KOWA

SERVICE INSTRUCTIONS

# Spoke Cutter

## KSC-001 ver,5

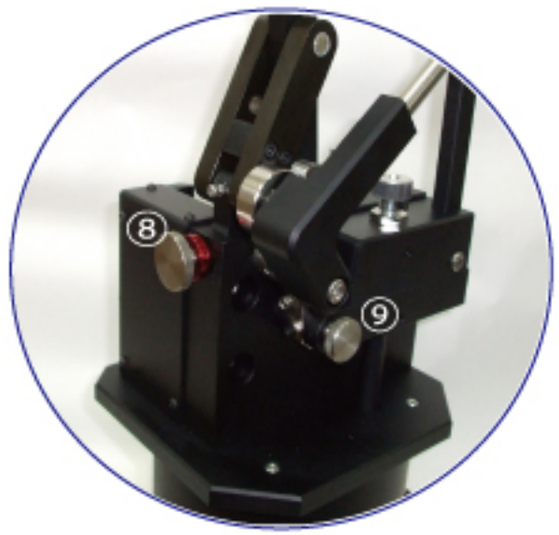
Please read well and understand well before use this product.And please keep this service instruction.If you do not understand well Please read this hund book again.

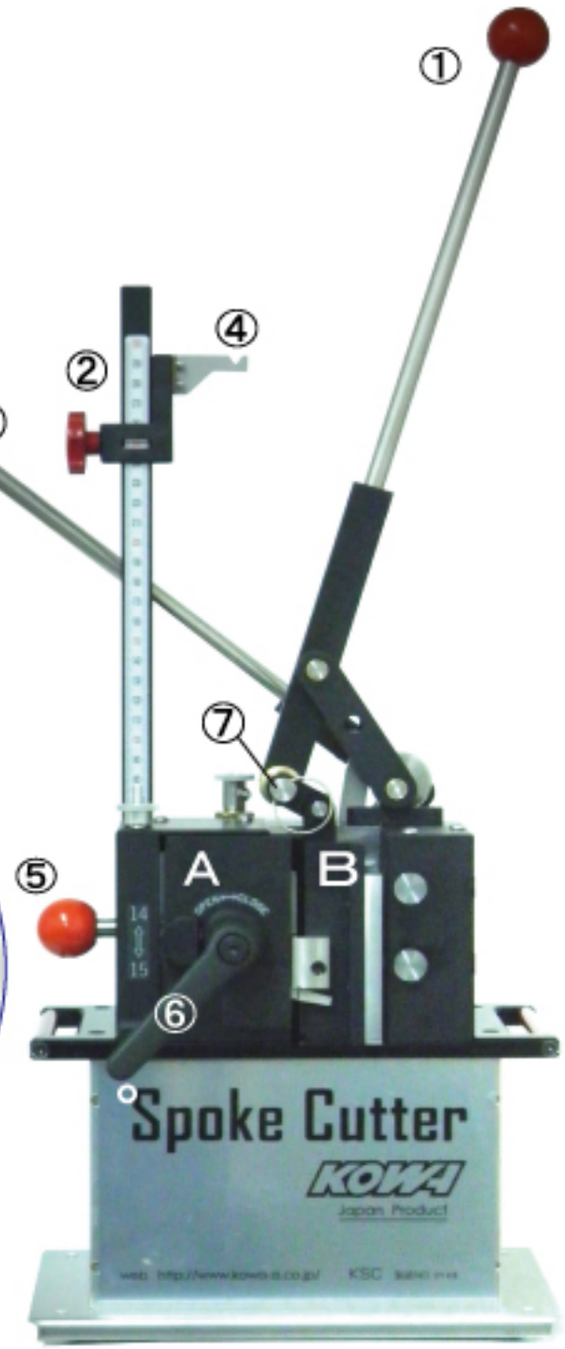

PRODUCED BY KOWA INDUSTRY CO.,LTD
MADE IN JAPAN

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## PART NAME

① Rolling Thread Lever
② Scale
③ Lever
④ Spoke Hook
⑤ Gauge Adjuster knob
⑥ Adjuster Lever
⑦ Pin 1 ⑧ Pin 2 ⑨ Pin 3
A Dies Holder Unit A
B Dies Holder Unit B
C Trash Pocket




### About hazard descriptions

**⚠DANGER**

This symbol denotes that improper handling poses a high risk of causing death or serious injury.

**⚠WARNING**

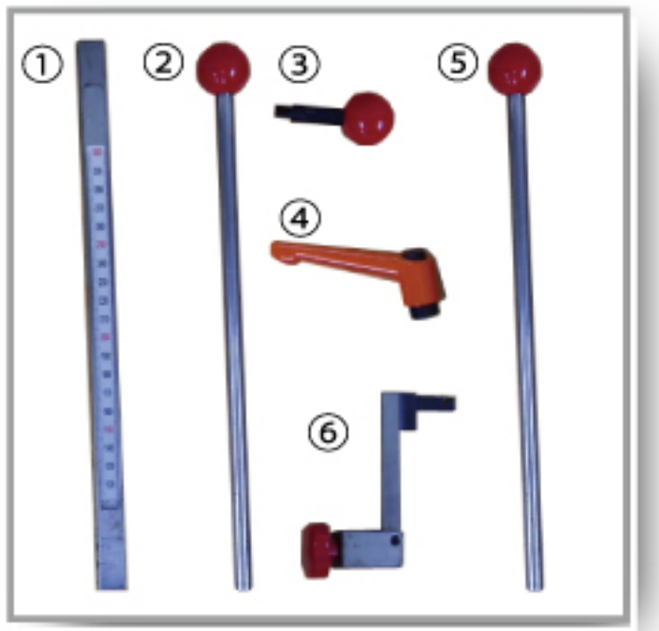
This symbol denotes that improper handling poses the risk of causing death or serious injury.

**⚠CAUTION**

This symbol denotes that improper handling poses the risk of causing damege to the product or property.

