

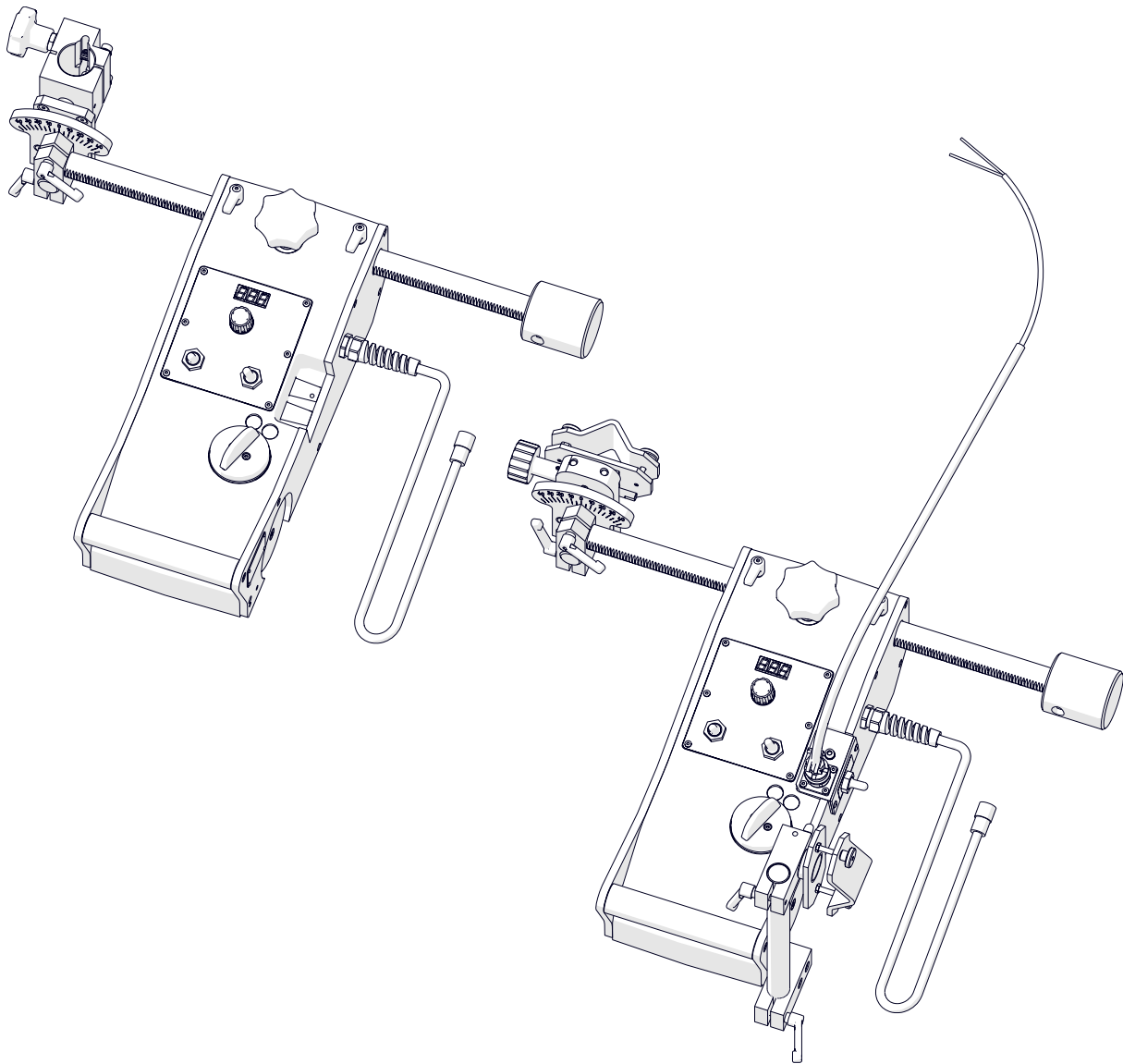


The tools of innovation.

OPERATOR'S MANUAL

Torch Runner (HS)

CUTTING CARRIAGE



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1. GENERAL INFORMATION

1.1. Application

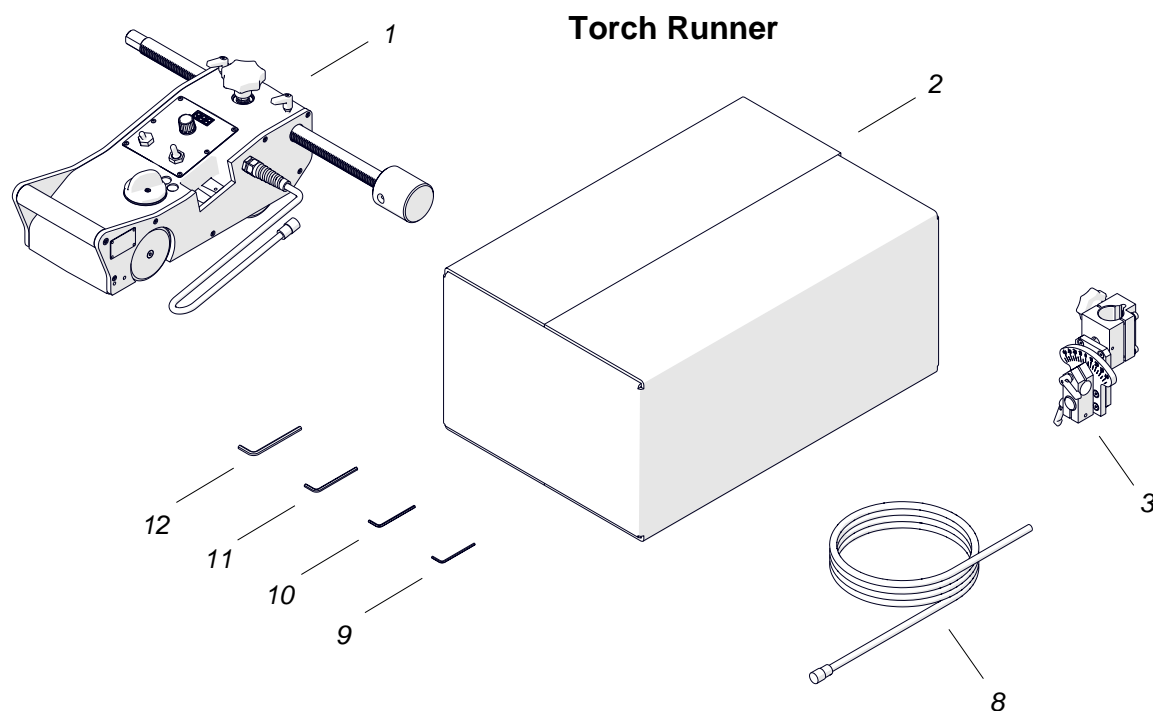
The Torch Runner (HS) is a cutting carriage designed to cut steel by using oxy-fuel torches with the diameter of 35 mm (1.38") or plasma torches with the diameter of 28–35 mm (1.10–1.38"). The carriage travels horizontally on the workpiece or track tilted up to 10°.

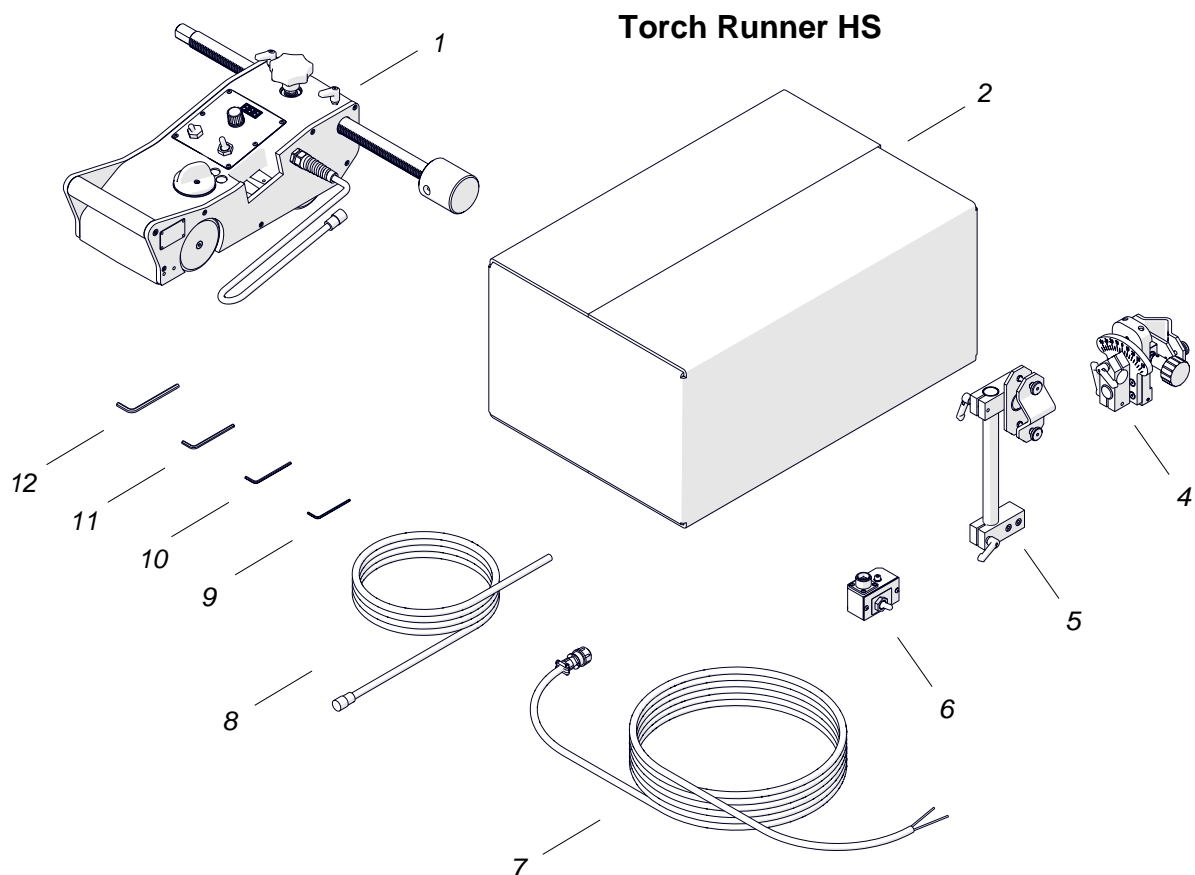
Accessories allow using torches with different diameters, using two torches at the same time, and cutting holes with the radius of 240–2500 mm (0.8–8.2 ft).

1.2. Technical data

	Torch Runner	Torch Runner HS
Voltage	1~ 115–230 V, 50–60 Hz	1~ 115–230 V, 50–60 Hz
Power	20 W	20 W
Work position	Horizontal	Horizontal
Torch diameter	35 mm (1.38")	28–35 mm (1.10–1.38")
Ground clearance	8 mm (0.31")	8 mm (0.31")
Speed	0–150 cm/min (0–59 in/min)	10–300 cm/min (4–118 in/min)
Weight	16.8 kg (37 lbs)	16.8 kg (37 lbs)

