



## Manual for HTG-250 VS Grinding Machine

## **Contents**

### **一. Introduction**

- 1.1 Summary
- 1.2 Responsibility
- 1.3 Spare parts
- 1.4 Package Acceptance
- 1.5 Nameplate
- 1.6 Processing and storage
- 1.7 Warranty items

### **二. Safety instructions**

- 2.1 Overview
- 2.2 Operational safety instructions
- 2.3 Electrical safety guidance

### **三. Machine**

- 3.1 Overview
- 3.2 Parts description
- 3.3 Swing lever sub-assembly
  - 3.3.1 Overview
  - 3.3.2 Swing lever angle adjustment
- 3.4 Water valve
- 3.5 Wheel lift bar

### **四. The operation of the machine**

- 4.1 Overview
- 4.2 Position description of machine
  - 4.2.1 Machine working position
  - 4.2.2 Machine packaging

4.2.3 Locations of the handle

4.2.4 Precautions

4.3 The connection of the vacuum hose

4.4 Start and stop the grinder

4.5 Replace the grinding plate

4.6 Replace the diamond tools

4.7 The best grinding route

## **五 Equipment maintenance**

5.1 Overview

5.2. Day check

5.2.1 Check the switch

5.2.2 Check the disc cover

5.3.3 Check the disc

5.4 Overload protection

5.5 Maintenance

5.5.1 Daily Maintenance of machine:

5.5.2 Weekly maintenance

5.5.3 Monthly maintenance

5.5.4 Yearly maintenance

## **6. Frequently Asked Questions and Solutions**

## **7. Technical data**

## **8. Warranty and CE mark**

8.1 Warranty

8.2 CE mark

## **1.Introduction**

### **1.1Summary**

Xingyi machine are used to handle the floor surface. The scope of use of the machine depends on the choice of the tool. In addition to the use and general functions, this manual describes information on the use, repair and maintenance of the grinder. You can contact your local retailer for further information.

### **1.2 Responsibility**

We make every effort to make this manual as complete and accurate as possible, and we are not responsible for any errors or loss of information. Xingyi reserves the right to change the instructions in this manual without prior notice.

This manual is protected by copyright law and cannot be reproduced or used in any part without the express written consent of Xingyi.

### **1.3 Spare parts**

The product mainly includes the following items, if anything lost, please contact the retailer.

- (1) a grinding machine
- (2) a manual
- (3) 3 piece of convert block
- (4) a dust skirt
- (5) a wrench

### **1.4 Package Acceptance**

Carefully check the packaging and equipment for transport damage. If the machine has any signs of damage, please contact the retailer, and report the damage. If the package is damaged, report the packaging condition to the shipping company for damage.

Check whether the delivery meets the order. If you have any questions, please contact the retailer.

### 1.5 Machine Nameplate

	1	
	2	
	3	
	4	
	5	8
	6	9
	7	10
	10	
	中国制造	

- |                       |              |
|-----------------------|--------------|
| 1. model              | 6. voltage   |
| 2. type               | 7. current   |
| 3. company            | 8. frequency |
| 4. manufacturing date | 9. weight    |
| 5. power              | 10. address  |

### 1.6 Processing and storage

The grinding machine should be stored in a dry place at normal temperature when not in use. Otherwise, it may be damaged by condensation and cold. The size and weight of the grinder are given in the technical data.

Note! If the operation is outside of normal procedures, the grinder may be overturned, causing personal injury and damage to the equipment.

### **1.7 Warranty Items**

1.7.1 From purchase date, the problem which is caused by non-human factor during guarantee .

1.7.2 Study Manual items before use, then follow manual items.

1.7.3 Follow complain process and explain problems with detailed photo and video. If it is a quality problem confirmed in written form, Xingyi will offer guarantee machine parts replacement.

#### **Note:**

This warranty covers only manufacturing defects. Xingyi does not assume responsibility for damage in the transport, opening of the box or use. The manufacturer is not liable under any circumstances for damage and defects caused by improper use, corrosion or use beyond the specified specifications. The manufacturer shall not be liable for any indirect damage or expense under any circumstances. For complete information on the manufacturer's warranty period, please refer to the current warranty terms of Xingyi. Local distributors may have special warranty terms for the terms of sale, delivery and warranty. If there are any uncertainty about the warranty terms, please contact your retailer.

## **2 Safety Instructions**

### **2.1 Overview**

This manual sets out the important information for the safe operation of this machine! Must read carefully this manual before using this machine for the first time!

Any non-standard operation or unauthorized modification, maintenance of the machine may cause the machine not work or other losses, and may be dangerous. All work must be done by qualified personnel, and any parts of the machine must be provided by Xingyi.

Xingyi machines can only be used in the way recommended by Xingyi. Xingyi machines can only be used for commercial purposes. Anyone who uses the machine should know its function, the location of the emergency stop, the safety rules that the operator should have to ensure , and when the machine starts, the unauthorized person can not be stationed at work Area.

All workers should be equipped with professional personal protective equipment: safety goggles, protective gloves, safety shoes, breathing masks, hearing, etc., do not wear loose clothes or anything can grasp things such as scarves, bracelets, rings and so on.

**Note:**

1. This machine is only used for surface grinding and polishing.
2. Read and understand the safety instructions of the machine manual. Different models, accessories, control operations are different.
3. This machine operation is only for one person. When machine work, should pay attention to children or unrelated personnel close to the machine, to maintain a certain distance.
4. Without training, poor physical condition prohibit the operation of the machine. Operators and maintenance workers must be physically fit, able to withstand the weight of the machine and the motor-driven work intensity.
5. In the absence of machine operating instructions, do not rent the machine.
6. When using the machine needs to put on the dress, such as dust masks, protective gloves, overalls, helmets, insulated shoes.
7. Body, jewelry and spacious clothes should be kept away from the machine moving parts, or may bring physical damage.
8. Do not arbitrarily change the machine. Can only use the parts provided by Xingyi company for maintenance and changes.
9. Do not use the machine outside in rain or fog.
10. The machine cannot be near the place where there are explosive flammable materials and steam. Do not operate the machine beside dust, solvents, thinner or other flammable materials.

## **2.2 Operational safety instructions**

1. Operators should be equipped with professional personal protective equipment: safety goggles, protective gloves, safety shoes, breathing masks, hearing, etc., do not wear loose clothes or anything can grasp things such as scarves, bracelets, rings and so on.

2. The machine must be determined before the work has been checked the machine, the machine without leakage, no oil, no leakage and so on. The machine can be used normally.

