Secotom-1

Instruction Manual

Manual No.: 15707001

Date of Release 2016.06.06

Secotom-1
Instruction Manual

Table of Contents **Page**

Always state *Serial No* and *Voltage/frequency* if you have technical questions or when ordering spare parts. You will find the Serial No. and Voltage on the type plate of the machine itself. We may also need the *Date* and *Article No* of the manual. This information is found on the front cover.

The following restrictions should be observed, as violation of the restrictions may cause cancellation of Struers legal obligations:
Instruction Manuals: Struers Instruction Manuals may only be used in connection with Struers equipment covered by the Instruction Manual.
Service Manuals: Struers Service Manuals may only be used by a trained technician authorised by Struers. The Service Manual may only be used in connection with Struers equipment covered by the Service Manual.

Struers assumes no responsibility for errors in the manual text/illustrations. The information in this manual is subject to changes without notice. The manual may mention accessories or parts not included in the present version of the equipment.

Struers
Pederstrupvej 84
DK-2750 Ballerup
Denmark
Telephone +45 44 600 800
Fax +45 44 600 801

Secotom-1
Safety Precaution Sheet

To be read carefully before use

1. The operator should be fully aware of the use of the machine according to the Instruction Manual and the instructions of the cut-off wheels.

2. The machine must be placed on a safe and stable support table. All safety functions and guards of the machine must be in working order.

3. The unit must be installed in compliance with local safety regulations.

4. Use only intact cut-off wheels. The cut-off wheels must be approved for min. 3.500 rpm.

5. The machine is not for use with saw-blade type cut-off wheels.

6. Observe the current safety regulations for handling, mixing, filling, emptying and disposal of the additive for cooling fluid.

7. To achieve maximum safety and lifetime of the machine, use only original Struers consumables.

8. Struers recommends using cooling fluid when cutting as the materials being cut may emit harmful dust. Additionally an adequate exhaust system should be used.

9. The machine emits only moderate noise. However, the cutting process itself may emit noise, depending on the nature of the workpiece. In such cases, the use of hearing protection is recommended.

10. Always use Safety Goggles when operating the machine.

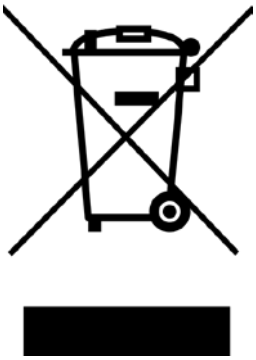
11. Use of working gloves is recommended as workpieces may be both very hot and produce sharp edges.

12. The machine must be disconnected from the mains prior to any service.

The equipment should only be used for its intended purpose and as detailed in the Instruction Manual.

The equipment is designed for use with consumables supplied by Struers. If subjected to misuse, improper installation, alteration, neglect, accident or improper repair, Struers will accept no responsibility for damage(s) to the user or the equipment.

Dismantling of any part of the equipment, during service or repair, should always be performed by a qualified technician (electromechanical, electronic, mechanical, pneumatic, etc.).



Disposal

Equipment marked with a WEEE symbol contain electrical and electronic components and must not be disposed of as general waste.
Please contact your local authorities for information on the correct method of disposal in accordance with national legislation.

User's Guide

Table of Contents **Page**

1. Getting Started

Checking the Contents of the Packing Box

In the packing box you should find the following parts:

1 Secotom-1 with manual cutting table
2 Mains cables
1 Stop pin
1 Spanner 17 mm
10 Pieces of rubber foam
1 Pair of Safety Goggles
1 Hose for connection to exhaust, 1.5 m x 32 mm dia.
1 Hose clamp, 25-40 mm dia.
1 Cover for ventilation hole
1 Instruction Manual Set

Removing Secotom-1 from the Pallet

Secotom-1 is secured to the wooden pallet with 3 screws. Remove these screws with a 13 mm spanner.

Placing Secotom-1

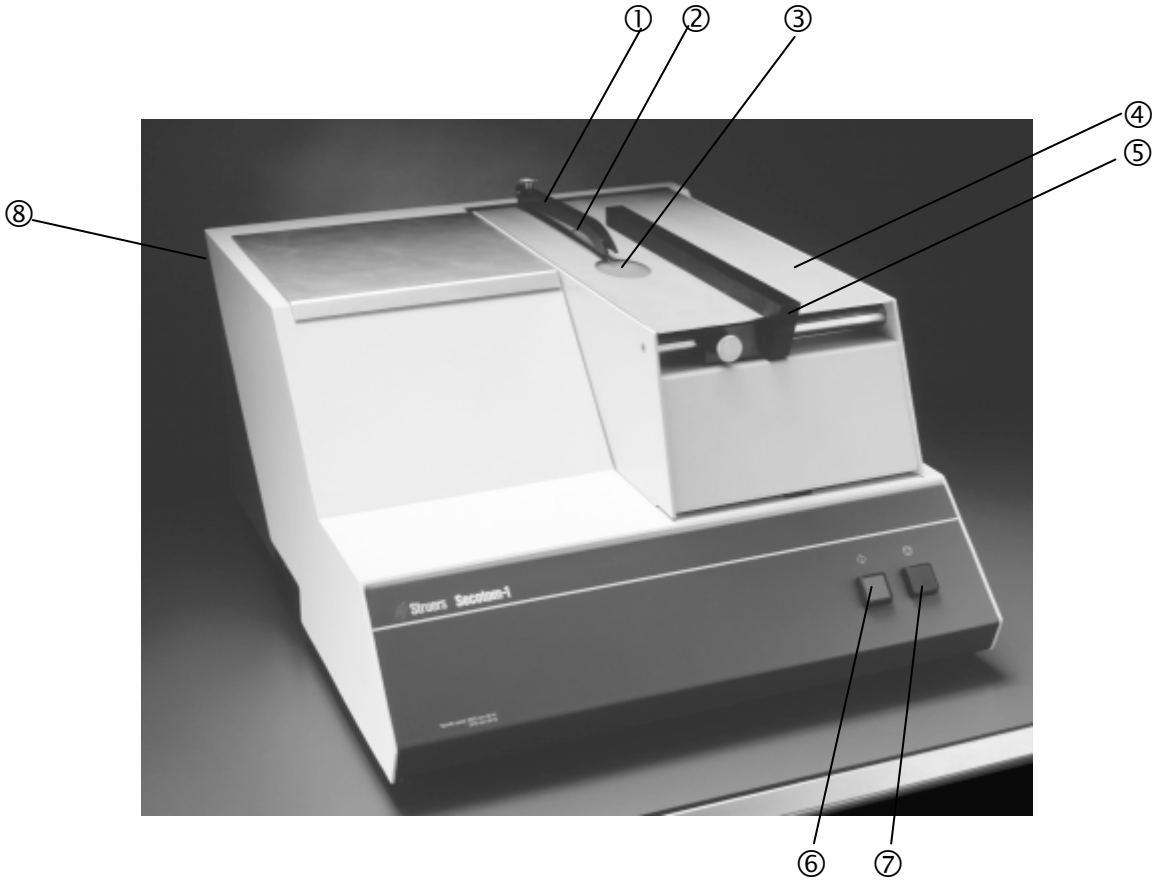
Secotom-1 should be placed on a safe and stable support table with an adequate working height. The table must be able to carry at least 50 kg. The machine must be placed close to the power supply.

Cover for Ventilation Hole

The ventilation pipe at the back of the cutting chamber can be replaced with the cover for the ventilation hole if Secotom-1 is not to be connected to an exhaust system.

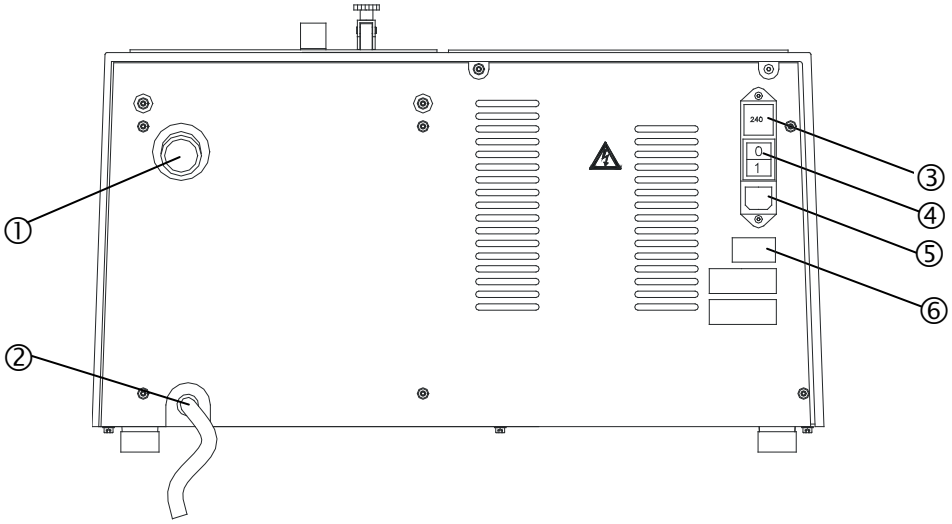
Getting Acquainted with Secotom-1

Take a moment to familiarise yourself with the location and names of the Secotom-1 components.



① Protection guard
② Cut-off wheel
③ Light in cutting table
④ Manual cutting table
⑤ Guide rail
⑥ Start button
⑦ Stop button
⑧ Main switch (at the back of the machine)

Rear of Secotom-1



① Ventilation Hole
② Water outlet
③ Fuses
④ Main switch
⑤ Mains connection
⑥ Type Plate

Supplying Power

Always remember to switch the power off when installing electrical equipment!