## Assembly Procedure

Please confirm whether there is a following parts



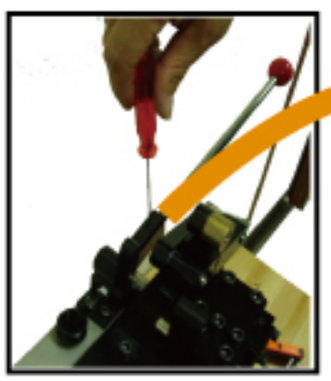

① Scale

②⑤ Rolling Thread Lever
Lever

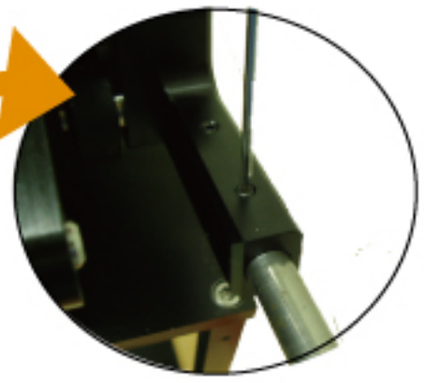
③ Gauge Adjuster Knob

④ Adjuster Lever

⑥ Scale Adjuster



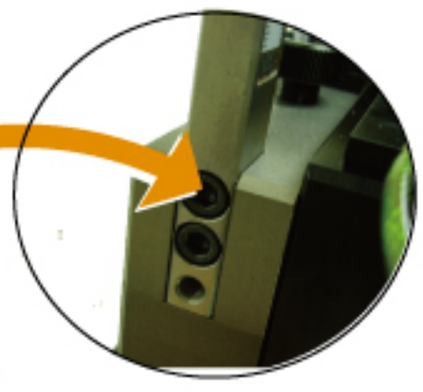
1,Installing Lever





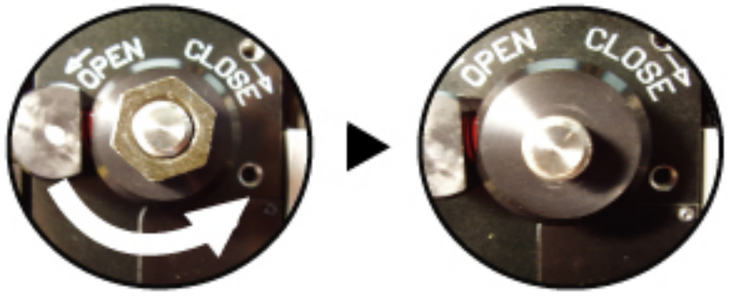
2,Installing Scale

Installing "Scale Adjuster" in "Scale"



## Assembly Procedure

3, Installing Adjuster Lever

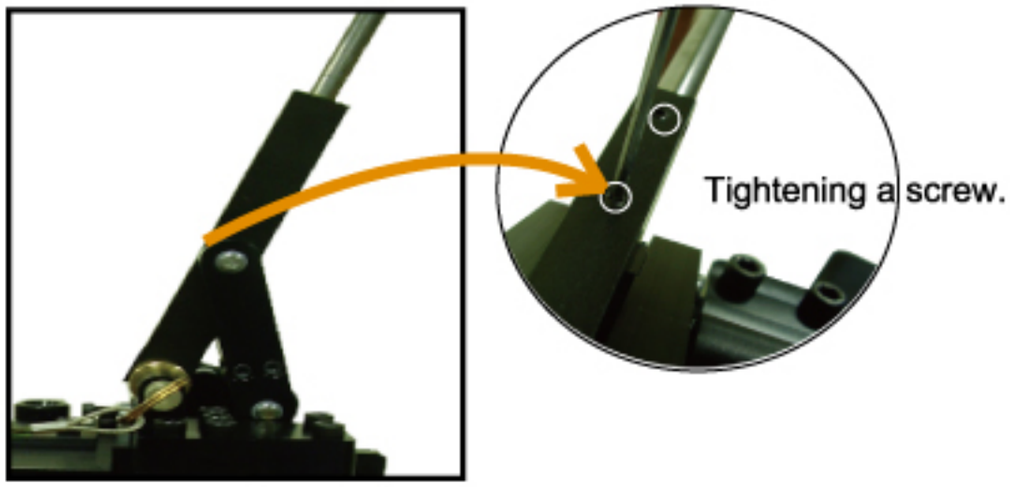



Taking off the Nut that installed in "Fixed Block "



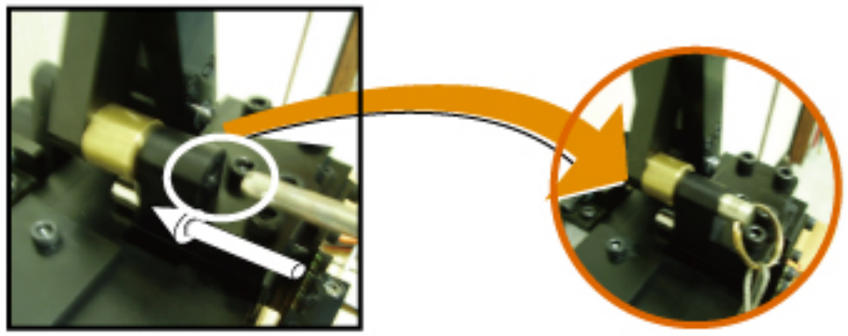

Turning the Adjuster Lever in the direction of the arrow and installing

4,Installing "Rolling Thread Lever"