3. Before the operation, we should check the integrity of the machine to ensure that the electric parts is without moisture phenomenon and the operation control switch is in good condition.

4. Make sure there are no obstructions or people in the work area to ensure that there is sufficient lighting in the work area.

5. For the safety of the operator and others, the dust belt must be in place, for the dry grinding must be equipped with a vacuum cleaner.

6. The machine is connected to a suitable electrical outlet. Use only power wires that can withstand high current.

7. Do not adjust any of the joystick movements during machine operation. Only when the machine is stopped and the emergency stop switch has been pressed can the adjustment be made.

8. The machine lever has a different position locking function. The function of these locations in this manual has the picture content description.

9. Replace the grinding plate or accessories, you must ensure that the machine has stopped running and confirm that the emergency stop button has been pressed, if necessary, disconnect the power or pull out the plug.

10. The machine is away from the drain and the mouth or other dangerous goods, otherwise it will cause personal injury or machine, property damage.

11. Hold the handle, turn the emergency stop switch clockwise, turn the front and reverse switch to start the machine.

12. Note that the emergency stop switch can only be pressed or rotated, prohibit upward pull.

13. Check the ground area to be ground before the machine is working, remove any hard objects such as bolts and nails that could cause grinding, machine damage.

14. When inserting the power supply, the machine must determine the working voltage of the machine, the frequency is the same as the input voltage and frequency, and the input power is not missing. (If the input power and the machine does not work the normal power supply, resulting in damage to the machine, do not give warranty).

15. Install the appropriate vacuum cleaner on the suction pipe connection to facilitate dust-free operation.

16. Install the appropriate abrasive. Improper abrasive may cause personal injury.

17. After installing the abrasive, contact the grinding disc with the ground. The handle should be



adjusted to the "upright position". The operator can operate comfortably.

18. The machine jumps "overload protection" implies a problem with the machine (the power cord specification is too small or the voltage is unstable.)

Refer to the recommended power cord specifications below. Or reduce the grinding pressure (without adding iron). (Other losses caused by continuous use of the machine during overloading are not warranted.)

19. After grinding for several minutes, stop the machine to check the wear level. This can effectively save the economic losses due to the use of the wrong grinding.

20. Do not tilt the machine while the machine is still running, otherwise it will cause a personal threat.

## **2.3 Electrical safety Instructions**

1. All circuit repairs can only be carried out by qualified personnel;

2. Note: After the machine is stopped, the line is still energized. Disconnect all power before servicing the machine.

3. The machine is equipped with overload protection device and the overload situation will be display above the control panel, then need to unplug the power, re-plug it can be;

4. Machine current such as overload, must pay special attention;

5. Do not connect or disconnect the wire when it is live or wire.

6. Use of damaged power cords may cause electric shock. Do not use damaged power cords.

7. The wires should be away from the high temperature surface.

8. The dryness of all electrical equipment of the machine shall be maintained and the machine shall be kept in a dry place.

9. Machine motor prohibited water (due to water causes, the other losses caused by the machine and the machine can not work properly manufacturers do not give warranty)

10. The machine must use the manufacturer's specifications for the wire, the voltage specification (the machine label indicates the power supply specifications)!

## **3 Machine**

### **3.1 Overview**

HTG-250VS is used to handle various types of flooring. Used for edge grinding, rough grinding, fine grinding, polishing concrete, natural stone and terrazzo floors or materials specified in this manual or recommended by Xingyi.

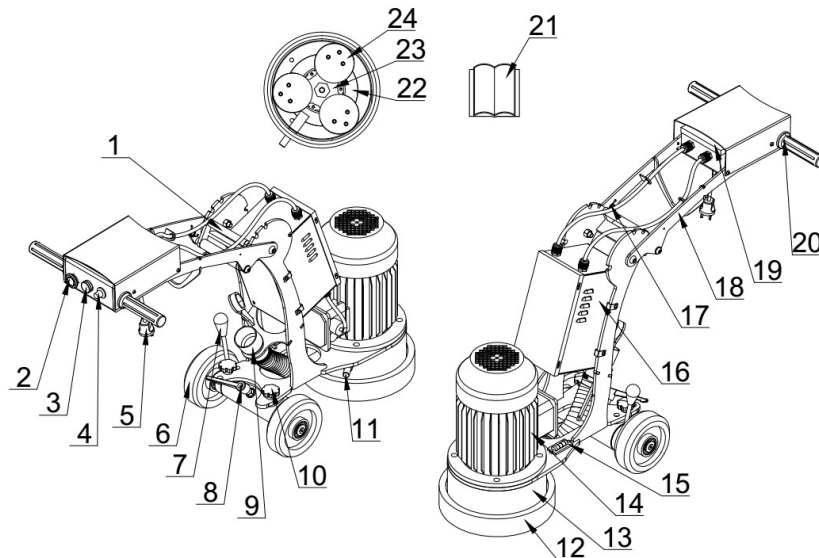
The machine is made up of some of the main components. The handle can be set according to your needs to many different tilt positions. The dust skirt covers the working area of the grinding head area, because it is floating, so all the time it can contact with the floor, not only to ensure that the operator does not touch the rotating mechanical parts, but also to reduce the dust exposure, and improve the dust absorption of vacuum cleaner.

When dry grinding, make sure that a vacuum cleaner is connected to the grinder (preferably equipped with a vacuum cleaner recommended by Xingyi). To prevent dust from being exposed to the air, posing a threat to the health of the operator and nearby people. Due to inhalation of dust is harmful in the course of operation, even with a vacuum cleaner should also bring a good protective mask to protect their own health.

The machine can use different Xingyi diamond tools, according to the ground material, we use different kinds of diamond tools. .

The machine can not only dry grinding can also water grinding, when in the water grinding, after rotate the water switch, it can sprinkle the water on the disc, cooling abrasive, so that grinding more effective. But also to prevent dust, protect the user's personal safety.