DANGER!

The machine must be earthed

IMPORTANT

Check that the mains voltage corresponds to the voltage stated on the type plate on the back of the machine.

Changing the voltage setting

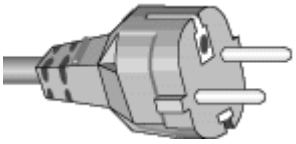
The factory setting for Secotom-1 is 240V.

If the factory setting is not the correct setting for your mains supply the setting can be changed from 240V to 220V:

- Pull out the fuse holder from the cable terminal at the back of the machine.
- Pull out the voltage switch, turn it into the correct position and reinsert it.
- Put the fuse holder back into the cable terminal.

Secotom-1 is shipped with 2 types of Mains cables:

Single-phase Supply



The 2-pin (European Schuko) plug is for use on single-phase, 200-240 V connections.

If the plug supplied on this cable is not approved in your country, then the plug must be replaced with an approved plug. The leads must be connected as follows:

Yellow/green: earth
Brown: line (live)
Blue: neutral

2-phase Supply

The 3-pin (North American NEMA) plug is for use on 2-phase, 200-240 V power connections.

If the plug supplied on this cable is not approved in your country, then the plug must be replaced with an approved plug. The leads must be connected as follows:

Green: earth
Black: line (live)
White: line (live)

Connection to the Machine

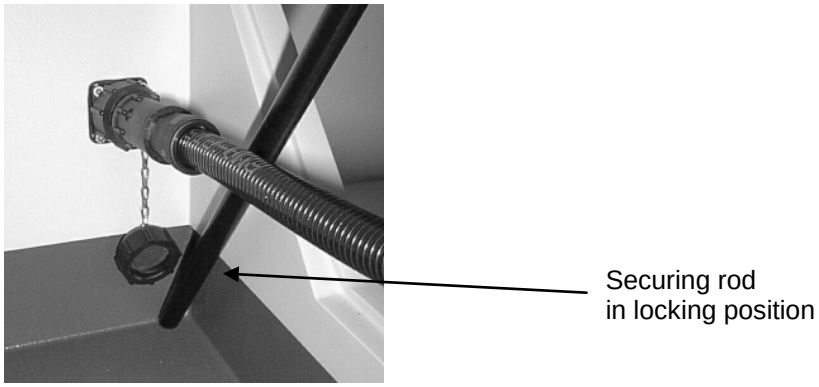
Both cables are on the other end equipped with an IEC 320 cable connector that has to be connected to the Secotom.

WARNING!
The output voltage from this cable is 200 – 240V and not 110V. DO NOT use this cable to connect equipment that use a 110V power supply. Failure to adhere to this may result in material damage.

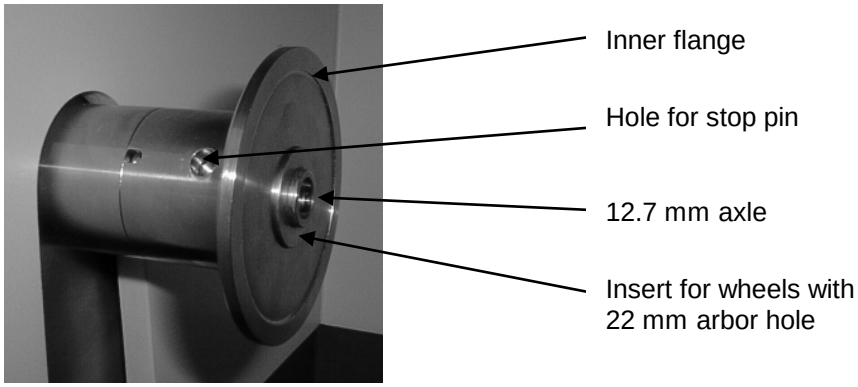
Mounting the Cut-off Wheel

IMPORTANT
For manual cutting only diamond or CBN cut-off wheels with a metal body are allowed. Abrasive SiC or Al_2O_3 cut-off wheels or saw blades may not be used for cutting on Secotom-1.

- Move the manual cutting table into the upwards position and engage the securing rod into the locking position.



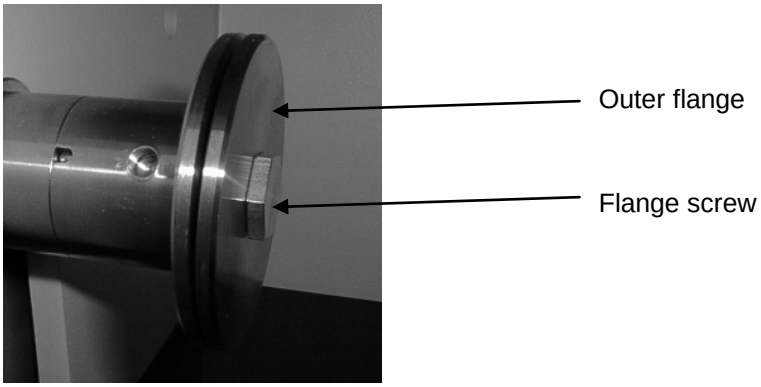
- Insert the stop pin into the hole of the inner flange.



- Use the 17 mm spanner to loosen the flange screw.
- Remove the outer flange.

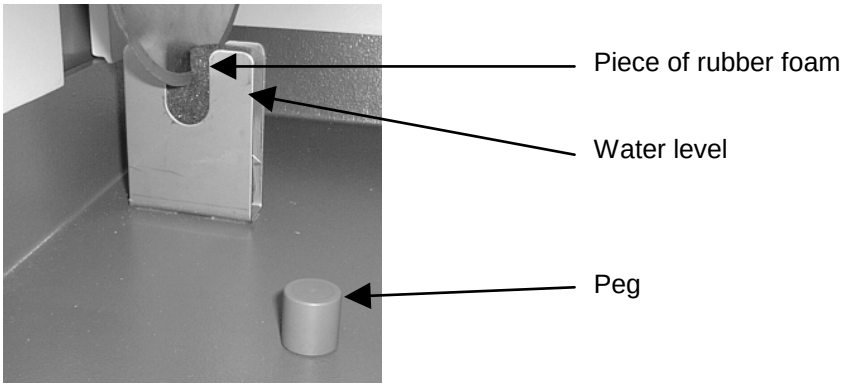
IMPORTANT
The tolerance between the spindle and inner flange is very small which means that the two surfaces must be absolutely clean. Never try to squeeze the cut-off wheel on as this may damage the spindle or the cut-off wheel. If there are any small burrs, remove them with grinding paper (grit size 1200).

- Mount the cut-off wheel and remount the outer flange, with the machined face towards the inner flange.
- Insert the locking pin in the hole in the inner flange.
  Gently fasten the flange screw using the 17 mm spanner.
- Release the securing rod and move the manual cutting table down again.

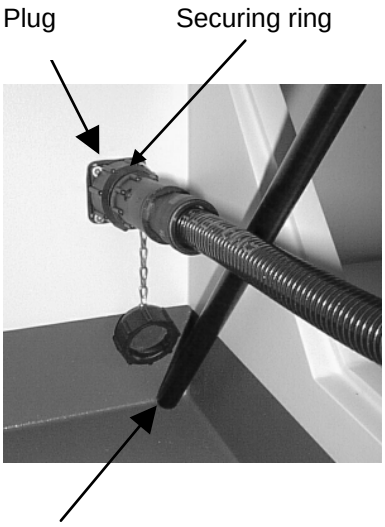


Filling the Cut-off Machine with Cutting Fluid

- Make sure that the peg is in place inside the cutting chamber.
- Place one folded piece of the **wet** rubber foam supplied with the machine in the holder on each side of the cut-off wheel. The cut-off wheel must protrude slightly (about 5 mm) into the rubber foam to take a sufficient amount of cooling water with it.
- Fill the cutting chamber up to where the cut-out for the wheel starts (approx. 4.5 litres of water)
  Use 4.37 l water and 135 ml Struers additive for cooling fluid, Corrozip.

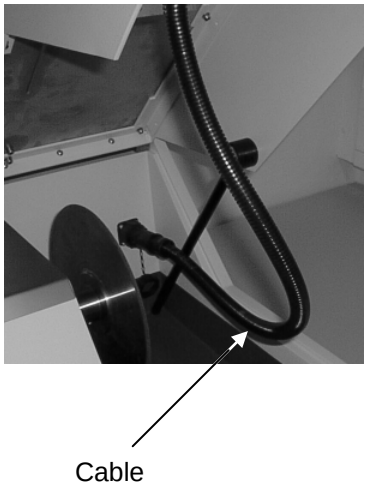


Removing the Manual Cutting Table



- Lift the manual cutting table up and engage the securing rod into the locking position.
- Turn the plug securing ring and remove the plug from the socket.
- Move the cutting table all the way to the vertical position, lift it straight up and remove.

