



USER MANUAL

INSTRUCTIONAL HANDBOOK



ALLOY WHEEL BLAST CABINET W/ FILTRATION + DUST COLLECTOR

WM700

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INTRODUCTION

This instructional handbook is predisposed according to the DIRECTIVE 2006/42/CE of the Parliament and of the Council of 17 May 2006 on machinery. concerning the drawing nearer of Countries members' legislation regarding the machines. It must be considered integrating part of the machine.

The instructional handbook is delivered together with the machine (in the packing). The receiver (buyer or user) must put it to the complete disposal of people who is responsible, assigned to use of machine. He must provide that this handbook is kept without any possibility of deterioration. It must be always kept unabridged readable, available and easy to reach for consultation for the whole life of the machine.

If this instructional handbook should lose and/or deteriorate, it is possible to request a new copy. Before requesting, it needs to take note of marking dates of plate indicated on point 1.8 Chapter 1.

However, Wheel Restore Company ApS will happily provide additional information not included in this instructional handbook or clarify potential doubts which may arise during the application phase.

OBJECT

This handbook called "INSTRUCTIONS FOR USE" as explicitly mentioned of DIRECTIVE 2006/42 CE, has the object of enabling to the assigned people to know the machine and to use it in a safe and long-lived. It also indicates all the instructions and indispensable measures to be adopted and all necessary humane medium and materials to be predisposed from when the machine is introduced on the market up to its breakage.

The allowed uses and shapes are those which are indicated on the following chapters because they are the only allowed by Wheel Restore Company ApS. Other uses or shapes may be allowed only if before agreed and/or subject of enclosures to this handbook.

People, who are addressee of this handbook, previously defined receiver in a generic way, will be those who, for own competence, have the necessity or are obliged to give instructions or work using the machine.

This handbook does not substitute experience and technical knowledge of assigned people, but it has to be considered a guide instrument while carrying out one's duties.

The assigned people, following the instructions which are contained in this handbook will be able to guarantee the maximum efficiency of the machine for all its life.

STRUCTURE OF THIS HANDBOOK

This handbook is a single volume, written out in a descriptive-figurative jargon to enable a better facility of reading and interpretation. The text often refers to norms, laws, directives rules which should be kept by who uses this handbook.

MODIFICATIONS AND INTEGRATIONS

The handbook reflects the state of art of the time when the machine is introduced on the market and it is its integrating part.

Eventual modifications, improvements, conformings which could be made on the machine successively commercialized, do not oblige WHEEL RESTORE COMPANY APS either to intervene on the machine which is supplied previously or to consider inadequate the machine and relating handbook. However, if WHEEL RESTORE COMPANY APS deems it necessary, the handbooks on the market are subject for revisions, by sending the updated pages of revision to customers. The new pages must be kept in the original handbook.

GUARANTEES AND RESPONSIBILITY

The guarantee for a good working of machine is subordinate to the correct and diligent application of all instruction which are mentioned in this manual. With reference to what is contained in this instructional handbook, the manufacturer declines all responsibility in the case of:

- Unlawful use of safety and accident prevention
- Incorrect pre-arrangement of structures and places where machine will work
- Incorrect or non-observance of instructions which are in this handbook
- Faulty power supply/installation
- Non authorized modifications on the machine
- Use of machine by untrained operators
- Using un-original or in-appropriate spare parts.