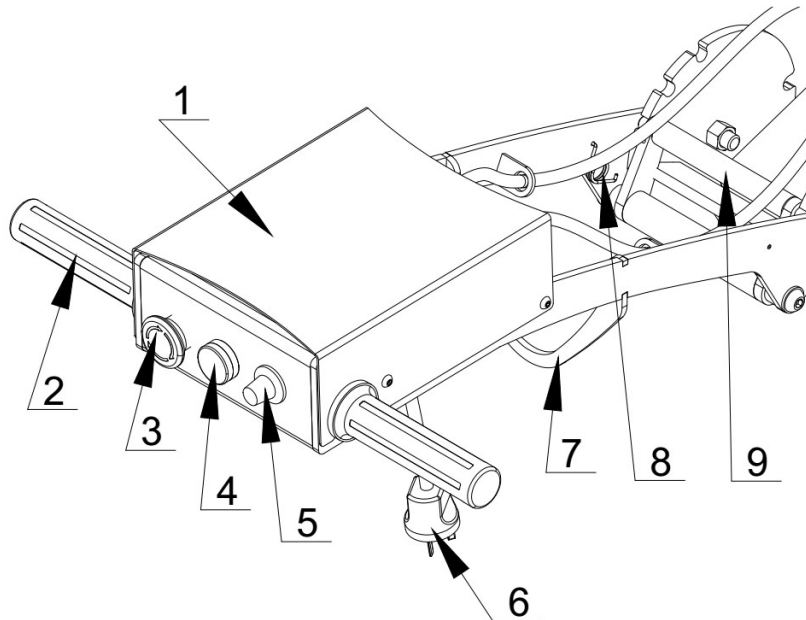
### 3.2 Parts description



- |                            |                            |
|----------------------------|----------------------------|
| 1, swing lock lever        | 13, disc cover             |
| 2, emergency switch        | 14, motor                  |
| 3, start button            | 15, level                  |
| 4, speed control           | 16, inverter box           |
| 5, power plug              | 17, connecting lock spring |
| 6, wheels                  | 18, frame                  |
| 7, wheel adjustment handle | 19, electric control box   |
| 8, wheel fast lock handle  | 20, handle plastic sleeve  |
| 9, vacuum tube             | 21, manual                 |
| 10, angle adjustment knob  | 22, gear box disc          |
| 11, disc lock pole         | 23, convert block          |
| 12, float dust skirt       | 24, disc                   |

### 3.3 Swing lever sub-assembly

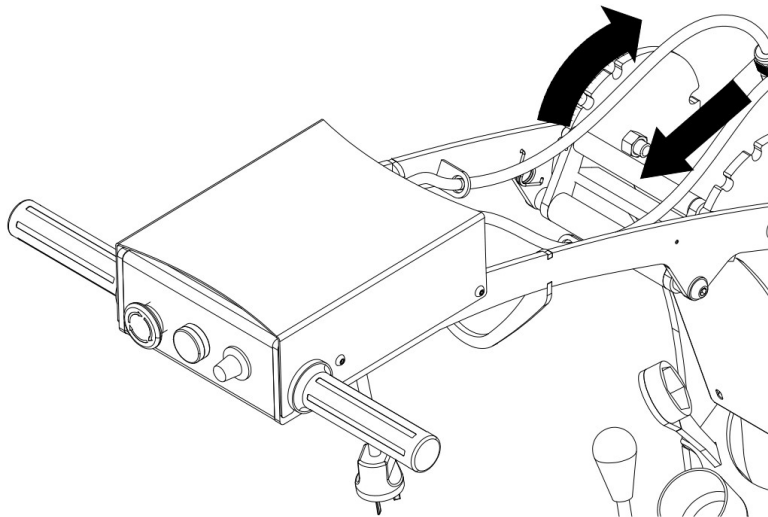
#### 3.3.1 Overview



1. Electric control box: Protects the wires and circuits from contact with dust, and water,
2. The handle: The position where people put them in hand.
3. Emergency switch: When the machine is in a dangerous state or to stop, through the emergency stop switch to cut off the power, stop the operation of equipment to achieve the protection of personal and equipment safety.
4. Start button: need to open the emergency stop switch, and then click the start button can really start the machine.
5. Speed control: mainly used to adjust the motor speed of rotation.
6. Power plug: used to connect the power supply, providing power sources.
7. Vacuum tube frame: the machine and the vacuum cleaner can be connected to the vacuum tube to bypass the bracket, to avoid dust and the ground caused by friction and damage.
8. Connecting lock spring: part of the frame lock lever, mainly used to control the lock lever, making it automatically reset.
9. Swing lock lever: match up with the fan plate can adjust the swing lever to the different position.

### 3.3.2 Swing lever angle adjustment

The swing lever adjustment device is controlled by the swing lever adjustment handle to control the different positions of the swing lever to accommodate the machine placement mode in different states (see Machine Type (see page for post-layout)). One hand hold the handle to support the swing lever, the other hand tighten the swing lever adjustment handle and keep it not move, according to the hole on the fan plate, to swing the swing lever to the desired position, release the swing lever adjustment handle.

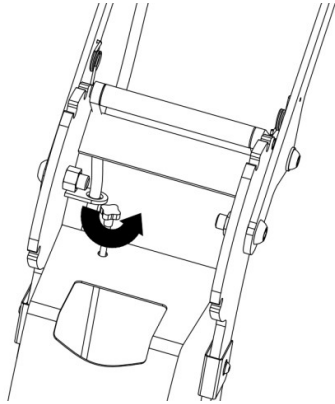


**Note:**

Adjust the swing lever position, you need to check whether the swing lever has been limited, can be manipulated machine.

### 3.4 Water valve

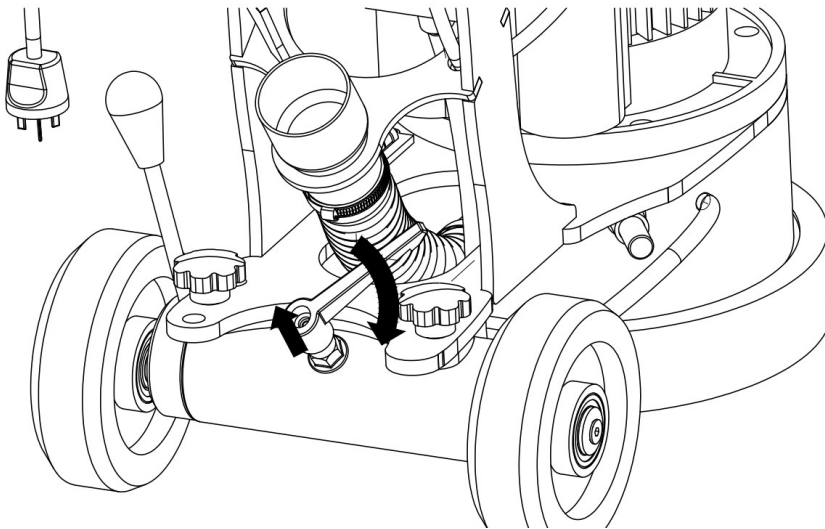
According to the different floor materials, you can choose to use wet or dry grinding way, when chose the wet grinding, you can add moderate amount of water inside the tank. In the process of the wet grinding, rotate the water switch, it can sprinkle on the disc, cooling abrasive, so that grinding more effectively. But also prevent dust, protect the user's personal safety.