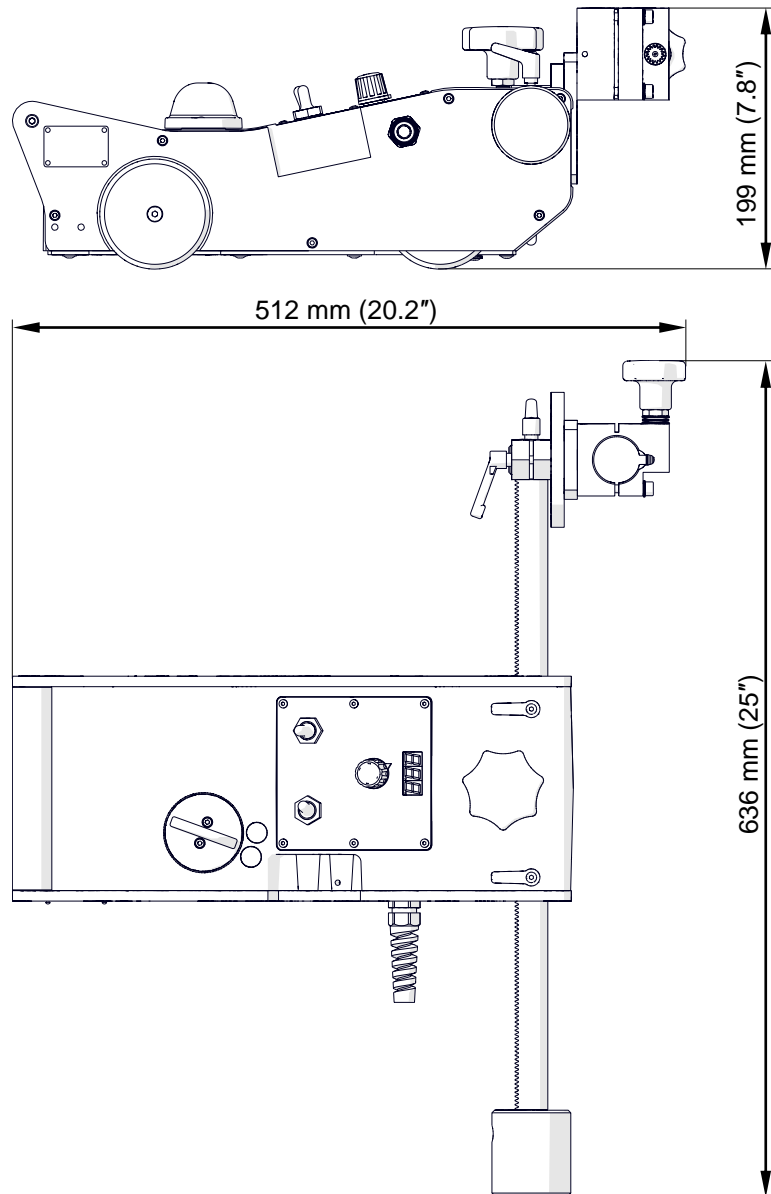
1.3. Equipment included



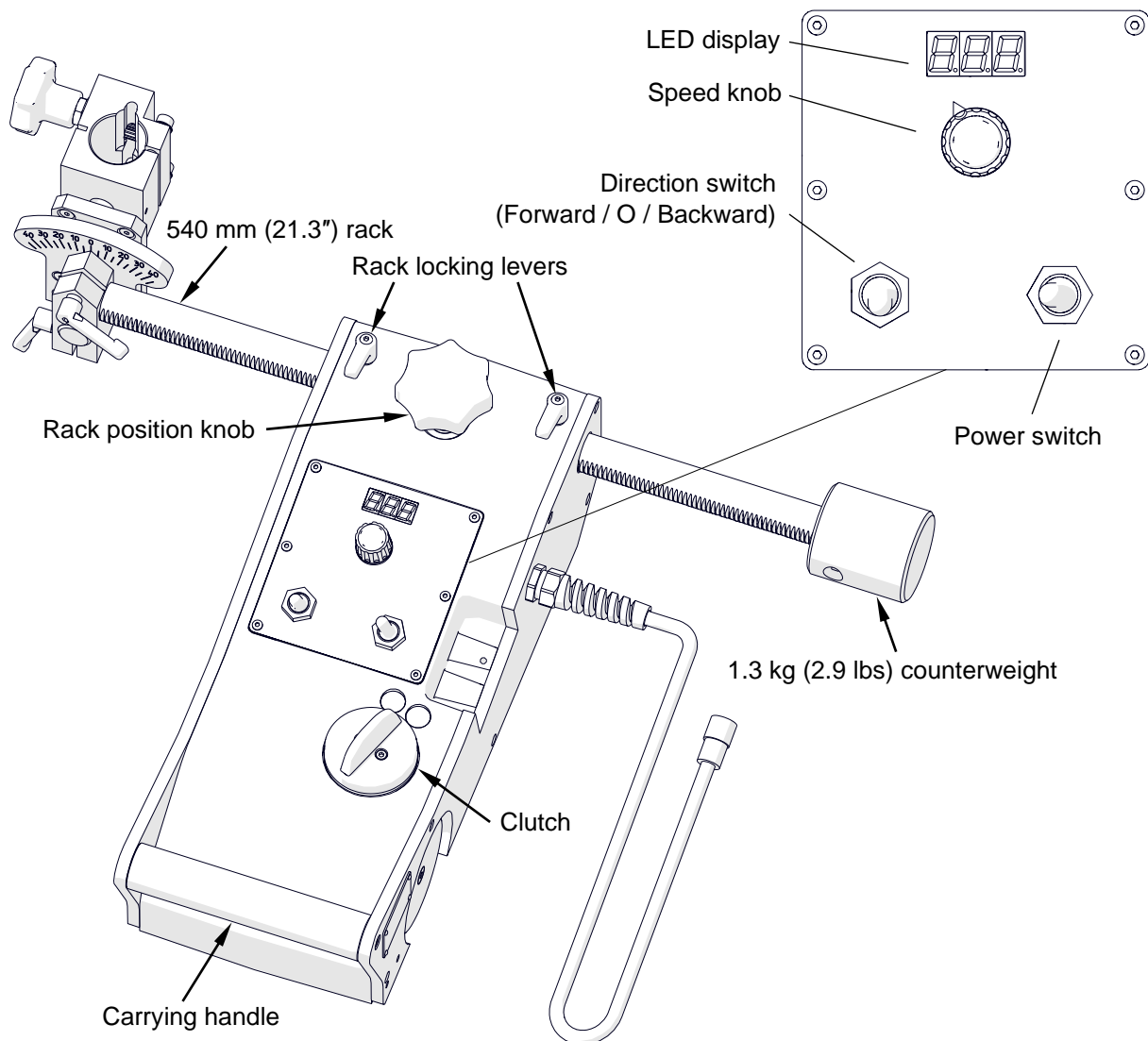


		Torch Runner	Torch Runner HS
1	Carriage	1 unit	1 unit
2	Cardboard box	1 unit	1 unit
3	35 mm precise machine torch holder	1 unit	—
4	28–35 mm precise torch holder	—	1 unit
5	Cable anchor	—	1 unit
6	Arc ignition set	—	1 unit
7	6.5 m (21 ft) arc ignition cable	—	1 unit
8	3 m (10 ft) power cord	1 unit	1 unit
9	2.5 mm hex wrench	1 unit	1 unit
10	3 mm hex wrench	1 unit	1 unit
11	4 mm hex wrench	1 unit	1 unit
12	5 mm hex wrench	1 unit	1 unit
—	Operator's Manual	1 unit	1 unit

1.4. Dimensions



1.5. Design



2. SAFETY PRECAUTIONS

1. Before use, read this Operator's Manual and complete a training in occupational safety and health.
2. Use only in applications specified in this Operator's Manual.
3. Make sure that the carriage has all parts and they are genuine and not damaged.
4. Make sure that the specifications of the power source are the same as those specified on the rating plate.
5. Connect the carriage to a correctly grounded power source.
6. Do not carry the carriage by the cords or arc ignition cable, and do not pull them. This can cause damage and electric shock.
7. Keep untrained bystanders away from the carriage.
8. Before each use, ensure the correct condition of the carriage, power source, power cords, arc ignition cable, plugs, and control panel.
9. Before each use, make sure that no part is cracked or loose. Make sure to maintain correct conditions that can have an effect on the operation of the carriage.
10. Keep the carriage dry. Do not expose the carriage to rain, snow, or frost.
11. Keep the work area well lit, clean, and free of obstacles.
12. Do not use near flammable materials, or in explosive environments.
13. Transport and position the carriage by using the carrying handle.
14. Do not stay below the carriage that is put at heights.
15. Connect the cords and arc ignition cable only after you set the power switch to 'O'.
16. Keep the sockets clean. Do not use high pressure during cleaning.
17. Install only torches whose diameter matches the diameter of the torch holder.
18. Keep the torch cables away from the surface. Hang the cables to decrease the load applied on the carriage.
19. Use the torch as specified in the manual of the torch.
20. Keep the carriage in horizontal position during work.
21. Use eye protection (helmet, shield, and screen), ear protection, gloves, and protective clothing. Do not use loose clothing.
22. Do not stop the carriage by hand. To stop, set the clutch to OFF or the direction switch to 'O'.

- 23. Maintain only after you unplug the carriage from the power source.
- 24. Repair only in a service center appointed by the seller.
- 25. If the carriage falls, is wet, or has any damage, stop the work and immediately send the carriage to the service center for check and repair.
- 26. Do not leave the carriage when it operates.
- 27. If you are not going to use the carriage, remove it from the work area and keep in a safe and dry place.

3. STARTUP AND OPERATION

3.1. Preparing

Before use, clean the wheels of the carriage and remove the anti-corrosion material from the track. Use the carrying handle to transport the carriage to the work area. Set the power switch and the direction switch to 'O', and set the clutch to OFF. Then, plug the power cord into the power source, put the torch into the standard torch holder (Fig. 1), and tighten with the knobs.

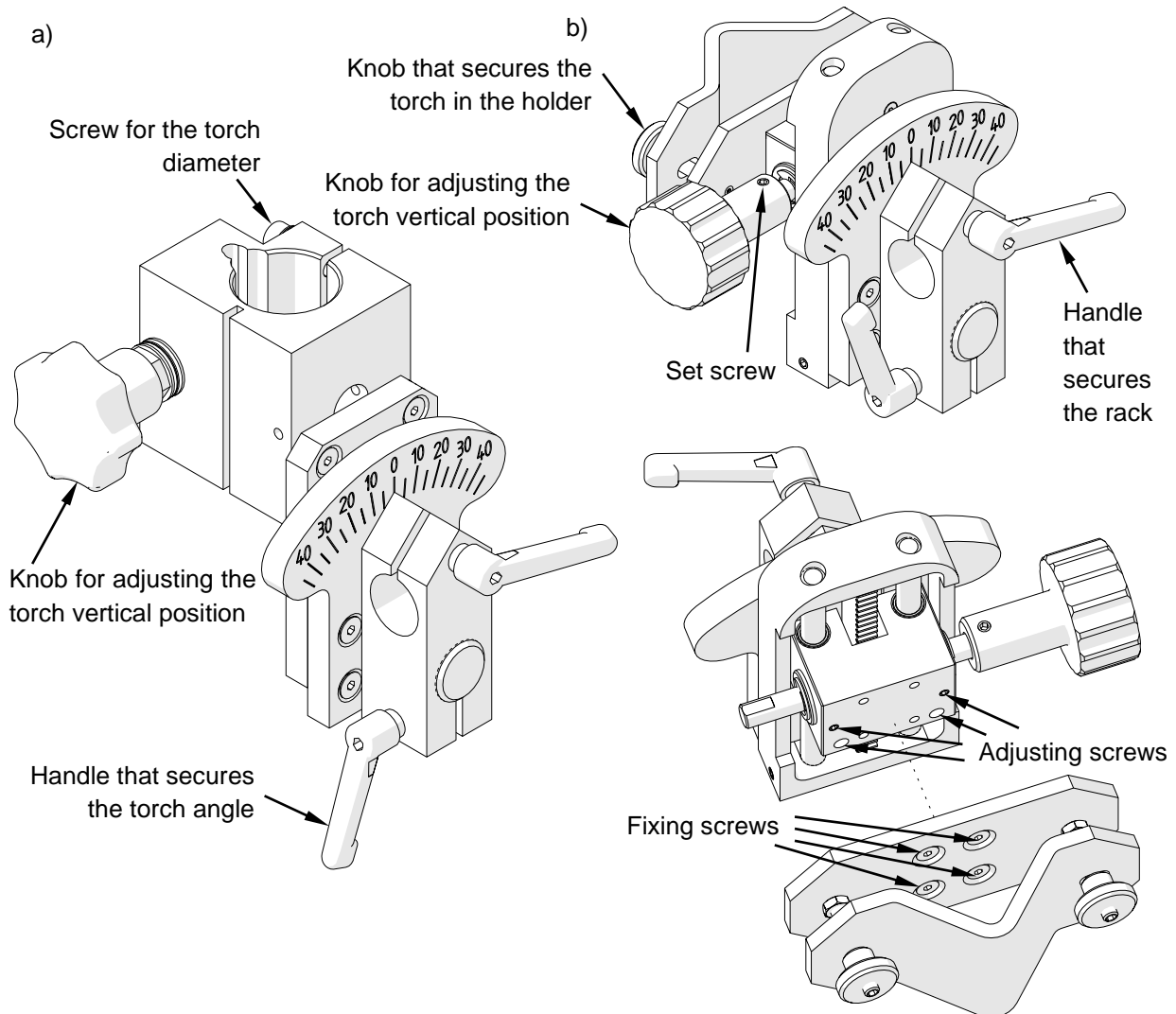


Fig. 1. Design of the precise machine torch holder for oxy-fuel cutting (a) and of the precise torch holder for plasma cutting (b)

The precise machine torch holder (Fig. 1a) allows torches with the diameter of 35 mm (1.38") equipped with a rack. Loosen the lower handle to precisely set the torch angle. Use the knob to adjust the vertical position of the torch.

The precise torch holder (Fig. 1b) is designed for torches with the diameter of 28–35 mm (1.10–1.38") and allows precise adjustment of the torch angle. Use the knob to adjust the vertical position. Install the knob at any side by using the 2.5 mm hex wrench and the set screw. To adjust the resistance of the vertical travel, use the 2.5 mm hex wrench to remove the fixing screws. Then, use the 2 mm hex wrench to rotate the adjusting screws.

Use the rack position knob to adjust the horizontal position of the torch, and use the rack locking levers to lock the rack in position.

Then, connect the torch to a correct gas source. Depending on the cutting method (oxy-fuel or plasma), install into the carriage slot either a gas manifold or the arc ignition set as described in the subsection of the respective accessory.

Put the carriage on the workpiece or track so that the torch is right above the starting point of the cut. Then, set the clutch to ON.

3.2. Operating

Set the power switch to 'I' to turn on the carriage. Then, the display comes on (888). Next, if the unit of speed is set to centimeters per minute, *EUR* shows. If the unit is set to inches per minute, *US* shows. Next, the carriage speed shows. Use the speed knob to set the required speed. If needed, set the clutch to OFF and travel the carriage by hand.

To start the cutting, light the torch as described in the manual of the torch. Obey all rules included in the manual of the torch.

Use the direction switch to select a direction of travel. Then, the real speed of the carriage shows on the display. To stop the travel, set the direction switch to 'O' or the clutch to OFF. To extinguish the torch flame, continue as described in the manual of the torch.

After the work is finished, use the power switch to turn off the carriage. Then, unplug the carriage from the power source.

3.3. Changing the unit of speed

To change the unit of speed between centimeters per minute and inches per minute, unplug the carriage from the power source and follow the steps shown in Fig. 2.

After you change the unit and turn on the carriage, the current unit of measure shows. When the jumper cap connects the left and center pin, the display shows *EUR* and the speed is shown in centimeters per minute. When the jumper cap connects the center and right pin, the display shows *USA* and the speed is shown in inches per minute.

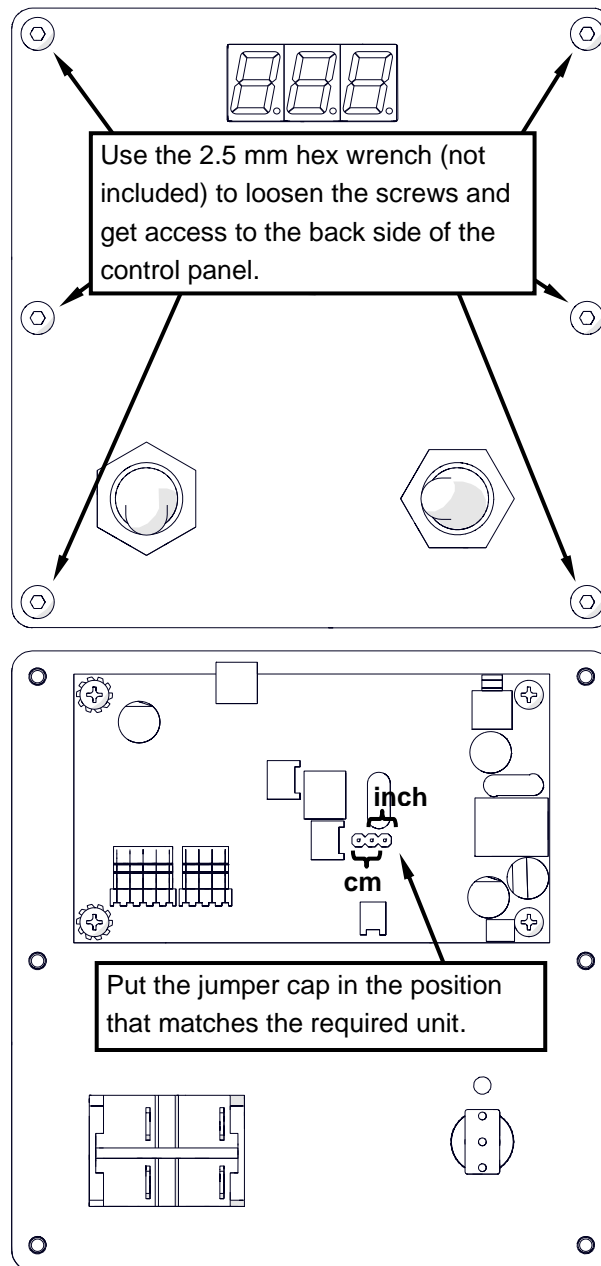


Fig. 2. Changing the unit of speed

3.4. Troubleshooting

Message	Problem	Solution
0.55.	Display not fully on after powering.	Contact service center for check and repair.
EUR	Speed shown in centimeters per minute instead of inches per minute.	Refer to the section “Changing the unit of speed.”
USA	Speed shown in inches per minute instead of centimeters per minute.	Refer to the section “Changing the unit of speed.”
Er.5.	Direction switch not set to ‘O’ when powering.	Set the direction switch to ‘O’. If the message still shows, contact service center for check and repair.
	Shown during travel indicates a malfunction.	Contact service center for check and repair.
crl	Motor overload. The carriage stops.	Adjust the position of the cables so that they do not block the carriage. Remove other objects that block the carriage or its wheels. If this message still shows, contact service center for check and repair.