Placing the Manual Cutting Table



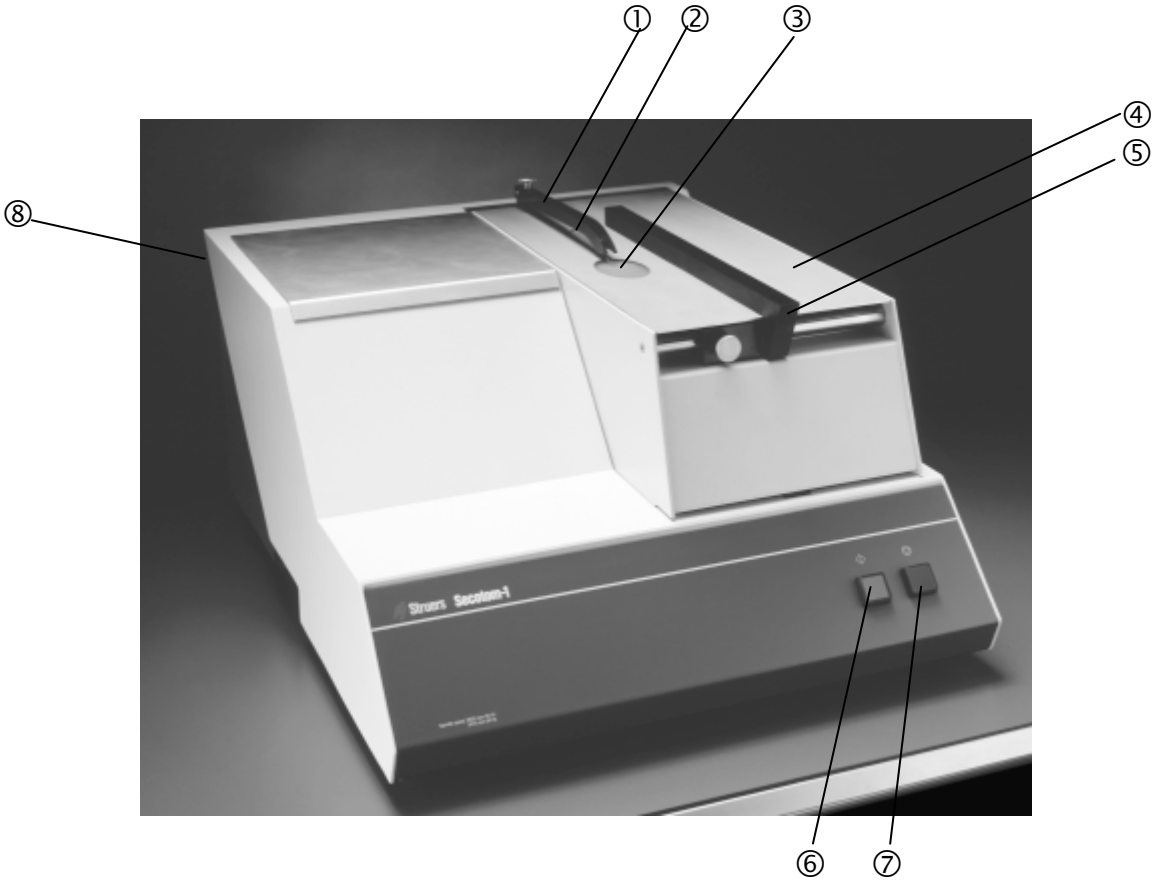
- Hold the cutting table vertically and place the machined bar in the hinges.
- Move the cutting table slightly downwards to allow the securing rod to engage into the locking position.
- Place the plug in the socket at the rear wall inside the cutting chamber and secure it by turning the ring.
- Release the securing rod and move the manual cutting table all the way down.

IMPORTANT
Always make sure that the cable from the socket to the lamp housing does not bend towards the cut-off wheel so that there is no risk of cutting into the cable.

2. Operation

Using the Controls

Pos. No.	Key	Function
⑧ MAIN SWITCH		The main switch is located on the back of the machine.
⑦ STOP	▽	Push button to stop the machine. Both the cut-off wheel and the light in the manual cutting table are switched off.
⑥ START	◇	Push button for starting the machine. Starts the cut-off wheel and the switches on the light in the manual cutting table.



Changing the Cut-off Wheel

Securing rod

IMPORTANT

For manual cutting only diamond or CBN cut-off wheels with a metal body are allowed. Abrasive SiC or Al_2O_3 cut-off wheels or saw blades may not be used for cutting on Secotom-1.

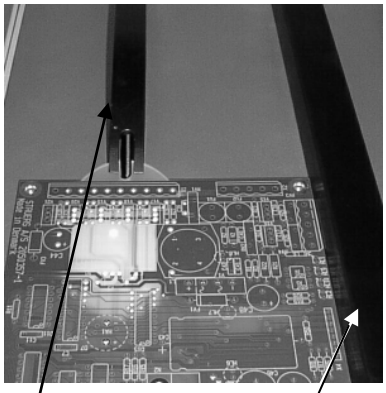
- Move the manual cutting table into the upwards position and engage the securing rod into the locking position.
- Insert the stop pin into the hole of the inner flange.
- Use the 17 mm spanner to loosen the flange screw.
- Remove the outer flange and the wheel.

IMPORTANT

The tolerance between the spindle and inner flange is very small which means that the two surfaces must be absolutely clean. Never try to squeeze the cut-off wheel on as this may damage the spindle or the cut-off wheel. If there are any small burrs, remove them with grinding paper (grit size 1200).

- Mount the new cut-off wheel and remount the outer flange, with the machined face towards the inner flange.
- Insert the locking pin in the hole in the inner flange.
  Gently fasten the flange screw using the 17 mm spanner.
- Release the securing rod and move the manual cutting table down again.

Starting the Cutting Process



- Press the button, START ⏀.
- Position the specimen correctly in front of the cut-off wheel. When cutting PCB's the light in the cutting table can be used to adjust and align the PCB.
- Adjust the guide rail.
- Move the specimen slowly along the guide rail towards the cut-off wheel.

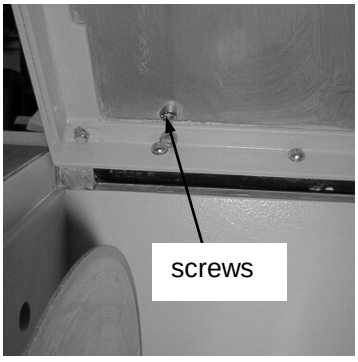
IMPORTANT
Always adjust the protection guard to a distance of about 3 mm above the specimen to be cut.

Stopping the Cutting Process

The machine can be stopped at any time during the cutting process by pressing the STOP button ⏁.

Removing the Protection Guard

When cutting very large PCB's or other samples it might be necessary to remove the protection guard to be able to cut through the entire length of a sample in one operation.



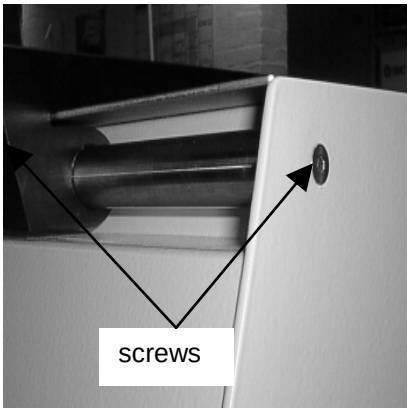
- Move the manual cutting table into the top position and engage the securing rod into the locking position.
- Remove the two screws holding the protection guard using a 4 mm Allen key. Keep the protection guard together with the two screws in a safe place.
- Release the securing rod and move the manual cutting table all the way down.

Replacing the Protection Guard

- Move the manual cutting table into the top position and engage the securing rod into the locking position.
- Place the protection guard in position and secure it with the 2 screws using a 4 mm Allen key.
- Release the securing rod and move the manual cutting table all the way down.

IMPORTANT
Always put the protection guard back on again
after cutting large samples.
Always use safety goggles when cutting.

Removing the Guide Rail



When cutting very large PCB's or other samples it might be necessary to remove the guide rail to be able to cut through the sample in the correct position.

- Remove the two screws holding the guide rail using a 3 mm Allen key. Keep the guide rail together with the two screws in a safe place.

Replacing the Guide Rail

- Place the guide rail in position and secure it with the 2 screws using a 3 mm Allen key.

Changing the Cooling Fluid

- Hang the outlet tube from the back of the machine into a bucket.
- Move the manual cutting table into the upwards position and make sure it is secured with the securing rod.
- Remove the peg from inside the cutting chamber and allow all cooling fluid to run into the bucket.
- Use a soft brush and clean water to clean the inside of the cutting chamber.
- Empty the cutting chamber of water and reinsert the peg.
- Fill the cutting chamber with water and additive as described in the section on:
  Filling the Cut-off Machine with Cutting Fluid.
- Release the securing rod and move the manual cutting table down again.
- Remove the bucket and dispose of the water according to the local regulations.

3. Routine Maintenance

Daily Service

- Clean the cutting chamber, especially the cutting table and the T-slots.
  To ensure a longer lifetime for your Secotom, Struers strongly recommends daily cleaning of the cutting chamber:

Weekly Service

- Clean the cutting chamber thoroughly.
- Oil the spindle/bushing where the cut-off wheel is mounted (e.g. with universal household oil).

Checking the Recirculation Cooling Unit

- Check the level of the cooling water after 8 hours use or at least every week. Refill if necessary.
  Replace the cooling fluid if it appears dirty (build up of cutting debris).
  Remember to add Struers additive, Corrozip.
  To check the concentration of additive, use a refractometer.
  Please see the instructions for use on the label.

  It is recommended to change the cooling water at least once a month to prevent the growth of microorganisms.

Monthly Service

If necessary,

- Oil the hinges of the cutting table (e.g. with universal household oil).

Cut-off Wheels

Abrasive Cut-off Wheels

Store the dry cut-off wheels in a horizontal position on a plane surface, preferably under light pressure.

Diamond and CBN Cut-off Wheels

A clean and dry cut-off wheel does not corrode. Therefore clean and dry the cut-off wheel before it is put away. Use ordinary household detergents.

Dressing Cut-off Wheels

A newly dressed cut-off wheel will give an optimum cut. A badly maintained and dressed cut-off wheel demands a higher cutting pressure that will result in more frictional heat. The wheel may also bend and cause a skew cut. A combination of both factors may result in damage to the cut-off wheel.
It is a fact that a badly dressed cut-off wheel is the most frequent reason for damage to the wheel.