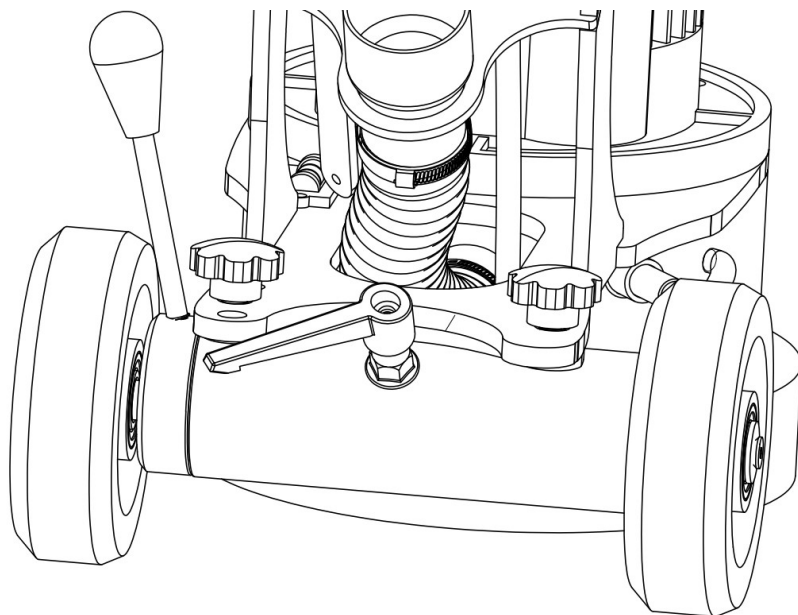


### 3.5 Wheel lift bar

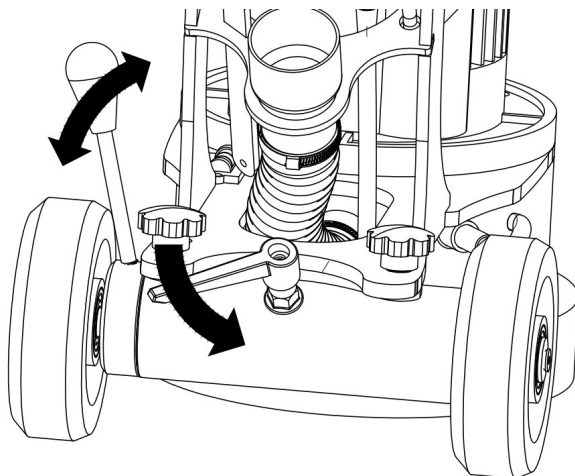
Wheel life bar is mainly to adjust the level of the wheel to adjust the level of the machine.

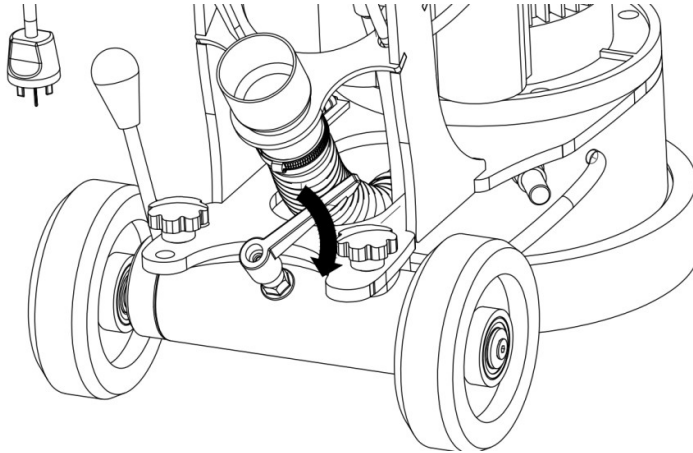
Fast lock handle in order to facilitate the user to rotate, so when the rotation to a certain position is not good rotation, the lock handle up to mention, so that it is rotated to the appropriate location in the operation.





Rotate the lock lever counterclockwise to unlock the wheel with a high degree of lock, then adjust the wheel height adjustment handle forward (or backward) and adjust the wheel height to the proper position to lock the wheel lock lever clockwise.



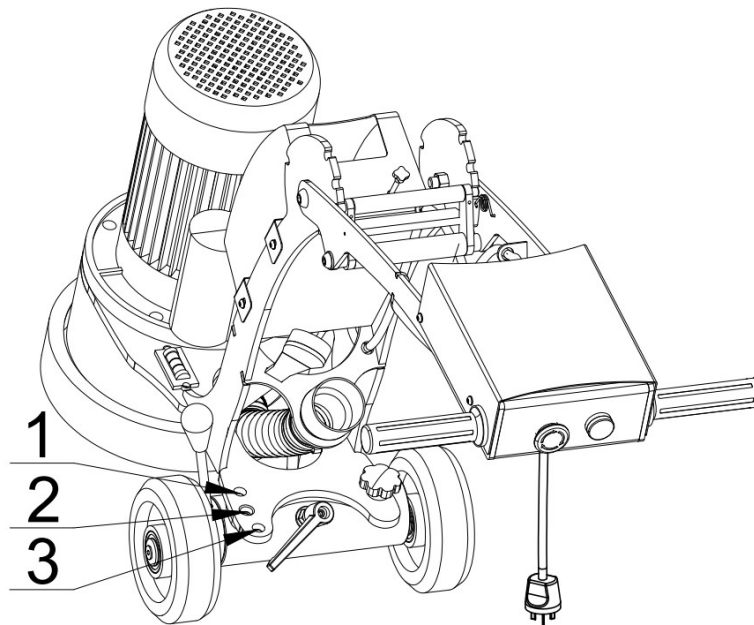


**Note:**

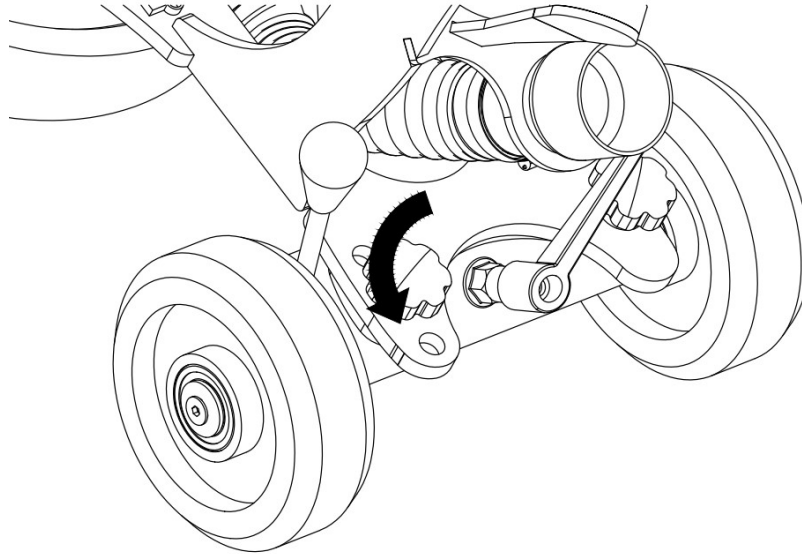
If you want the grinding machine to be in the horizontal grinding position, you can adjust the level of the grinding machine side, adjust the level to the level of the middle of the water droplets to reach the middle of the three sections, which means that the grinding machine has been adjusted to the horizontal position.

