



MEGA-T300b Abrasive Cutter

INSTRUCTION MANUAL

3601 E. 34th St. Tucson, AZ 85713 USA Tel. +1 520-882-6598 Fax +1 520-882-6599 email: pace@metallographic.com Web: http://www.metallographic.com



Equipment Type: 300 mm (~12-inch) Manual Abrasive Cut-off Machine

Model: **MEGA-T300b**

Electrical Requirements: 208Y / 380 Volts (3-phase)
Optional 480V 3-phase)

Frequency: 50/60 Hz

Motor Horsepower: 5.5 hp (4 KW) (3-phase)

Manual Revision Date: August 27, 2015

This instruction manual is provided with each piece of delivered equipment.

Please read this instruction manual carefully and follow all installation, operating and safety guidelines.



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WARRANTY

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PACE Technologies maximum aggregate liability for loss and damage arising under, resulting from or in connection with the supply or use of the Equipment and Consumables provided under this purchase, or from the performance or breach of any obligation (s) imposed hereunder, whether such liability arises from any one or more claims or actions for breach of contract, tort, (including negligence), delayed completion, warranty, indemnity, strict liability or otherwise, unless otherwise limited by the terms hereof, shall be limited to one hundred percent (100%) of the purchase price.

3. DELIVERY:

Customer assumes and shall bear the risk of all loss or damage to the Products from every cause whatsoever, whether or not insured, and title to such Products shall pass to Customer upon PACE Technologies delivery of the Products to the common carrier of Pace Technologies choice, or the carrier specified in writing by Customer, for shipment to Customer. Any claims for breakage, loss, delay, or damage shall be made to the carrier by the Customer and Pace Technologies will render customer reasonable assistance in prosecuting such claims.



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4. ACCEPTANCE:

Customer shall inspect the Products promptly upon receipt of delivery. Unless customer objects in writing within thirty (30) business days thereafter, customer shall be deemed to have accepted the Products. All claims for damages, errors, or shortage in Products delivered shall be made by Customer in writing within such five (5) business day period. Failure to make any claim timely shall constitute acceptance of the Products.

5. PAYMENT:

Customer agrees to provide timely payment for the Products in accordance with the terms of payment set forth on the reverse side hereof or in any proposal submitted herewith. If any payment is not paid on or before its due date, Customer shall pay interest on such late payment from the due date until paid at the lesser of 12% per annum or the maximum rate allowed by law.

6. DEFAULT:

If Buyer is in default (including, but not limited to, the failure by Buyer to pay all amounts due and payable to Seller) under the work or purchase order or any other agreement between Buyer and Seller, Buyer's rights under the warranty shall be suspended during any period of such default and the original warranty period will not be extended beyond its original expiration date despite such suspension of warranty rights.

7. MISCELLANEOUS PROVISIONS:

This agreement has been made in and shall be governed by the laws of the State of Arizona. These terms and conditions and the description of the Products on the reverse side hereof or in any proposal submitted herewith constitute the entire agreement and understanding of the parties with respect to this sale and supersede all prior and contemporaneous agreements or understandings, inducements or representations, expressed or implied, written or oral, between the parties with respect hereto. Any term or provision of this Agreement may be amended, and any observance of any term of this Agreement may be waived, only by a writing signed by the party to be bounds. The waiver by a party of any breach shall not be deemed to constitute a waiver of any other breach. Should suit be brought on this Agreement, the prevailing party shall be entitled to recover its reasonable attorneys' fees and other costs of suit including costs and attorneys' fees incurred on appeal or in collection of any judgment.



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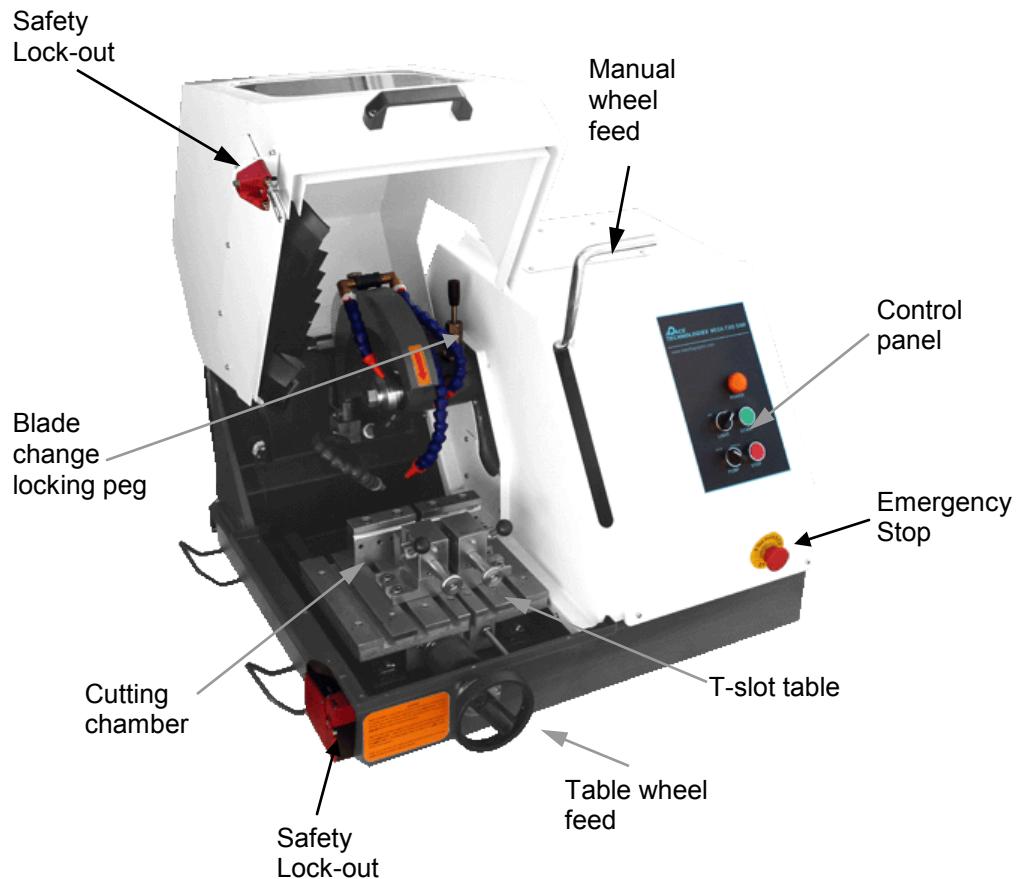
Please read this instruction manual carefully and follow all installation, operating and safety guidelines. iii