4. MAINTENANCE

Each day:

1. Clean the wheels.
2. Clean the torch nozzle and replace if damaged.

Each week:

1. Clean the teeth of the rack.

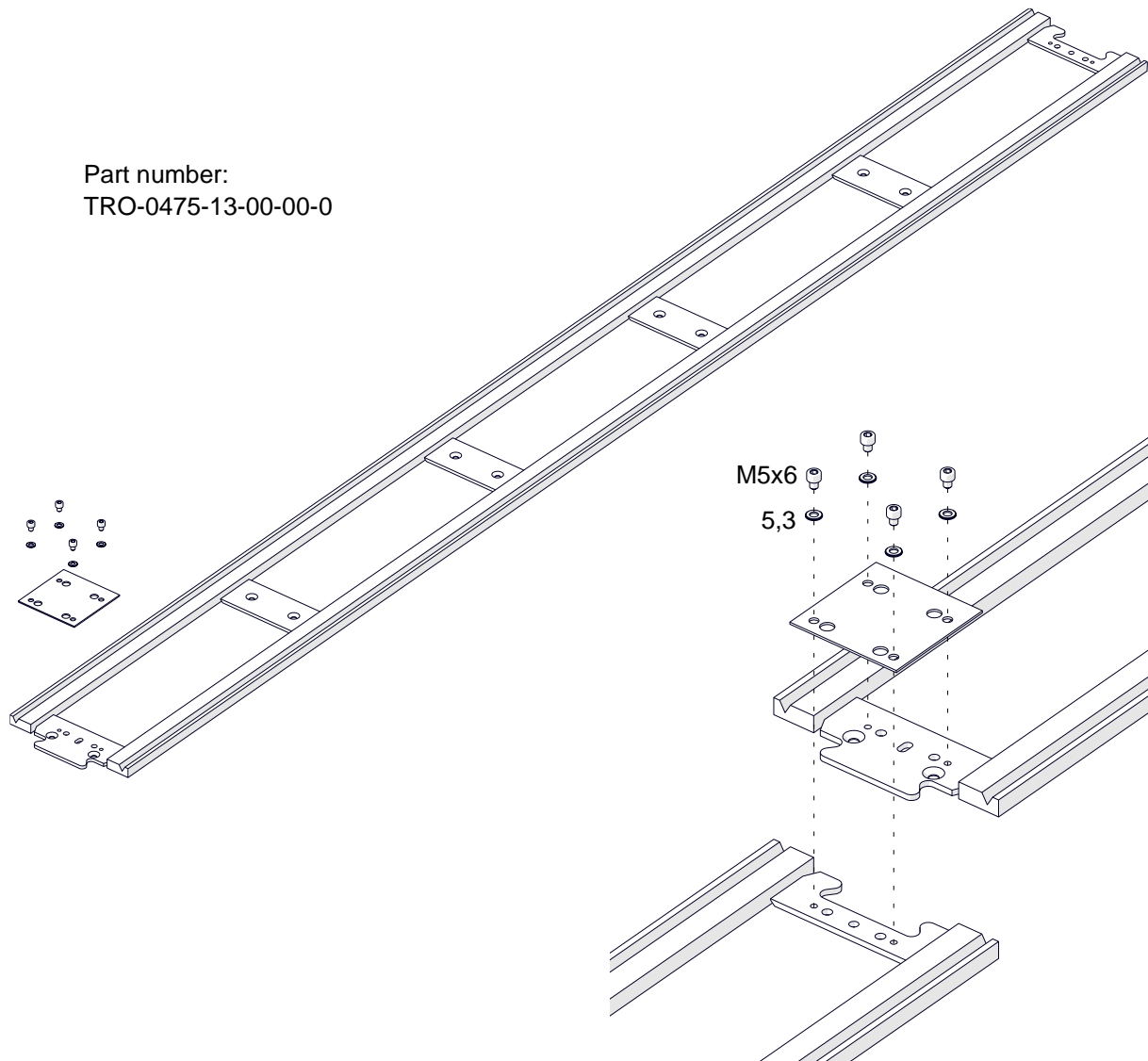
Each month:

1. Make sure that the knob and the switches work as intended. Replace if they are loose or damaged.
2. Examine cables and cords, and replace if damaged.
3. Tighten screws if loose.

5. ACCESSORIES

5.1. Track

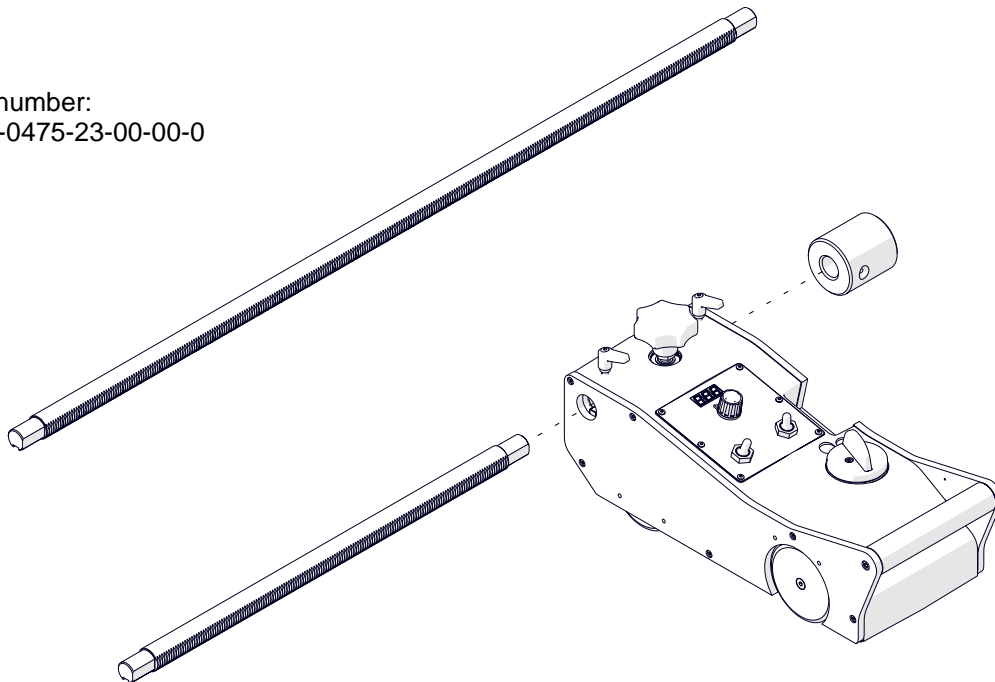
Increases the cutting precision by forcing straight-line travel. The length of a single rail is 1800 mm (70.9") and the V-groove centerline is 152 mm (6"). To connect two rails, use the 4 mm hex wrench and the connecting plate as shown in the figure.



5.2. 1000 mm (39") rack

Increases the reach of the torch holder.

Part number:
RAM-0475-23-00-00-0

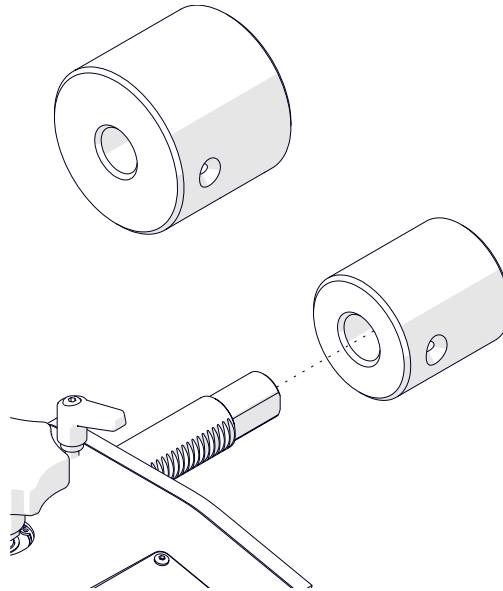


To remove the rack, use the 3 mm hex wrench to loosen the set screw and remove the counterweight. Then, loosen the handle of the torch holder and remove the holder. Next, unlock two rack locking levers and rotate the rack position knob to move the rack out of the carriage body. Install in reverse order. Put the rack teeth to the side to engage them with the gear of the knob. If you use the 1000 mm (39") rack, you may also need a roller support or a 2.6 kg counterweight to balance the carriage.

5.3. 2.6 kg (5.7 lbs) counterweight

Provides balance when using additional holders, a 1000 mm (39") rack, or a heavier torch. To remove the counterweight, use the 3 mm hex wrench to loosen the set screw. Install in reverse order.

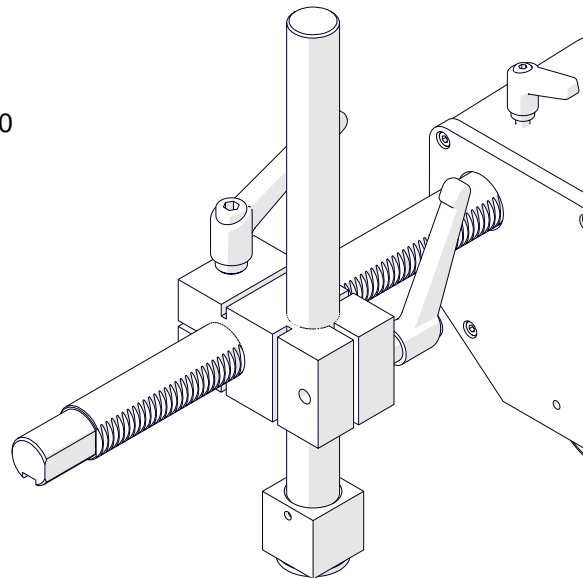
Part number:
PWG-0475-10-00-00-0



5.4. Roller support

Provides balance when using the 1000 mm (39") rack or a heavier torch.

Part number:
PDT-0475-26-00-00-0

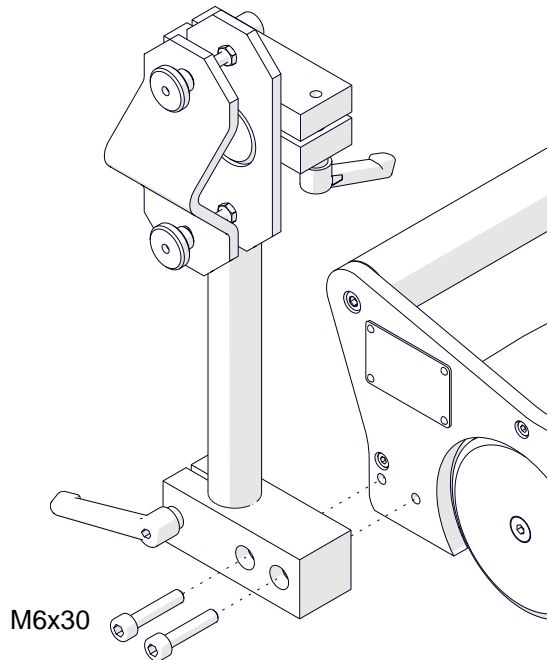


To install, loosen the handle of the torch holder and remove the holder. Then, put the support onto the rack, tighten with the handle, and install the holder again.

5.5. Cable anchor

Attaches the gas cables and the power cord to decrease the load applied on the torch holder. Install with the 5 mm hex wrench.

Part number:
PDT-0475-34-00-00-0

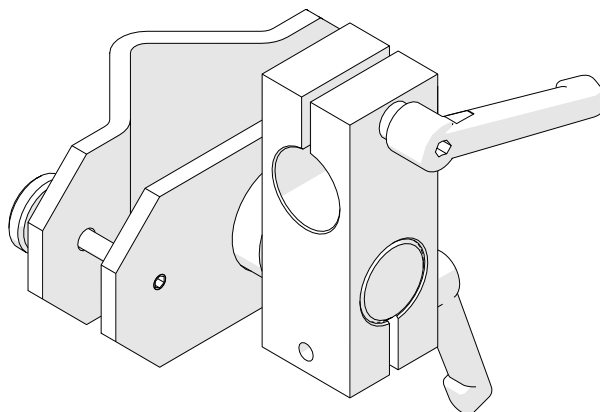


5.6. Torch holders

5.6.1. Standard torch holder

For torches with the diameter of 28–35 mm (1.10–1.38"). Allows rough adjustment of the torch angle.

Part number:
UCW-0475-28-00-00-0

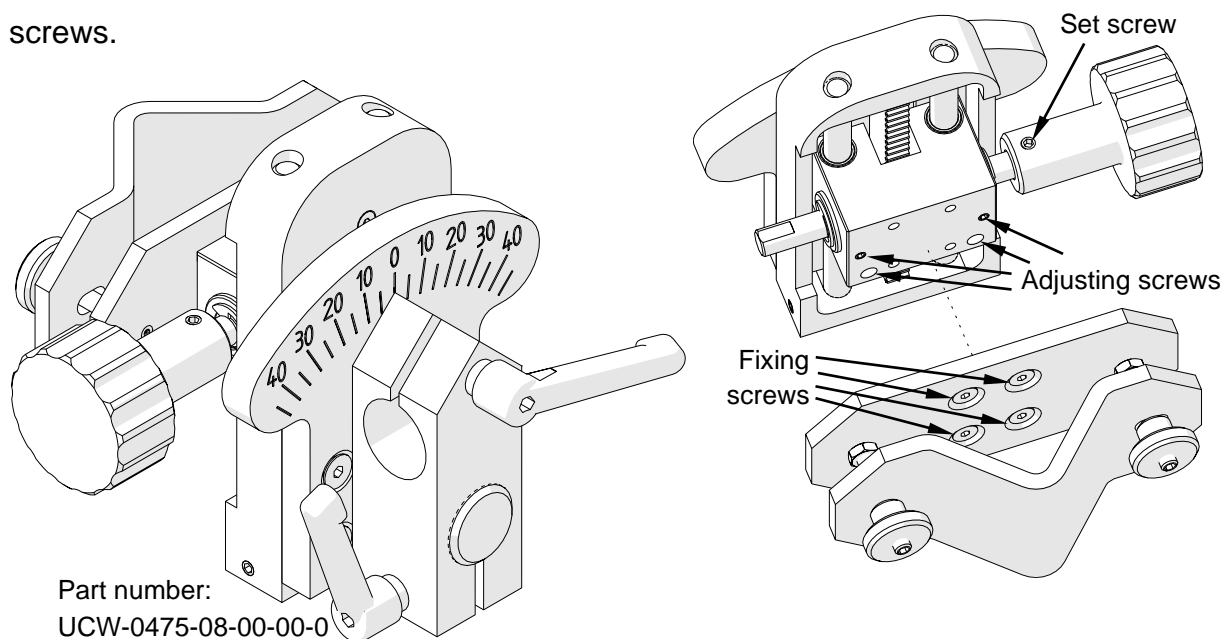


5.6.2. Precise torch holder

For torches with the diameter of 28–35 mm (1.10–1.38"). Allows precise adjustment of the torch angle.

Use the knob to adjust the vertical position. Install the knob at any side by using the 2.5 mm hex wrench and the set screw.

To adjust the resistance of the vertical travel, use the 2.5 mm hex wrench to remove the fixing screws. Then, use the 2 mm hex wrench to rotate the adjusting screws.

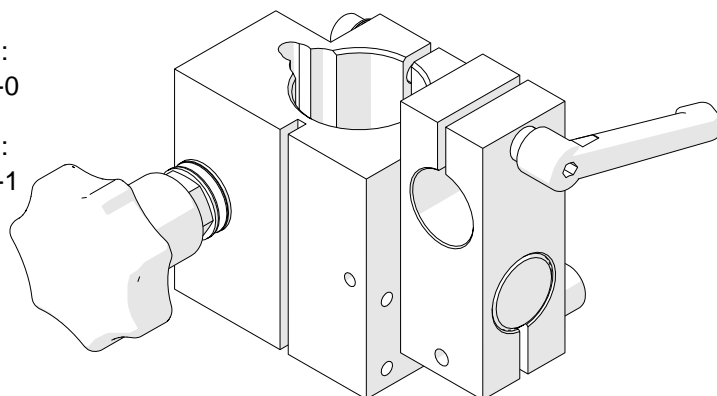


5.6.3. Machine torch holder (for oxy-fuel cutting)

For torches with the diameter of 35 mm (1.38") that have a rack. The holder allows adjustment of the vertical position of the torch by using the knob and rough adjustment of the angle.