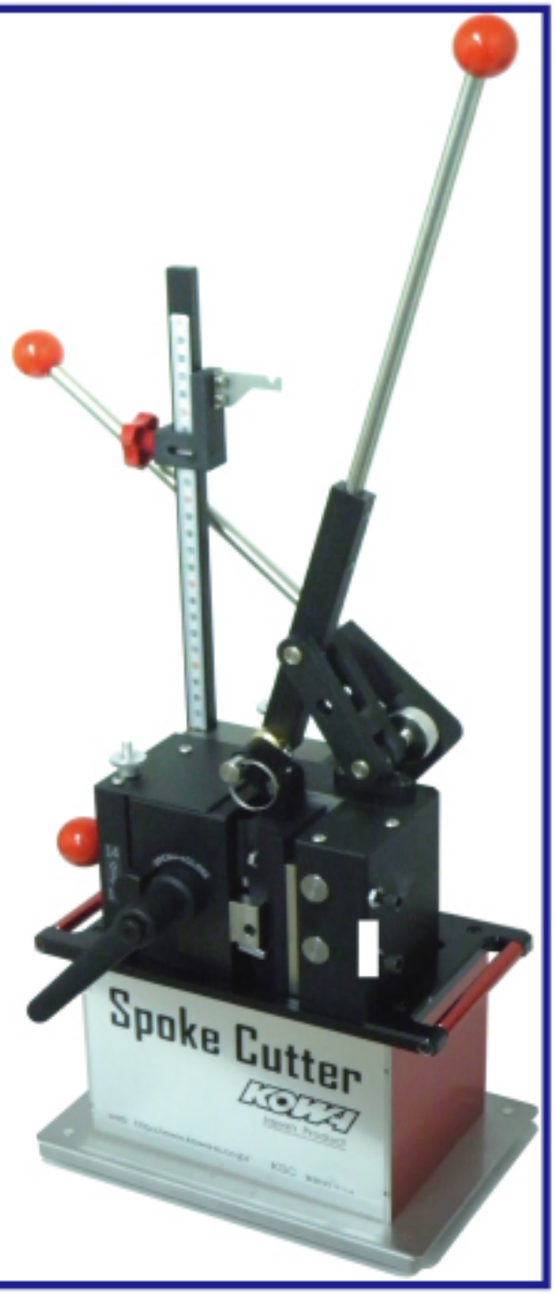
Tightening a screw.

## Assembly Procedure



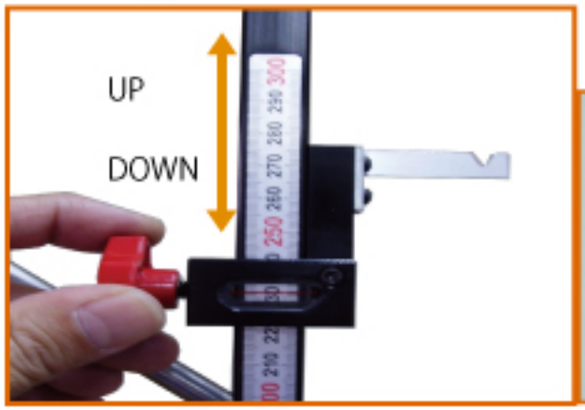
5,Putting in Pin

### Completion

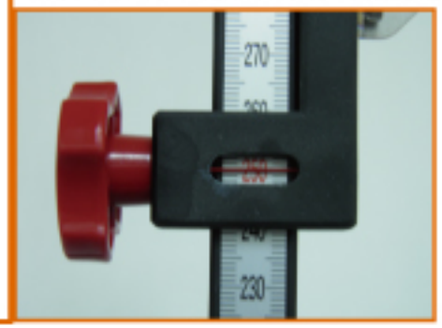



## Spoke Cutter Operation

### 1 Cutting

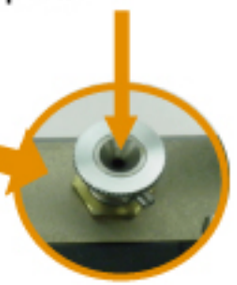



Move "Scale Adjuster" up and down to match the cut size

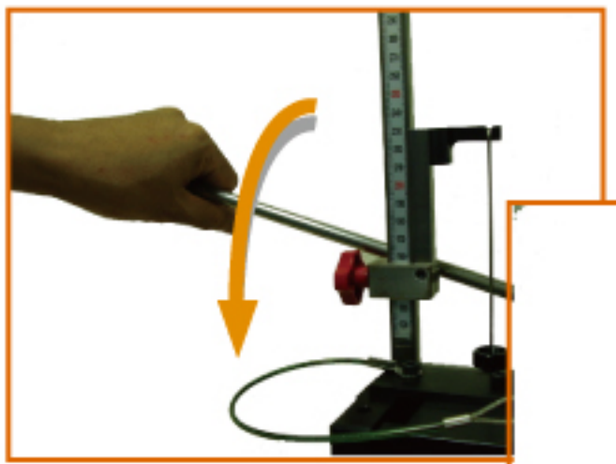




Hung the spoke

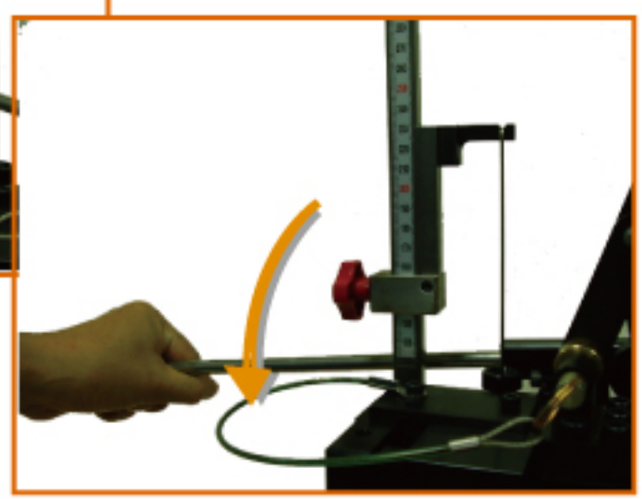


Put the spoke in to this hole



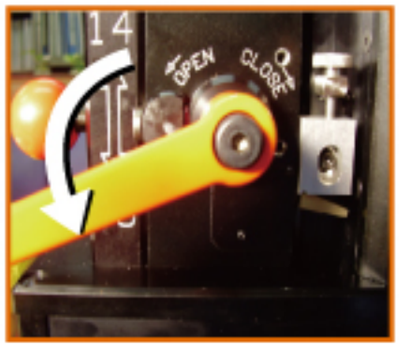
Take down the lever

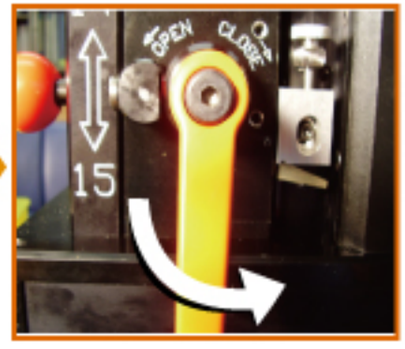
Please check the cut surface whether it is flat