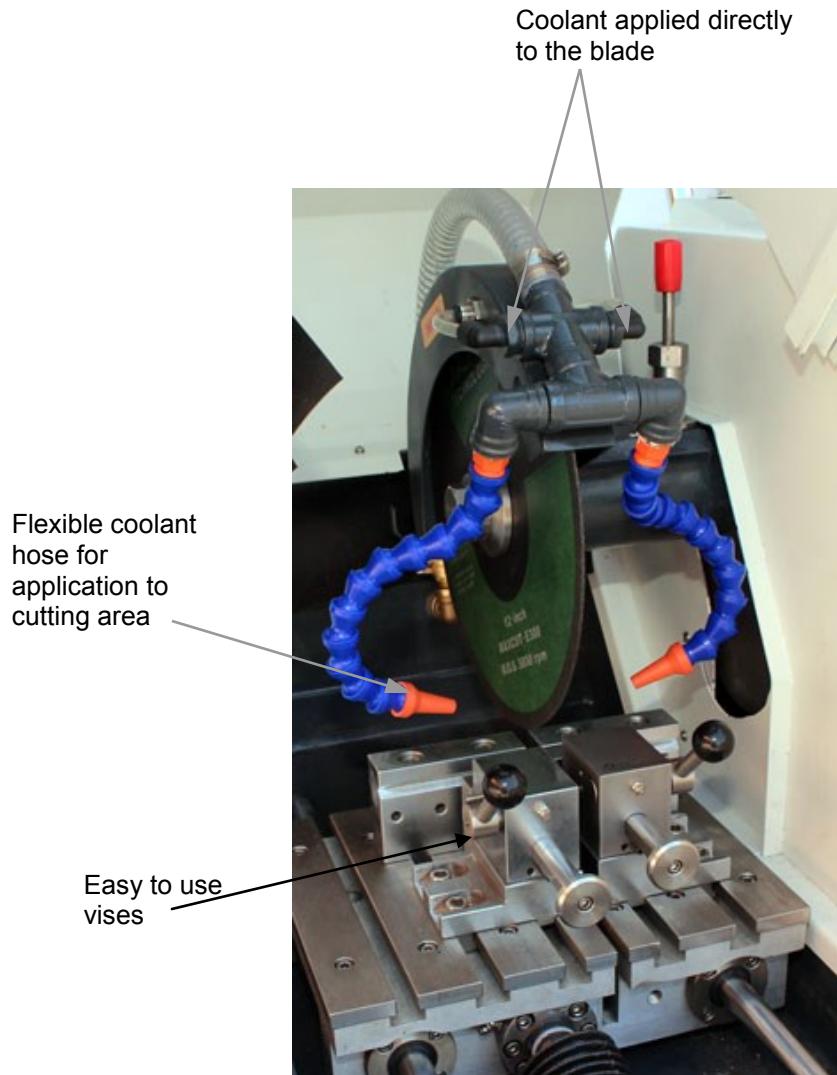
1.0 Product Description

1.1 General Description

The **MEGA-T300** is a manual wheel feed or table feed abrasive cut-off machine for cutting materials ranging from soft aluminum metals to hardened tool steels. It is ideal for the metallographic laboratory, as well as for small industrial or production applications.

The **MEGA-T300** is very robust and durable with its cast aluminum alloy and stainless steel construction. Featuring a corrosion-free T-slot table, the **MEGA-T300** is a very versatile table feed bench top model metallographic cutter.







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1.2 Technical Specifications

Electrical specifications:	208Y (phase-phase or 120/120/120 to ground), 380V, 400, 480V 3-phase optional)
Motor power:	4.5 hp (3 kW) - 3-phase to ground
Cut-off wheels:	300 mm (~12-inch) diameter
Wheel arbor:	32 mm (~1.25 inch) diameter
Maximum sample diameter:	4-inch (100 mm)
Weight:	Approx. 350 lbs (160 kg)
Dimensions (WxHxD):	Approx. 36" x 34" x 26" (hood closed) (90 cm x 86 cm x 65 cm)
	Approx. 36" x 34" x 32" (hood open) (90 cm x 86 cm x 82 cm)
Table dimensions (WxD):	12" x 9" (300 mm x 230 mm)
Cutting chamber:	Cast aluminum block construction
Hood and body	Fabricated steel with shock resistant plastic window
Working temperature:	32° - 100°F (0 - 40°C)
Shipping temperature:	32° - 100°F (0 - 40°C)
Storage temperature:	32° - 100°F (0 - 40°C)
Recirculation system (included):	15 gallons (60 liters)



EU Directives:	Machinery directive 2006/42/EC Low Voltage Directive 2006/95/EC Electromagnetic Compatibility directive 2004/108/EC
EU Harmonized Standards:	EN ISO 1200:2010 EN 61010-1:2010 EN 61326-1:2006

Please read this instruction manual carefully and follow all installation, operating and safety guidelines.



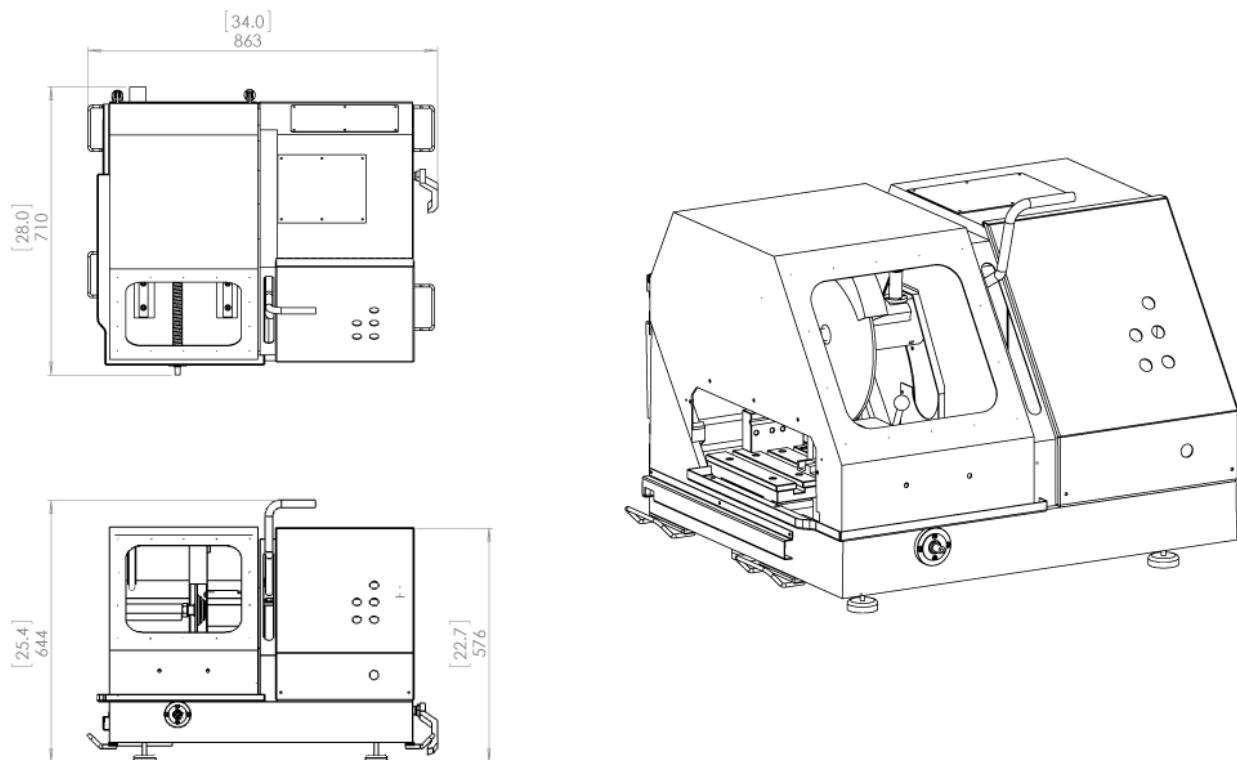
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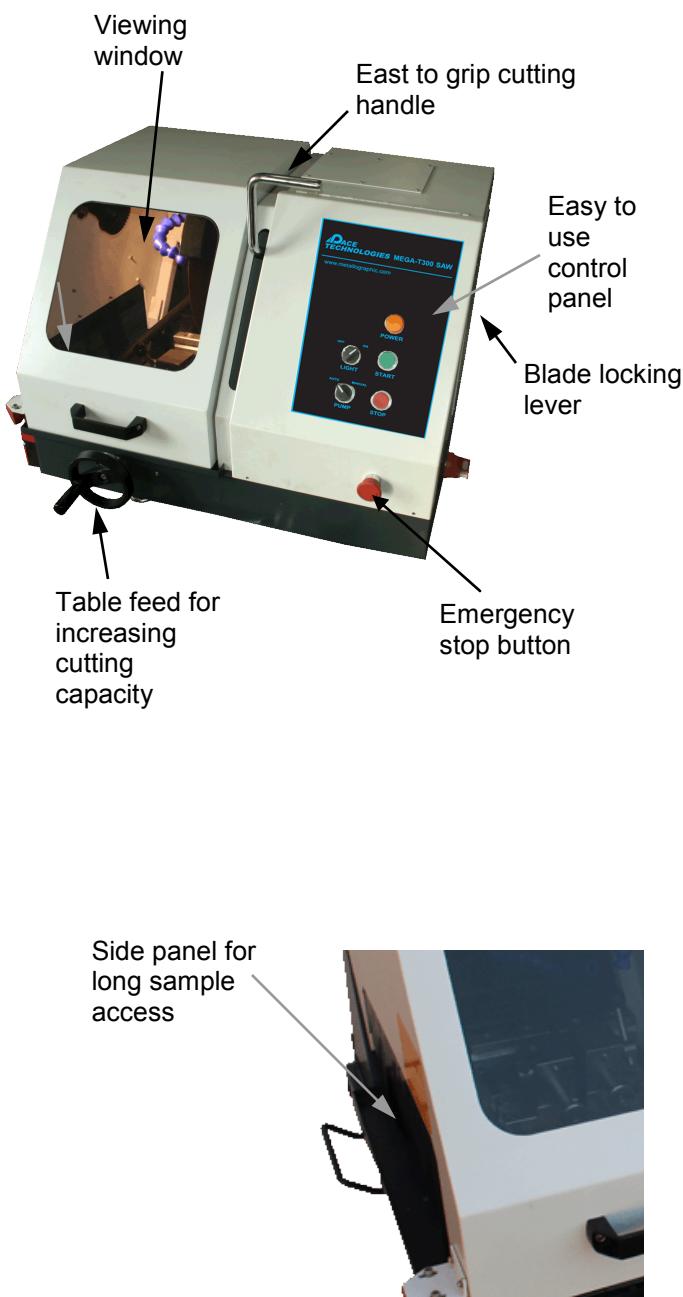
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1.3 Mechanical Schematic



