pad has an identification mark at the center of its reverse side. Make sure the top surface of the pad is clean when attaching a polishing film. Attach a polishing film to this pad with double-sided tape. For mega-axis holders, please use repositionable spray glue or film with PSA backing. Do not use thinner, acetone, or other solvents, since these solvents will affect to the quality of the pad.



Important!

Apply the double-sided tape to the center diameter of 30mm on the pad so that the ferrule end faces, during polishing, will not be on the area that the double-sided tape be placed.

When changing film, clean the surface of the pad and make sure the pad surface is free of foreign particles. Such particles can cause the film to come loose, or scratch the ferrule.

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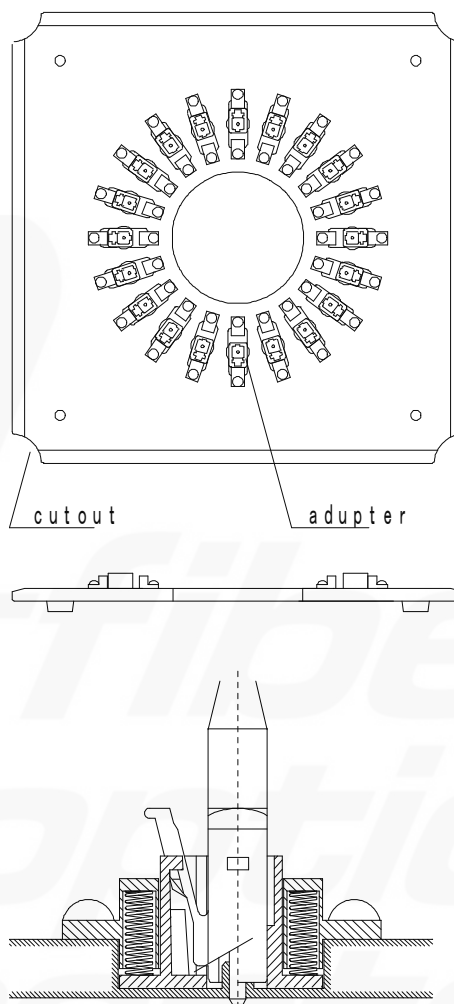
2-3 Polishing Holder

Polishing Holder Design

There are two types of polishing holders; one for right-angled flat or right-angled convex polishing and the other for angled flat or angled convex polishing. Each holder is available to suit different connector types.

The polishing holder has round shape cutouts on the four corners to place it onto the clamping posts of the base plate.

The polishing holders have up to 48-axis at maximum (depending on connector type). After the adhesive removal process, the tip of ferrules must protrude 0.5mm from the bottom side of the polishing holder. The protrusion is critical to the accuracy of the polishing process.



☆☆☆ CAUTION ☆☆☆

Make sure that the ferrule outer diameter and the ferrule insertion hole are clean. This will ensure that all ferrules protrude to the same height, thereby ensure desired polishing results.

Maintenance Requirement

Accuracy of polishing holders affects to polishing result. Thus, please be aware with these points.

- Before installing ferrules, please make sure to clean ferrules and ferrule insertion holes of polishing holder.
- The polishing holders are made of stainless steel. However, to avoid its rusting, it is recommended that all traces of water must be removed and lubrication oil is sprayed after use. Although the polishing holders are heat-treated, please avoid anything leads to damage such as bending, falling, or applying any shock.

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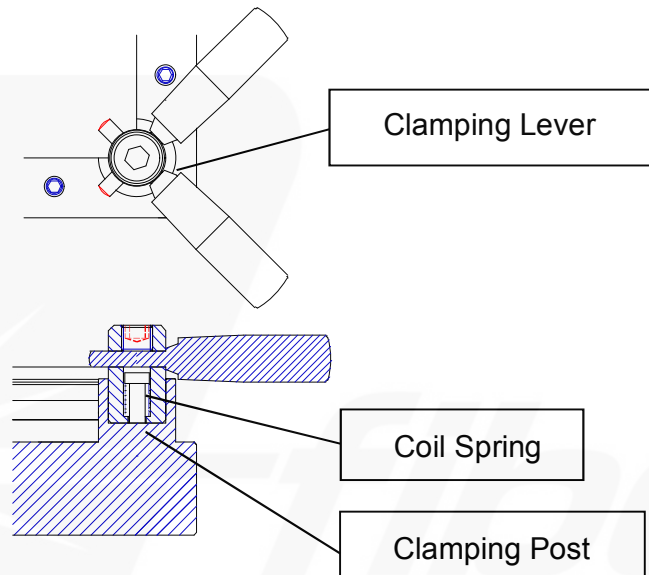
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2-4 Pressurizing & Holding Unit

The clamping posts standing on the four corners of the base plate have pressurizing units with coil springs inside. The clamps on the corners hold the polishing holder.



