

Operation Manual

Before operating the units, please read this manual thoroughly and retain it for future reference.

1. Delivery and stock of resin grinding wheel

- 1) Gently take and put down, avoid collision and stock in dry environment and ensure that the packaging is not damaged
- 2) Place stable in the dry and ventilated place and do not touch the ground. It is best placed on the turnover tray, stacking height not more than one meter. Grinding wheels can not be long-term exposure in the humid air and can not have corrosive contact with the goods
- 3) Grinding wheels using follows the principle of first in, first out, which is against long-time storage time affects the performance.
- 4) With more than one years, the grinding wheels need to take re-rotating test of the intensity to confirm quality before use.

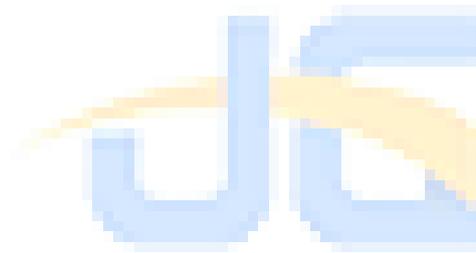
2. Test and Installation precautions

- 1) After receiving the sample, check the product whether there are cracks, nicks and dumb sounds. If the above situation occurs, please do not use it. If it is used, the grinding wheel may rupture and hurt the operator.
- 2) Every piece of grinding wheel is marked with the highest speed and linear speed, installed please after confirm your machine speed.
Exceeding the service speed and linear speed of the grinding wheel may cause the grinding wheel to rupture.
- 3) The operating current, voltage is stable
The stability of the current and voltage directly affect the speed of the cutting machine, indirectly affect the sharpness of the grinding wheel
- 4) Confirm that the actual power is within the scope of the cutter.
If not reaching the marked power, the grinding wheel stops.
- 5) Testing if cutting machine belt is aging or its elasticity needs to debug
If the belt is loose, it will affect the cutting speed of the grinding wheel and even rupture. Belt aging or relaxation and without reaching cutting machine power will affect the cutting results.
- 6) Cutter flange size, shape must be standard, and the diameter meets the requirements. What is more important is the groove on both sides without serious wear and tear.
Serious wear and tear of the groove will cause the ring hole to fall off and the grinding wheel to rupture
- 7) The processed work-pieces must be fixed well.
Do not cut the overlapping work pieces, which will avoid work-pieces loosening to crack cutting wheels.
- 8) Suitable materials for our products: general alloy, ordinary metal such as iron, stainless steel

The use of non-specific grinding wheels for grinding and cutting special steel or special alloy will affect its sharpness, which will even cause the grinding wheel to rupture and even grit to crack.

- 9) Cutter operator force is uniform.

If the force is not uniform, which will affect the cutting life span.



S.AURORA