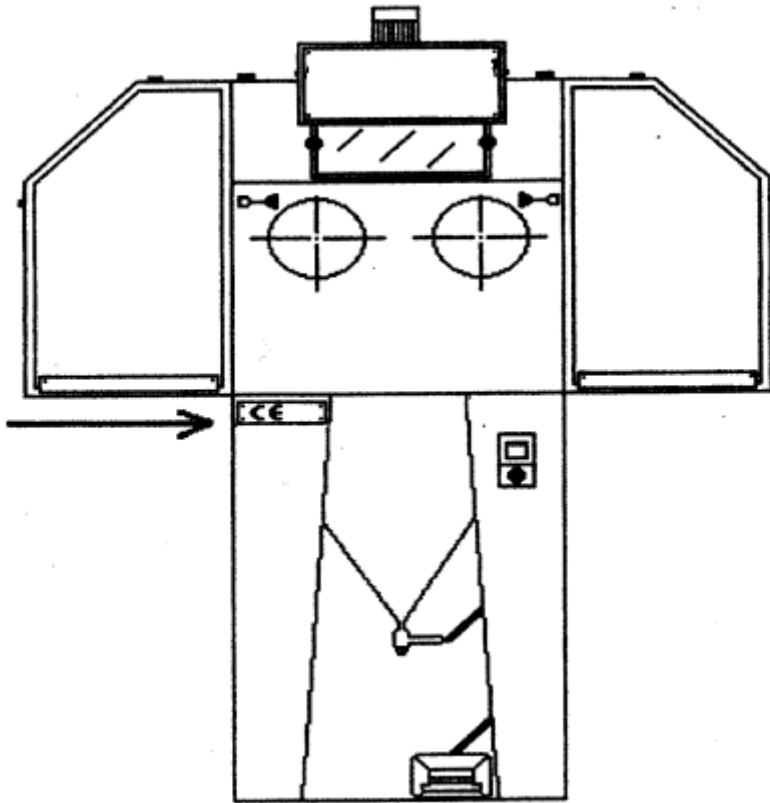
The guarantee consists in the substitution or repairing the faulty piece, FOB our establishment of Støvring, Denmark, after having received it, without any shipping expenses. The guarantee is excluded if sales conditions were not followed.

CONFORMING TO THE DIRECTIVES

Machines are manufactured in conformity with DIRECTIVE 89/392 CEE called "MACHINE DIRECTIVE" and following amendments 91/368 CEE, 93/44 CEE e 93/68 CEE. All part which constitute the machine, are adequate to the requests of DIRECTIVE.

MARKING

The plate of sander is put on the position following indicated. Its content is following described.



the plate must be always kept readable relating to all dates which are indicated on it, providing for cleaning periodically.

PACKING

The machine is packed with transparent thermometrically polyethylene. The opening of packing must be carried out with care: cut the covering, paying attention to do not cut any part of machine and remove the covering without tugs. The material of packing must be discarded according to the laws of own Country.

TRANSPORT

The transport should be carried out by qualified transporters who should be able to guarantee the correct movement of transported good. The manufacturer does not undertake any responsibility in the case transport is ex works.

The transport must be carried out, making sure that:

- the packed machine does not suffer any crushing
- there are no other packages on the machine
- the machine is not exposed to the rain, frost or source of heat
- the machine is not kept in wet places
- the machine is transported as shown in figure, keeping into consideration its characteristics and form.

DISCHARGE AND MOVEMENT

The machine must be discharged and/or moved with lifting equipments, slinging it with chains, ropes etc.. It is necessary to check the suitability of these chains or ropes etc. In the act of discharge and before opening the packing, check the integrity of all parts of machine and inform the manufacturer about eventual faults.

- If the machine will be stored for a long period after working, it is necessary:
- to clean (with much care) the machine, the pneumatic plant and all the pneumatic devices.
- put the machine in a place protected from atmospheric agents.

THE USE OF MACHINE AFTER LONG STORAGE

Before starting up the machine, after a long period of storage, it is necessary to carry out the following operations:

- remove all the packing
- check the conditions of pneumatic devices
- carry out a complete operation of maintenance

USE OF MACHINE

The operator should carefully read the instructional manual before use to understand the possible operations, the limits of use, the offered performances and in order to understand movements and contemporaneity which are allowed. The operator should have also received consistent training by the owner of machine in such a way as to be able to operate in security for himself and for other people. The operator could make sure that machine is placed on the floor in a stable way; pipe of connection between machine and operator is protected in such way as to cannot be crushed or broken and not be a cause of hook. The above mentioned is also valid for pipe of connection between machine and compressed source. The machine cannot expose to atmospheric agents, used in saturated surroundings of smoke or corrosive vapors, or situated near heat sources. The machine must be used only in condition of proved and checked efficiency, observing fully indications which has been given by manufacturer and that are present in this instructional manual.