2-5 Operation

- ① Mount optical connectors or ferrules on the polishing holder.
- ② Install the polishing holder on the polishing machine.
- ③ Turn the clamping levers on the four corners so that their pressure pins are clear off the polishing holder area.
- ④ Place the polishing holder on the polishing machine between the clamps.
- ⑤ Pull up and turn the four clamping levers until their pressure pins are fully over the polishing holder.
- ⑥ Turn the four clamping levers when the holder is removed.

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February 20, 2013
SFP-550C Operating Manual
FP-IM55C (Ver. 2.0)

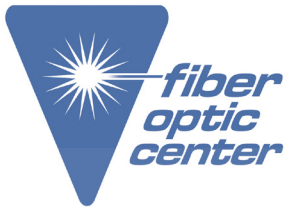
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**Manufacturer:**

Seikoh Giken

Product Name:

Seikoh Giken SFP-550C High Duty Cycle Fiber Optic Polishing Machine

Manufacturer Part Number:

SFP-550C

▶ [Click here for more details on the Seikoh Giken SFP-550C High Duty Cycle Fiber Optic Polishing Machine](#)

SFP-550C

Maintenance Manual



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Introduction

This manual covers maintenance procedures for the periodic inspection required for the SFP-550C Polishing Machine. At the periodic inspection or in the event of problems arising, read this manual and familiarize yourself with the machine before maintaining it. Make sure that power is off when performing inspections or maintenance on the machine.

Note

This manual covers maintenance of the SFP-550C when used in accordance with SFP-550C Polishing Machine Operating Manual. Also, read the Operating Manual and the Polishing Process Manual along with this manual.

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1 Inspection

1-1 Functioning Inspection

At the first starting or operating the machine after your purchase or any problem arising, conduct performance inspection as outlined below.

Power Cable Plugging

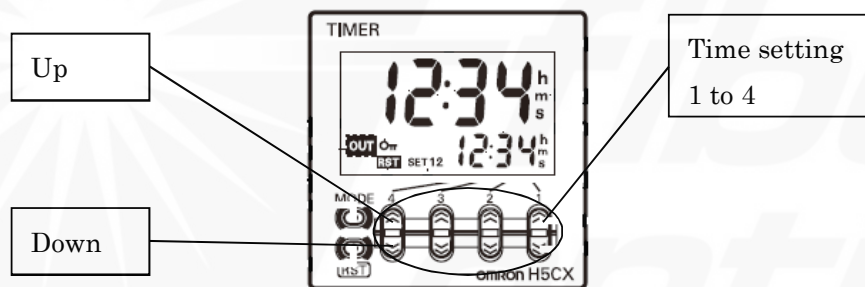
Make sure an adaptation of electrical specifications before plugging in a power cable.

Timer Setting

Digital Timer

Check if switch 1 to 4 works.

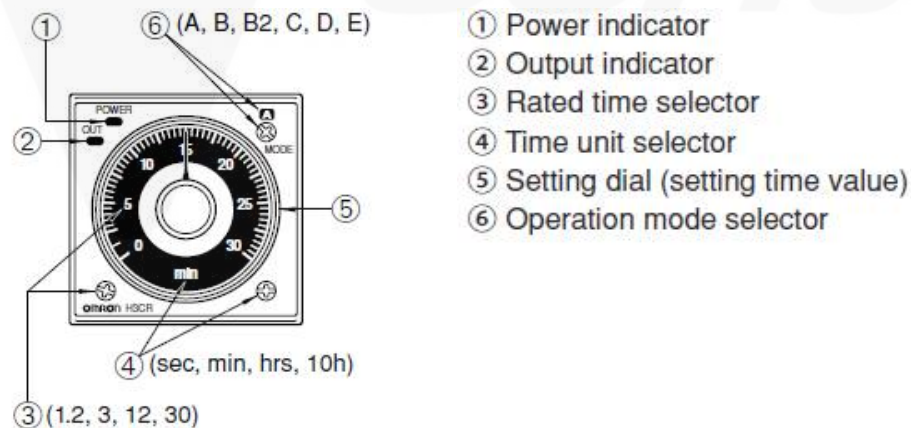
For detail, please refer P13 of the Operating Manual



Analog Timer

Make sure the scales on the timer are set as ③[30] ④[min] and ⑥[A].

For detail, please refer P17 on the Operating Manual



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Please check if the machine properly functions as follows.