Note: Installation of the **MEGA-T300** should be on a flat sturdy surface, with easy access to electrical connections.

1.4 Features



Powerful motor

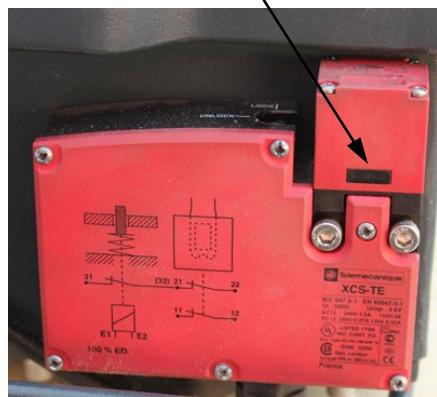
The **MEGA-T300** is equipped with a powerful belt drive motor. In addition, the motor has an inductive brake for faster stopping of the blade.

Manual feed and table feed cutting

The **MEGA-T300** is an easy-to-use manual cutter with simple controls. Cutting can be accomplished with either a wheel feed or table feed.

The **MEGA-T300** also has a removable side port panel for sectioning longer samples.

Safety lock-out
for protecting
user against
moving blade





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2.0 Unpacking, Shipping and Installation

2.1 Unpacking

Unit is delivered in a crate. Unpack and check for completeness of parts.

Measures WxHxD: Approx. 36" x 36" x 36"

Weight: Approximately 375 lbs.

2.2 Shipping

When moving crate, lift from bottom. To move MEGA-T300 use support bars provided with the machine.



The **MEGA-T300** is constructed of sensitive electronic and mechanical components. **Do not drop.**

! **Caution:** Heavy equipment. Take care to avoid bodily injury.

(Installation continued on next page)

Please read this instruction manual carefully and follow all installation, operating and safety guidelines.

2.3 Installation

! Install unit carefully! Improper installation voids warranty.

The **MEGA-T300** should be placed on a flat stable surface.

! TO OPEN HOOD, CUTTER IS SHIPPED WITH THE LOCKOUT SWITCH TURNED TO UNLOCK. AFTER CONNECTING POWER, TURN SWITCH TO LOCK TO OPEN HOOD AND TO USE CUTTER

Connect coolant tank supply, drain and electrical connections.



Shipped in the
Unlock



! Electrical connections—The standard saw is designed to operate at 208-220V 3-phase (120V-120V-120V-ground) (optional 380/400/480V)

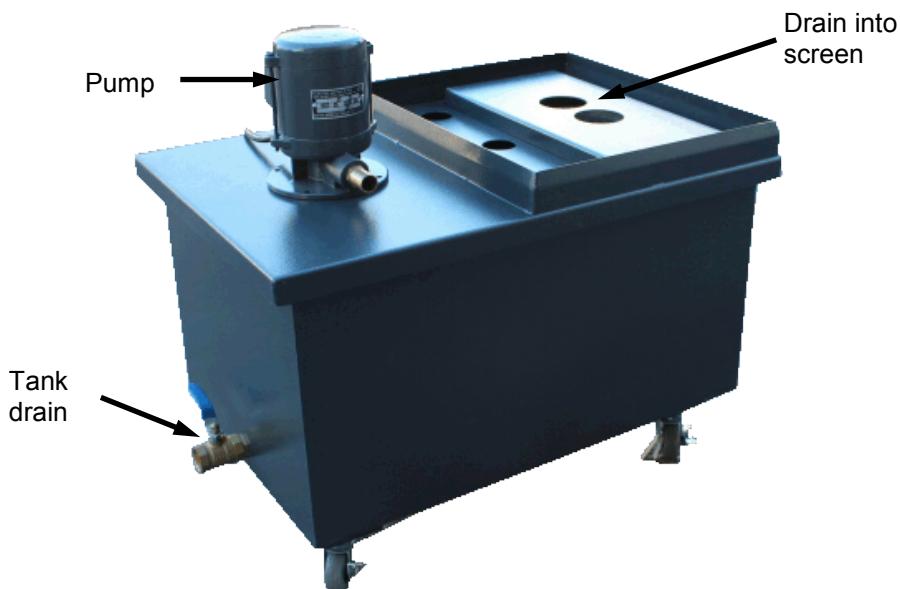
Verify voltage on nameplate



Main Power switch

! Verify the direction of rotation of the cut-off wheel. The wheel should turn counter-clockwise as viewed from the front of the machine.

(Installation continued on next page)

Recirculating tank connections

External coolant supply: Attach 3/4-inch tube between pump and cutter.

Drain: 1.5-inch (38 mm) tube.

Electrical connections: Connect six-foot electrical power cable to source.

Note: Inspect the operating voltage on the name plate.

Electrical connection for external coolant supply: Power for recirculation system comes from the **MEGA-T300**,

(Installation continued on next page)



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3.0 Safety Guidelines

3.1 Warning Sign

- ! This sign points to special safety features on the machine.

3.2 Safety Precautions

Careful attention to this instruction manual and the recommended safety guidelines is essential for the safe operation of the **MEGA-T300**.

Proper operator training is required for the safe operation of the **MEGA-T300**. Any unauthorized mechanical and electrical change, as well as improper operation, voids all warranty claims. All service issues need to be reported to the manufacturer / supplier.

- ! Before operating, cutting chamber hood must be closed. After cutting, the safety latch will not open for approximately 5 seconds after pressing the stop (red) button.
- ! Use only certified cut-off wheels from a professional supplier. Improper blades selection voids warranty. (For appropriate blade selection, refer to the Abrasive Blade Selection Guidelines Chart in Section 4.4)
- ! Disconnect power before opening the main unit.
- ! Replacement parts should be installed only by qualified personnel.
- ! Securely clamp the part / sample to the working table. During cutting, consider that the part may pinch and cause jamming of the cut-off wheel. Use the appropriate clamping devices to avoid this occurrence.
- ! Never start a cut under load.
- ! Make sure that the cut-off blade is rotating down and into the sample.