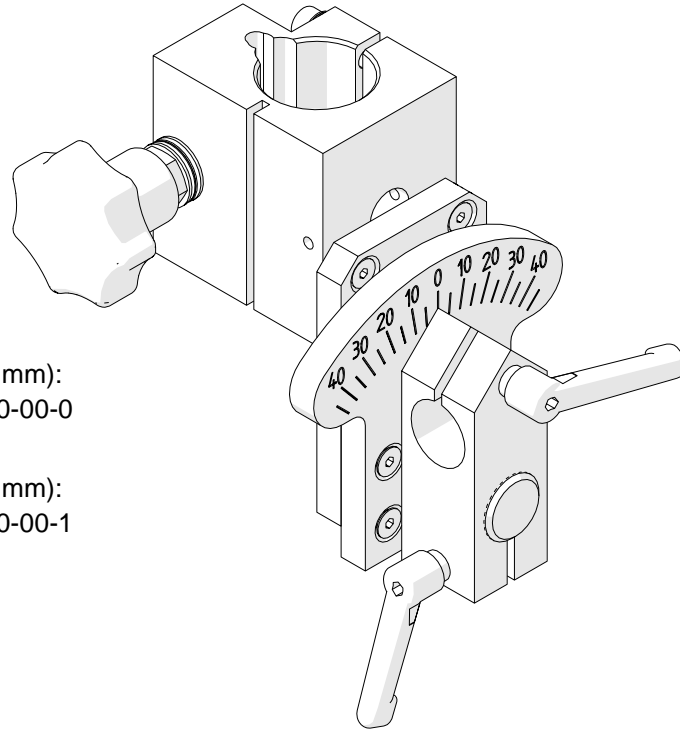
Part number (30 mm):
UCW-0475-61-00-00-0

Part number (35 mm):
UCW-0475-29-00-00-1



5.6.4. Precise machine torch holder (for oxy-fuel cutting)

For torches with the diameter of 35 mm (1.38") equipped with a rack. The holder allows adjustment of the vertical position of the torch by using the knob and precise adjustment of the angle.

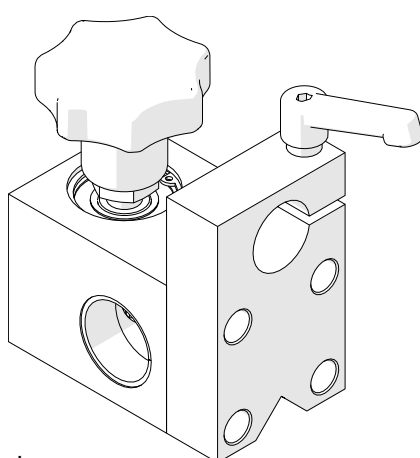


Part number (30 mm):
UCW-0475-59-00-00-0

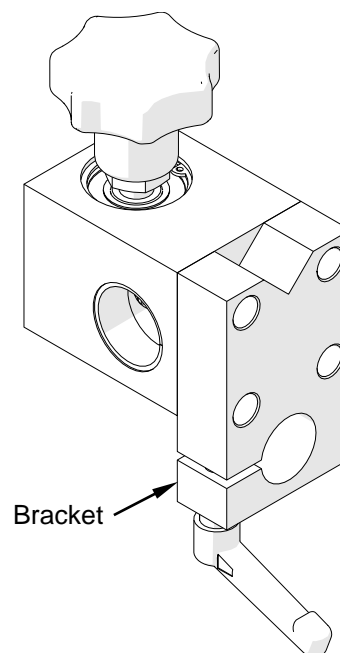
Part number (35 mm):
UCW-0475-42-00-00-1

5.7. Slide rack holder

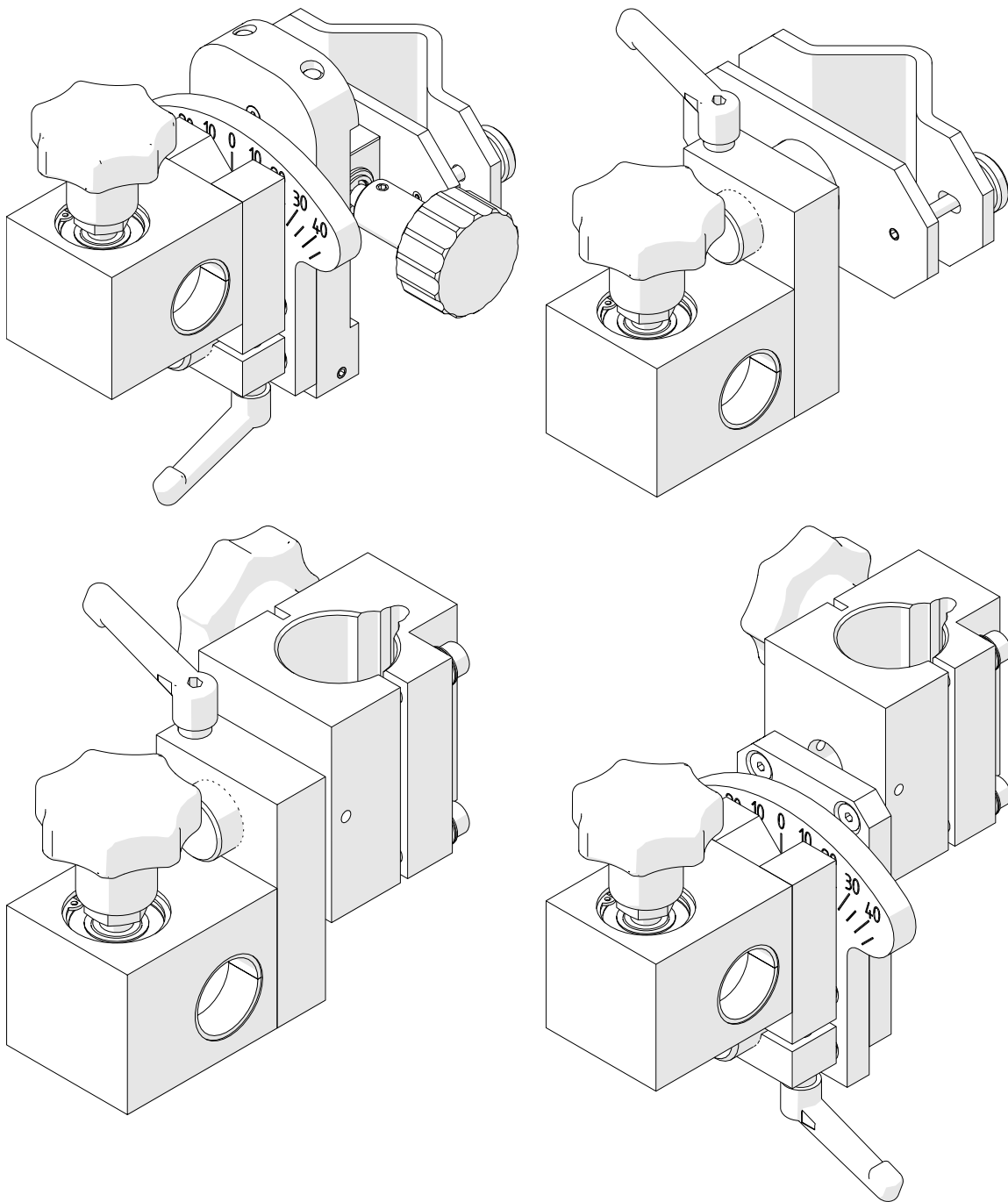
Can be put together with torch holders. This allows use of a second torch independently of the standard torch.



Part number:
UCW-0475-15-00-00-1



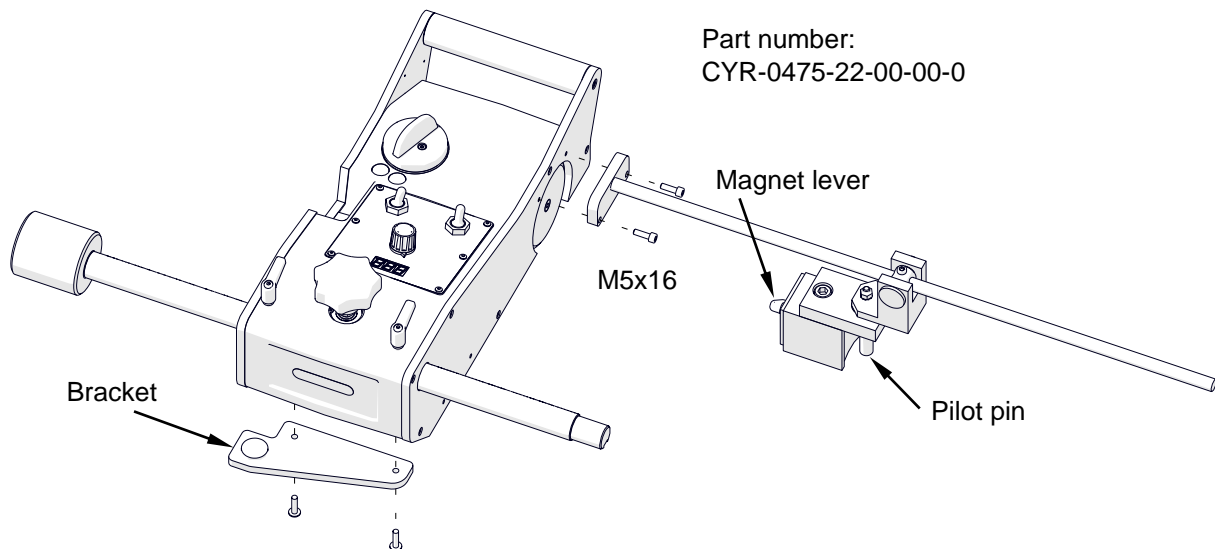
To adapt the rack holder for use with a precise torch holder, use the 4 mm hex wrench and remove four screws from the rack holder. Then, rotate the bracket by 180° and tighten with the screws. Before you attach a torch holder to the rack holder, remove the clamping block (part with one or two handles) from the torch holder. Remove the counterweight or holder in use, and then put the combined holder onto the rack. Next, rotate the knob to set the combined holder in the required position on the rack.



5.8. Circle cutting attachments

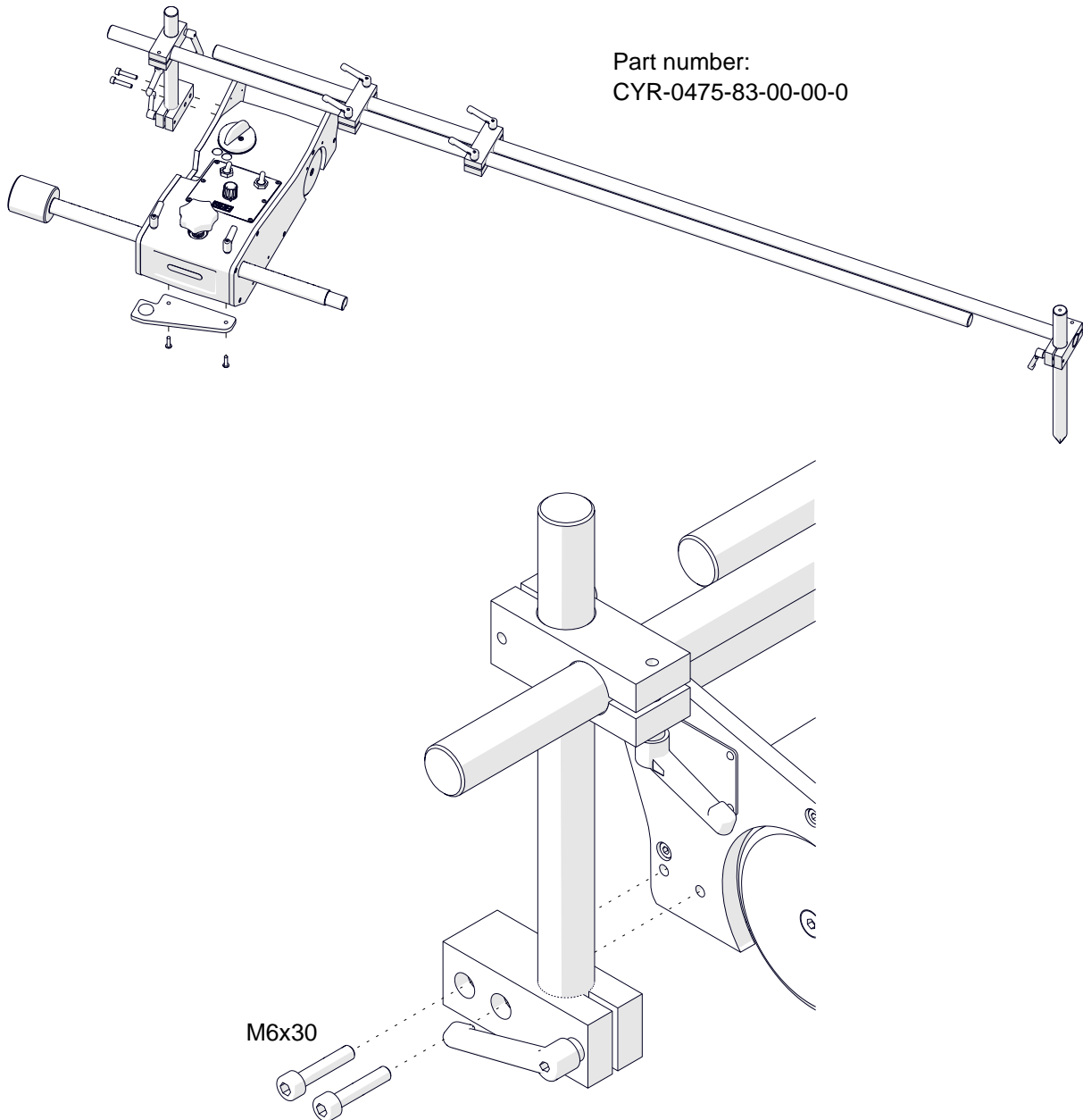
5.8.1. Circle cutting attachment for 240–1000 mm radius

Allows cutting holes with the radius of 240–1000 mm (0.8–3.3 ft; when used with the standard rack). To install, use the 3 mm hex wrench and remove two front screws from the bottom plate, and then use them to tighten the bracket in the same place. Use the 4 mm hex wrench to attach the arm to the side wall. Put the pilot pin above the center of the circle and use the lever to turn on the magnet.



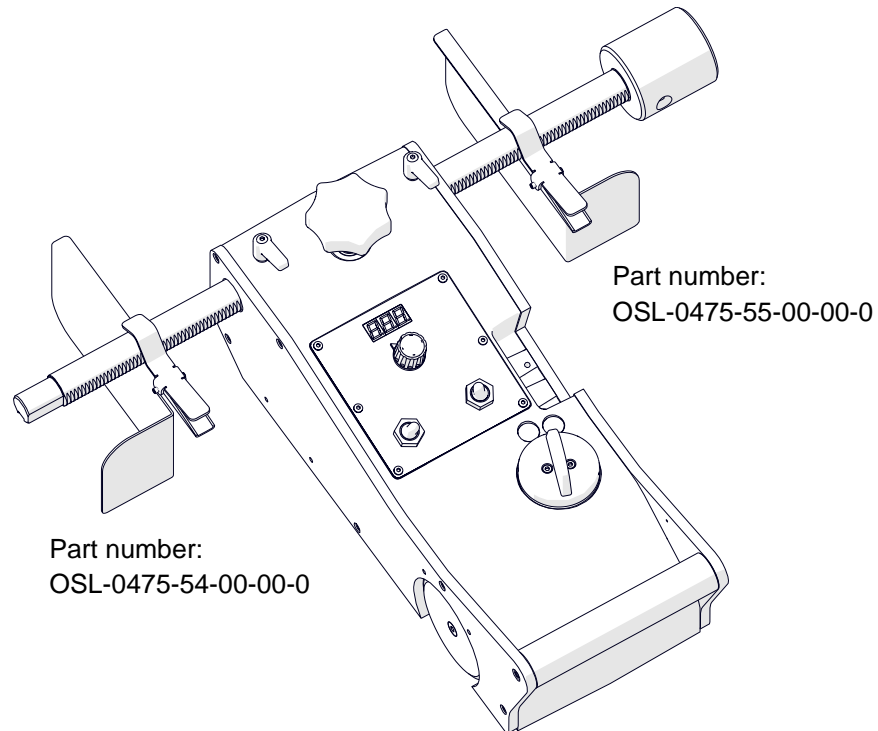
5.8.2. Circle cutting attachment for 400–2500 mm radius

Allows cutting holes with the radius of 400–2500 mm (1.3–8.2 ft; when used with the standard rack). To install, use the 3 mm hex wrench and remove two front screws from the bottom plate and use them to install the bracket in the same place. Use the 5 mm hex wrench to install the arm to the side wall. Put the tip of the pilot pin in the center of the circle and tighten the levers of the attachment.