To dress the cut-off wheel, use the aluminium oxide dressing stick supplied with the cut-off wheel.

- Mount the dressing stick like a workpiece. Do not dress manually.
- Cut through the dressing stick using a moderate cutting pressure and plenty of cooling fluid.
- Repeat the treatment if the cut-off wheel does not cut satisfactorily.
  NB Do not perform more dressing than necessary as this will cause needless wear on the wheel.

Reference Guide

Table of Contents **Page**

1. Consumables

The use of Struers consumables is recommended.
Other products (e.g. coolants) may contain aggressive solvents, which dissolve e.g. rubber seals. The warranty may not cover damaged machine parts (e.g. seals and tubes), where the damage can be directly related to the use of non-Struers consumables.

Cut-off Wheels

Please refer to the Selection Guide in the *Struers Cut-off Wheels brochure.*

Other consumables

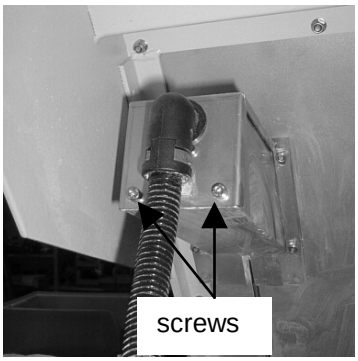
Specification	Cat No:
Corrozip Additive for Cooling Fluid. To protect the machine from corrosion and to improve cutting and cooling qualities. For Recirculation Cooling Unit. 1 l 5 l	 449900045 449900046
Corrozip-Cu Additive for Cooling Fluid. To protect the machine from corrosion and to improve cutting and cooling qualities. For Recirculation Cooling Unit. For machines which mainly cut copper and copper alloys. 1 l 5 l	 49900058 49900059
Dressing stick *Aluminium oxide stick, 1 pc*	 40800044

2. Trouble-Shooting

Error	Cause	Action
Vibrations	The diamond layer is worn down to the level of the metal disc	Replace with a new cut-off wheel
	The workpiece forces the cut-off wheel to the side when cutting. Heavy friction causes vibrations	Cut more slowly
No coolant during cutting	The level of cooling fluid is too low	Refill to the recommended level
	The rubber foam is dry	Wet the rubber foam before placing it into the holder, the capillary action will then keep the moisture level constant
Cutting chamber shows signs of corrosion	The workpiece is made of Copper/ Copper Alloy.	Use Corrozip-Cu.

3. Maintenance

Replacing the Bulb in the Cutting Table



- Move the manual cutting table into the top position and engage the securing rod into the locking position.
- Remove the 2 screws securing the shield around the bulb using a 3 mm Allen key.
- Replace the defective bulb with a new 12 V 20 W halogen bulb. (Do not touch the glass with your fingers).
- Secure the shield again with the 2 screws.
- Release the securing rod and move the manual cutting table down again.

4. Technical Data

Subject	**Specifications**	
Cutting	Motor	800 W
	Voltage/frequency 1/3 x 220 - 240 V / 50-60 Hz	*Nom. load* 3.1 A
	Cut-off wheels	203 mm (8") dia.
	Output axle	Rotational speed 2.800 rpm at 50 Hz 3.400 rpm at 60 Hz Diameter: 12.7/22 mm dia. (0.5 / 0.86" dia.)
Safety standards	Please refer to the Declaration of Conformity	
Noise level	Approx. 56 dB (A) measured at idle running, at a distance of 1.0 m/39.4” from the machine.	
Dimensions	Width: 575 mm / 22.6" Depth: 735 mm / 28.9" Height: 335 mm / 13.2" Weight: 46 kg / 101 lb	
Operating environment	Surrounding temperature	5-40°C/41-104°F
	Humidity	0-95% RH non condensing

English

Declaration of Conformity

Manufacturer

Struers ApS
Pederstrupvej 84
DK-2750 Ballerup, Denmark
Telephone +45 44 600 800

Herewith declares that

Name:	Secotom-1
Cat. No.:	05706127
Function:	Precision cut-off machine
Type No.:	570

fulfils all the relevant provisions of the:

Machinery Directive 2006/42/EC
according to the following standard(s):
EN ISO 12100:2010, EN 60204-1:2006/AC:2010, EN ISO 14120:2015.

and is in conformity with the:

EMC Directive 2014/30/EU
according to the following standard(s):
EN 61000-6-1:2007, EN 61000-6-3:2007/A1:2011.

RoHS Directive 2011/65/EU
according to the following standard(s):
EN 50581:2012.

Supplementary Information
The equipment complies with the following standards:
NFPA70:2014, NFPA79:2012, FCC 47 CFR part 15.

The above has been declared according to the global approach, module A.

Authorized to compile the Technical File:

Klavs Tvenge
Director of Business Development
Struers ApS
Pederstrupvej 84
DK-2750 Ballerup, Denmark

Date of Issue: 2017.10.05

Pederstrupvej 84
DK-2750 Ballerup
Denmark

Secotom-1

Spare Parts and Diagrams

Manual No.: 15707001

Date of Release 2016.07.22

Secotom-1
Spare Parts and Diagrams

Always state *Serial No* and *Voltage/frequency*
if you have technical questions or when ordering spare parts.

The following restrictions should be observed, as violation of the restrictions may cause cancellation of Struers legal obligations:
Instruction Manuals: Struers Instruction Manuals may only be used in connection with Struers equipment covered by the Instruction Manual.
Service Manuals: Struers Service Manuals may only be used by a trained technician authorised by Struers. The Service Manual may only be used in connection with Struers equipment covered by the Service Manual.

Struers assumes no responsibility for errors in the manual text/illustrations. The information in this manual is subject to change without notice. The manual may mention accessories or parts not included in the present version of the equipment.

Struers
Pederstrupvej 84
DK-2750 Ballerup
Denmark
Telephone +45 44 600 800
Telefax: +45 44 600 801

Spare Parts and Diagrams

Table of contents **Drawing**

Secotom-1

Drawings

Diagrams

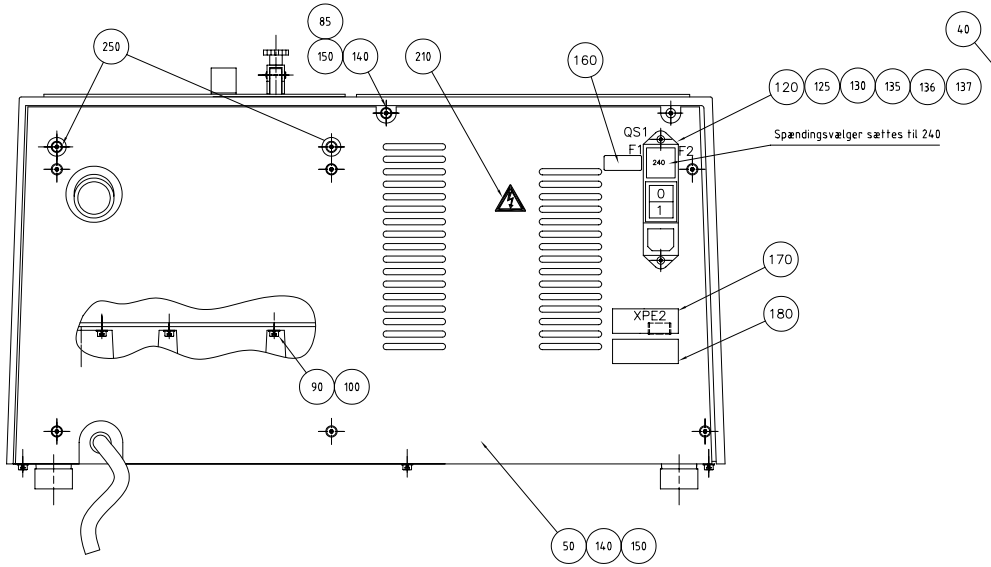
Some of the drawings may contain position numbers
not used in connection with this manual.