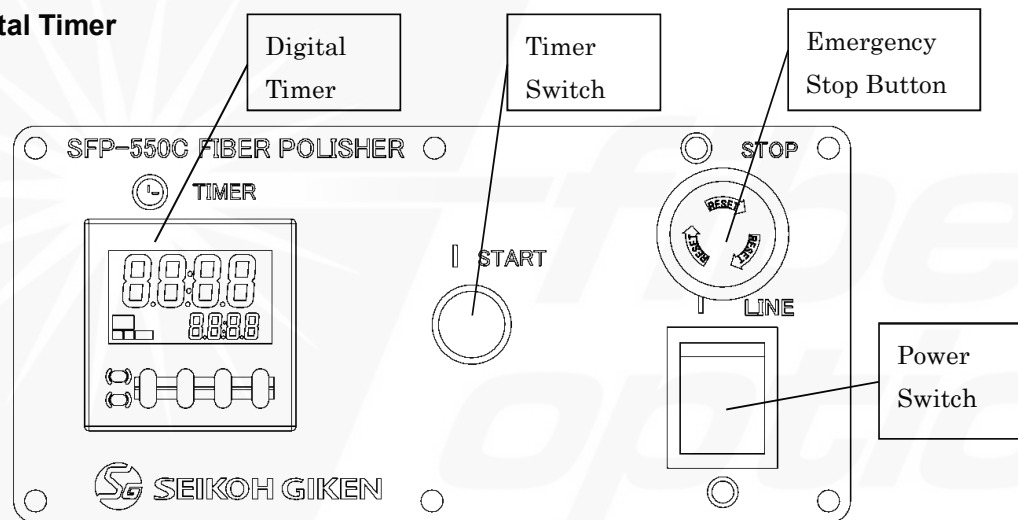
When the Power Switch is ON

- Does the lamp (green) light on?
- Is the cooling fan running?

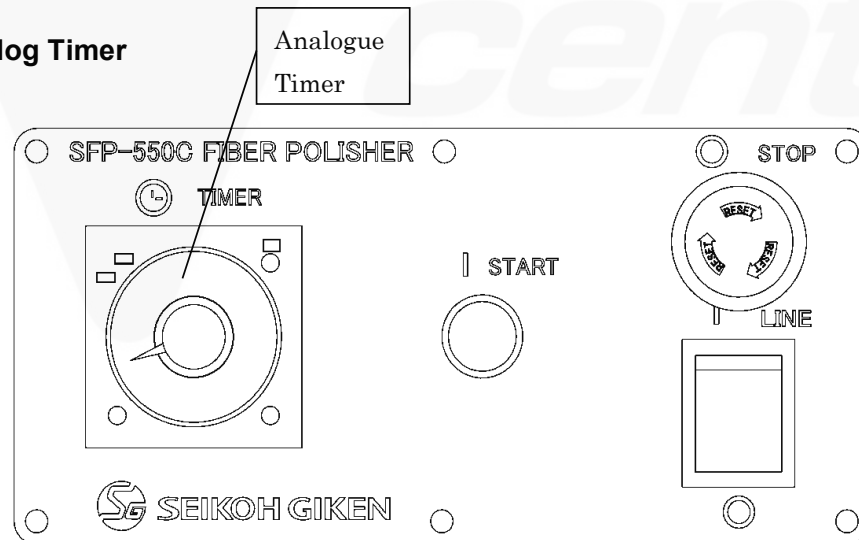
When the Timer Switch is ON

- Does the [START] lamp on the timer light on?
- Does the turntable begin revolution and rotation?
- Does the cooling fan keep running?

Digital Timer



Analog Timer



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When the Timer time is up

- Does the [START] lamp on the timer go out?
- Does the turntable stop revolution and rotation?
- Does the cooling fan keep running?

When the Emergency Stop Switch is ON

- Does [START] lamp on the front panel go out?
- Does the cooling fan stop running?

When Power Switch is OFF

- Does [START] lamp on the front panel go out?
- Does the cooling fan stop running?

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1-2 Regular Inspection and Maintenance

Critical points in a principle of polishing with SFP-550C Polishing Machine are following:

1. Polishing track of ferrule by revolution and rotation of the turntable
2. Pressure of polishing (the height between the clamping posts on the four corners and the turntable, the protrusion length of ferrules from the bottom side of the polishing holder)

Read and familiarize with the followings before inspection.

Please use Seikoh Giken grease (P/N: FP-GS) for all SFP series polishing machines wherever grease is necessary to use.

1-2-1 Grease check in the contact area and drive unit (once a month or 100 driving hours)

Remove the turntable and check the drive unit if grease is properly applied.

See Figure 1-2-1.

1-2-2 Grease check in the teeth of 90T gear (once every 6 months or 500 driving hours)

Apply the grease (FP-GS) on teeth of 90T gear and contacting area between the 90T gear and base plate See Figure 1-2-2.

1-2-3 Dimension check for the height between the clamping posts and the turntable (once every 6 months or 500 driving hours)

*The space between each clamping post and the turntable: **5.5+/-0.02mm**

See Figure 1-2-3.

1-2-4 Pressurizing unit check (once every 6 months or 500 driving hours)

Check thickness of Liner shaft

*Rotate or replace the Liner shaft if wear is **0.2mm or more**

See Figure 1-2-4.

Check the free length of the pressurizing coil springs installed in the clamping posts.

*The free length of the pressurizing coil springs (P/N: RP55C-14): **19.0mm or more**

See Figure 1-2-4.