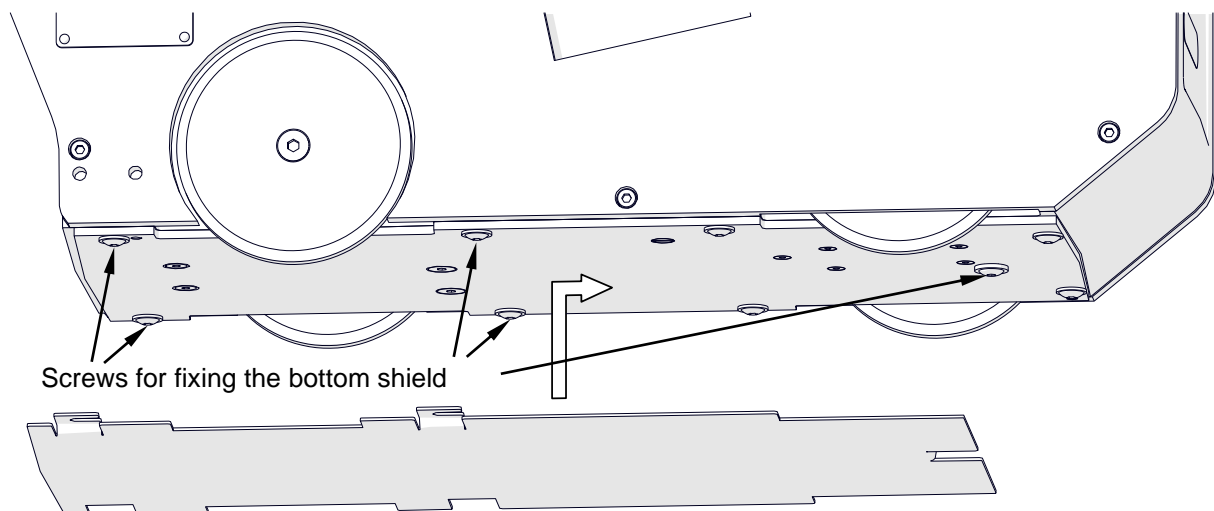
5.9. Left and right heat protection shield

Additionally protect the carriage from a high temperature.



5.10. Bottom heat protection shield

Additionally protects the carriage from a high temperature. To install, loosen five screws with the 3 mm hex wrench, put the shield under the heads of the screws according to the direction of the arrow, and then tighten the screws.



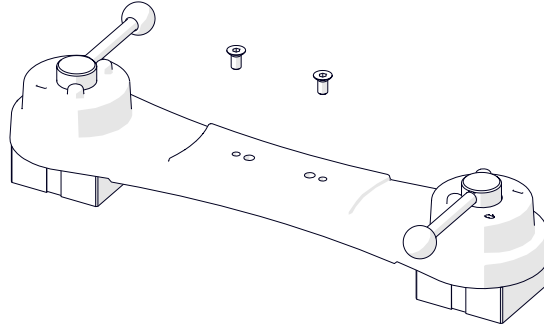
Part number: OSL-0475-53-00-00-0

5.11. Magnetic units

5.11.1. Magnetic unit

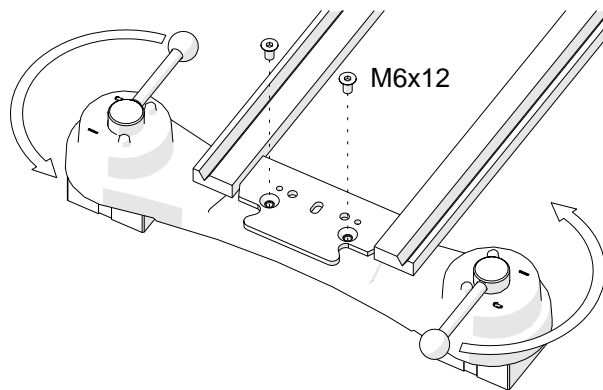
Allows clamping the track to ferromagnetic surfaces.

Part number:
ZSP-0475-44-00-00-0



Holding force on a 5 mm (0.2") thick surface	Temperature
100% (1200 N)	20°C (68°F)
75% (900 N)	80°C (176°F)
50% (600 N)	120°C (248°F)

Use the 4 mm hex wrench to attach the unit as shown in the figure. Then, set the levers to 'I'.

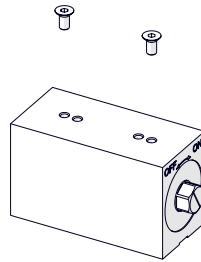


5.11.2. Narrow magnetic unit

Allows clamping the track to ferromagnetic surfaces.

Part number:

PDS-0582-10-00-02-0

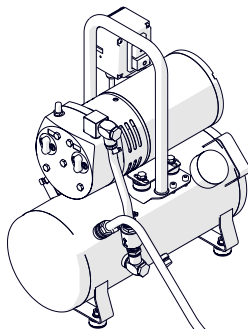


Holding force on a 5 mm (0.2") thick surface	Temperature
100% (1000 N)	20°C (68°F)
75% (750 N)	80°C (176°F)
50% (500 N)	120°C (248°F)

Install the unit in the same way as the magnetic unit is installed. To clamp the unit to the surface, use the 17 mm flat wrench (not included) and set the side screw to ON.

5.12. Vacuum track system

Allows clamping the track to non-ferromagnetic surfaces.

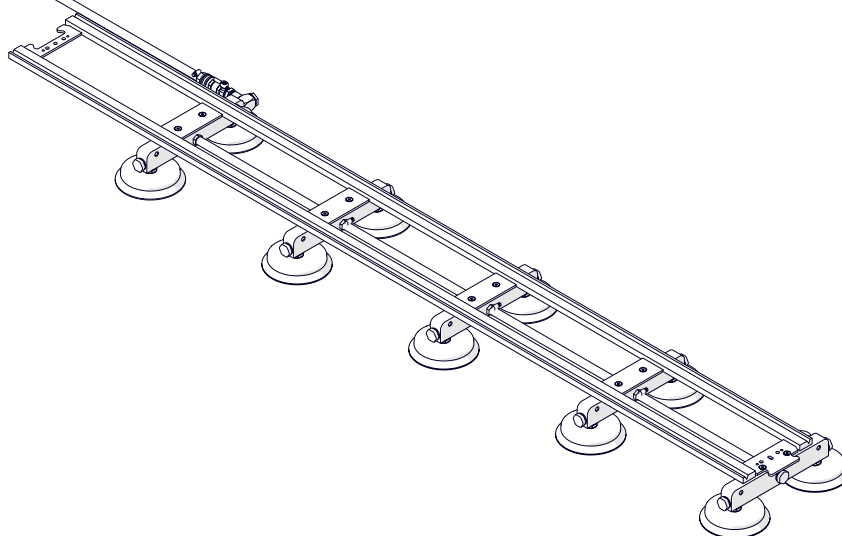


Part number (vacuum pump with safety reservoir):

AGR-0541-24-10-00-0 (115 V US)

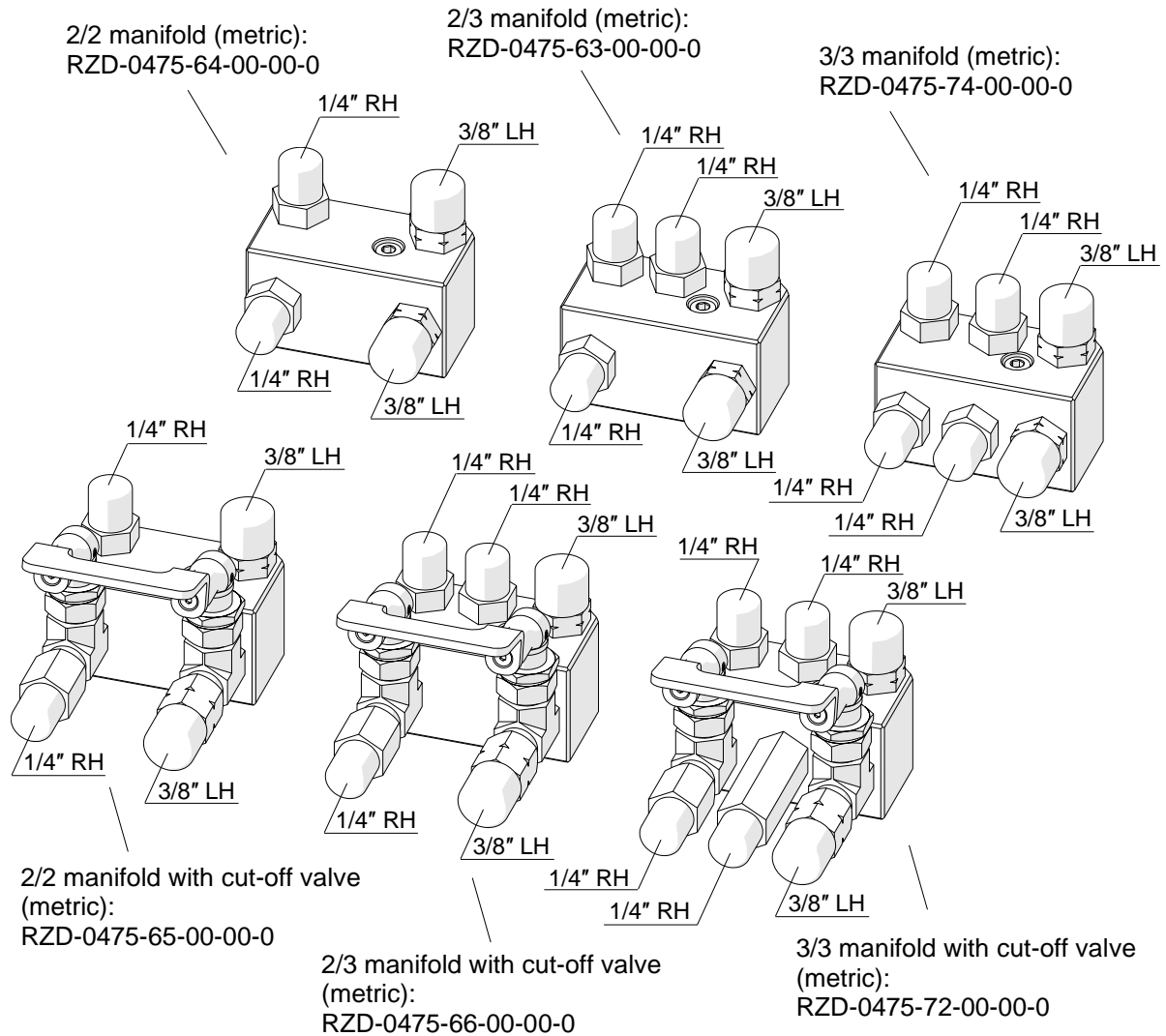
AGR-0541-24-20-00-0 (230 V CEE)

Other parts of the system are described in a related manual.



5.13. Gas manifold (for oxy-fuel cutting)

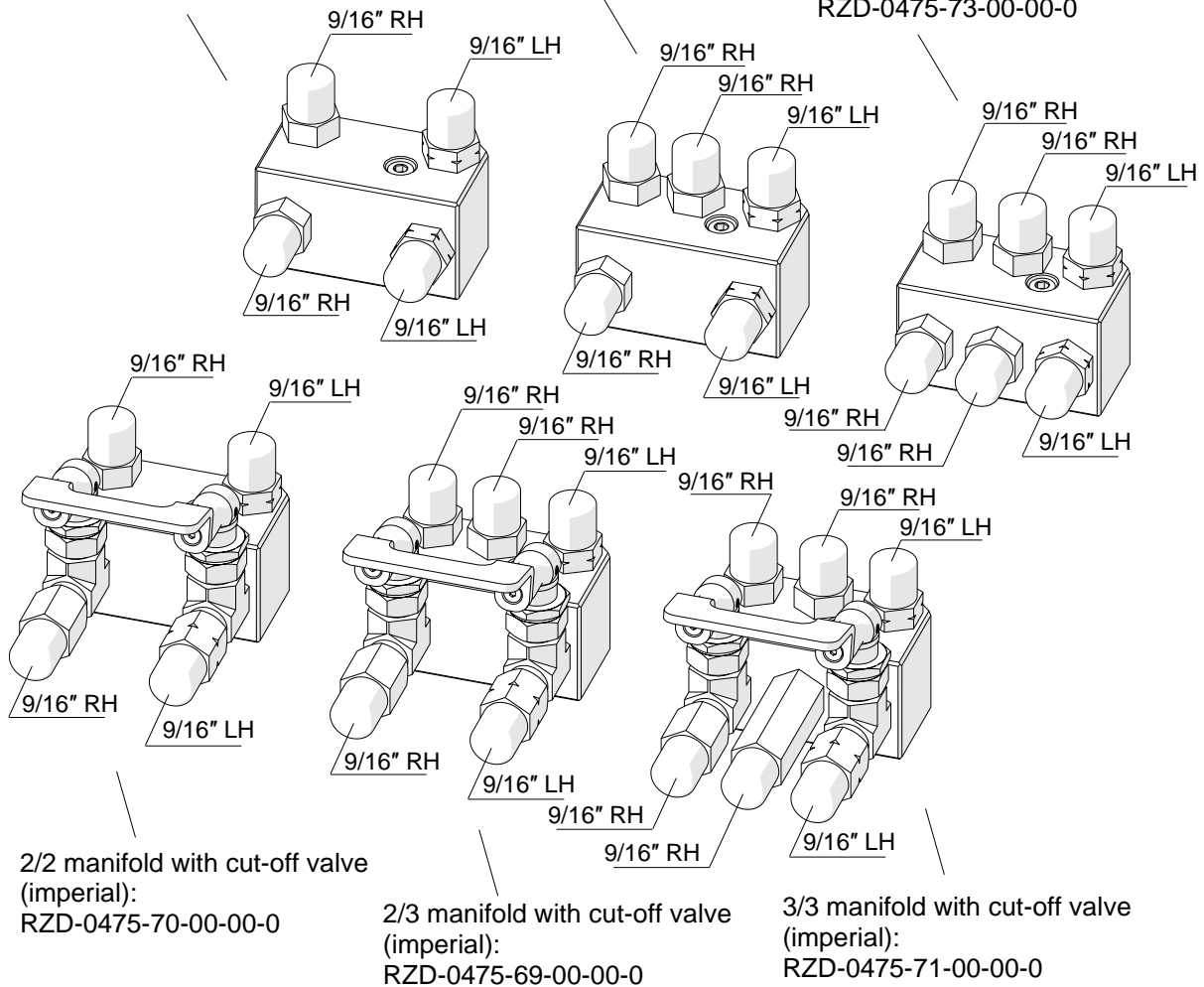
Provides safe gas delivery to 2- or 3-hose torches. Manifolds are available with or without gas cut-off valve in both metric and imperial versions.