**3.5 Machine angle adjustment device**

There are three holes on the floor, respectively, to control the angle adjustment of the machine. To adjust, turn the angle adjustment knob counterclockwise to remove the angle adjustment knob and make adjustments.

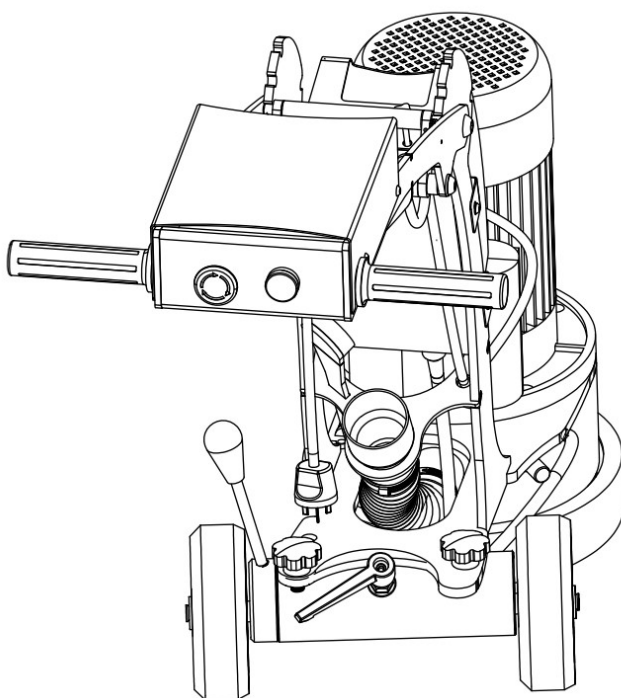
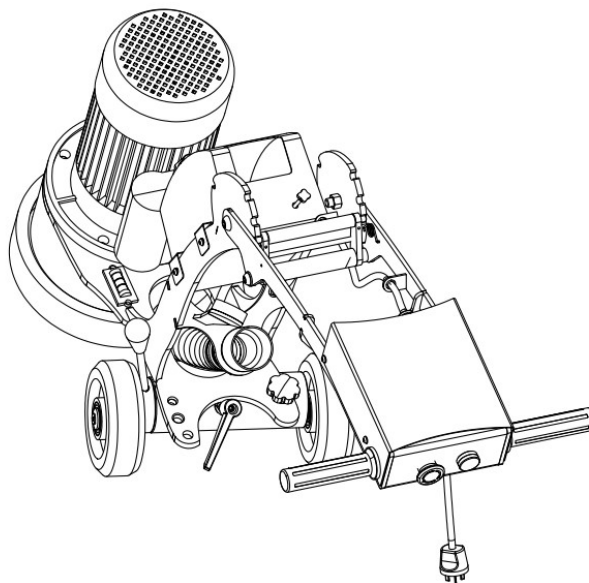






**Position 1:**

Pull the angle adjustment knob, rotate the wheel to align the hole in the hole with the hole, and then position the angle adjustment knob. This position can make the machine disc to the left side, so that the machine grinding process, you can grind the left side of the wall, corner.

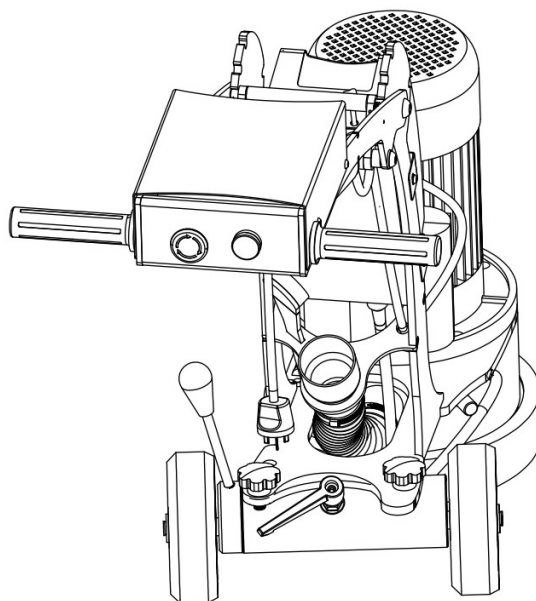
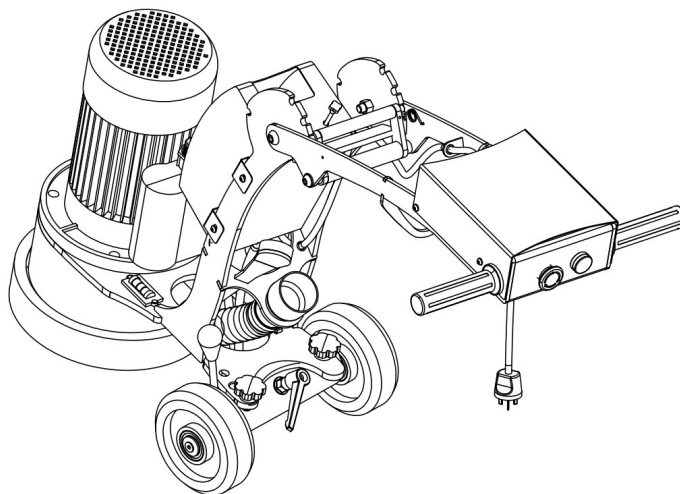


**Position 2:**

Normal grinding, in position 2 position, the main horizontal horizontal grinding, generally not offset. Hold the angle adjustment knob counterclockwise to remove the angle adjustment knob and rotate the wheel unit to adjust it to the horizontal position.

Position 3:

Pull the angle adjustment knob, rotate the wheel to align the No. 3 hole to the hole on the wheel and position the angle adjustment knob. This position can make the machine disc to the right side, so that the machine grinding process, you can grind the right side of the wall, corner.