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Figure 1-2-1:

Grease check in the contact area and drive unit – once a month or every 100 driving hours

The turntable can be removed as it is lifted up. Next, remove Bearing, Position plate, Eccentric support plate, and Plastic washer on the 90T gear and clean up the gear. And then, please apply grease (FP-GS) as per the following instruction.



Apply the grease (FP-GS) on insertion holes of Eccentric support plate and their contacting areas.



Apply the grease (FP-GS) on back side of the Turntable and insertion holes of Eccentric support plate and Bearing.



Apply the grease (FP-GS) on contact area and install Resin washer, Eccentric support plates and Position plate. After installing these parts, install the Turntable.

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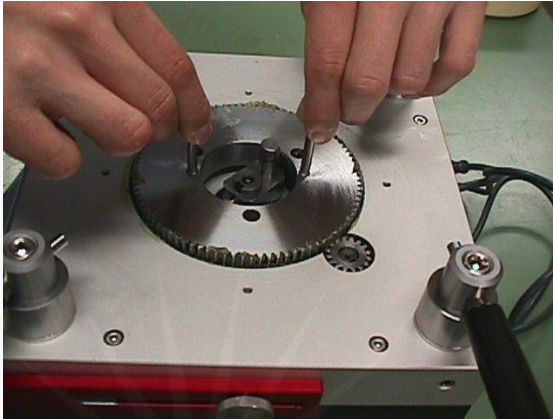
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Figure 1-2-2:

Grease check in the teeth of the 90T gear-- once 6 month or every 500 driving hours

After removing the Support ring, remove the 90T gear as follows



Evenly tighten 2pcs of the Maintenance tool of the M5-L45 socket head screw to the 90T gear. As the screws are tightened the gear is lifted up and can be removed



Apply the grease (FP-GS) in the teeth of the 90T gear



Apply the grease (FP-GS) on sidewall and bottom surface where the area 90T gear sits

After applying the grease (FP-GS), place the 90T gear into the Baseplate by mating with the 16Tgear.

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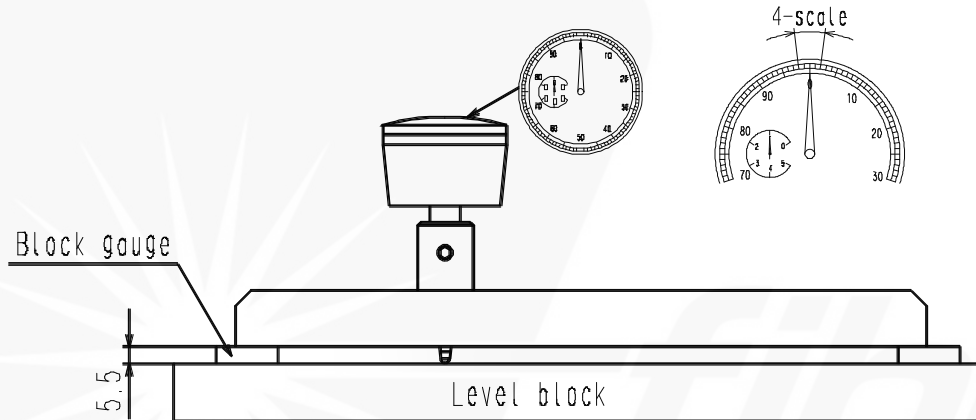
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Figure 1-2-3: Dimension check for the height between the Clamping posts and the Turntable— once 6 month or every 500 driving hours

We provide the height gauge P/N “FP-HG55+BG (THM-550)” for this inspection purpose as the optional tool.

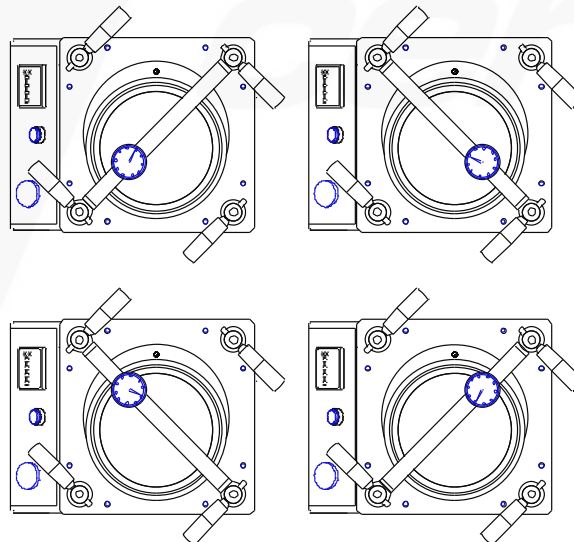
Reference

- Place the 5.5mm-thickness block gauge and the height gauge on the level block and set the dial of the height gauge as the hand comes to zero.



Measurement

- Place the gauge on the clamping posts diagonally and check each four posts. Make sure that the space on each point is within the specification of **5.50mm+/-0.02mm**. At the scale indication, the specification value is 0(Zero)+/-2. If the measurement result is out of this specification at the scale indication, adjust the space in accordance with the followings.