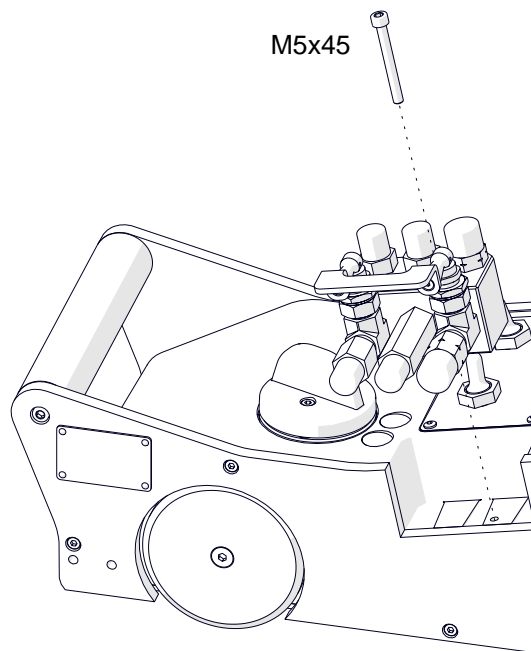
2/2 manifold (imperial):
RZD-0475-68-00-00-0

2/3 manifold (imperial):
RZD-0475-67-00-00-0

3/3 manifold (imperial):
RZD-0475-73-00-00-0

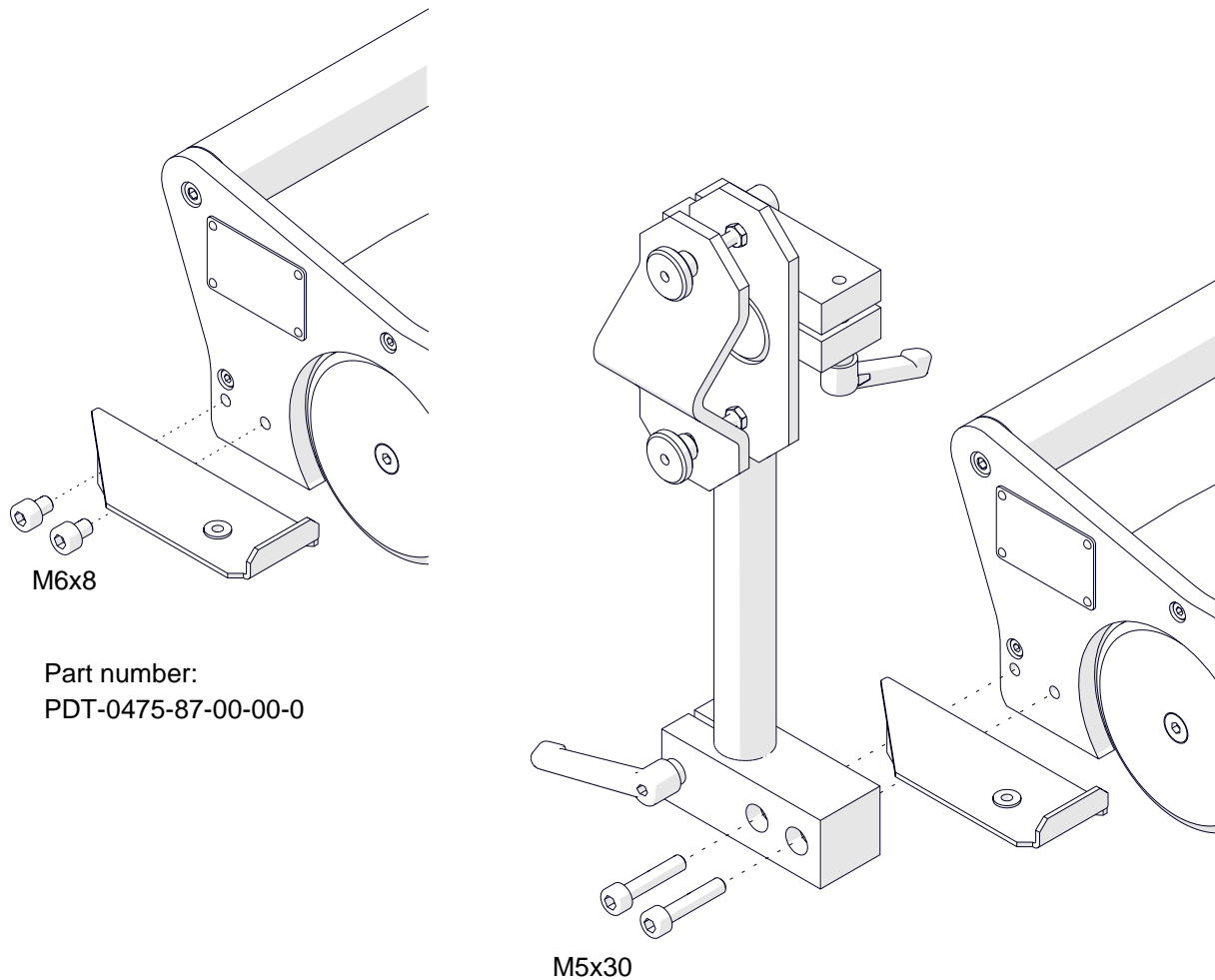


Install the manifold with the 4 mm hex wrench as shown in the figure.



5.14. Gas manifold bracket (for oxy-fuel cutting)

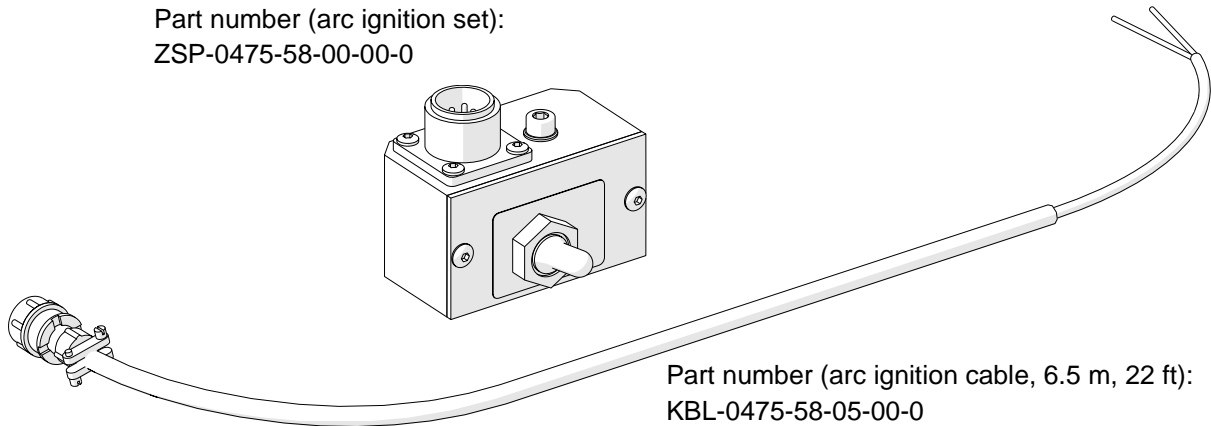
Allows use of a second gas manifold. Install the bracket with the 4 mm or 5 mm hex wrench as shown in the figures.



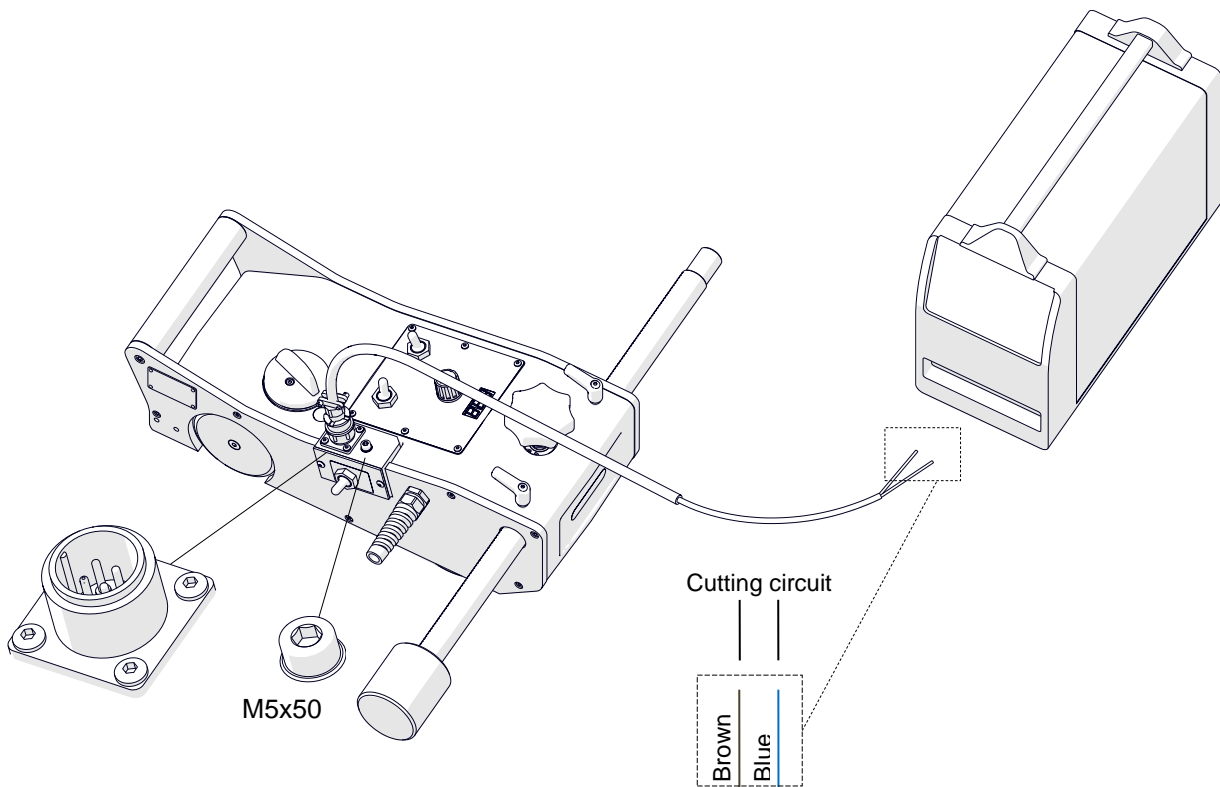
5.15. Arc ignition set (for plasma cutting)

Allows control of one torch by using the arc ignition cable.

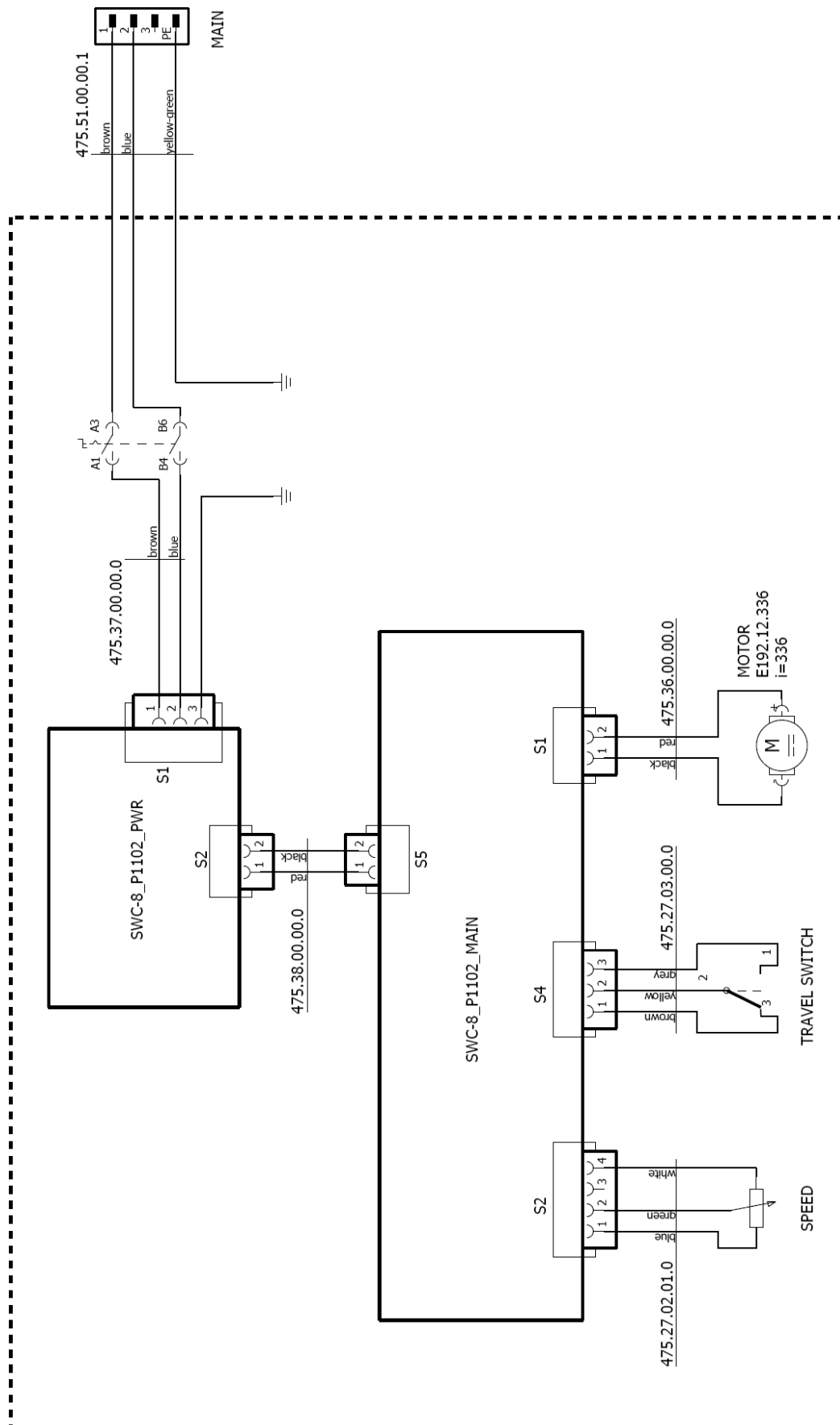
Part number (arc ignition set):
ZSP-0475-58-00-00-0



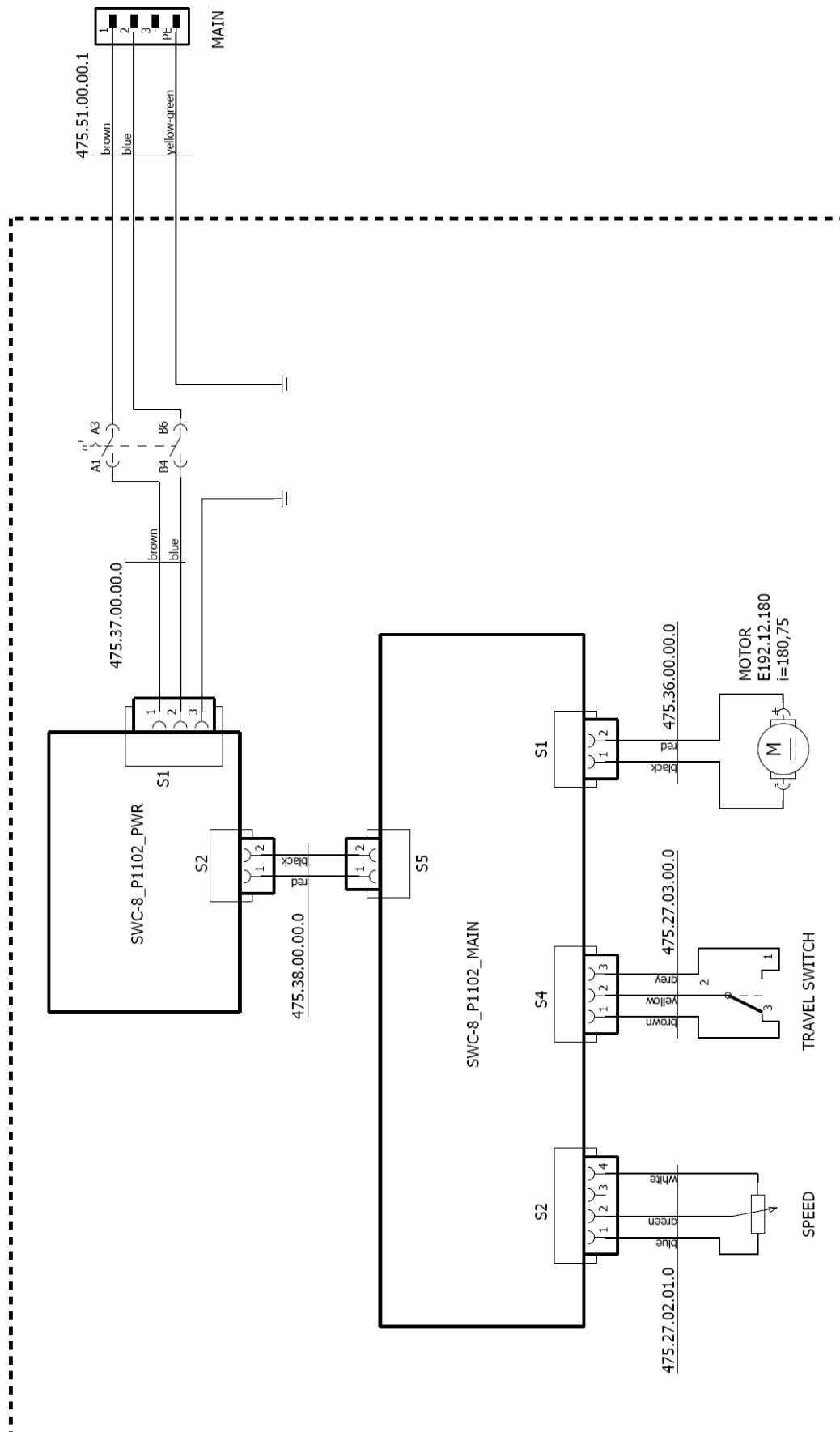
Install with the 4 mm hex wrench as shown in the figure. Plug the cable into the socket. Refer to the diagram from the figure and connect one brown wire to one terminal of the cutting circuit. Then, connect the blue wire to the other terminal of the same circuit.