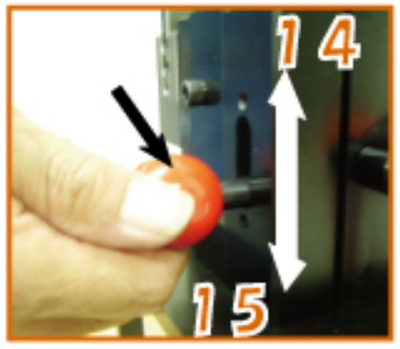
## Spoke Cutter Operation

### 2 Threading



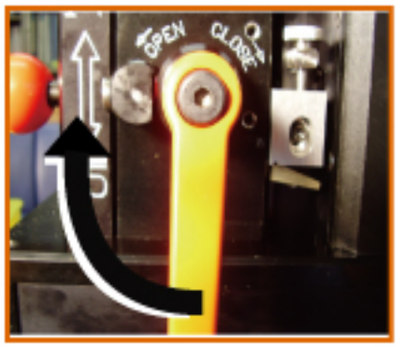




loosen "Fixes -Gauge Lever" like the photograph




Set up "Switching Gauge Lever" to match to the outside diameter of the Spoke.

| Outside Diameter Of A Spoke | |
|---|---|
| 2.0mm | 14gauge |
| 1.8mm | 15gauge |







Return "Fixes Gauge Lever" to original position

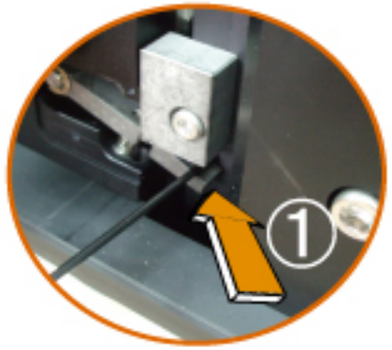


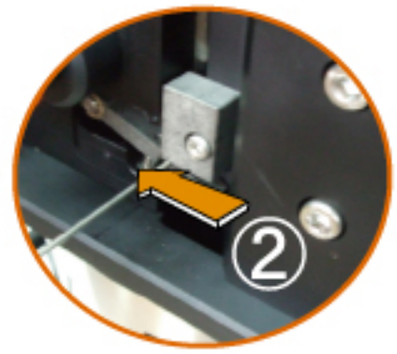


Install the spoke in the direction of the arrow.

## Spoke Cutter Operation

### 2 Threading



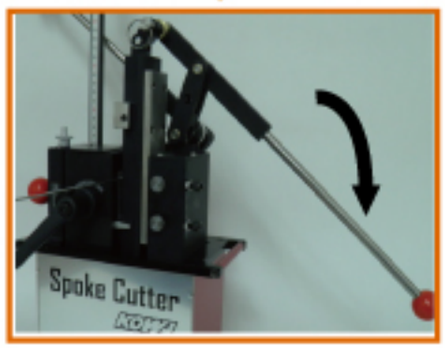




1,Install the Spoke like ①
2,Next, Please slip sideways.
3,Finaly, Press in the Spoke




Take down "Rolling Thread Lever" to direction of the arrow.

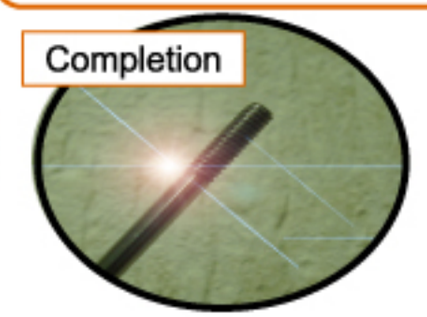



**⚠NOTICE**

- To make the thread smoothly, put the grease regularly
- Please spray air on Die,after thread the painted spoke
- The exchange time of the new die is about 10,000.pcs
- Please note that the spoke doesn't incline when the screw is cut

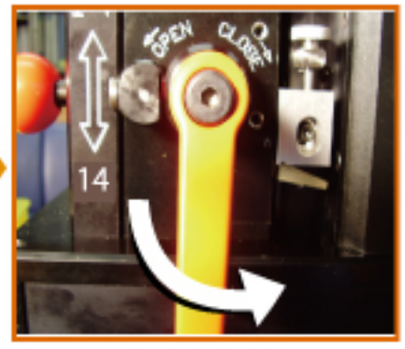
Completion



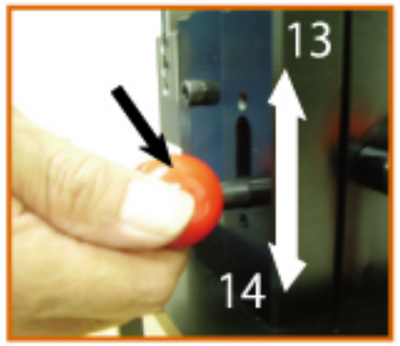
## Spoke Cutter Operation

### 2 Threading



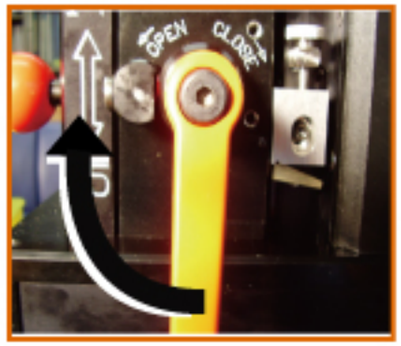




loosen "Fixes -Gauge Lever" like the photograph




Set up "Switching Gauge Lever" to match to the outside diameter of the Spoke.