3.3 Emergency Statement

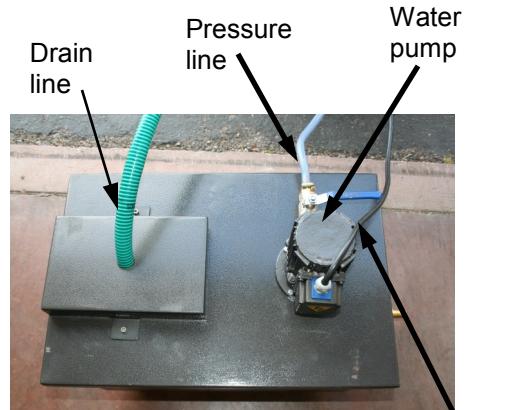
The MEGA-T300 abrasive cutter has been designed for cutting metallographic specimens. DO NOT CUT oversize samples. Always follow proper operational guidelines and avoid contact with moving parts, lubricants and abrasives. Seek appropriate medical care for cutting injuries.

Recirculation tank

The **MEGA-T300** is equipped with a mobile three-chamber counter-current coolant tank. The first chamber contains a coarse strainer for removing larger debris.

Replacement of the coolant is accomplished by rolling out the tank and removing the water pump.

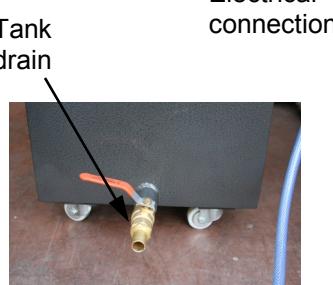
Note: Dispose of the old coolant in accordance with federal, state and local regulations.



Three Chamber tank with counter-current flow



Coarse strainer



Tank drain

Rinse line

After cutting, it is recommended that the cutting chamber be rinsed to prevent debris and corrosion build-up.



Water flow regulating valve

3.4 Safety Tests



Emergency stop switch

! Examine and verify that the **MEGA-T300** safety devices and operating performance are in good working condition prior to use. The following safety checks are considered important:

Emergency stop switch

Test: Activate main switch and close hood; depress emergency stop switch.

Proper Response: Machine powers down.

Malfunction: Machine does not lose power.

Corrective measure: If system does not power down, disconnect power supply cord and call service technician.

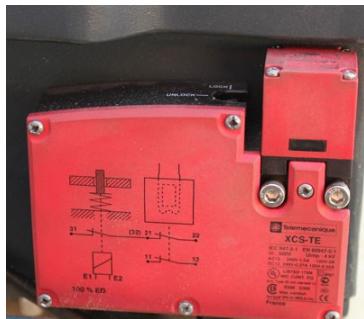
Magnetic safety lock out switch

Test: Activate main switch and close hood; turn cut-off wheel ON then OFF; Try to open the hood.

Proper Response: Hood does not open for approximately 5 seconds.

Malfunction: Hood opens immediately.

Corrective measure: If cut-off wheel does not power down, disconnect power supply cord and call service technician.



Magnetic Safety switch

4.0 Start-up and Operation

4.1 General

The **MEGA-T300** is a manual wheel and manual table feed cutter.

4.2 Control Panel



Cutting wheel ON: Starts the cutting wheel.

Cutting wheel OFF: Stops the cutting wheel (inductive brake engages to slow wheel). Hood cannot be opened until safety lock releases in approximately 5 seconds after pressing the stop button.

Coolant ON/OFF: Operates the coolant pump in Auto or Manual mode.

Light ON/OFF: Turns inside chamber light On or Off.

Ammeter: Number of amps being pulled by the motor.

Amp overload signal light: Red light turns on if too many amps are being pulled by the motor. This is a warning light to indicate that the cutting force needs to be reduced.

4.3 Wheel and Table Feed

4.3.1 Wheel feed cutting



4.3.2 Table feed cutting



4.4 Changing abrasive cut-off wheels

1. Remove blade locking bolt (reverse threaded).
2. Position new 300 mm abrasive cut-off wheel into position.
- ! Use only certified abrasive cut-off wheels.
3. Gently tighten blade locking bolt (Note: locking bolt is reverse threaded).

Changing Blade

Remove: Loosen by turning clockwise

Tighten: Turn counter-clockwise

To prevent shaft from turning, push in locking rod to hold in place





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ABRASIVE Cutting CONSUMABLES SELECTION GUIDELINES CHART

Abrasive Cutting Fluids

Pace Product Name	Catalog Number	Packaging
MAXCUT™ Abrasive Cutting Fluid (32 oz)	MAXCUT 1000-32	32 oz
MAXCUT™ Abrasive Cutting Fluid (128 oz)	MAXCUT 1000-128	1 gallon
MAXCUT™ 2 Cutting Fluid with Anticorrosion Additive (32 oz)	MAXCUT2 1000-32	32 oz
MAXCUT™ 2 Cutting Fluid with Anticorrosion Additive (128 oz)	MAXCUT2 1000-128	1 gallon

300 mm (~12") MAXCUT™ Abrasive Blades 32mm (~1¼") Arbor

Pace Product Name	Catalog Number	Packaging
Soft Non-ferrous Materials (Aluminum, Brass, Zinc, Etc.)	MAX-E300	10
Hard Non-ferrous Materials	MAX-C300	10
Soft Steels	MAX-E300	10
Case Hardened Steels	MAX-D300	10
Hard Steels	MAX-D300	10
General Purpose Industrial Blade	MAX-I300	10

4.5 Manual cutting (step-by-step procedure)

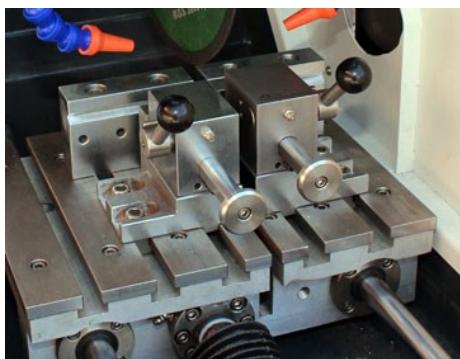
1. Connect electrical power and turn on master power switch on the side panel before opening the hood.
2. Position fixtures and sample near to cut-off wheel.
3. Close hood.
4. Turn on coolant and cutter motor.
5. Hand feed the cutting wheel or table feed into the sample.
6. Turn off cutter and allow blade to completely stop before opening cover.
Note magnet safety switch has an approximately 5 second delay. Cutter hood cannot be opened until safety switch is deactivated.

4.6 Fixturing sample

For proper clamping, use the appropriate clamping vises to securely hold the sample in place. It is recommended that both sides of the part be clamped to avoid pinching of the blade (possibly breaking the blade) and to minimize burning of the workpiece during cutting.

! For proper fixturing, take into account the initial stress on the samples.

Fixture examples



Fast clamping

Left lever (Cat. No. QCL-1100)
Right lever (Cat. No. QCR-1100)

Note: vises have a slot in them so that the face does not rotate



UNIVERSAL Clamping vise

UNIVERSAL (Cat. No. MG15-01)
Clamping height 0 - 3.5 in (0 - 90 mm)



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5.0 Maintenance

5.1 Introduction

The **MEGA-T300** requires very minimal maintenance. However, to increase the life of the saw, it is suggested that the cutting chamber be rinsed after cutting.

It is also recommended that the hood be left open in order to minimize corrosion inside of the chamber due to high humidity from the cutting operation and cutting fluid.

5.2 Cleaning outside cabinet

The cabinet and front shield should be cleaned occasionally with a moistened cloth. Do not use any chemicals or cleaning abrasives. We recommend an anti-condensation gel be used on the front panel.



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6.0 Trouble Shooting

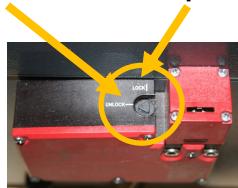
More extensive trouble shooting, repair guides, video's, parts list are provided online at www.metalgraphic.com or

<http://www.metalgraphic.com/PACE-service/MEGA-T300-service.html>

Problem	Cause	Solution
No power or function	a. Unit is disconnected from main electrical power supply. b. Main power switch is off. c. Emergency stop button engaged.	a. Verify electrical source and connection. b. Turn on main power switch. c. Release by turning clockwise.
Main motor does not operate	a. Interlocking safety switch is in Unlock position (for shipping) b. Hood not closed. c. Overload relays activated	a. Turn safety switch to Lock position to operate cutter. b. Close hood c. Restart after resetting Q1 relay.
Pump motor does not operate	a. Plug is disconnected b. Overload relay activated	a. Check plug. b. Restart after resetting Q2 relay.
Excessive vibration during cutting	a. Not cutting with enough force b. Specimen locked too far back on cutting table c. Incorrect blade selection	a. Increase cutting force. b. Move specimen forward. c. Use correct blade.