SAFETY RULES

People that are assigned to use the machine, must be employee of that firm where the machine has been installed and they:

- ✓ must be of age
- ✓ must not have physical impairments which was proved by authorized and qualified institutions
- ✓ must know to react in case of danger
- ✓ The responsible person of Firm must make sure the operator have read this manual and received training
- ✓ Before starting any operation, the operator must have checked all conditions on point 3.1).
- ✓ Before starting up the blasting machine, make sure that in the area (see point 3.1) there are not any objects or things which can deteriorate due to an eventual incorrect use of abrasive jet.
- ✓ Be prudent to make movements during blasting.
- ✓ If the outfeed of abrasive from the nozzle has a different intensity, the operator must leave the foot remote control "O" immediately.
- ✓ Every time it is necessary a maintenance or replacement operation of damaged parts, it is obligatory to disconnect the machine from the compressed air.
- ✓ The air-abrasive jet must not be directed towards oneself, other people, animals or things.
- ✓ The machine must be used only following the instructions which are contained in this manual.

WEIGHTS AND DIMENSIONS

Alloy Wheel Blast Cabinet

Cabinet Dimensions (H×W×L)	750×1100×850mm
External Dimensions (H×W×L)	1800×1150×1300mm
Rotating Table	Ø mm 700
Motor-Driven Exhaust Fan	0.75 HP
Compressed Air Consumption	780 lt/1' – 6 atm
Power Supply	220 – 380 V 3-Phase 50 Hz

Filtration – Dust Collector

External Dimensions (H×W×L)	1890×620×640mm
Filtering surface	3 m2
Cartridge	1 Polyester

TECHNICAL CHARACTERISTICS OF MACHINE

Blasting cabinets are studied for treatment of surfaces with glass microbeads or abrasive. These treatments change from simple cleaning, paint removing of various pieces, at superficial treatment of painting, or not abrasive of for an anesthetic purpose, etc. The blasting action is done with a jet of mixture abrasive/air, generated with effect internal in the aluminum gun, directed at the surface you have to treat. In the blasting machines can be utilized, traditional abrasives (ex. Corundum) or not abrasives materials like glass microbeads or micro ceramic for shot-peening working.



INSTALLATION

Our blasting cabinets are tested and checked in our factory.

They operate with feeding lines that has the following characteristics:

- Triphase line 380Volt/50Hz + Neutro + T, 2KVA for electric connection
- Air compressed line able to guarantee a capacity of 00 lt/1' air with pressure of 7 bar (with standard nozzle of Ø mm.8).

Before making various connections, we suggest you put the machine and its components on a flat place where they are not to be an obstruction or have casual impacts. After having ranged them like mentioned on this manual, you have to do the things that follows:

- 1 Open the electric board and execute the connection of the electric input
- 2 Connect the compressed air input in dehumidifier filter on the back side of the cabinet. We suggest you connect it with a tube of Ø 1/2"to avoid harmful pressure loss.
- 3 Apply the filter bag on the exit (Ø mm.100) of the exhaust fan or cyclone (if assembled), tighten around the clip in dotation.

- 4 In the case the machine is complete with filter cabinet, proceed with connection like indicated on the instruction manual.

Before starting, after having done the above-mentioned connection, be sure that the air that arrived from the line is clean and without humidity. In case dehumidifier filter on the machine is not enough to bring the purpose, it will be necessary put on the back a drier filter or a refrigerator. Then assure you that pieces introduced in the cabinet are clean from water and/or oil.

STARTING OF THE MACHINE WITH CYCLONE

After have executed with attention the things indicated in the chapter "INSTALLATION" proceed opening the door of charge of the cyclone to lodge the abrasive to arrive at quantity of 3-5 Kg., after this, close the door.

Open charge doors and introduce the materials to sand; remember to close, because the security limit switches will take the machine in lock until this operation will be done.