| Outside Diameter Of A Spoke | |
|---|---|
| 2.25 ㎜ | 13G |
| 2.0 ㎜ | 14G |







Return "Fixes Gauge Lever" to original position

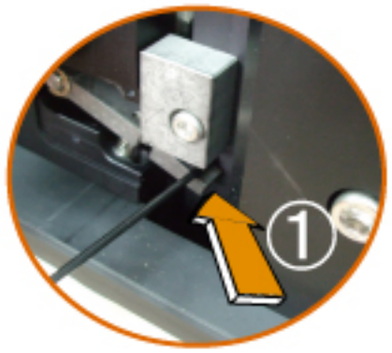


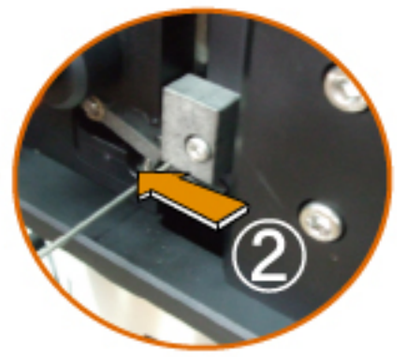


Install the spoke in the direction of the arrow.

## Spoke Cutter Operation

### 2 Threading

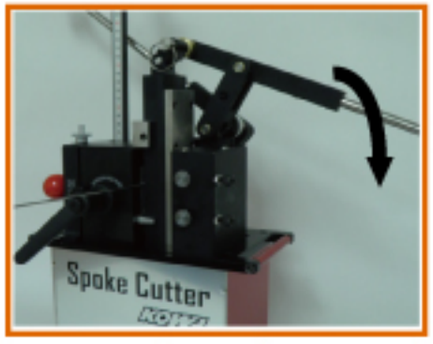


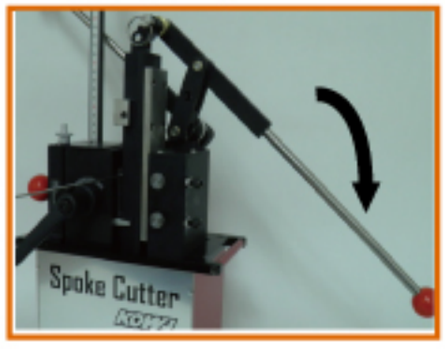




1,Install the Spoke like ①
2,Next, Please slip sideways.
3,Finaly, Press in the Spoke




Take down "Rolling Thread Lever" to direction of the arrow.

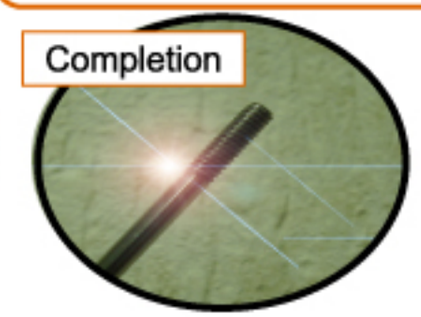



**⚠NOTICE**

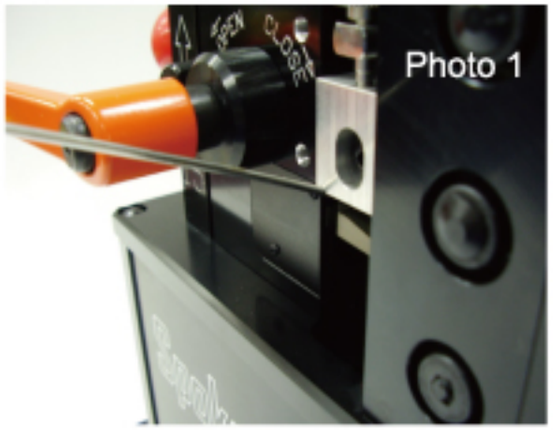
- To make the thread smoothly, put the grease regularly
- Please spray air on Die,after thread the painted spoke
- The exchange time of the new die is about 10,000.pcs
- Please note that the spoke doesn't incline when the screw is cut

