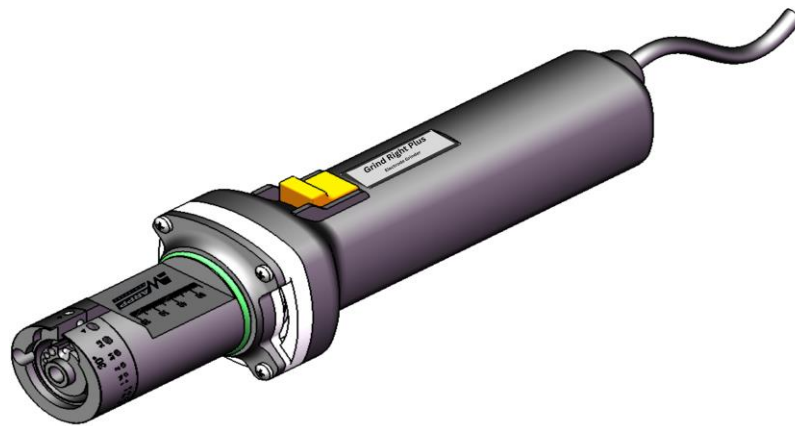


Operation & Maintenance Manual

TUNGSTEN GRINDER

MODEL – GRIND RIGHT PLUS



For cutting, grinding and facing electrodes

WARPP ENGINEERS PVT.LTD.

Survey No. 36, House No. 15/3, Unique Industrial Estate

Dhumal Nagar Vasai (East) Distt. Palghar (Maharashtra) INDIA – PIN
-401208

Tel : 8551817744 / 8551819944 / 8551817868 - 69 / 8551812002

Customer Care Tel : 8080808734

Email : service@warpp.co.in . Website : www.warpp.co.in

1 Warning messages

Warning: When using power tools, be sure to adhere to the following safety measures to prevent danger of shock, injury and fire. Read all instructions and notes before using this electrical tool and keep the notes on safety properly stored. Always ensure that the device is in good working condition, and always comply with these notes on safety.

- Keep the complete documentation close by the device.
- All regulations generally valid for the prevention of accidents must be observed.

1.1 Proper use

It is intended only to be used to process welding electrodes

1.2 Safety regulations

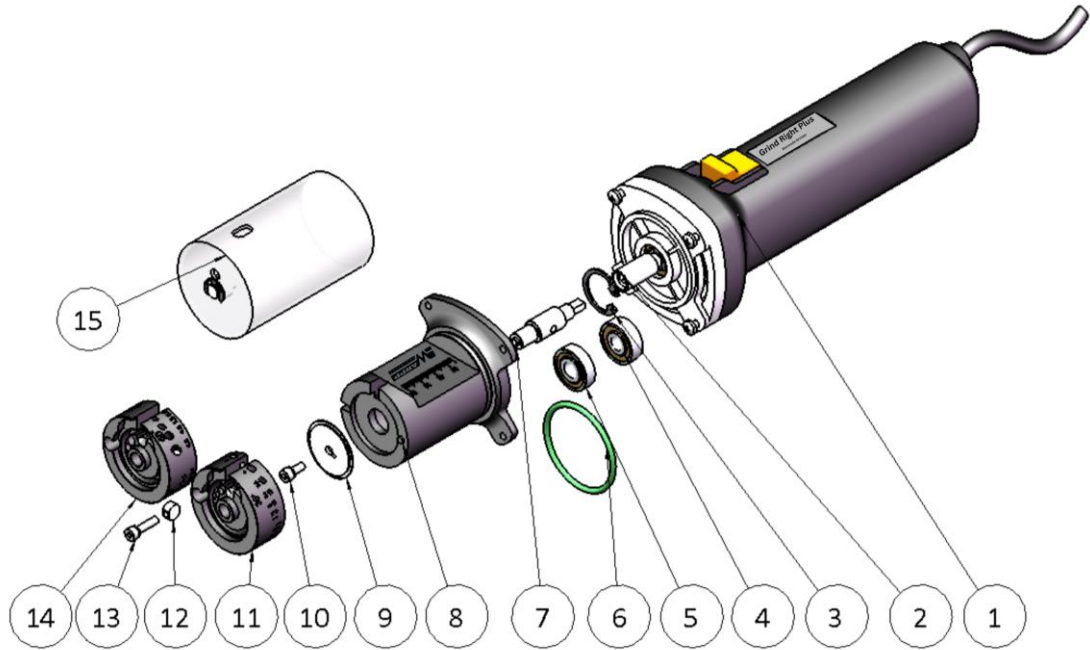
- Only use the dimensions and materials quoted in these instructions.
- Only use authentic Tools spare parts and materials
- Check the machine daily for any externally visible damage or defects. Have any damage or defects repaired immediately.
- Work on the electrical equipment should only be carried out by a qualified electrician
- Only operate the machine if the electrical protective devices function.
- The tapped holes at the machine must always be free of dust, clean if necessary
- Pull out the power plug before carrying out repair and maintenance work

1.3 Work safely

- Report any changes in operating performance to the responsible person immediately.
- Carry out all work with an awareness of safety.
- When working with the machine, wear protective goggles, safety gloves and breathing mask.
- Turn the device off at the end of each operating cycle.
- Before cleaning pull out the machine power plug and let the device coast.