Operate the general switch on the power board so the machine will be fed; successively, by means of the selectors on the power switch, fed the illumination lights of the cabinet and of the cyclone exhaust-fun.

Successively, operating on pressure governor on the front part of machine, increase progressively the pressure work, to arrive to 6-7 bar of the plate, readable on the appropriate gauge. Now you can proceed at work, but you have to take too stopped the gun and actioning the foot pedal placed on low of cabinet.

When you note a decrease of abrasive material, you have to check the level within the hopper, if this is exhausting, provide at its supply.

The blasting will be done as far as the foot pedal will be leaved or will be enter in action one or more security valves that are in the lip of machine.

Our cabinets are provided with, in conformity to the security European Directives, equipment's that are be able to eliminate the action of the machine in case of emergency. In those protections there are the magnetometries switches in the power board, the limit switches placed on the charge doors and the Stop switch.

After having terminate blasting operations, remember to bring on the " " position the general switch and deactivate the alimentation of compressed air.

CLEAN OF THE SLAGS

Blasting and shot-peening machines, during their work emit slags like powder, because glass microbeads and/or abrasive crush and wear out themselves, so they must be collected to avoid their scattering in the environment; is for this reason that there is the necessity to place at the exhaust-fun or at the cyclone a filter bag for their salvage dump.

You have to execute another cleaning operation to discharge the slags contained in the sifter of the cyclone; to do this, open the cyclone door when the machine is turn off and take out the filter sifter, discharge it and reinstatement in its seat. Empty the drawer salvage dump 1-2 times in a week.

MAINTENANCE

ATTENTION, we recommend you, before execute any intervene of maintenance to stop the machine from the electric and pneumatic alimentation lines.

REPLACEMENT OF THE PARTS

Our cabinets are equipped with a visibility window on which are assembled 2 glasses; the first, the exterior, is realized with double thickness, to protect from the possible impacts or unexpected breakages, the other, internal, must be substituted every time when, grounding during working processing, create an obstacle at the view and it risk to break or damage the external glass that normally have not to be substituted.

REPLACEMENT OF THE GLASS

Screw out hand clamp on the frame of the window, hoist this latest and the stratified glass. Then, extract the internal glass and substitute it. After this, close all and execute in the inversed way the operations done before.

REPLACEMENT OF THE GLOVES

If the gloves are damaged you have to replace them. First ease off the hoses clamp, withdraw the gloves and insert the new glove. Finally tighten the clamps.

REPLACEMENT OF THE NOZZLE

During working process, the abrasive causes the wear of the nozzle placed in the gun; when its diameter increase, it causes a great wear of air in the machine and so it must be replaced. To do this, screw out the nut of the nozzle on the gun, replace the nozzle and retighten the nut.

ORDINARY MAINTENANCE

Check periodically the state of the machine, replacing the various parts as soon as you note an excessive wear (guns, tubes, gaskets,etc...).

RISK CERTIFICATE

Wheel Restore Company ApS. declare that own machines are realized with constructive characteristics suitable to the community directives regarding the matter of safety.

Machines are provided with protection against overcurrent's by means of thermic relay and total mushroom stop switch.

Besides on the doors of cabinet are placed suitable security limit switches that inhibit the function of the installation when those are open.

Between the possible risks during work exist the possibility of the bunching of the electrostatic charges caused from the action of the wiping produced from abrasion. This condition is not recurring because it is binded at the variability of the atmospheric conditions and for this is not foreseeable.

To avoid fastidious electrostatics discharges we recommend at the operators to not put on, during the work, metal objects like necklaces, rings, etc...; we suggest you to not put the machine on insulating footboards and to connect the machine at an inadequate grounding system.

The use of the blasting machine is forbidden in fire risk area.

The use of the inflammable and/or explosives powder is forbidden too.

The latest risk can be due from the working of the materials composed from magnesium or from its leagues because dust produced during the abrasion can be explosive; we recommend you to avoid absolutely the working of this material.