Completion



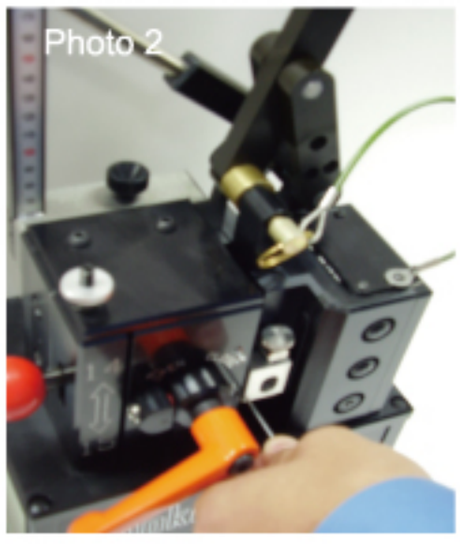
## Spoke Cutter Operation

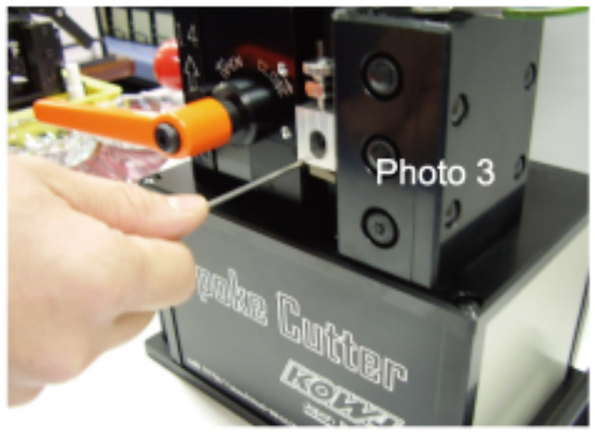
### 2 — 1 Note Point of Screw Cutting



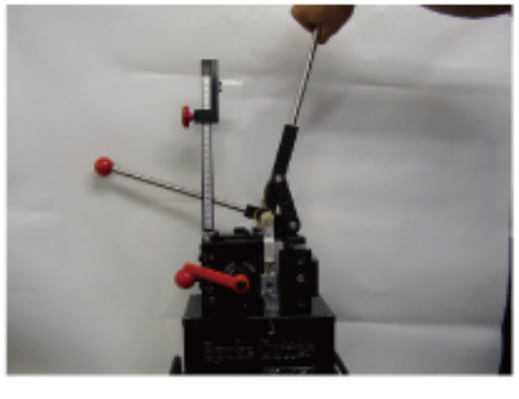

●When you begin to cut the screw, If the spoke would become diagonally like photo (1)

■ 1 Please affix the hand to the spoke lightly like phot 2 &3




■ 2 Please pull down the lever slowly while affixing the hand



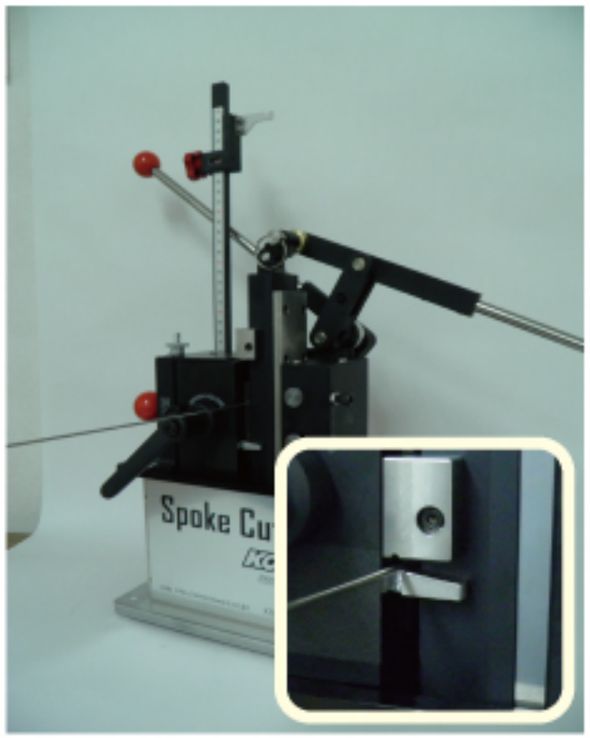
■ 3 If the spoke is beginning to go up straight, please separate the hand from the spoke.



## Spoke Cutter Operation

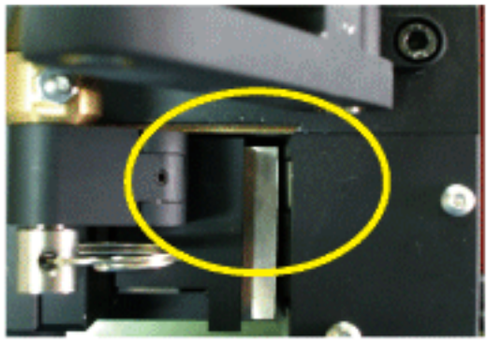
Please make sure to check whether the spoke is becoming straight.



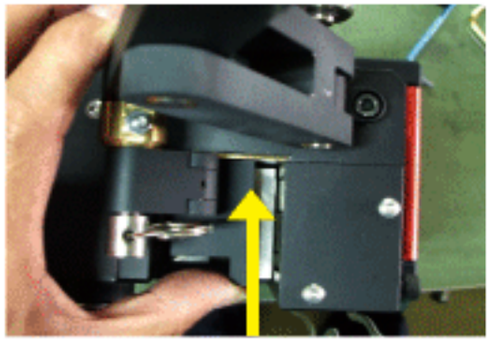




## Spoke Cutter Operation



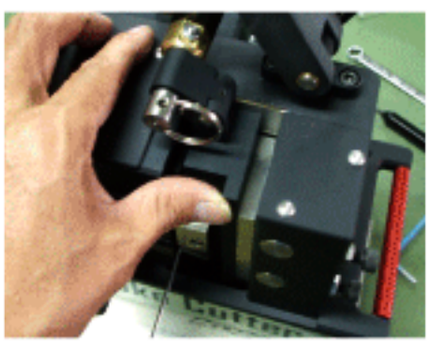
Before doing the rolling threading,
please confirm whether it does not become slanting like a picture



In this case,please pusu it by a finger lightly like a picture.