## **4 The operation of the machine**

### **4.1 Overview**

The following sections describe the different locations of grinder, the main operation and how to install the diamond tools.

Note:

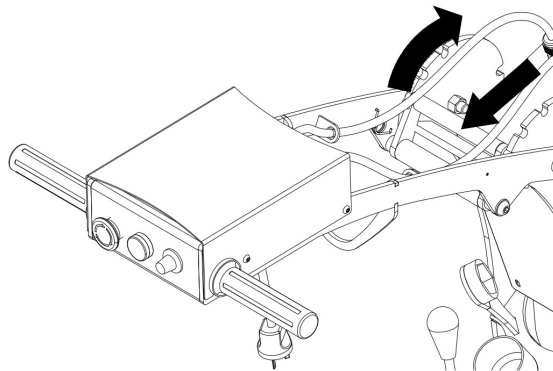
1, The grinder can only be use by the worker who has the necessary theoretical and practical training and has been carefully read the user manual.

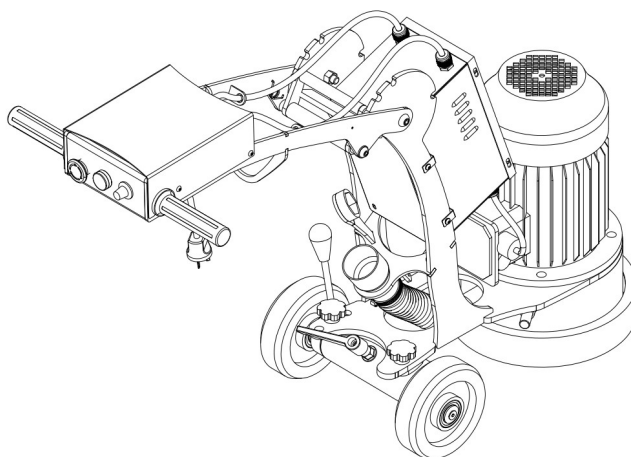
2, When operate grinder, need to use protective equipment, such as protective gloves, protective masks, overalls, helmets, insulated shoes, etc.

### **4.2 Position description of machine**

#### **4.2.1 Machine working position**

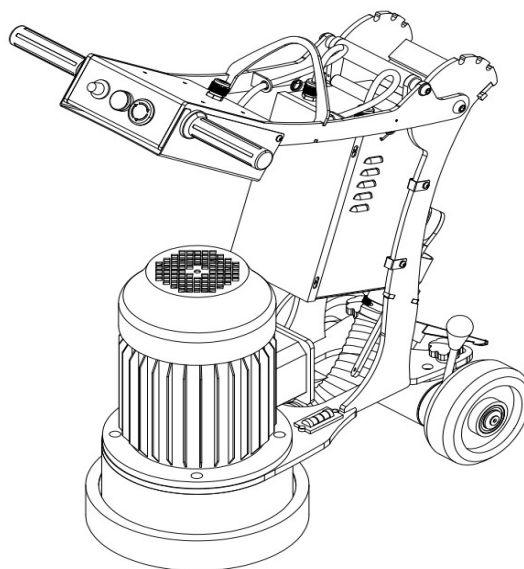
When the grinder work, adjust the handle and swing lever position, to achieve the most suitable working position.



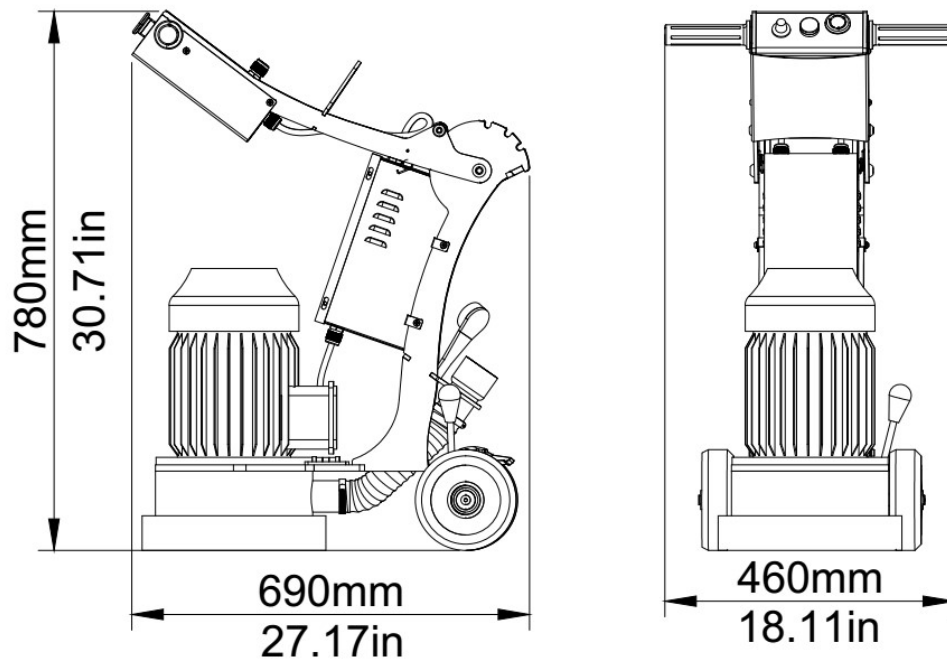


#### **4.2.2 Machine packaging**

When packaging, you can adjust the swing lever, foot pedal, handle position, to reach the packaging position.



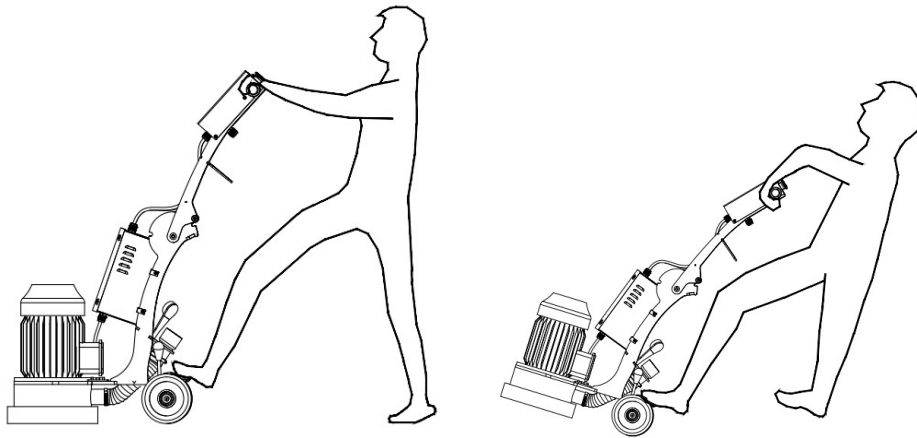
The minimum package size is as follows, and can be packaged according to its size.