Shipped in the
Unlock position

Turn to Lock position
to operate saw



If motor or pump
does not turn on
check Q1 - motor
and Q2- pump
relays



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7.0 List of Spare Parts

Part no.	Description	Images
	Electrical	
M3-CB	MEGA-T300 Full control board replacement for MEGA T300	
GV2ME20C	QF1 overload switch (Schneider GV2-ME20C/13-18A)	
GV2ME14C	MEGA-T300 QF1 overload switch (380V and 480V motor) (Schneider GV2-ME14C/6-10A)	
GV2ME05C	MEGA M250 QF2 overload switch (pump) (Schneider GV2-ME05C/0.63-1A)	
MEG-RCMU	RCMU timer (blade)	
MEG-RAMU	RAMU timer (safety switch)	

Replacement of spare parts is possible with minimal expertise. Spare parts for recirculation system are also available upon request.



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Part no.	Description	Images
	Electrical	
LC1D18B7C	KM1, KM3 AC contactor (MEGA-T300) (Schneider LC1D12B7C)	
LC1D18B7C	KM2 AC contactor (MEGA-T300) (Schneider LC1D09B7C)	
M3-F-H	Fuse Holder (each)	
M3-F1	MEGA-T300 F1 fuse (2A)	
M3-F2	MEGA-T300 F1 fuse (2A)	
M3-F3	MEGA-T300 F1 fuse (20A)	
M3-F4	MEGA-T300 F1 fuse (20A)	
M3-F5	MEGA-T300 F1 fuse (2A)	
M3-F6	MEGA-T300 F1 fuse (2A)	
M3-MOTOR	MEGA-T300 Motor (4 KW)	
M2-SAFE-T	MEGA M250 Safety lock out switch (top piece)	

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Part no.	Description	Images
	Electrical	
M2-SAFE-B	MEGA M250 Safety lock out switch (bottom piece)	
M2-SAFE-K	Safety key	
MEG-RL1	RL1 switch (24 V)	
RELAY-B	24V relay base	
GTB	Ground terminal block	
TB	Terminal block	
MEG-LITE	Light housing	

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Part no.	Description	Images
	Electrical	
M-250B	Light bulb (OSRAM Halogen DC24V 20 Watt)	
M-SEAL	Wire plastic seal connector	
MEG-PUMP-220	Pump (220/380V)	
MEG-PUMP-480	Pump (400-480V)	
MEG-FPC	Female pump connector	
MEG-MPC	Male pump connectors	
MEG-AM1	Ammeter set-up kit	
MEG-R	Rectifier	

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Part no.	Description	Images
	Electrical	
MEG-AM2	Amp overload light	
MEG-AM3	Amp overload light controller	
MEG-TC-220	220-380V Transformer	
MEG-TC-480	440-480V Transformer	
MEG-PS	Main power switch	



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Part no.	Description	Images
	Electrical	
MEG-ON	On button (green)	
MEG-LS	Light ON/Off switch	
MEG-LB	Power on light button	
MEG-OFF	Off button (red)	
MEG-W	Water ON/OFF Switch	
P150-210	Emergency Stop	



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Part no.	Description	Images
	Mechanical-motor	
M3-SH	MEGA-T300 Blade shroud	A grey metal shroud with a semi-circular cutout at the bottom, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-001	Arbor bolt	A cylindrical bolt with a hexagonal head, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-002	Arbor inside flange	A circular metal flange with a central hole and a ribbed outer edge, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-003	Arbor blade outside flange	A larger circular metal flange with a central hole and a ribbed outer edge, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-004-1	Flange-lock-housing	A cylindrical housing with a flange and several mounting holes, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-004-2	Flange lock nut	A hexagonal lock nut, featuring the PACE TECHNOLOGIES logo and website address.
T3-M-004-3	Flange lock shaft	A long, thin cylindrical shaft, featuring the PACE TECHNOLOGIES logo and website address.

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Part no.	Description	Images
	Mechanical-motor	
T3-M-003	Motor table base	
T3-M-005	Motor table lock slot	
T3-M-006	Motor base adjustment guide	
T3-M-007	Motor base adjustment block	
T3-M-008	Motor extension shaft	
T3-M-009	Motor extension shaft housing	

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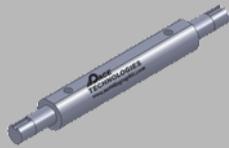
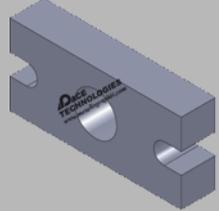
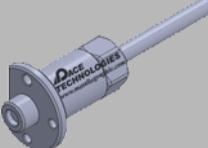
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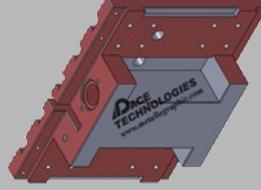
Part no.	Description	Images
	Mechanical-motor	
T3-M-010	Motor shaft	
T3-M-011	Motor shaft screw holder	
GS-T300	MEGA-T300 (400 Newton) gas cylinder pistons for hood	
T3-M-0012	Motor feed handle	
T3-M-004	MEGA-T300 blade locking rod	



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Part no.	Description	Images
	Mechanical-table	
M3-TG	MEGA-T300 Table feed guide rods (pair)	
M3-BOOT	MEGA-T300 Table feed boot	
M3-TFW	MEGA-T300 Table feed wheel	
T3-M-013	MEGA-T300 Table feed screw	
T3-M-014	MEGA-T300 T-slot table	
T3-M-015	MEGA-T300 wheel feed locking lever	
T3-M-016	Table feed rail guide plate	

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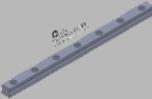
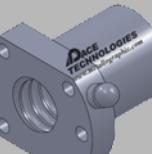
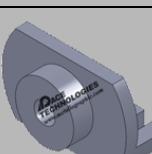
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Part no.	Description	Images
	Mechanical-table	
T3-M-017	Table feed back screw cover	
T3-M-018	Table feed rail guide block	
T3-M-019	Table feed sliding rail guide	
T3-M-020	Screw feed casting base outside cover-wheel	
T3-M-021	Screw feed casting base inside cover	
T3-M-054	Screw feed drive outside guide for table	
T3-M-022	Screw feed drive inside guide for table	
T3-M-023	Screw feed table wheel cover	

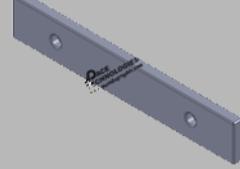
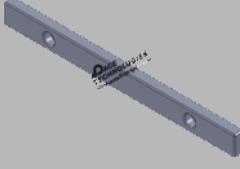
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Part no.	Description	Images
	Mechanical-table	
T3-M-024	Screw feed wheel-base cover-1	
T3-M-025	Table feed support bar large	
T3-M-026	Table feed support bar small	

Part no.	Description	Images
	Mechanical-tank	
MEG-TANK	Recirculating tank	
MEG-TANK-C1	Recirculating tank cover with square screen	



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Part no.	Description	Images
	Mechanical-table	
MEG-TANK-C2	Recirculating tank cover with round screen	
MEG-SCREEN-COV1	Tank screen/ single drain cover (MEGA-M250 / T300)	
MEG-SCREEN-SQ	Coarse screen for MEGA abrasive cutter tanks (square)	
MEG-SCREEN-RD	Coarse screen for MEGA abrasive cutter tanks (round)	