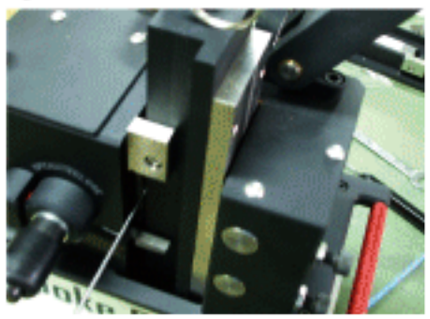



①
Put in a spoke



②
Push the "DIES HOLDER UNIT B" to the main body lightly

③



④



## Spoke Cutter Operation

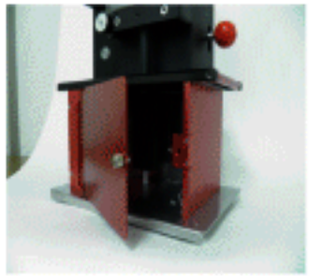



1,Adjustment of 14G

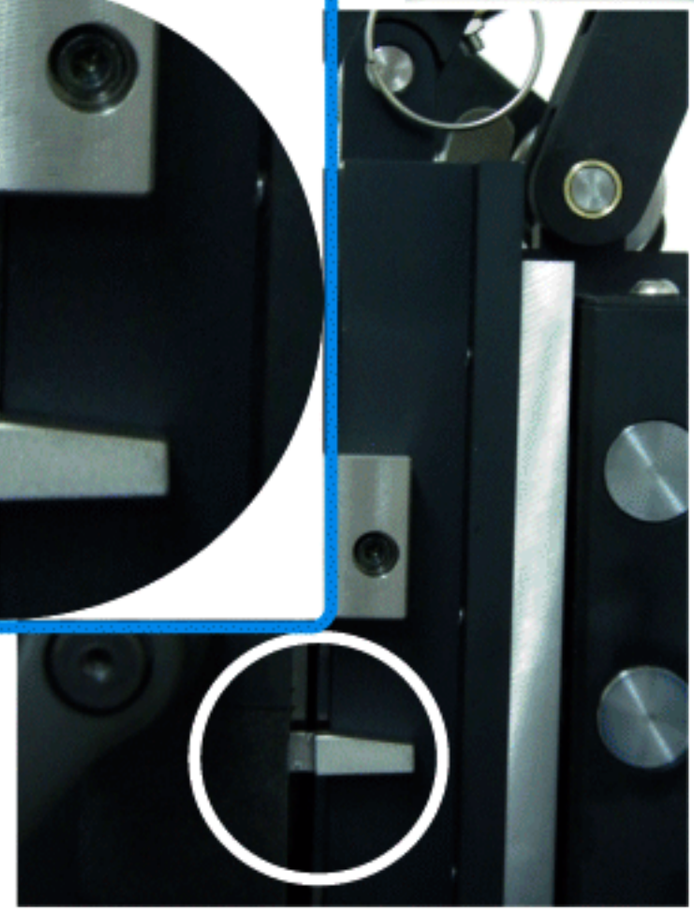
Turning the screw to the right.
A space of the die in left and right becomes small
The acrew thread becomes high

2,adjustment of15G

the screw to which 15G is adjusted is under the body



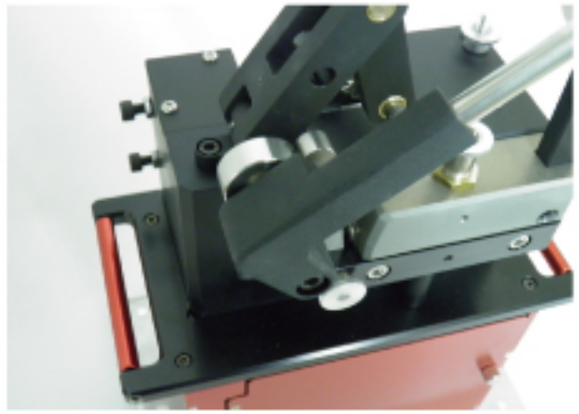




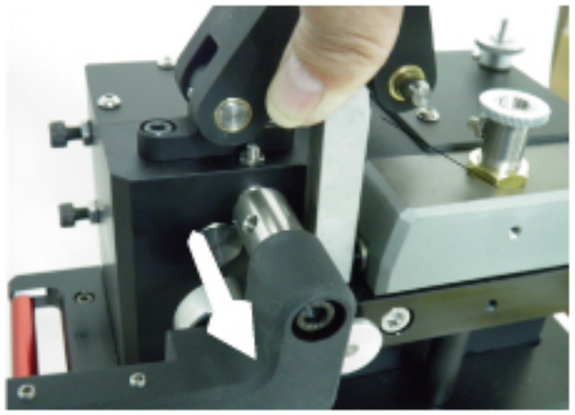
## Adjustment Procedure of Cutting Blade

Rotaly Chip Blade that is one of the features of this product can adjust it very easily.