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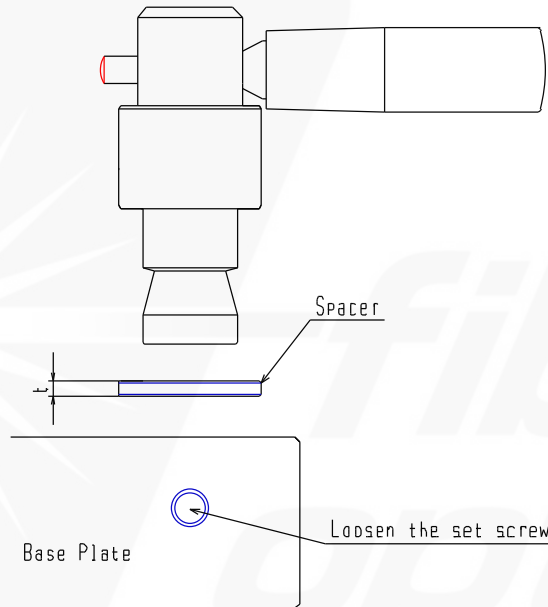
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Adjustment

If the space between the clamping posts and the turntable is out of the specification value, adjust Spacers in accordance with the following procedure.

- Loosen the set screws on the side of the Baseplate (screw for each clamping post).
- Remove the clamping post (pressurizing unit) and spacer.
- Measure the thickness of the spacer, t.



- Calculate the required thickness of the spacer, with the former measurement result of the spacer, t, in accordance with the following expression.

Required thickness of the spacer = Measured value (space between the turntable and clamping post) + the thickness of the present spacer, t

Example:

Space between the turntable and clamping post: 4-scale to minus (-0.04mm) and the thickness of the present spacer, t: 3.00mm, then

Required thickness of the spacer = (-0.04mm) + 3.00mm = 2.96mm

Repeat this procedure for all four clamping posts.

- When you order the spacer (RP55C-10), please designate the thickness of the spacer.

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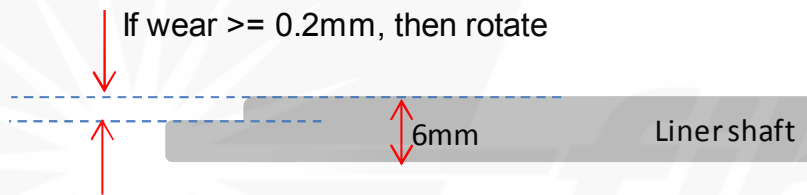
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Figure 1-2-4: Pressurizing unit check

Linear shafts equipped in the 4pcs of pressurizing unit get gradually worn out by contact with polishing holder. If the wear is more than 0.2mm or more, pressurizing force becomes under specified value and may influence to polishing quality. Below explains how to check and countermeasure.

- Loosen the M12—L10 set screw and remove the Bar grip and the Linear shaft from the Clamp pin. And then, measure the outer diameter of the removed Linear shaft with caliper.
- If depth of wear is 0.2mm or more, rotate the position of the Linear shaft in 90-deg and place the non-wear portion in bottom.



- When the Linear shaft is no longer usable, then please remove the Liner shaft from the Bar grip and replace with new one.

Specification for the free length of the coil spring: Min. 19.0mm (with no pressure)

Remove the M12-L10 set screw with the Maintenance tool of the Long length hex key (3mm) in the Maintenance kit.

- If the free length of the pressurizing coil spring (RP55C-14) is out of the specification, exchange it for new one.
- Next page explains schematic drawing for how to replace the coil spring.