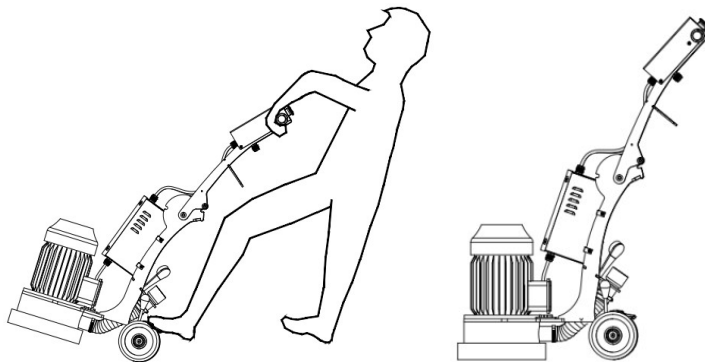
#### 4.2.3 Locations of the handle

Adjust the handle, swing lever position to the machine upright position. (The best recommended location).

Two Hands clasped the handle, one foot on the foot pedal above, forced the machine down.



Put the machine down, you need to hold the handle with both hands, feet on the foot pedal above, use own gravity to balance the machine, put it slowly down to protect the grinding disc. When laying down the machine, pay attention to own strength, do according to one's abilities to ensure the safety. The Company don't charge any loss of equipment or personal injury caused by improper operation.



#### **4.2.4 Precautions**

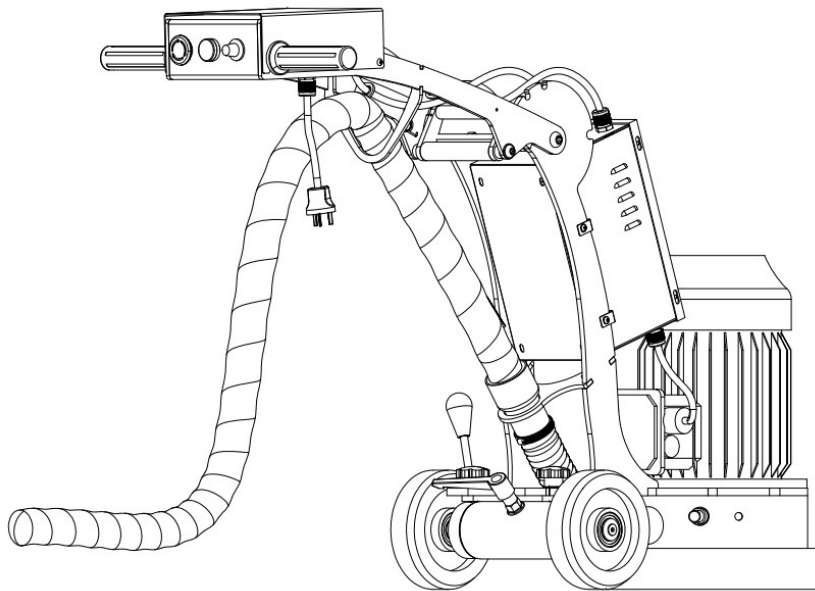
- 1, If there is a operation inadvertently, the machine will be overturned, resulting in equipment damage and personal injury.
- 2, When pull out the latch, sometimes it will be locked, then need to shake the handle.
- 3, At the adjustment process, we must make sure the lock device reset, before the operation of the machine.
- 4, when the machine is located at the transport or packaging position, there is the risk of extrusion, be sure to be careful.

5, At the grinding process, the dust inhalation is harmful, please bring a professional masks in operation to ensure personal safety.

6, At the process of upward and laying down, must pay the attention to own safety, and avoid damage to the machine.

#### **4.3 The connection of the vacuum hose**

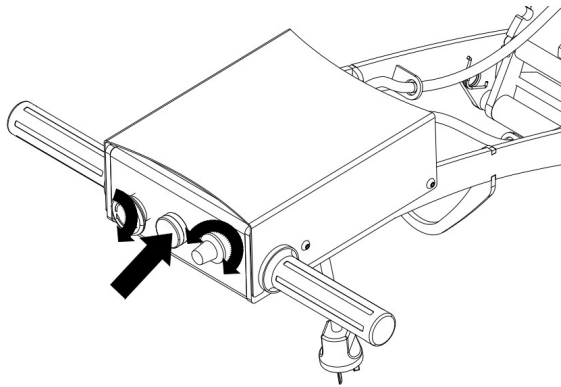
S250 can be connected with the vacuum cleaner, preventing the damage of friction caused by vacuum tube with ground, bypass the frame, as shown below.



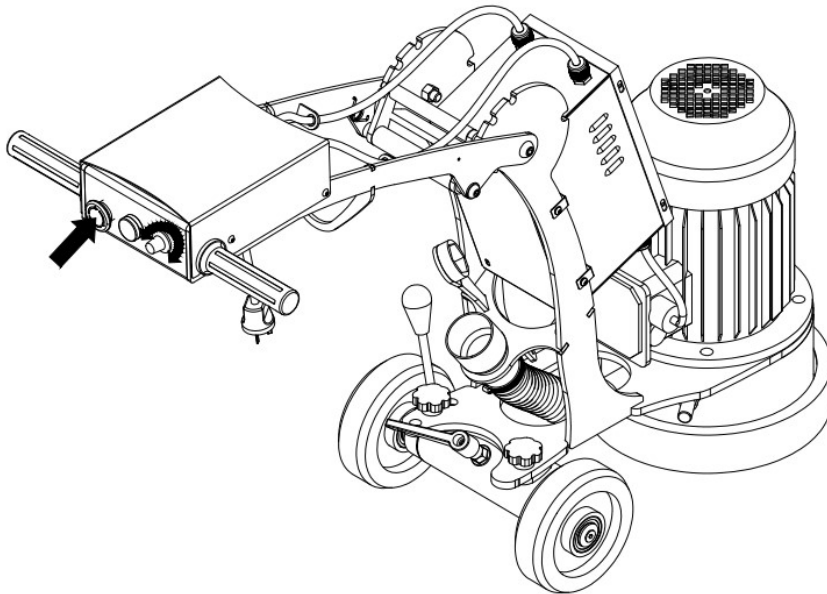
#### **4.4 Start and stop the grinder**

1, Turn on the emergency switch, press the start button, you can start the machine.