1.4 Return material administration

Discarded electric tools and accessories contain a large share of valuable raw and synthetic materials which can be recycled, By actively using the offered return and collection systems, you actively contribute to the reuse, recycling and utilization of electrical (electronic) devices.



2 Construction

Item	Description	Part No.
1	Motor	050519-01
2	Conversion axis	050519-02
3	Card spring	050519-03
4	Bearing	050519-04
5	Bearing	050519-05
6	Sealing ring	050519-06
7	Transmission shaft	050519-07
8	Grinding head body	050519-08
9	Grinding wheel	050519-09
10	Hex Socket Head Cap Screw with Spring Washer M4 * 10	050519-10
11	T- Grinding head	050519-11
12	Round nut	050519-12
13	Hex Socket Head Cap Screw with Spring Washer M4*16	050519-13
14	P- Grinding head	050519-14
15	Dust collector	050519-15

3 Operation

3.1 Preparation

Make sure the switch is off, then plug in the power plug and turn on the power.

3.2 Selection :

Select the corresponding hole position according to the tungsten electrode diameter and the grinding angle



6.3 Grinding

Hold the grinder with one hand and turn on the switch with one hand;
Insert the tungsten electrode into the corresponding hole and rotate it at the same time. Note that the electrode must be pushed gradually and kept rotating at a constant speed; observe in time whether it is finished.



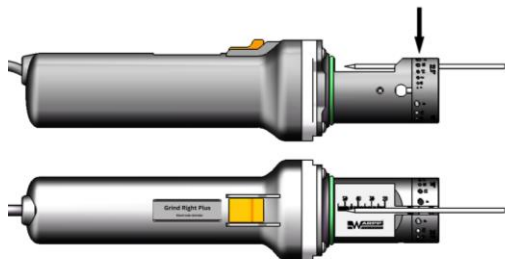
6.4 Facing

Insert the electrode into the corresponding hole, and touch the grinding pad lightly to complete the flat head of the electrode



6.4 Cutting

Cutting the electrode under the scale, then rotate the electrode until it is cut off;



Tip: When grinding, do not use excessive force to make the tungsten needle contact the grinding disc. The way to judge is to listen to the sound.

The sound during normal grinding should be close to the sound when the motor is idling.

If the sound changes significantly, the grinding is in an improper state and the operation must be stopped. First, reduce the pressing force and grind again. If the sound is still abnormal, the equipment should be sent back to the supplier for inspection and

further use is prohibited.

The best results are obtained by applying slight pressure to the tungsten electrode while rotating it on the grinding disc. Remove the tungsten electrode before turning off the machine.

Excessive pressure while grinding can damage the equipment and cause excessive use of the grinding disc; performance will be compromised.

Signs to determine whether excessive force is used: first, check whether the ground cone surface has small flat surfaces (and the cone surface is not round); second, observe whether the color of the tungsten needle is blue or black.

7. Replace grinding disc

Before doing any work on the device, unplug the power plug from the socket!

Grinding discs should be inspected and replaced regularly. Worn out grinding discs will seriously affect the grinding quality.

8. Use of dust cover

The dust cover is an optional accessory. When you purchase parts with a dust cover, please use it as shown below:

First put the dust cover into the fuselage, then rotate it to align the notches with the corresponding holes. .



Note: Frequently cleaning the dust in the dust cover can extend the service life of the machine. :

10. Maintenance



DANGER

Danger of death by electric shock!

Non-observance could result in death or critical injury.

Before maintenance work remove the mains plug.

Weekly/daily

- The tapped holes at the machine always be free of dust, clean if necessary.
- The device may not be moist and may not be used in a humid environment.

- No unbalance in the grinding wheel may occur when the machine is switched on.
- Check whether head and the screw sit firm, if necessary, tighten.
- Check the power supply cable for damage.

Fault elimination:

Fault	Possible cause	Remedy
Motor does not run	Power cable defective.	Replace the power cable.
	Motor defective.	Replace the motor.
Head does not stick	Fastened	Tighten the screw.
The wheel does not rotate	No tension.	Examine tension
	Engine defectively.	Replace the motor.
Unbalance of the grinding wheel when started up.	Grinding wheel mounted incorrectly	Tighten or replace the wheel immediately