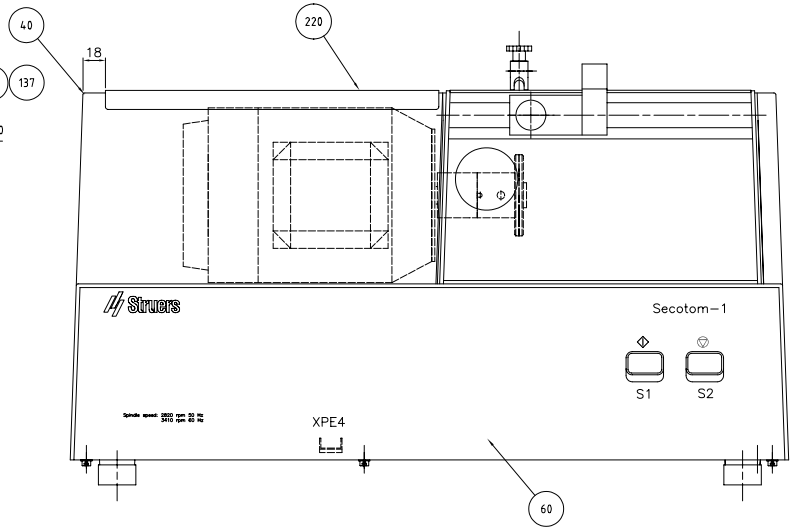
Spare Part List for Secotom-1

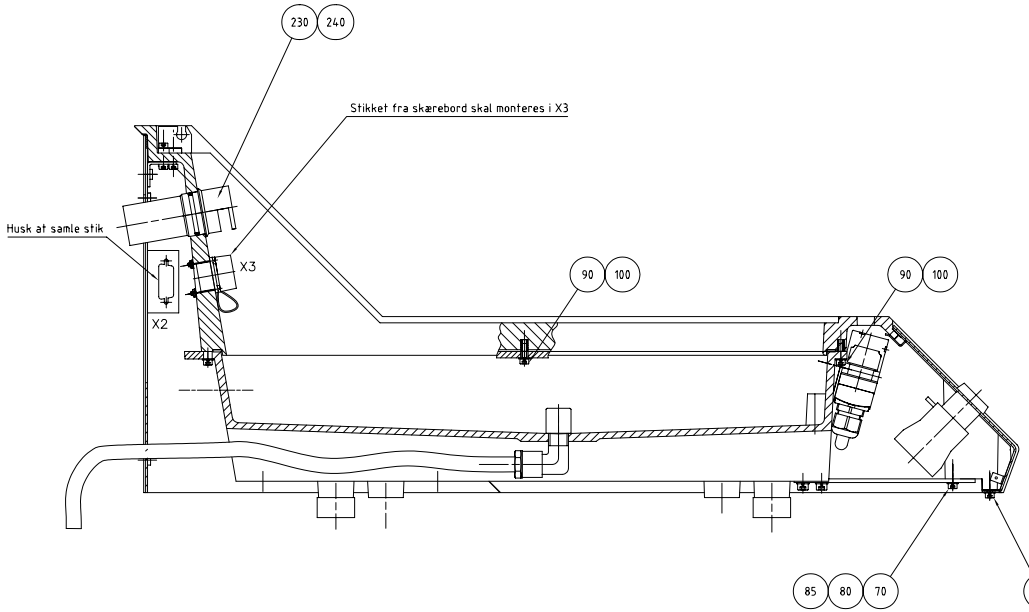
Drawing	Pos.	Spare Part	Cat no.
15700002		**Secotom-1, complete**	
	0120	10.0A T Fuse glass tube	2FU14400
	0195	Power cable Euro norm	2WC04668
		Power cable US norm	2WC09003
	0230	Suction pipe	15030844
	0240	O-ring for suction pipe	2IO26215
15700010		**Lamp**	
	0050	Halogen bulb	2HW00314
	0130	Hose for power supply cable (1 m)	2NU31112
	0140	Hose clamping	2NM10200
15700020		**Cutting table**	
		Securing rod	15702901
	0060	Angle for cutting table	15700340
	0210	Spring	2GF11082
	0230	Finger screw	2GH00210
	0240	Screen	15700360
	0260	Rod	15700895
	0300	Finger screw	2GH00211
15700030		**Front panel**	
	0030	Contact element	2SB10059
	0040	Coupling	2SA41632
	0050	Button	2SA40021
	0060	Cover for button, red	2SA41306
	0070	Cover for button, green	2SA41510
15700051		**Bottom plate**	
	0070	Plug	15700055
		O-ring for plug	2IO16010
	0190	Flange, back	15030101
	0200	Ring for Ø22 disc	15030102
	0210	Flange, front	14940531
	0220	Flange screw	15030753
	0230	Holder	15700805
	0235	Foam plate	15700845
	0240	Crinkle washer M4	2ZI20403
	0270	ON/OFF switch	2SS00007
15700070		**Cabinet**	
	0090	Hood for plug	2XM00001
	0100	Gasket for plug	2XM00002
		Miscellaneous	
		Counter holder	14940701
		Sponge for cut-off wheel	15700845

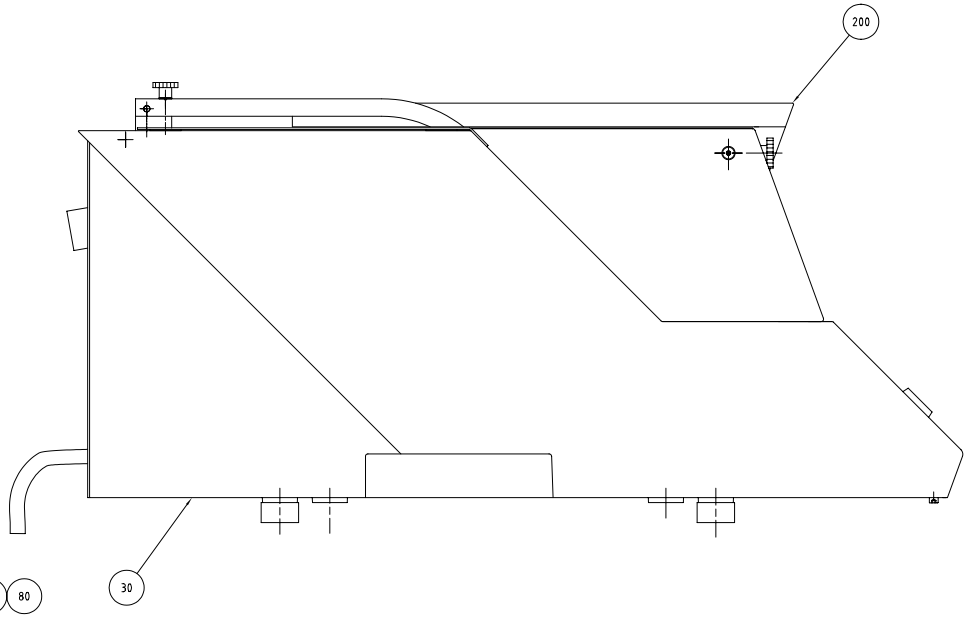
Spare Part List for Secotom-1

Drawing	Pos.	Spare Part	Cat no.
15700002		**Secotom-1, complete**	
	0120	10.0A T Fuse glass tube	2FU14400
	0195	Power cable Euro norm	2WC04668
		Power cable US norm	2WC09003
	0230	Suction pipe	15030844
	0240	O-ring for suction pipe	2IO26215
15700010		**Lamp**	
	0050	Halogen bulb	2HW00314
	0130	Hose for power supply cable (1 m)	2NU31112
	0140	Hose clamping	2NM10200
15700020		**Cutting table**	
		Securing rod	15702901
	0060	Angle for cutting table	15700340
	0210	Spring	2GF11082
	0230	Finger screw	2GH00210
	0240	Screen	15700360
	0260	Rod	15700895
	0300	Finger screw	2GH00211
15700030		**Front panel**	
	0030	Contact element	2SB10059
	0040	Coupling	2SA41632
	0050	Button	2SA40021
	0060	Cover for button, red	2SA41306
	0070	Cover for button, green	2SA41510
15700051		**Bottom plate**	
	0070	Plug	15700055
		O-ring for plug	2IO16010
	0190	Flange, back	15030101
	0200	Ring for Ø22 disc	15030102
	0210	Flange, front	14940531
	0220	Flange screw	15030753
	0230	Holder	15700805
	0235	Foam plate	15700845
	0240	Crinkle washer M4	2ZI20403
	0270	ON/OFF switch	2SS00007
15700070		**Cabinet**	
	0090	Hood for plug	2XM00001
	0100	Gasket for plug	2XM00002
		Miscellaneous	
		Counter holder	14940701
		Sponge for cut-off wheel	15700845









B. Pos.85 & 250, div. skiver tilf. Sikr.skilt flyttet. 140105 BRY/JTV.

Matr.:

Overfl.beh.:

Målforhold: Ikke ang. tol. efter DS/ISO 2768- -

Struers

Projektionsmetode

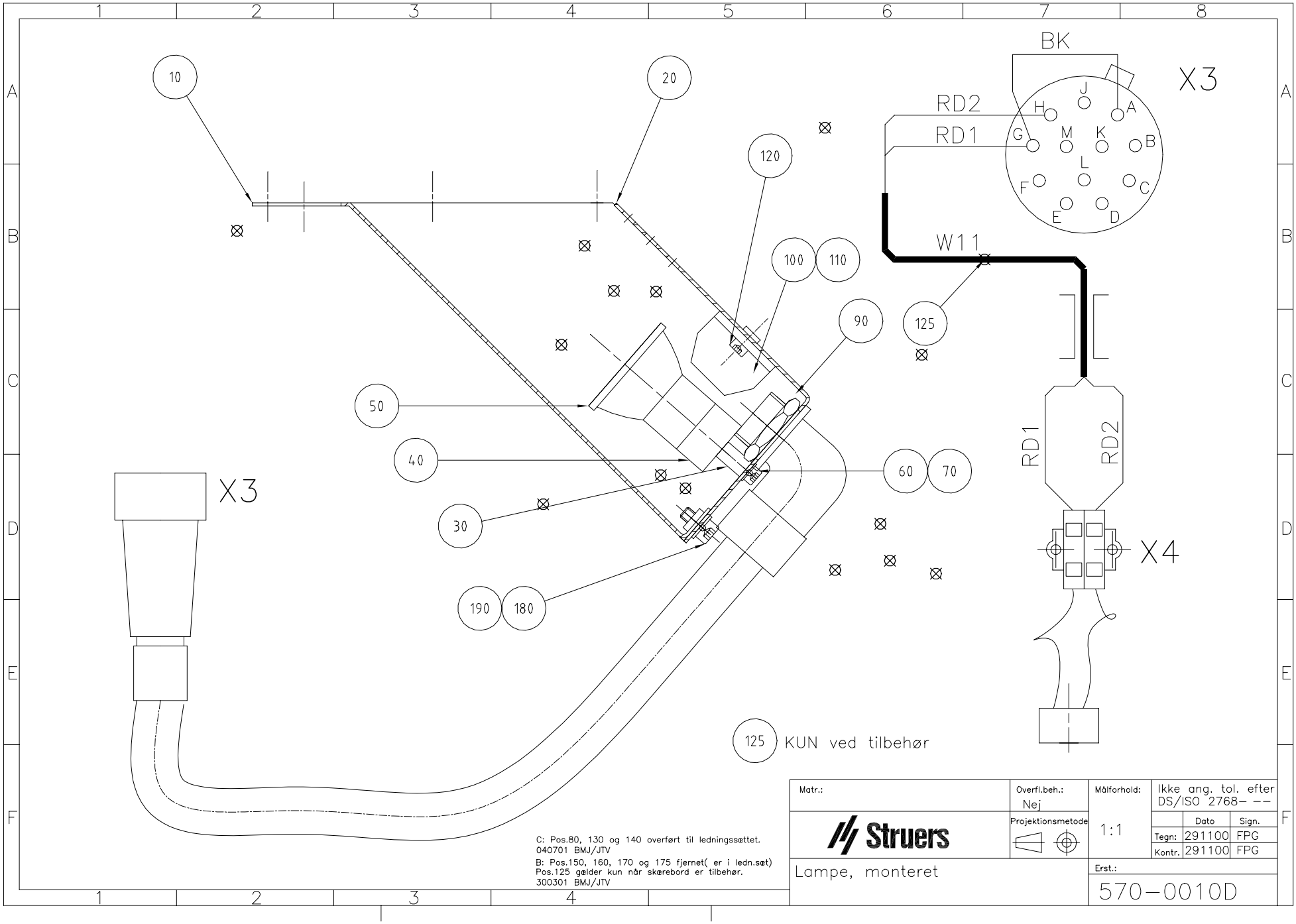
1:2

	Dato	Sign.
Tegn:	300103	FPG
Kontr.	300103	FPG

Secotom-1, komplet

Erst.: 570-0001

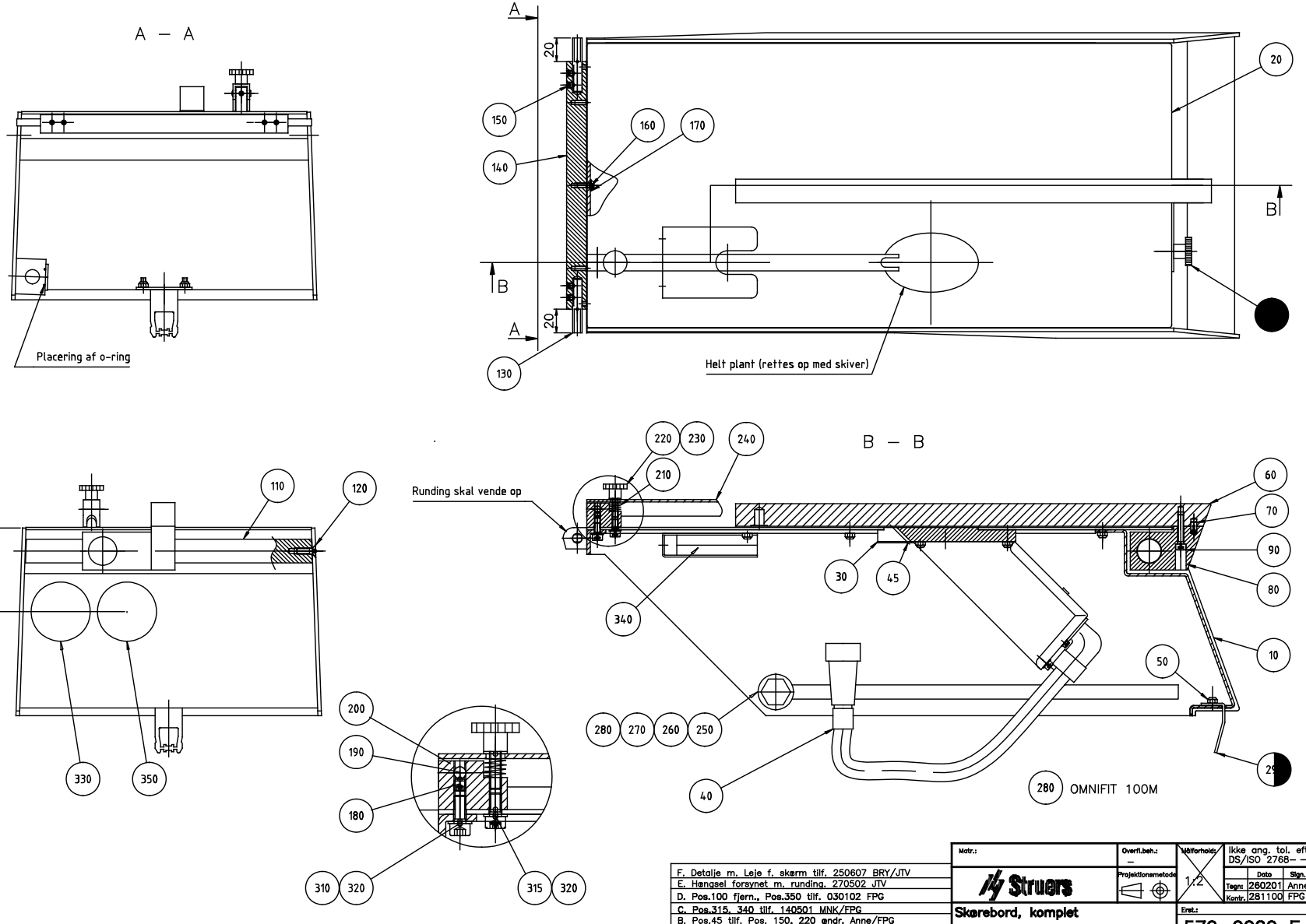
15700002 B



C: Pos.80, 130 og 140 overført til ledningssættet.
040701 BMJ/JTV

B: Pos.150, 160, 170 og 175 fjernet(er i ledn.sæt)
Pos.125 gælder kun når skærebord er tilbehør.
300301 BMJ/JTV

Matr.:	Overfl.beh.: Nej	Målforhold: 1:1	Ikke ang. tol. efter DS/ISO 2768– ––	
Struers	Projektionsmetode			Dato / Sign.
			Tegn: 291100 FPG	
			Kontr. 291100 FPG	
Lampe, monteret			Erst.:	
			570–0010D	



F.	Detalje m. Leje f. skærm tlf. 250607 BRY/JTV
E.	Hængsel forsynet m. runding. 270502 JTV
D.	Pos.100 fjern., Pos.350 tlf. 030102 FPG
C.	Pos.315, 340 tlf. 140501 MNK/FPG
B.	Pos.45 tlf. Pos. 150, 220 ændr. Anne/FPG

Matr.:

Overfl.beh.: –

Projektionsmetode

Målforhold: 1:2

Ikke ang. tol. efter DS/ISO 2768– –

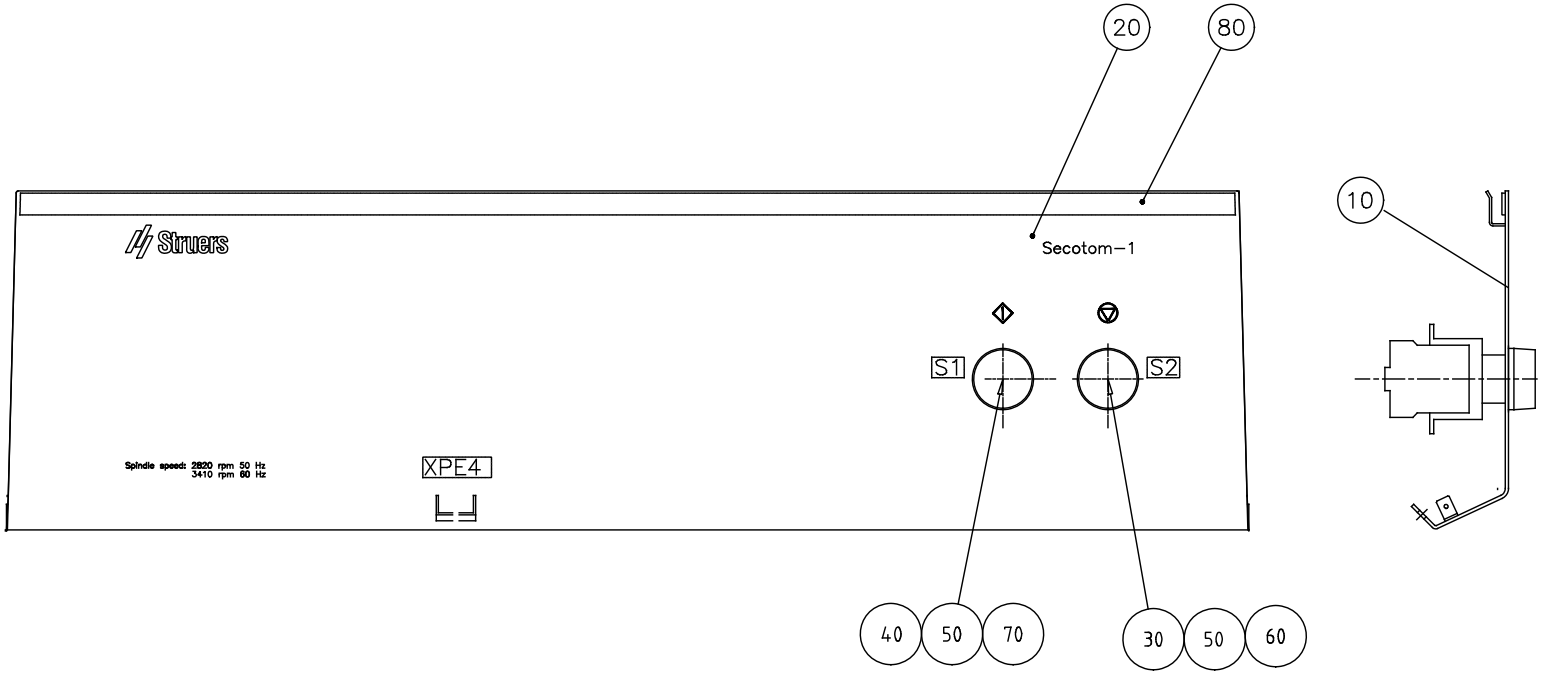
	Dato	Sign.
Tegn:	260201	Anne
Kontr.	281100	FPG