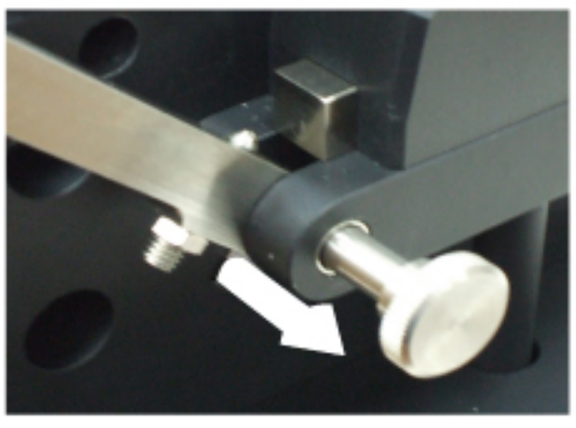
1,Detaching of Rotaly Blade



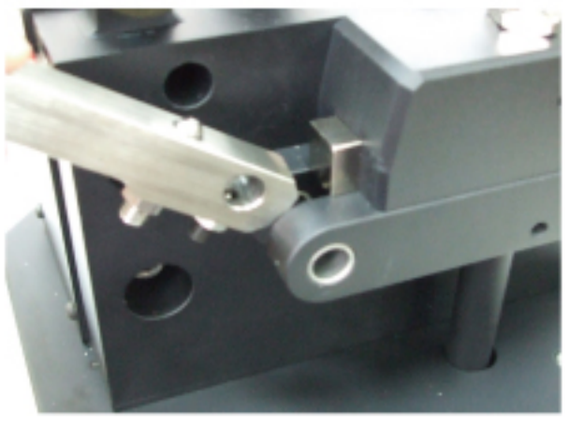
2,Detaching Pin #2



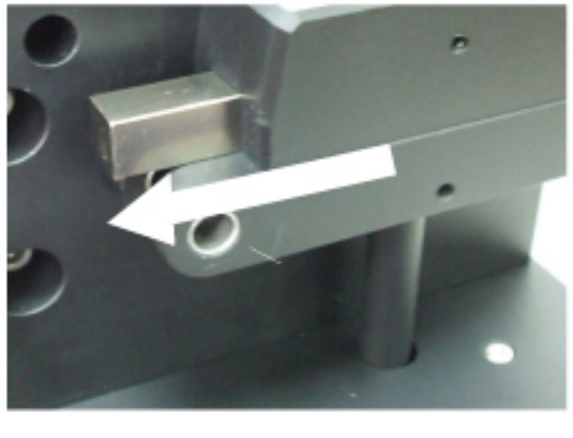
3,Detaching Pin #3

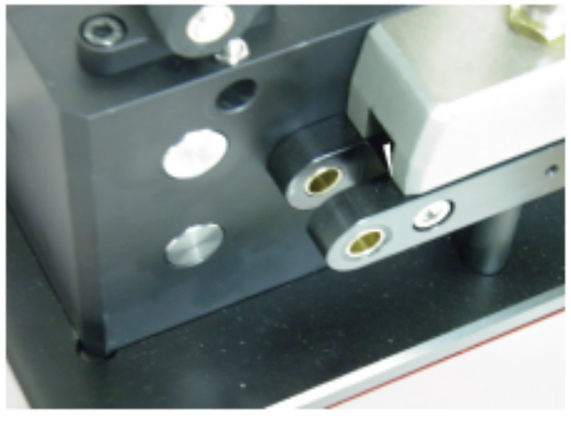


4, Pulling out the lever



5, Putting Out Rotaly Blade Unit

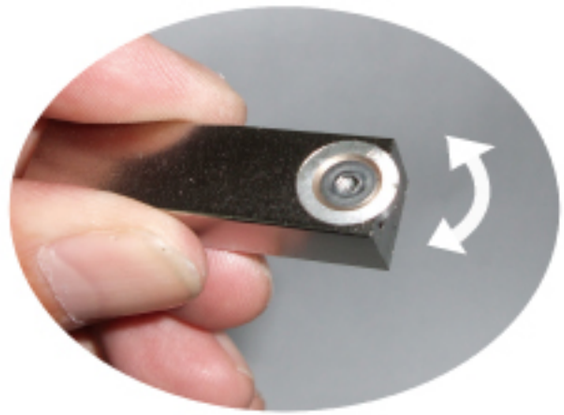




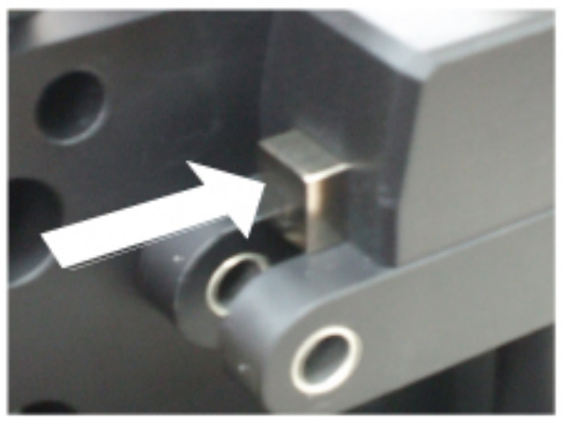
## Adjustment Procedure of Cutting Blade

7,Please loosen the screw at the center.
Please rotate the blade and set it at a different position..

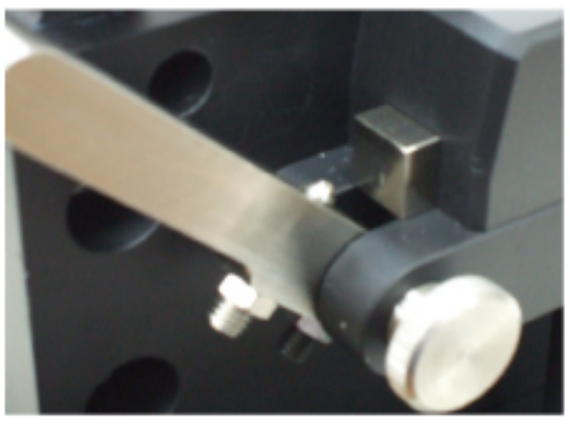




7



8



9



1 0



## Spoke Cutter Operation

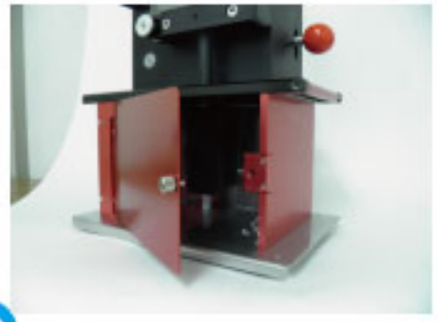



1,Adjustment of 14G

Turning the screw to the right.
A space of the die in left and right becomes small
The acrew thread becomes high

2,Adjustment of15G

The screw to which 15G is adjusted is under the body







## Spoke Cutter Operation

























## NOTICE

Please confirm the spoke through nipple whether there is loosing after cutting screw.

Please confirm the cutting-face is flat after cutting the spoke.

Please do not use the plating spoke.

Titanium spoke threading - Please  put oil or grease on the part of threading only a little.

Paints adhere to the cutting-dies after using the painting spoke,Please wipe the adhering paints off by alcohol.

Please make sure to confirm the spoke rolling horizontally straight when the cutting screw.

Please affix hand to the spoke lightly if the spoke is not rolled horizontally straight.

Please feel free to ask KOWA if you have any quesion.

The probability of fail become high in case of rolling threading of Titanuim-spoke, Please make it careful.

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製品改良のため、仕様・外観などを予告なく変更する場合があります。

## WARRANTY POLICY

| | | | |
|---|---|---|---|
| MODEL NAME | KSC-001 Ver.5<br>SPOKE CUTTER MACHINE | PRODUCTION NUMBER | |
| NAME | | PURCHASED DATE<br>YEAR / MONTH / DATE | |
| ADDRESS | | WARRANTY PERIOD;<br>ONE YEAR FROM THE PURCHASED DAY | |
| | | DEALER'S NAME | |
| PHONE NUMBER | | | |

保証期間経過後の修理等についてご不明な点はお買上店にご相談ください。

' 13.MAR.01th