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Part no.	Description	Images
	Mechanical-base	
M3-FEET	MEGA-T300 support feet (4/set)	
T3-M-028	MEGA-T300 lifting handles (2/set)	
T3-M-027	MEGA-T300 casting base	

Part no.	Description	Images
	Mechanical-Hood	
T3-M-029	MEGA-T300 Control panel fabricated cover	
T3-M-033	MEGA-T300 Cutting chamber hood	

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Part no.	Description	Images
	Mechanical-Hood	
T3-M-045	MEGA-T300 Right hood	
T3-M-030	Splash panel	
T3-M-031	Water shield	
T3-M-032-M	Side panel (metal)	
T3-M-032-P	Side panel (plastic)	
M3-BT	MEGA-T300 rubber boot or side access	
M3-T	MEGA-T300 template	

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Part no.	Description	Images
	Mechanical-Hood	
T3-M-034	Cooling sheet top panel	A rectangular metal plate with a slightly curved top edge and a flat bottom edge. It features a small circular hole near the bottom center and a vertical slot along the right edge. The Pace Technologies logo is printed on it.
T3-M-052	Electrical panel base plate	A rectangular metal plate with a central vertical slot and a small circular hole near the bottom center. The Pace Technologies logo is printed on it.
T3-M-053	Electrical panel support box	A rectangular metal plate with a central vertical slot and a small circular hole near the bottom center. The Pace Technologies logo is printed on it.
T3-M-035	Back sheet	A long, thin, rectangular metal strip with a slight curve at one end. The Pace Technologies logo is printed on it.
T3-M-036	Cooling back panel	A rectangular metal plate with a slightly curved top edge and a flat bottom edge. It features a small circular hole near the bottom center and a vertical slot along the right edge. The Pace Technologies logo is printed on it.
T3-M-037	Side cooling vent	A hexagonal metal plate with a grid of small holes across its surface. The Pace Technologies logo is printed on it.

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Part no.	Description	Images
	Mechanical-Hood	
T3-M-038	Hood handle	
T3-M-039	Left front panel	
T3-M-040	Lock shaft	
T3-M-041	Lock shaft block	
T3-M-043	Lock shaft ring	
T3-M-044	M8 gas spring back holder	
T3-M-046	Right hood sheet cover	

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Part no.	Description	Images
	Mechanical-Hood	
T3-M-047	Rubber shield holder	
M3-FW	MEGA-T300 front safety window	
T3-M-048	Safety glass frame	
T3-M-049	Small water shield	
T3-M-050	Water nozzle bracket	
T3-M-051	Water split block	

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Part no.	Description	Images
	Plumbing	
M3-D	MEGA-T300 Drain hose (40 mm) - 1.5m	
M3-H	MEGA-T300 Coolant line (20 mm) - 1.5 meter	
M3-COOL	MEGA-T300 Flexible coolant line (pair) (Part No. M3-COOL)	
MEG-RHV	Rinse hose and valve	
MEG-RH	Rinse hose	
M2-NOZ	Rinse hose nozzle	
M2-NOZ-T	Rinse hose nozzle tip	

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Part no.	Description	Images
	Plumbing	
MEG-V	Rinse hose shut-off valve	
MEG-IB	Brass inlet hose barb	
MEG-OB	Brass drain hose barb	

Part no.	Description	Images
	Tools	
G-GUN	Grease gun	
G-GUN-R	Grease refill	
MEG-SQ	Square	



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Part no.	Description	Images
	Tools	
MEG-TB	Tool box	
MEG-25HW	2.5 mm hex wrench	
MEG-10HW	M10 hex wrench	
M3-WCH	MEGA T300 Wrenches (30/32 mm)	

Part no.	Description	Images
	Vice Components	
QC-REPAIR	Vice repair kit MEGA-T400 (kit include cam shaft and bar, spring and adjustment set screw for one vise)	
MIG-01	Vertical clamping vise with 45 mm arm (1.8-inch) and shoe	
MG-15-01	Vertical clamping vise with 75 mm arm (3-inch) and shoe for MEGA-T400	

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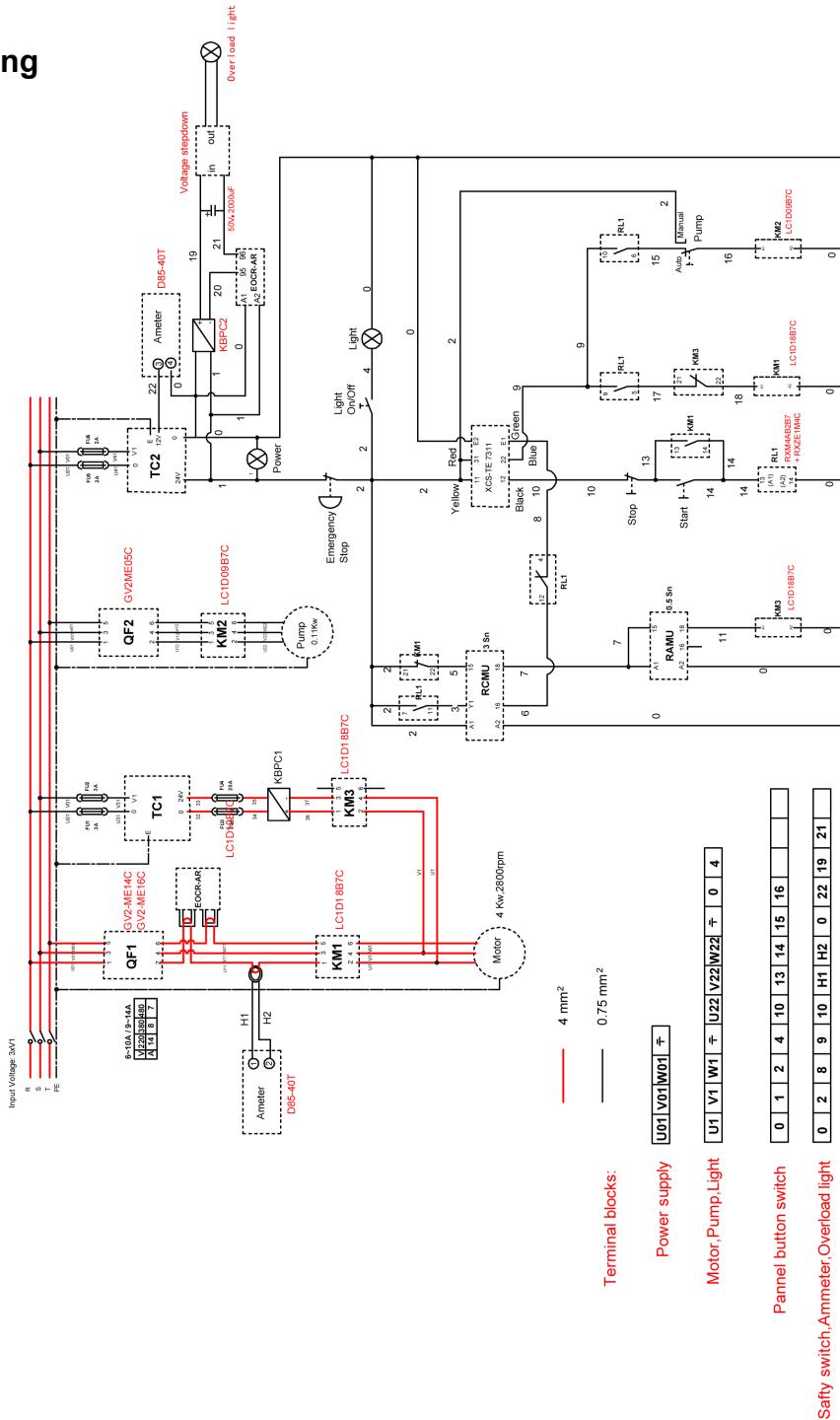
Part no.	Description	Images
	Vice Components	
MG-H	65 mm (2.6-inch) height adapter for either MIG-01 or MG15-01 vertical clamping vises	A yellow plastic height adapter with a black cap and a metal base, labeled PACE TECHNOLOGIES www.metallographic.com.
MG-TB	Vertical clamping vise t-slot bolt and nut	A black T-slot bolt and nut assembly, labeled PACE TECHNOLOGIES www.metallographic.com.
MG-VW	Vertical clamping vise adjustment t-wrench	A black T-wrench with a handle, labeled PACE TECHNOLOGIES www.metallographic.com.
MEG-TS	T-slot nuts (2/set)	Two silver T-slot nuts, labeled PACE TECHNOLOGIES www.metallographic.com.
QCR-1100	Right quick clamping vise for MEGA-T300 abrasive cutter	A silver quick clamping vise with a handle, labeled PACE TECHNOLOGIES www.metallographic.com.
QCL-1100	Left quick clamping vise for MEGA-T300 abrasive cutter	A silver quick clamping vise with a handle, labeled PACE TECHNOLOGIES www.metallographic.com.
MG-0159	Mechanical stop for cutting repetitive samples	A small silver mechanical stop with a handle, labeled PACE TECHNOLOGIES www.metallographic.com.