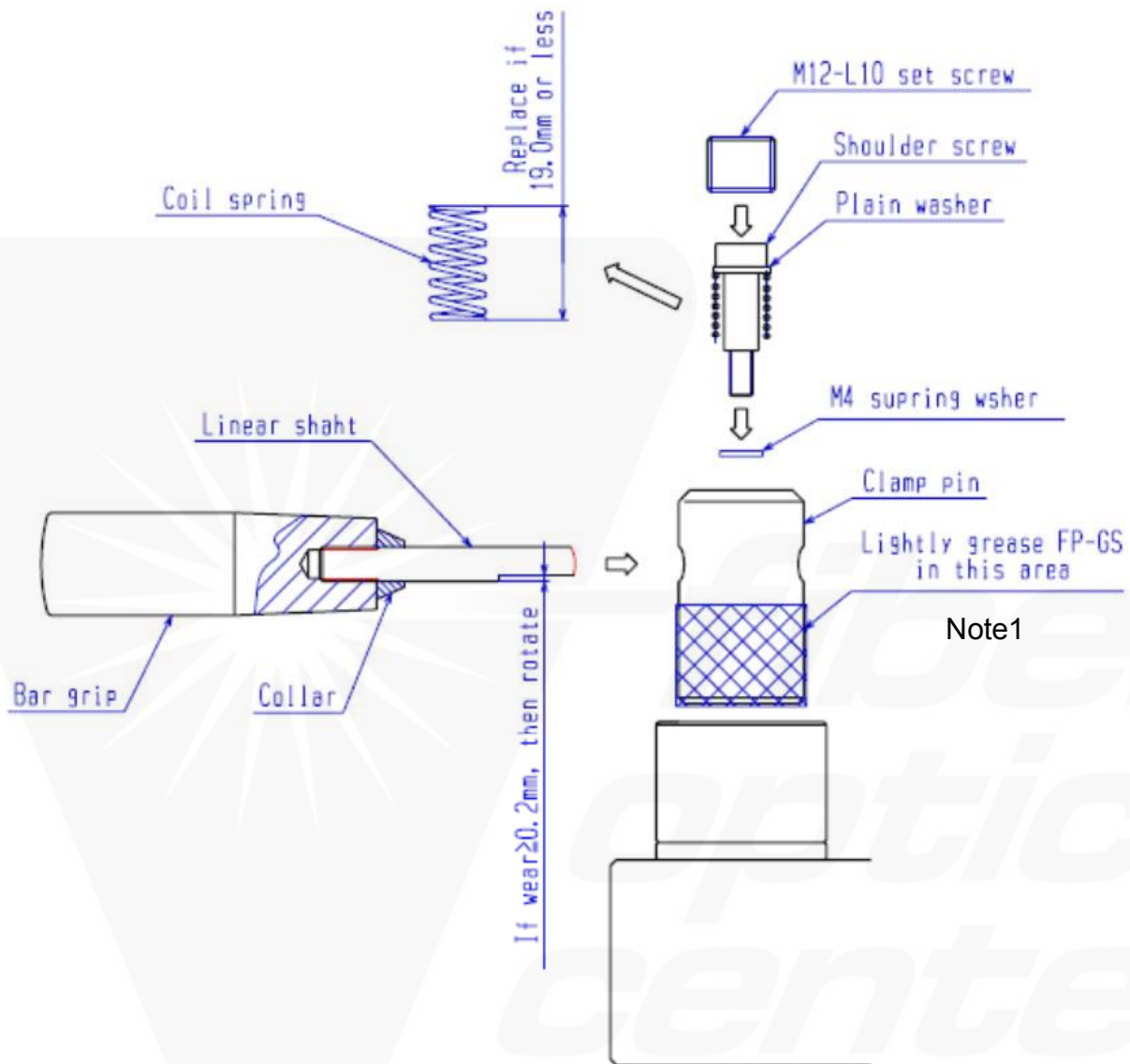
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Note1

Please clean up old grease and contaminations from the Clamp pin and Clamp post, where the Clamp pin is contacted with, before applying the grease (P/N FP-GS).

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2 Treatment for Unusual Conditions

CAUTION

Make sure the power cable is unplugged during inspection maintenance.

If the Turntable doesn't move smoothly during operation, please check the following points.
The turntable and the position plate can be removed as they are lifted up.

2-1 Wear of Bearing

Please replace Bearing if it does not rotate smoothly. And if inner diameter of the Bearing becomes 10.1mm or wider by wear, then the bearing also shall be replaced with new one.

See Figure 2

2-2 Wear of Knock pin for Eccentric drive plate

When outer diameter of the Knock pin for eccentric drive plate becomes 9.9mm or less, then the Eccentric drive plate shall be replaced with new one.

See Figure 2

2-3 Wear of Knock pin for Eccentric support plate

When outer diameter of the Knock pin for eccentric support plate becomes 7.9mm or less, then the Eccentric support plate shall be replaced with new one.

See Figure 2

2-4 Loose Eccentric drive plate

When Eccentric drive plate screw is loose, tighten the screw with the Maintenance tool of the Short length hex key (3mm). Also, when the screw is tighten, please be sure surface of the Eccentric drive plate and top of gear head shaft are in flat position.