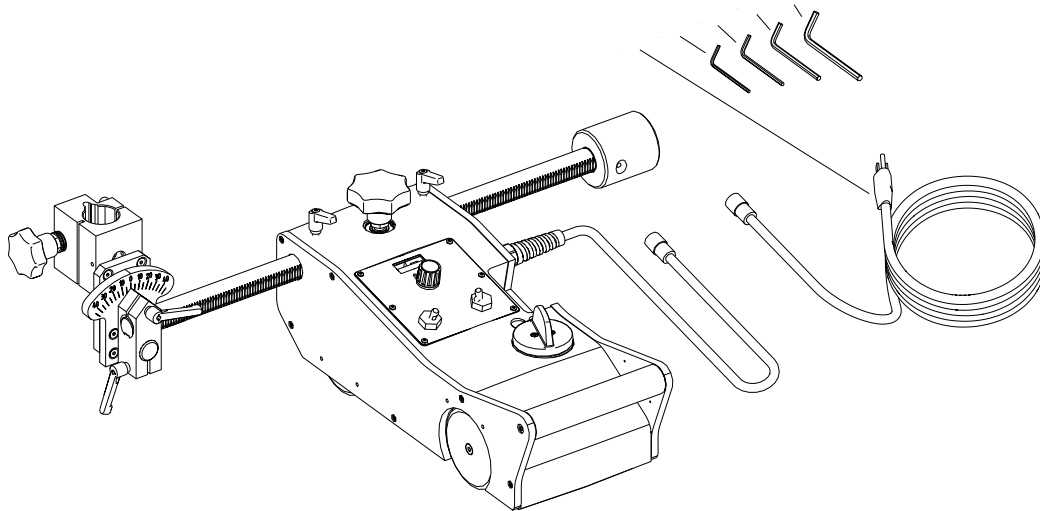
6. 115–230 V WIRING DIAGRAM



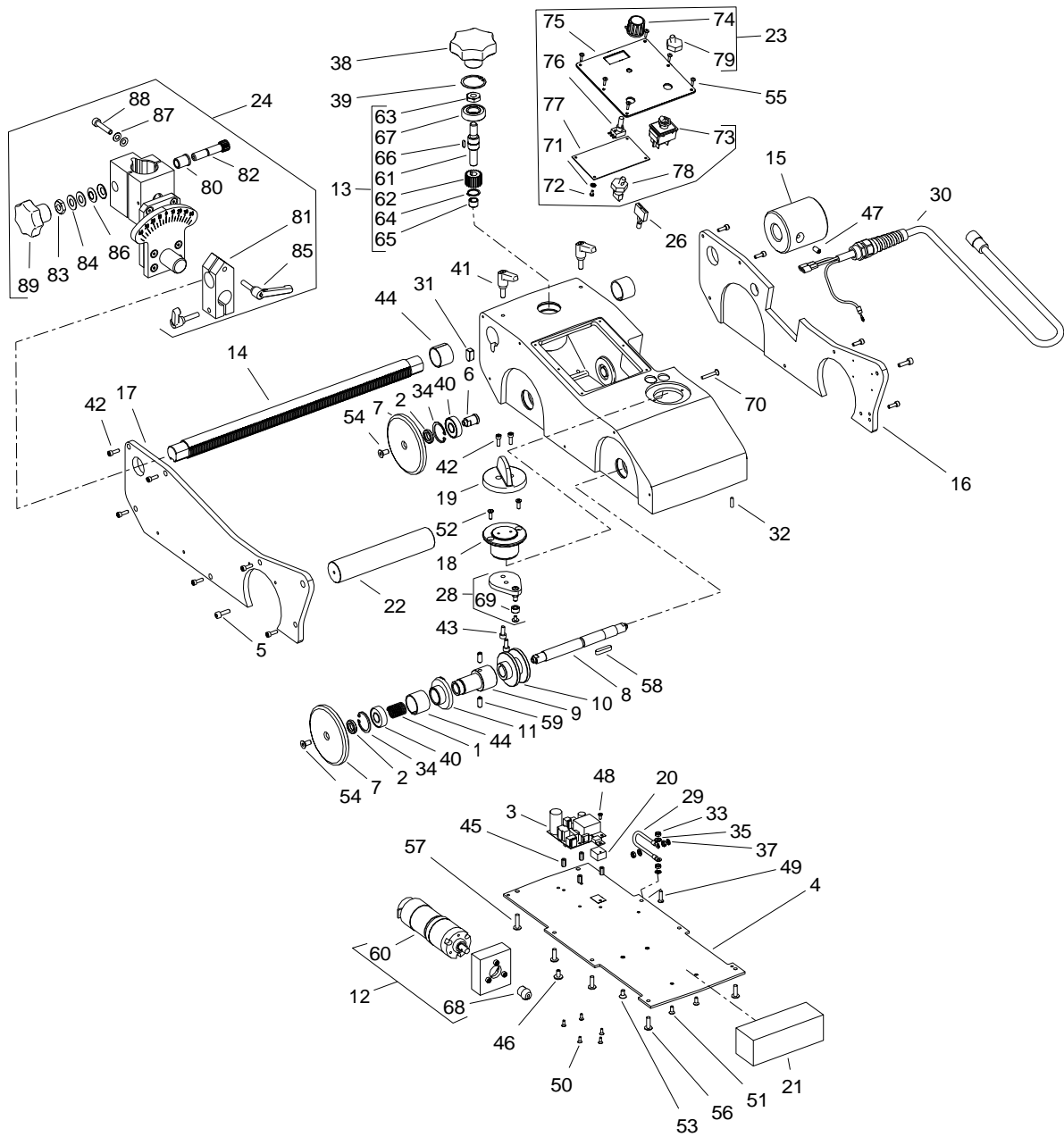
7. 115–230 V HS WIRING DIAGRAM



8. 115–230 V EXPLODED VIEWS AND PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PWD-0466-18-00-00-0	POWER CORD 230V (CEE)	1
1	PWD-0466-21-00-00-0	POWER CORD 230V (AU)	1
1	PWD-0466-16-00-00-0	POWER CORD 120V (USA)	1
1	PWD-0466-23-00-00-0	POWER CORD 120V (UK type G)	1
1	PWD-0466-24-00-00-0	POWER CORD 3x1.5 – WITHOUT PLUG	1
2	KLC-000005	2.5 MM HEX WRENCH	1
3	KLC-000006	3 MM HEX WRENCH	1
4	KLC-000007	4 MM HEX WRENCH	1
5	KLC-000008	5 MM HEX WRENCH	1

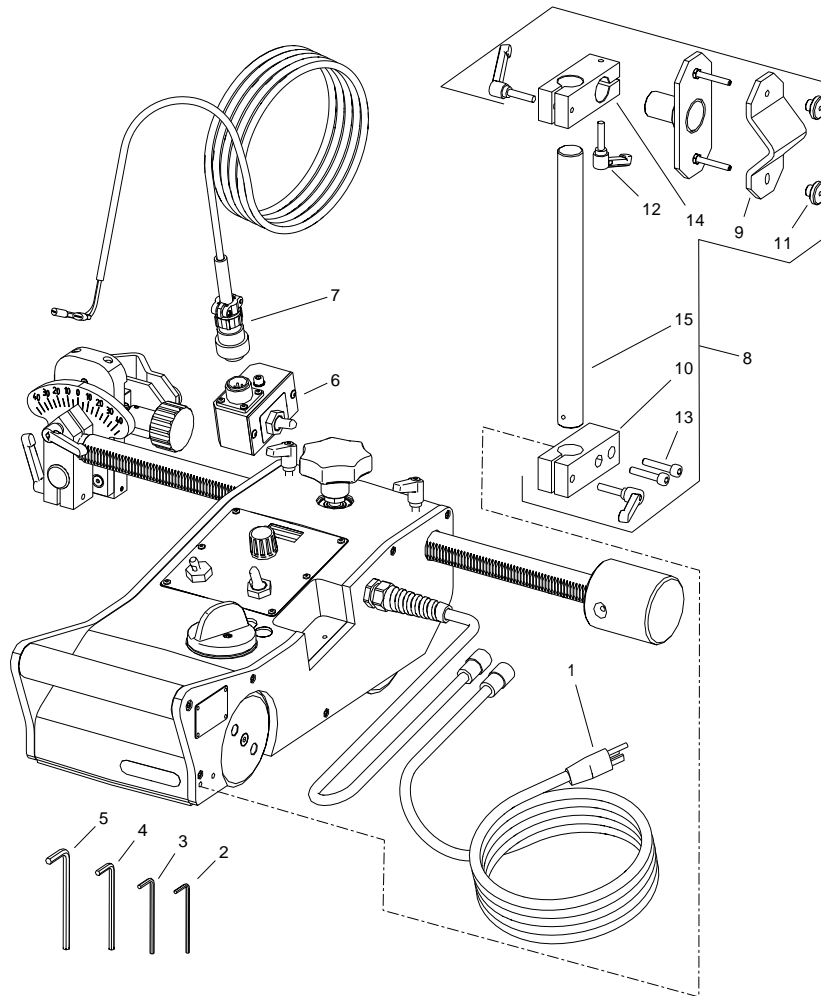


ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	SPR-0256-00-07-00-0	CLUTCH SPRING	1
2	PDK-0256-00-13-00-0	DISTANCE WASHER	4
3	MDL-0466-02-03-00-1	POWER SUPPLY ELECTRONIC CONTROLLER ASSY	1
4	PKR-0475-01-00-00-2	BOTTOM COVER	1
5	SRB-000083	HEX SOCKET HEAD CAP SCREW M5x16	2
6	WLK-0475-03-01-00-0	BACK SHAFT	2
7	KOL-0475-03-02-00-1	DRIVE WHEEL II	4
8	WLK-0475-04-01-00-1	DRIVE SHAFT	1
9	ZBI-0475-04-02-00-0	DRIVING RING I	1
10	ZBI-0475-04-03-00-0	DRIVING RING II	1
11	KOL-0475-04-05-00-0	WHEEL	1
12	ZSP-0475-05-00-00-0	MOTOR ASSY	1
13	ZSP-0475-06-00-00-1	FEED ASSY	1
14	RAM-0525-07-00-00-0	RACK 540 MM (21")	1
15	PWG-0475-09-00-00-0	COUNTERWEIGHT 1.3 KG (2.9 LBS)	1
16	OSL-0475-11-00-00-1	COVER I	1
17	OSL-0475-12-00-00-1	COVER II	1
18	WLC-0475-16-00-00-0	CLUTCH KNOB	1
19	PNK-0475-16-03-00-2	CLUTCH	1
20	WSP-0475-17-00-00-0	POWER SUPPLY BRACKET	1
21	BLO-0475-18-00-00-0	BALLAST	1
22	RKJ-0475-19-00-00-0	CARRYING HANDLE	1
23	PNL-0475-27-00-00-0	CONTROL PANEL	1
24	UCW-0475-42-00-00-1	PRECISE MACHINE TORCH HOLDER	1
25*	WZK-0475-36-00-00-0	MOTOR WIRE SET	1
26	WZK-0475-37-00-00-0	POWER SWITCH WIRE SET	1
27*	WZK-0475-38-00-00-0	POWER SUPPLY-CONTROL PANEL WIRE SET	1
28	RAM-0475-47-00-00-0	SWITCH ARM ASSY	1
29	WZK-0475-50-00-00-0	GROUNDING WIRE SET	1
30	WZK-0475-51-00-00-1	POWER WIRE SET	1
31	WPS-0475-52-00-00-0	KEY 8x7x16	1
32	KLK-000034	DOWEL PIN 4n6x14	2
33	NKR-000013	HEX NUT M4	4
34	PRS-000018	INTERNAL RETAINING RING 28w	3
35	PDK-000015	ROUND WASHER 4.3	2
36	PDK-000140	SILICONE WASHER 18x13	1
37	PDK-000166	EXTERNAL TOOTH LOCK WASHER 4.3	2
38	PKT-000038	STAR KNOB D63	1
39	PRS-000022	INTERNAL RETAINING RING 32w	1
40	LOZ-000038	BALL BEARING 12x28x8	4
41	RKJ-000070	HANDLEVER M6-16	2
42	SRB-000062	HEX SOCKET HEAD CAP SCREW M4x12	14
43	SRB-000078	HEX SOCKET HEAD CAP SCREW M5x12	2
44	TLJ-000069	SELF LUBRICATING SLEEVE SBT 25x28x20	3
45	TLJ-000023	SLEEVE M3x10	4
46	WKR-000335	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M5x10	1
47	WKR-000050	HEX SOCKET SET SCREW WITH FLAT POINT M6x12	1
48	WKR-000339	SELF-TAPPING SCREW M3x6	1
49	WKR-000166	COUNTERSUNK HEAD SCREW M4x16	1
50	WKR-000398	HEX SOCKET COUNTERSUNK HEAD SCREW M3x8	5