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8.0 Electrical Drawing

T300 Electrical drawing

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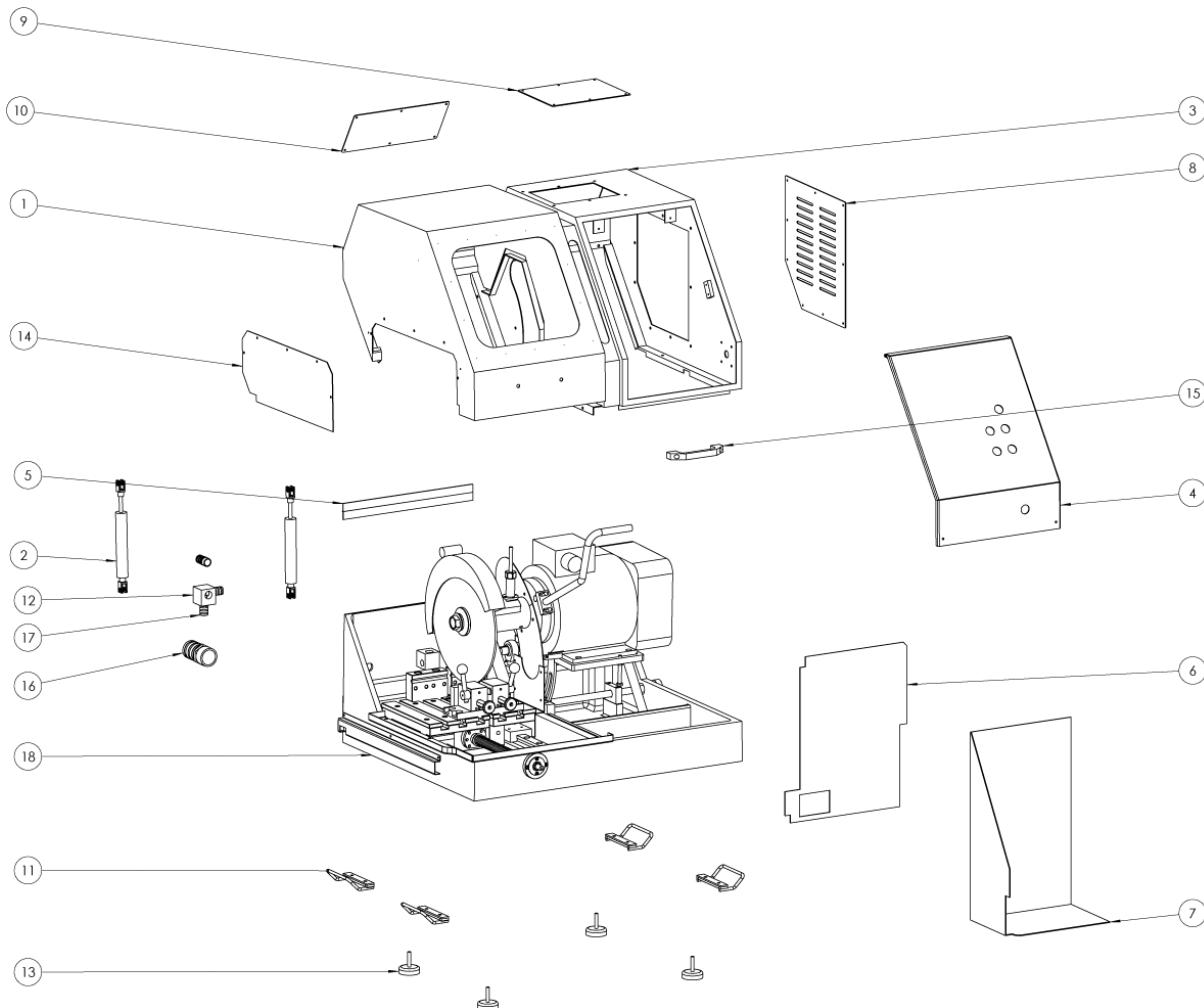




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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	T3-M-033	Cutting chamber hood	1
2	GS-T300	Hood gas spring	2
3	T3-M-045	Right hood	1
4	T3-M-029	Control panel fabricated cover	1
5	T3-M-060-1	Champer hood hinge	1
6	T3-M-052	Electrical panel base plate	1
7	T3-M-053	Electrical panel support box	1
8	T3-M-037	Side cooling vent	1
9	T3-M-036	Cooling back panel	1
10	T3-M-034	Cooling top panel	1
11	T3-M-028	Liffting handle	4
12	T3-M-057	Three ways water splitter	1
13	M3-FEET	Support feet	4
14	T3-M-032	Splash panel	1
15	T3-M-038	Hood handle	1
16	M-D-45	45mm hose barb	1
17	M-D-20	20mm hose barb	3
18	T300-EX-A	Base-cover assembly	1