See Figure 2

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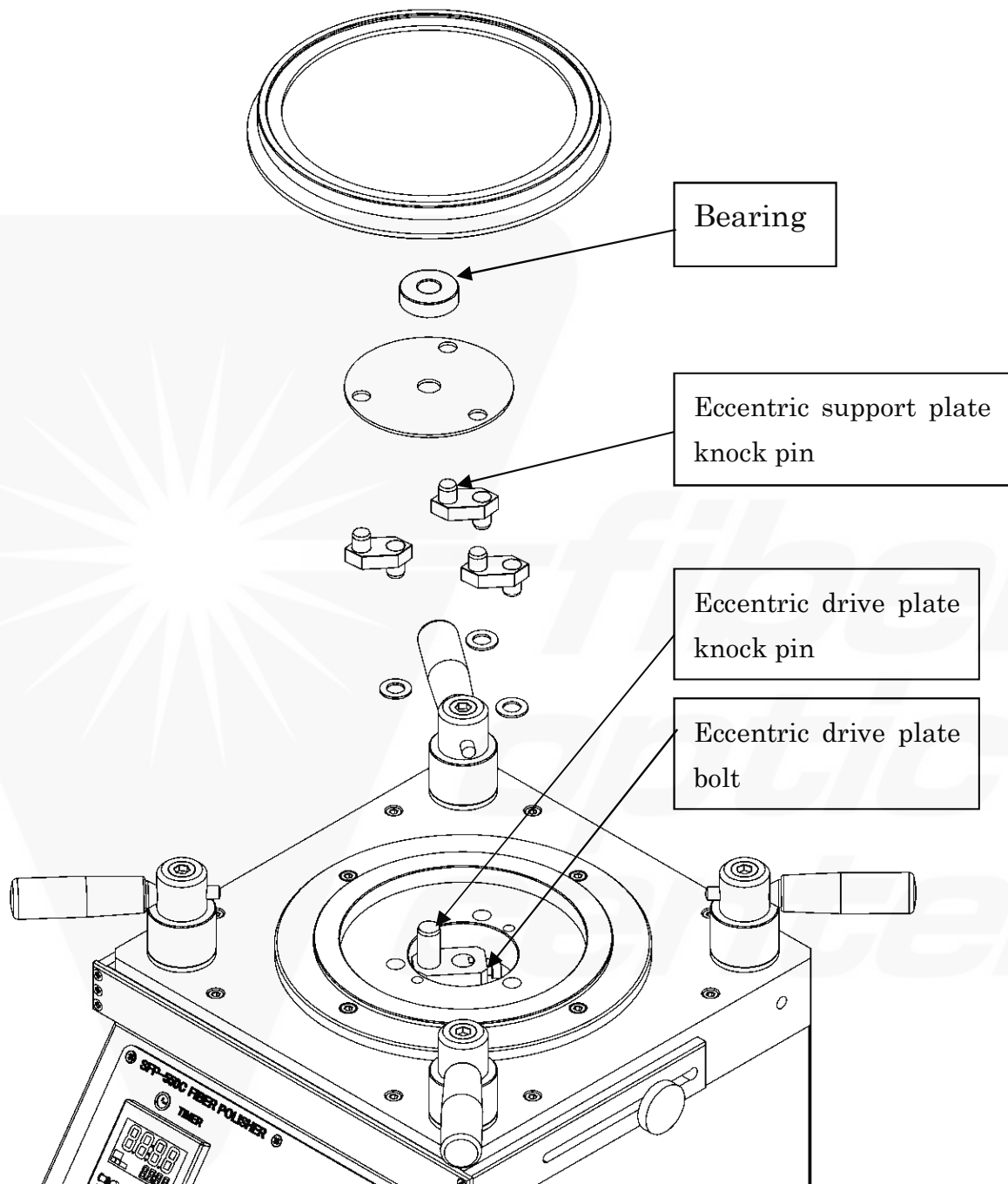
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Figure 2:



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3 Mechanical Structure

3-1 Mechanical Components

#	Part No.	Description	Qty/set
1	RP55C-01	Turntable	1
2	RP55C-02	Bearing	1
3	RP55C-03	Support ring	1
4	RP55C-04	Position plate	1
5	RP55C-05	Eccentric support plate (including knock pin)	3
6	RP55C-06	Resin washer	3
7	RP55C-07	90T gear	1
8	RP55C-08	Eccentric drive plate (including knock pin)	1
9	RP55C-09	Baseplate	1
10	RP55C-10	Adjustment spacer	4
11	RP55C-11	Clamp rod	4
12	RP55C-12	Clamp pin	4
13	RP55C-13	M4 spring lock washer	4
14	RP55C-14	Coil spring	4
15	RP55C-15	Plain washer	4
16	RP55C-16	Shoulder screw	4
17	RP55C-17	M12-L10 set screw	4
18	RP55C-18	Collar	4
19	RP55C-19	Linear shaft	4
20	RP55C-20	Bar grip	4
21	RP55C-21	25W motor & gear box	1
22	RP55C-22	6W motor & gear box	1
23	RP55C-23	16T gear	1
24	RP55C-24	Housing	1
25	RP55C-25	Rubber leg	4
26	RP55C-26	Operation panel	1
27	RP55C-27	Rubber packing	1
28	RP55C-28	Power switch	1
29	RP55C-29A	Analog timer	1
	RP55C-29D	Digital timer	1
30	RP55C-30	Start switch	1
31	RP55C-31	Emergency stop switch	1