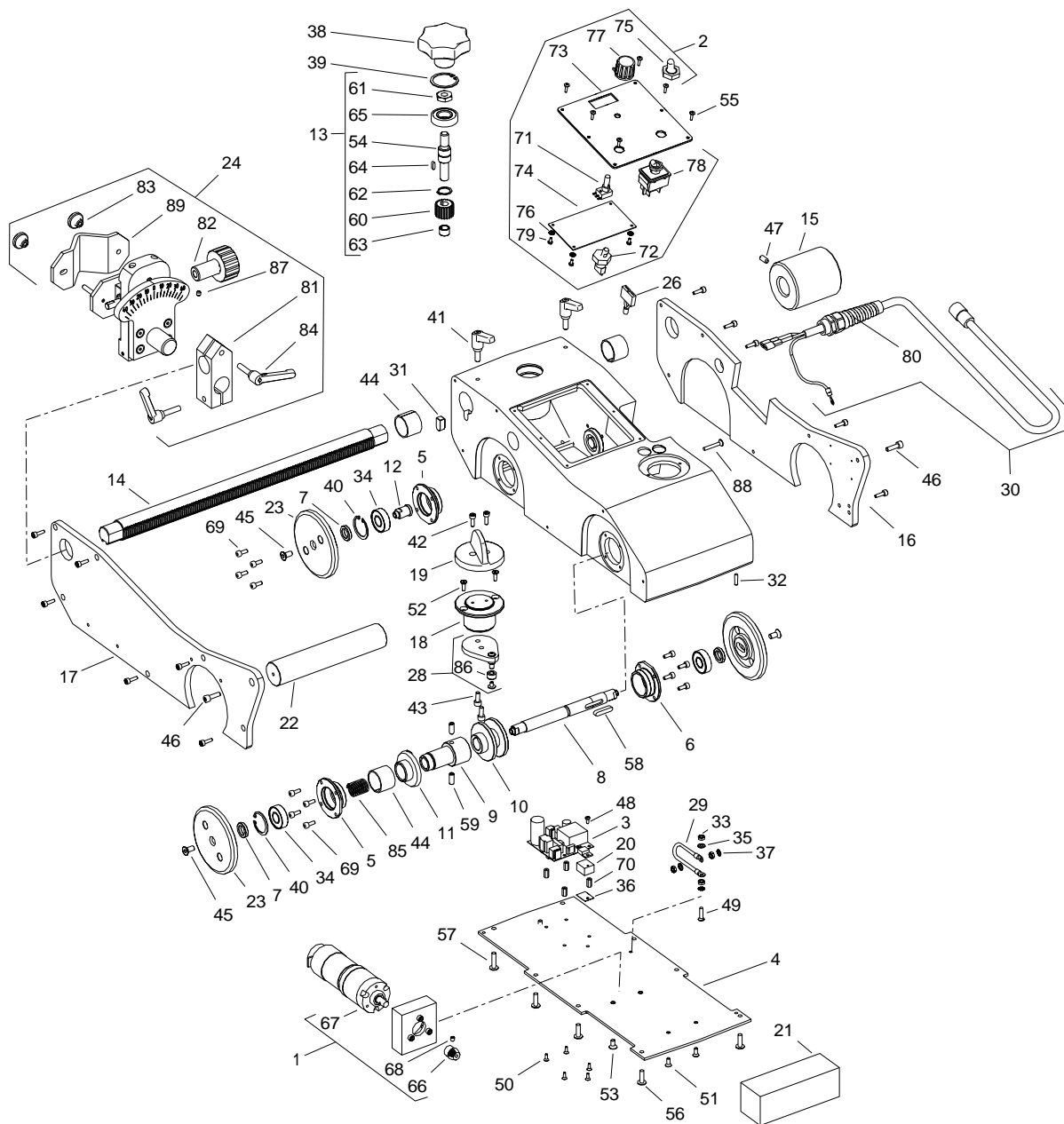
ITEM	PART NUMBER	DESCRIPTION	Q-TY
51	WKR-000130	HEX SOCKET COUNTERSUNK HEAD SCREW M4x10	2
52	WKR-000131	HEX SOCKET COUNTERSUNK HEAD SCREW M4x12	2
53	WKR-000133	HEX SOCKET COUNTERSUNK HEAD SCREW M5x10	2
54	WKR-000141	HEX SOCKET COUNTERSUNK HEAD SCREW M6x12	4
55	WKR-000287	HEX SOCKET BUTTON HEAD SCREW M3x10	6
56	WKR-000449	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M5x16	6
57	WKR-000395	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M5x20	2
58	WPS-000069	KEY A 5x5x25	1
59	ZTR-000004	BALL LOCK M6	2
60	MTR-0475-05-03-00-0	GEAR MOTOR ASSY	1
61	WLK-0475-06-02-00-1	GEAR SHAFT	1
62	KOL-0475-06-03-00-0	GEAR z=20 m=1	2
63	NKR-000087	NUT M10 SHORT	1
64	PRS-000005	EXTERNAL RETAINING RING 15z	1
65	TLJ-000095	SELF LUBRICATING SLEEVE 10/12x08	1
66	WPS-000005	KEY 3x3x10	1
67	LOZ-000101	BALL BEARING 15x32x8	1
68	ZBK-0475-05-02-00-0	COG	1
69	TLJ-0475-16-06-00-0	SLEEVE	1
70	WKR-000167	COUNTERSUNK HEAD SCREW M4x25	1
71	PDK-000058	EXTERNAL TOOTH LOCK WASHER 3.2	4
72	WKR-000181	CROSS RECESSED PAN HEAD SCREW M3x6	4
73	PNK-000026	LEVER SWITCH 641 H/3	1
74	PKT-000028	POTENTIOMETER KNOB	1
75	MSK-0475-27-01-00-0	PANEL PLATE ASSY	1
76	WZK-0475-27-02-01-0	POTENTIOMETER WIRE SET	1
77	MDL-0475-27-02-02-0	ELECTRONIC CONTROLLER	1
78	WZK-0475-27-03-00-0	TRAVEL DIRECTION WIRE SET	1
79	OSL-000036	LEVER SWITCH COVER	1
80	TLJ-0261-04-04-00-0	SLEEVE BEARING	1
81	KST-0475-08-03-00-0	BAR CLAMPING BLOCK	1
82	WLK-0475-29-04-00-0	GEAR SHAFT	1
83	NKR-000087	NUT M10 SHORT	1
84	PDK-000194	WASHER 10x22x1	2
85	RKJ-000043	HANDLEVER M6-25	2
86	SPR-000053	DISC SPRING 10.2x20x0.5	2
87	SPR-000010	DISC SPRING 6.2x12.5x0.6	4
88	SRB-000118	HEX SOCKET HEAD CAP SCREW M6x30	2
89	PKT-000039	KNOB D50xM10	1

* not shown in the drawing

9. 115–230 V HS EXPLODED VIEWS AND PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	PWD-0466-18-00-00-0	POWER CORD 230V (CEE)	1
1	PWD-0466-21-00-00-0	POWER CORD 230V (AU)	1
1	PWD-0466-16-00-00-0	POWER CORD 120V (USA)	1
1	PWD-0466-23-00-00-0	POWER CORD 120V (UK type G)	1
1	PWD-0466-24-00-00-0	POWER CORD 3x1.5 – WITHOUT PLUG	1
2	KLC-000005	2.5 MM HEX WRENCH	1
3	KLC-000006	3 MM HEX WRENCH	1
4	KLC-000007	4 MM HEX WRENCH	1
5	KLC-000008	5 MM HEX WRENCH	1
6	ZSP-0475-58-00-00-0	ARC IGNITION SET	1
7	KBL-0475-58-05-00-0	START-STOP ARC IGNITION CABLE 6.5 M (20 FT)	1
8	PDT-0475-34-00-00-0	CABLE ANCHOR	1
9	DCS-0475-25-00-00-0	TORCH CLAMP	1
10	KST-0475-34-02-00-0	CLAMPING BLOCK	1
11	NKR-000077	KNURLED NUT M5	2
12	RKJ-000043	HANDLEVER M6-25	3
13	SRB-000118	HEX SOCKET HEAD CAP SCREW M6x30	2
14	KST-0466-43-04-00-0	DOUBLE CLAMPING BLOCK	1
15	WLK-0475-26-03-00-0	BAR	1



ITEM	PART NUMBER	DESCRIPTION	Q-TY
1	ZSP-0527-01-01-00-0	MOTOR ASSY	1
2	PNL-0527-02-00-00-0	CONTROL PANEL	1
3	MDL-0466-02-03-00-1	POWER SUPPLY ELECTRONIC CONTROLLER ASSY	1
4	PKR-0475-01-00-00-2	BOTTOM COVER	1
5	TLJ-0256-00-02-00-0	RESISTING SHAFT SLEEVE	3
6	TLJ-0256-00-03-00-0	OPEN SHAFT SLEEVE	1
7	PDK-0256-00-13-00-0	DISTANCE WASHER	4
8	WLK-0475-04-01-00-1	DRIVE SHAFT	1
9	ZBI-0475-04-02-00-0	DRIVING RING I	1
10	ZBI-0475-04-03-00-0	DRIVING RING II	1
11	KOL-0475-04-05-00-0	WHEEL	1
12	WLK-0475-03-01-00-0	BACK SHAFT	2
13	ZSP-0475-06-00-00-1	FEED ASSY	1
14	RAM-0525-07-00-00-0	ARM I	1
15	PWG-0475-09-00-00-0	COUNTERWEIGHT 1.3 KG (2.9 LBS)	1
16	OSL-0475-11-00-00-1	COVER I	1
17	OSL-0475-12-00-00-1	COVER II	1
18	WLC-0475-16-00-00-0	CLUTCH KNOB	1
19	PNK-0475-16-03-00-2	CLUTCH	1
20	WSP-0475-17-00-00-0	POWER SUPPLY BRACKET	1
21	BLO-0475-18-00-00-0	BALLAST	1
22	RKJ-0475-19-00-00-0	CARRYING HANDLE	1
23	KOL-0475-03-02-00-0	DRIVE WHEEL II	4
24	UCW-0475-08-00-00-0	PRECISE HOLDER	1
25*	WZK-0475-36-00-00-0	MOTOR WIRE SET	1
26	WZK-0475-37-00-00-0	POWER SWITCH WIRE SET	1
27*	WZK-0475-38-00-00-0	POWER SUPPLY-CONTROL PANEL WIRE SET	1
28	RAM-0475-47-00-00-0	SWITCH ARM ASSY	1
29	WZK-0475-50-00-00-0	GROUNDING WIRE SET	1
30	WZK-0475-51-00-00-1	POWER WIRE SET	1
31	WPS-0475-52-00-00-0	KEY 8x7x16	1
32	KLK-000034	DOWEL PIN 4n6x14	2
33	NKR-000013	HEX NUT M4	4
34	LOZ-000038	BALL BEARING 12x28x8	4
35	PDK-000015	ROUND WASHER 4.3	2
36	PDK-000140	SILICONE WASHER 18x13	1
37	PDK-000166	EXTERNAL TOOTH LOCK WASHER 4.3	2
38	PKT-000038	STAR KNOB D63	1
39	PRS-000022	INTERNAL RETAINING RING 32w	1
40	PRS-000018	INTERNAL RETAINING RING 28w	3
41	RKJ-000070	HANDLEVER M6-16	2
42	SRB-000062	HEX SOCKET HEAD CAP SCREW M4x12	14
43	SRB-000078	HEX SOCKET HEAD CAP SCREW M5x12	2
44	TLJ-000069	SELF LUBRICATING SLEEVE SBT 25x28x20	3
45	WKR-000141	HEX SOCKET COUNTERSUNK HEAD SCREW M6x12	4
46	SRB-000083	HEX SOCKET HEAD CAP SCREW M5x16	2
47	WKR-000050	HEX SOCKET SET SCREW WITH FLAT POINT M6x12	1
48	WKR-000339	SELF-TAPPING SCREW M3x6	1
49	WKR-000166	COUNTERSUNK HEAD SCREW M4x16	1
50	WKR-000398	HEX SOCKET COUNTERSUNK HEAD SCREW M3x8	5

ITEM	PART NUMBER	DESCRIPTION	Q-TY
51	WKR-000130	HEX SOCKET COUNTERSUNK HEAD SCREW M4x10	2
52	WKR-000131	HEX SOCKET COUNTERSUNK HEAD SCREW M4x12	2
53	WKR-000133	HEX SOCKET COUNTERSUNK HEAD SCREW M5x10	3
54	WLK-0475-06-02-00-1	GEAR SHAFT	1
55	WKR-000287	HEX SOCKET BUTTON HEAD SCREW M3x10	6
56	WKR-000449	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M5x16	6
57	WKR-000395	HEX SOCKET ROUND HEAD SCREW WITH FLANGE M5x20	2
58	WPS-000069	KEY A 5x5x25	1
59	ZTR-000004	BALL LOCK M6	2
60	KOL-0475-06-03-00-0	GEAR z=20 m=1	1
61	NKR-000087	NUT M10 SHORT	1
62	PRS-000005	EXTERNAL RETAINING RING 15z	1
63	TLJ-000095	SELF LUBRICATING SLEEVE 10x12x08	1
64	WPS-000005	KEY 3x3x10	1
65	LOZ-000101	BALL BEARING 15x32x8	1
66	ZBK-0475-05-02-00-0	COG	1
67	MTR-0527-01-01-01-0	GEAR MOTOR ASSY	1
68	WKR-000047	HEX SOCKET SET SCREW WITH FLAT POINT M5x5	1
69	SRB-000061	HEX SOCKET HEAD CAP SCREW M4x10	16
70	TLJ-000023	SLEEVE M3x10	4
71	WZK-0475-27-02-01-0	POTENTIOMETER WIRE SET	1
72	WZK-0475-27-03-00-0	TRAVEL DIRECTION WIRE SET	1
73	MSK-0527-02-01-00-0	PANEL PLATE ASSY	1
74	MDL-0527-02-02-00-0	ELECTRONIC CONTROLLER	1
75	OSL-000036	LEVER SWITCH COVER	1
76	PDK-000058	EXTERNAL TOOTH LOCK WASHER 3.2	4
77	PKT-000028	POTENTIOMETER KNOB	1
78	PNK-000026	LEVER SWITCH 641 H/3	1
79	WKR-000181	CROSS RECESSED PAN HEAD SCREW M3x6	4
80	DLW-000007	CABLE GLAND WITH STRAIN RELIEF PG11	1
81	KST-0475-08-03-00-0	BAR CLAMPING BLOCK	1
82	PKT-0475-08-04-00-0	KNOB	1
83	NKR-000077	KNURLED NUT M5	2
84	RKJ-000043	HANDLEVER M6-25	2
85	SPR-0256-00-07-00-0	CLUTCH SPRING	1
86	TLJ-0475-16-06-00-0	SLEEVE	1
87	WKR-000047	HEX SOCKET SET SCREW WITH FLAT POINT M5x5	1
88	WKR-000167	COUNTERSUNK HEAD SCREW M4x25	1
89	DCS-0475-25-00-00-0	TORCH CLAMP	1

* not shown in the drawing

10. DECLARATION OF CONFORMITY

Declaration of Conformity

PROMOTECH sp. z o.o.
ul. Elewatorska 23/1
15-620 Białystok
Poland

We declare with full responsibility that:

TORCH RUNNER (HS) CUTTING CARRIAGE

is manufactured in accordance with the following standards:

- EN 12100
- EN 60204-1
- EN 60974-10

and satisfies regulations of the guidelines: 2014/30/EC, 2014/35/EC, 2006/42/EC.

Person authorized to compile the technical file:

Marek Siergieł, ul. Elewatorska 23/1, 15-620 Białystok, Poland



Białystok, 29 October 2018

Marek Siergieł
CEO

11. WARRANTY CARD

WARRANTY CARD No.....

..... in the name of Manufacturer warrants the Torch Runner (HS) Cutting Carriage to be free of defects in material and workmanship under normal use for a period of 12 months from the date of sale.

This warranty does not cover damage or wear that arise from misuse, accident, tempering or any other causes not related to defects in workmanship or material.

Serial number

Date of sale

Signature of seller.....

1.10 / 19 September 2019

WE RESERVE THE RIGHT TO MAKE CHANGES IN THIS MANUAL WITHOUT NOTICE