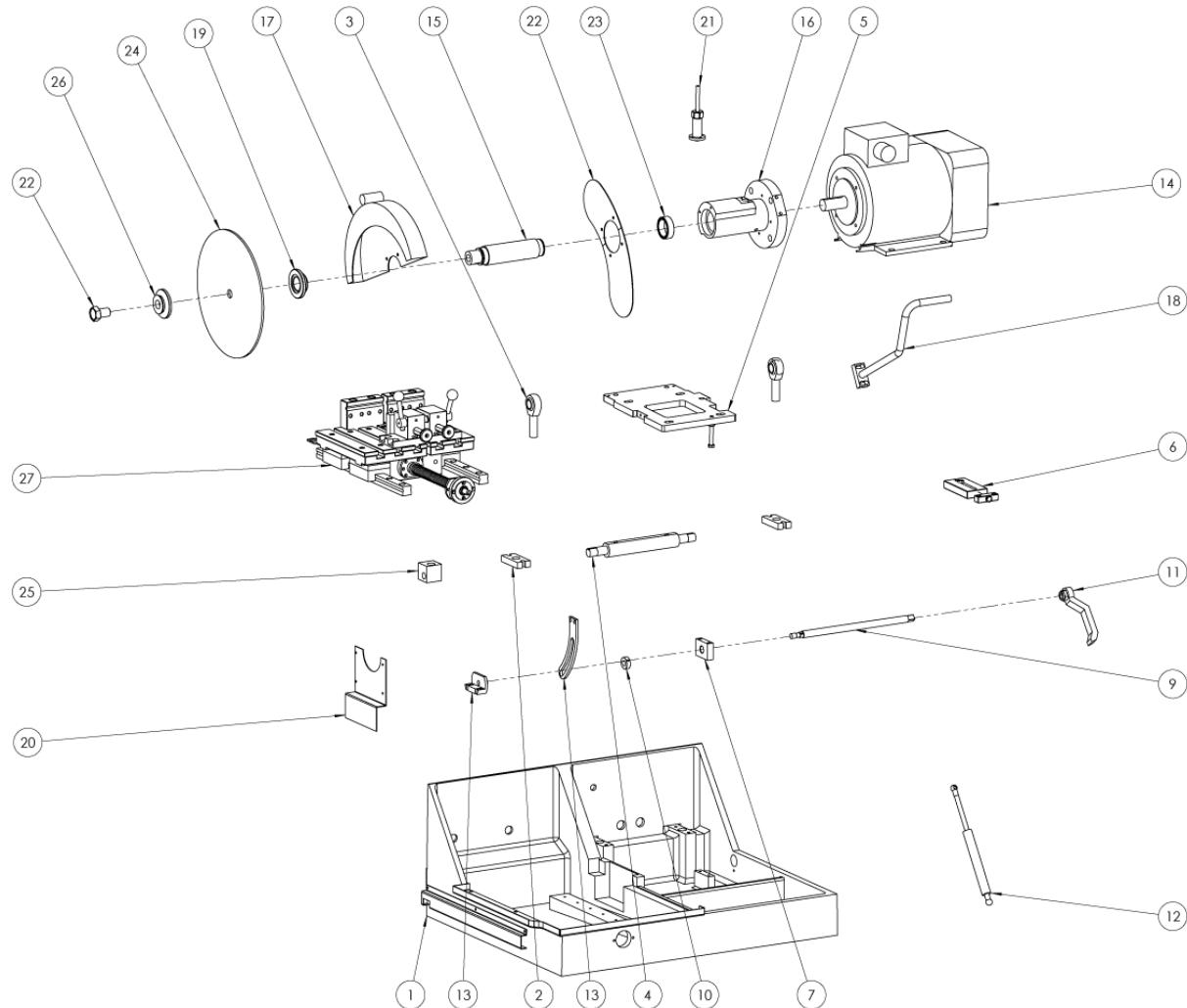
EX-Assembly



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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	T3-M-027	Casting base	1
2	T3-M-011	Motor shaft screw holder	2
3	T3-M-058	Motor table holder	2
4	T3-M-010	Motor shaft	1
5	T3-M-003	Motor table base	1
6	T3-M-006	Motor base adjustment guide	1
7	T3-M-041	Lock shaft block	1
13	T3-M-023	Locking bracket	1
9	T3-M-040	Lock shaft	1
10	T3-M-043	Lock shaft ring	1
11	T3-M-015	Feed locking level	1
12	T3-M-062-1	Motor gas spring support	1
13	T3-M-005	Motor table lock slot	1
14	M3-MOTOR	Motor	1
15	T3-M-008	Motor extension shaft	1
16	T3-M-009	Motor extension shaft housing	1
17	M3-SH	Blade shroud	1
18	T3-M-0012	Motor feed handle	1
19	T3-M-002	Arbor inside flange	1
20	T3-M-049	Small water shield	1
21	T3-M-004-3	Blade locking rod	1
22	T3-M-030	Splash panel	1
23	T3-M-Bearing	Blade holder bearing	1
24	T3-10-12	12-inch blade	1
25	T3-M-051	Four ways water splitter	1
26	T3-M-042	Arbor blade outside flange	1
27	T300-IN-A	Base-Motor assembly	1

IN-Assembly

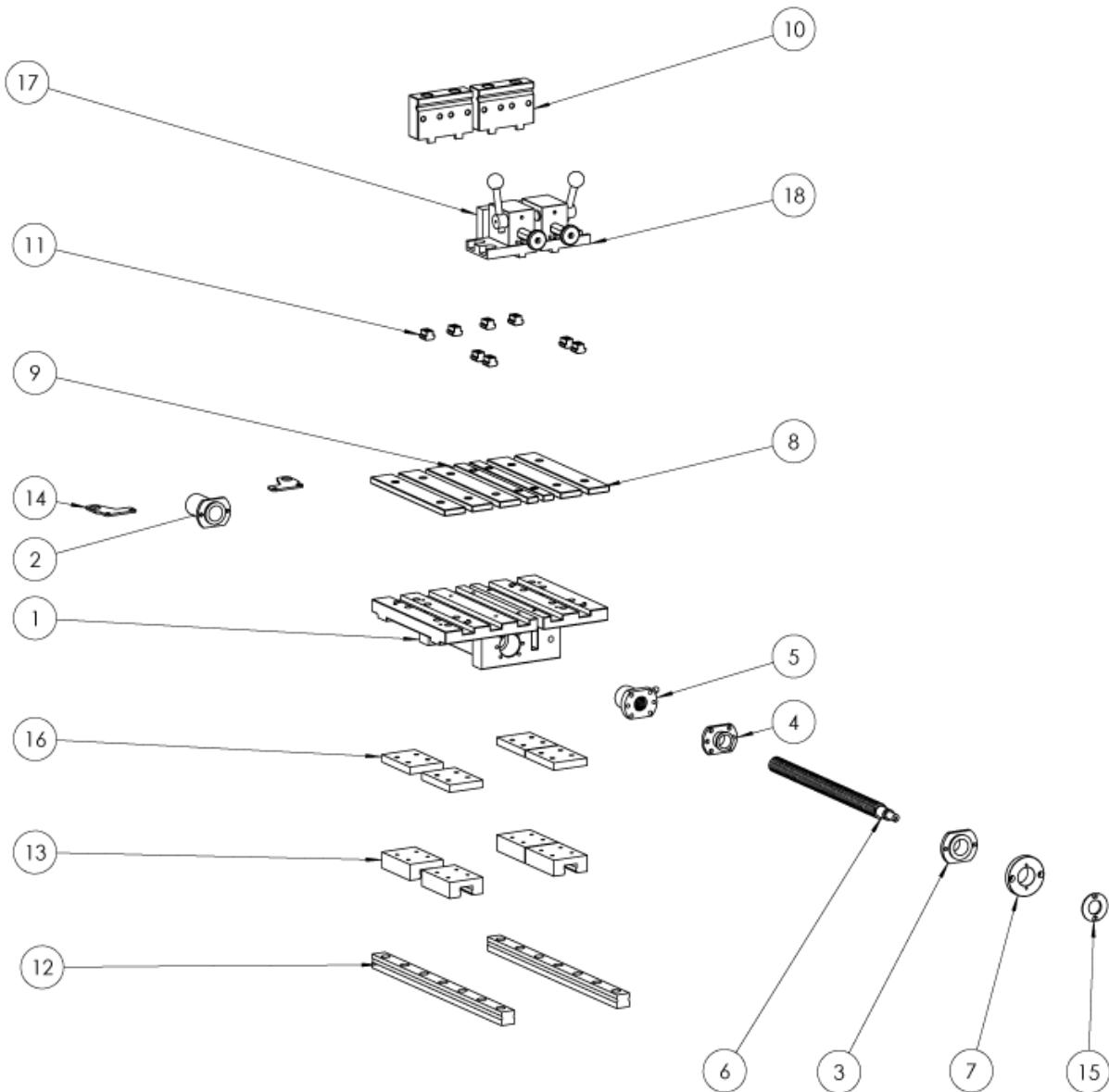
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	T3-M-014	T-slot table	1
2	T3-M-017	Table feed back screw cover	1
3	T3-M-021	Screw feed casting base inside cover	1
4	T3-M-054	Screw feed drive outside	1
5	T3-M-022	Screw feed drive inside	1
6	T3-M-013	Table feed screw	1
7	T3-M-020	Screw feed casting base outside cover	1
8	T3-M-025	Table feed support bar large	5
9	T3-M-026	Table feed support bar small	2
10	T3-QC-B	Quick clamping block	2
11	MG-TB	T-slot nuts	8
12	T3-M-019	Table feed sliding rail guide	2
13	T3-M-018	Table feed rail guide block	4
14	T3-M-050	Nozzle bracket	2
15	T3-M-024	Screw feed wheel-base cover	1
16	T3-M-016	Table feed rail guide plate	4
17	QCL-1100		1
18	QCR-1100		1

TB-Assembly