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32	RP55C-32	Power receptacle	1
33	RP55C-33	Cooling fan	1
34	RP55C-34	Retainer bar kit	1
35	RP55C-35	Cover bolt	2
36	RP55C-36	Cable rod stand	1
37	RP55C-37	Cable support rod A	1
38	RP55C-38	Strut clamp	1
39	RP55C-39	Cable support rod B	1
40	RP55C-40	Cable hook	2
51	RP55C-51	M4-L10 hex socket head screw	4
52	RP55C-52	M4-L10 hex socket head screw	1
53	RP55C-53	M4-L40 hex socket head screw	8
54	RP55C-54	M5-L50 hex socket head screw	4
55	RP55C-55	M4-L65 hex socket head screw	4
56	RP55C-56	M5-L5 hex socket set screw	2
57	RP55C-57	M8-L13.2 hex socket set screw (ball type)	4
58	RP55C-58	M5-L15 hex socket head screw	4
59	RP55C-59	M5 Hex nut	4
60	RP55C-60	M4-L10 Phillips pan head screw	4
61	RP55C-61	M4-L15 hex socket head screw	4

3-2 Maintenance Tools

#	Part No.	Description	Qty/set
71	RP55C-71	Long length hex key(3mm)	1
72	RP55C-72	Short length hex key(3mm)	1
73	RP55C-73	M5-L45 hex socket head screw	2

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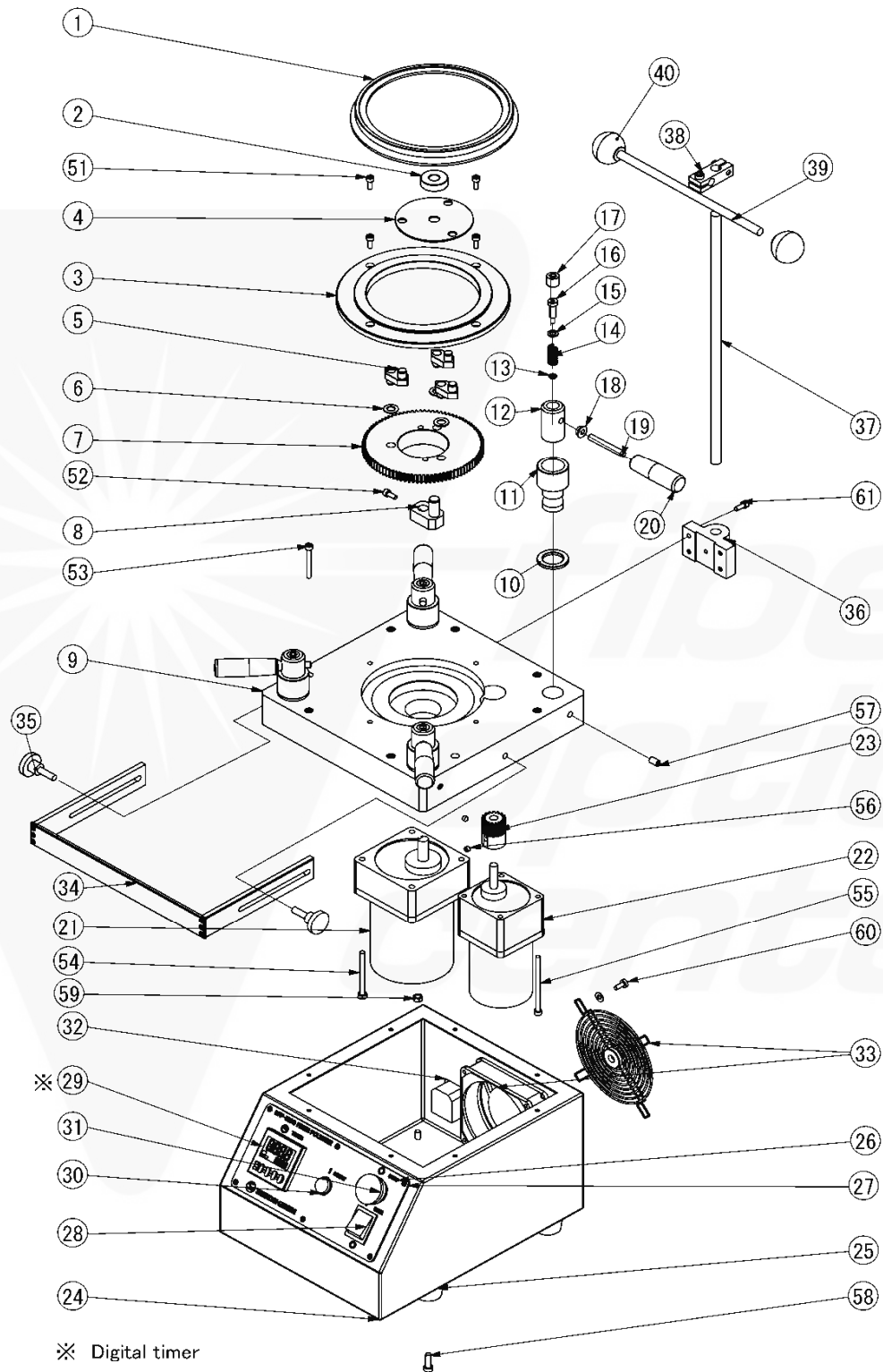
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3-3 Structure Schematic



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