Struers

Skørebord, komplet

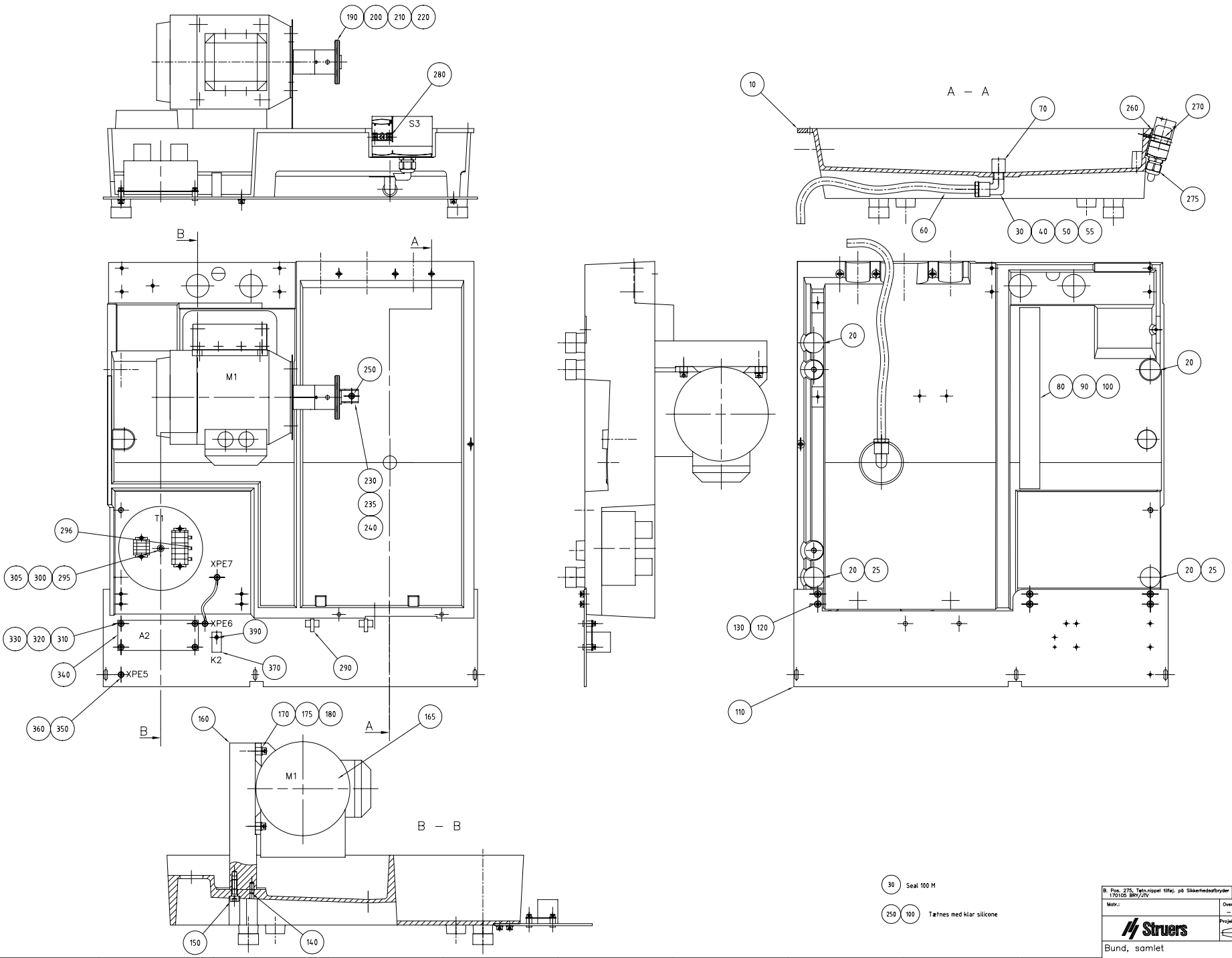
Erst.:

570–0020 F



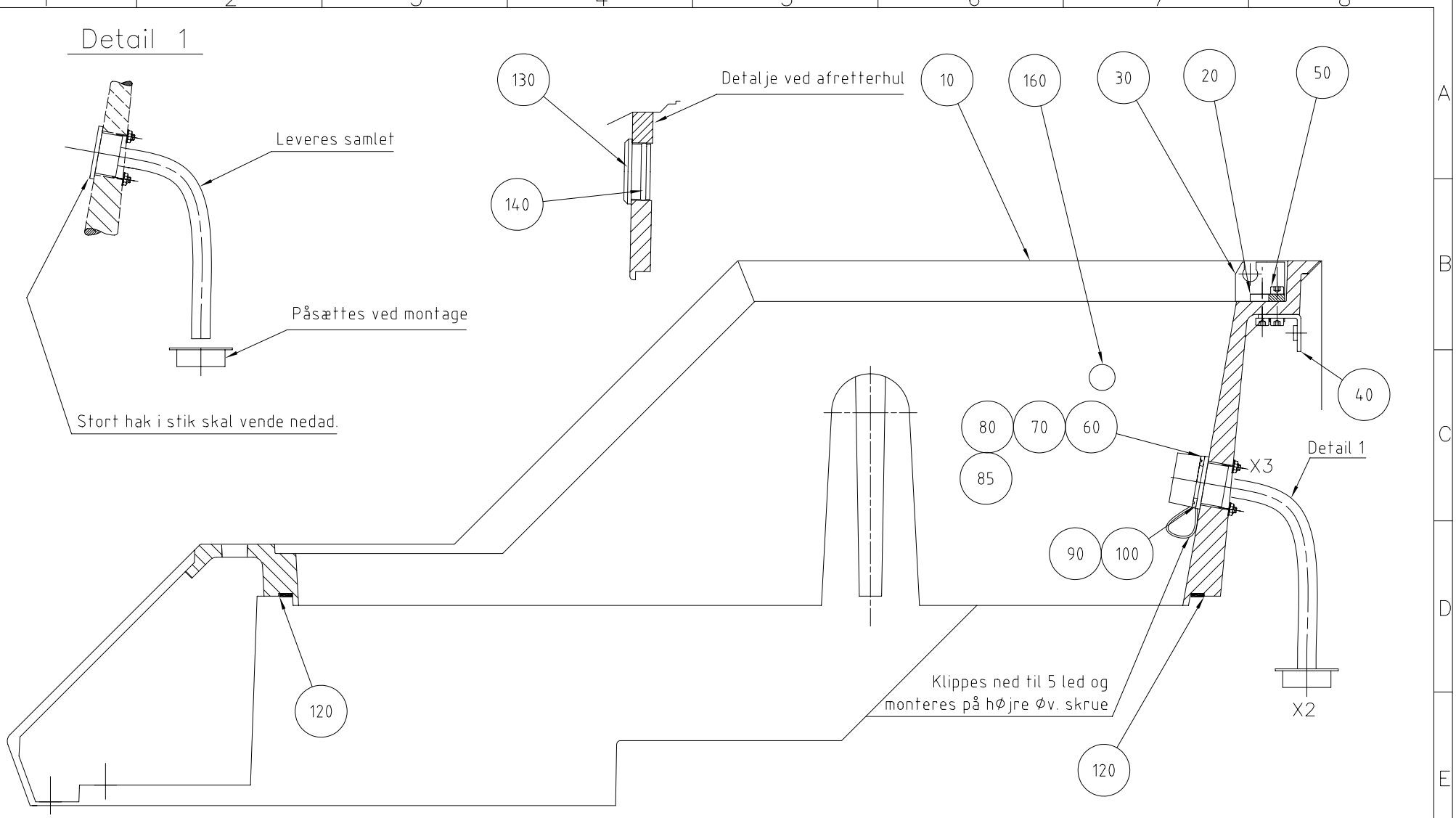
E. Start/stop knapper ændr.: Rafi –> Schlegel. 270106 BRY/JTV
D: 2 stk. pos. 90 tilf. 150205 BMJ/JTV
C. Folieforpl. redesignet. 210604 BRY/KKI
B: Pos.30 (kontaktelement) overført fra ledn.sæt. 020401 BMJ/JTV

Matr.:	Overfl.beh.: –	Målforhold:	Ikke ang. tol. efter DS/ISO 2768– –
Struers	Projektionsmetode	1:2	Dato / Sign. Tegn: 281100 FPG Kontr.: 281100 FPG
Forplade, samlet			Erst.: 570–0030 E



B. Pos. 275, Tætn.nippel tilføj. på Sikkerhedsafbryder 170105 BRY/JTV

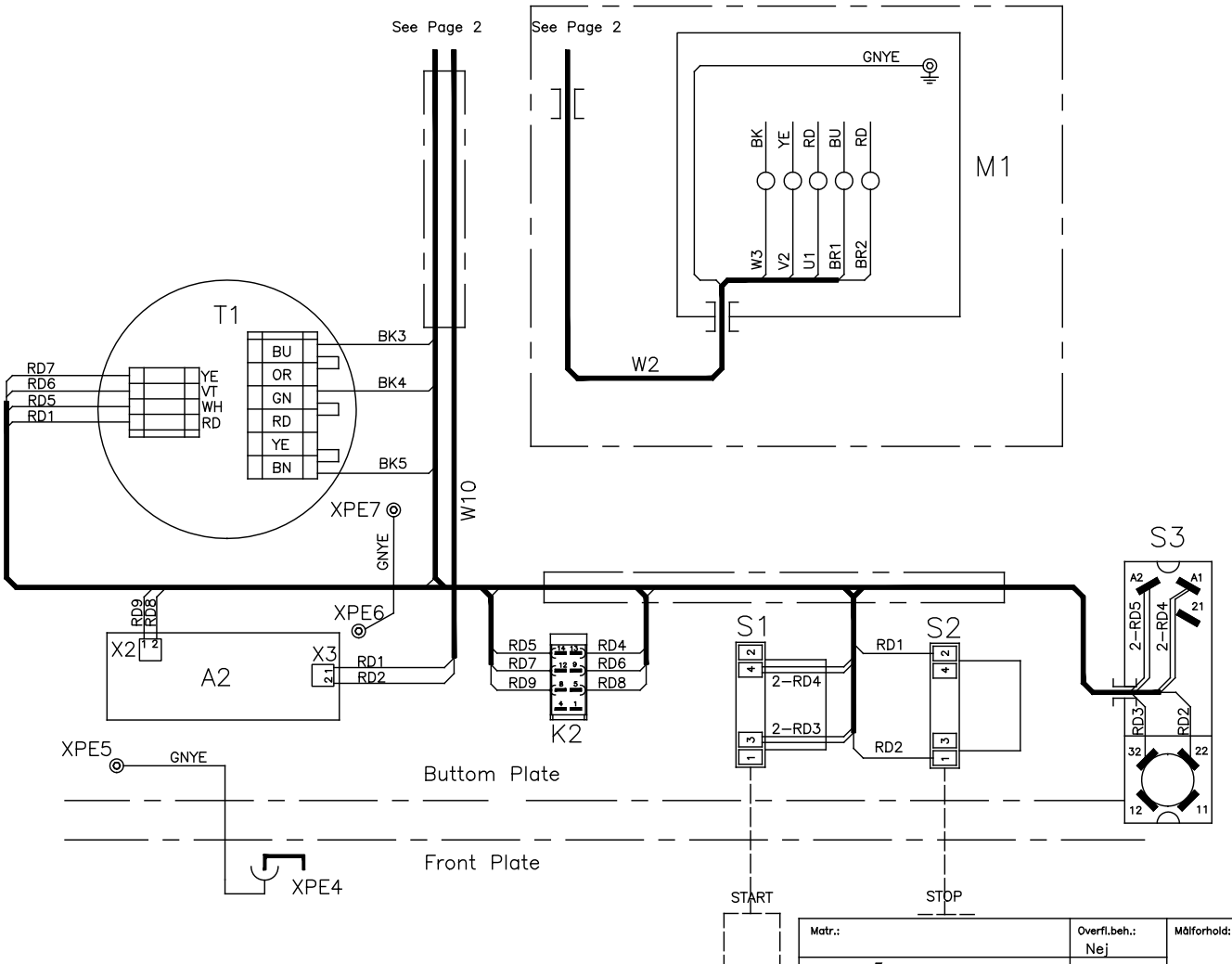
Mstr.:	Overfl.beh.: –	Målforhold: 1:2.5	Ikke ang. tol. efter DS/ISO 2768– –
Struers	Projektionsmetode		Dato / Sign.
			Tegn: 210203 FPG
			Kontr: 030303 FPG
Bund, samlet		Erst.: 570–0050	15700051 B



120 Klæbes ned i fals på de 3 sider af kabinettet

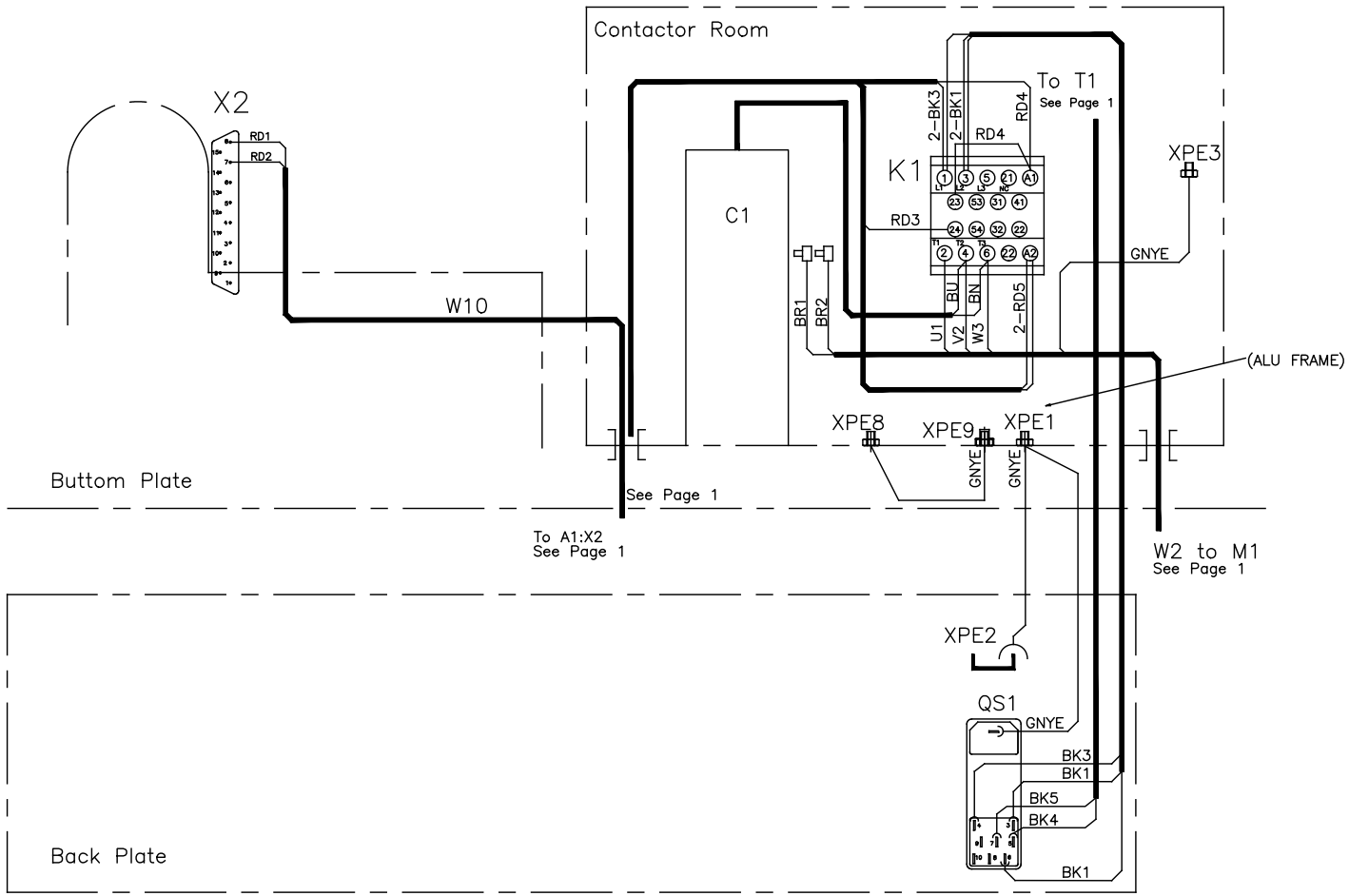
F. Pos.150 Beskyttelsespl. fjernet. 090704 BRY/KKI	G. Pos.85, 4-skiver tilføjet. 140105 BRY/JTV
D: Pos, 130,140 og 150 tilf. 090102 BMJ/JTV	E: Pos. 160 Elma dæksel tilf. 17.10.02 BMJ/JTV
B: Detail 1 tilf. Pos. 90 og 110 overført til ledn.sæt. Anne/FPG 270201	C: Pos.90 genindført. Tekster tilf. 010601 BMJ/JTV

Matr.:	Overfl.beh.:	Målforhold:	Ikke ang. tol. efter DS/ISO 2768- -	
Struers	Projektionsmetode	1:2		Dato / Sign.
			Tegn:	270201 Anne
			Kontr.	041200 FPG
Kabinet, samlet		Erst.:	570-0070 G	



D. Connections in motor connection box changed. 2014–03–27 BRY/CZO

Matr.:	Overfl.beh.: Nej	Målforhold: 1:2	Ikke ang. tol. efter DS/ISO 2768– mK
Struers	Projektionsmetode		Dato / Sign.
			Tegn: 050203 BMJ
			Kontr. 250203 KFC
Wiring Diagram Secotom–1 Page 1/2			Erst.: 570–3450
			15703451–1D



D. Color codes on W2 changed. 2014-03-27 BRY/CZO

Matr.:	Overfl.beh.: Nej	Målforhold: 1:2	Ikke ang. tol. efter DS/ISO 2768- mK	
Struers	Projektionsmetode			Dato / Sign.
			Tegn: 050203 BMJ	
			Kontr. 250203 KFC	
Wiring Diagram Secotom-1	Page 2/2		Erst.: 570-3450	
			15703451-2D	

Pederstrupvej 84
DK-2750 Ballerup
Denmark