2, Stop the grinding machine: pressing the emergency stop switch can stop the machine (remember to turn the motor reversing switch).



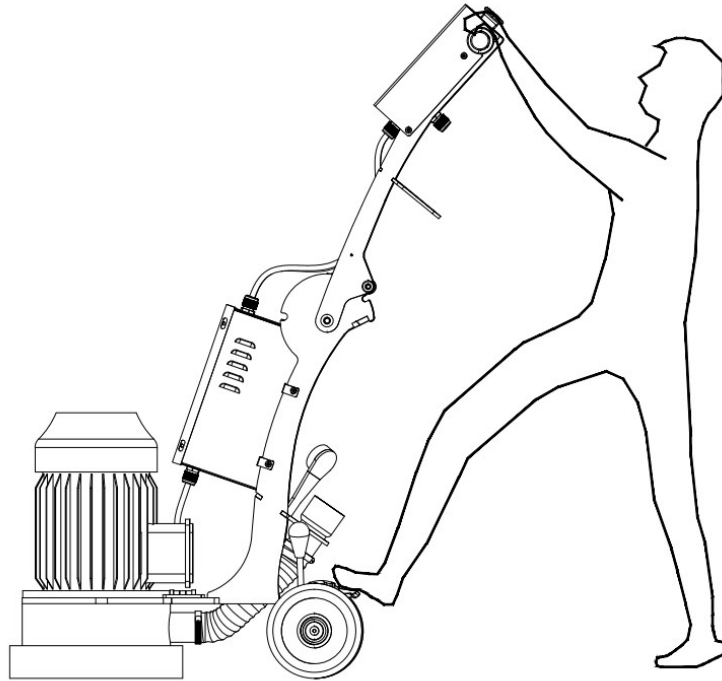
Note: When the machine is stopped, it is recommended to unplug the power supply for safety reasons.

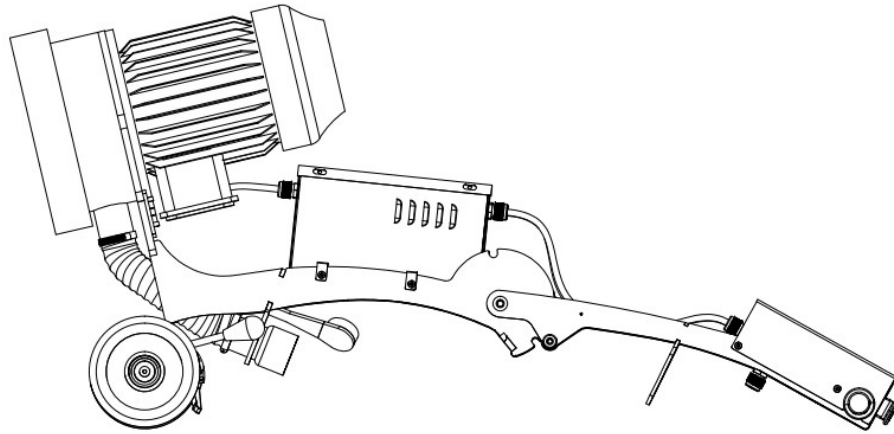
Emergency switch can only follow the emergency stop switch above the rotation and downward pressure, can not pull up.

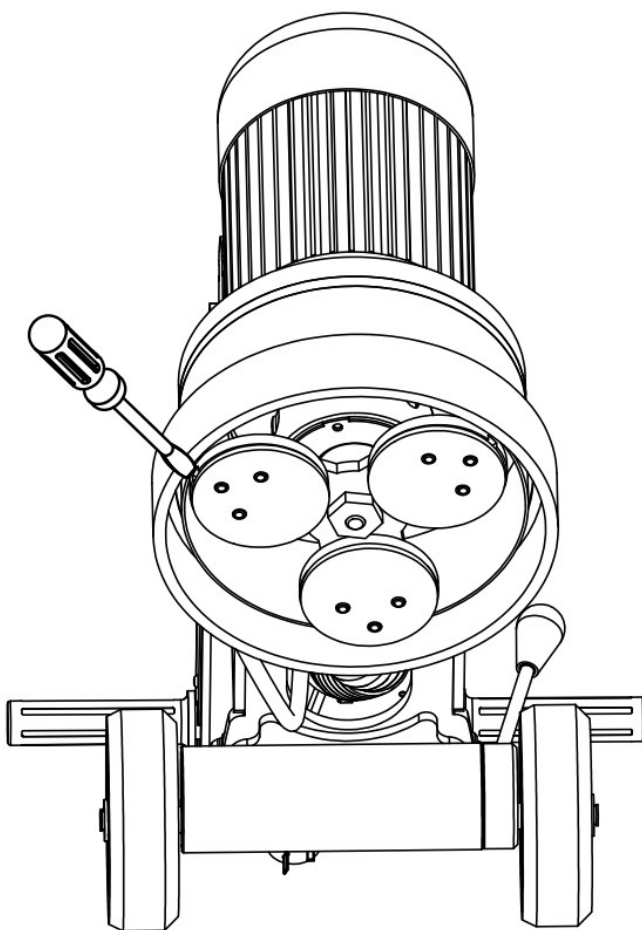
When starting the machine, it is recommended to press the handle, so that the machine slightly upward, reduce the disc pressure, reduce friction between the disc and the ground, for that motor is not overloaded when start the machine.

#### **4.5 Replace the grinding plate**

When changing the diamond tools, adjust the machine to the upward position, then tilt the machine, carefully flatten the machine. After flatten the machine, standing next to the machine, check the machine is stable. Use a flattened screwdriver, blade to replace the grinding plate.

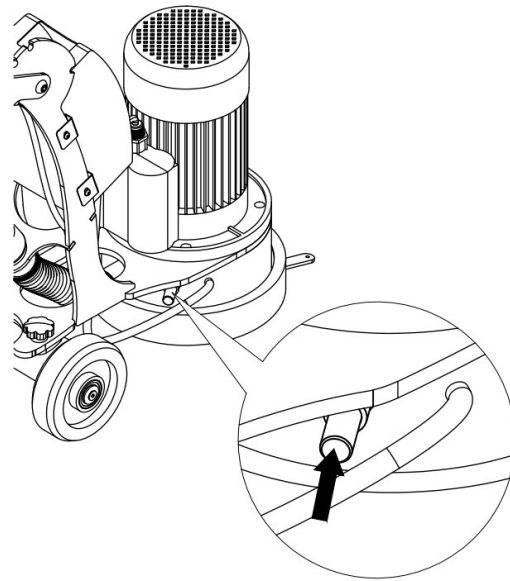
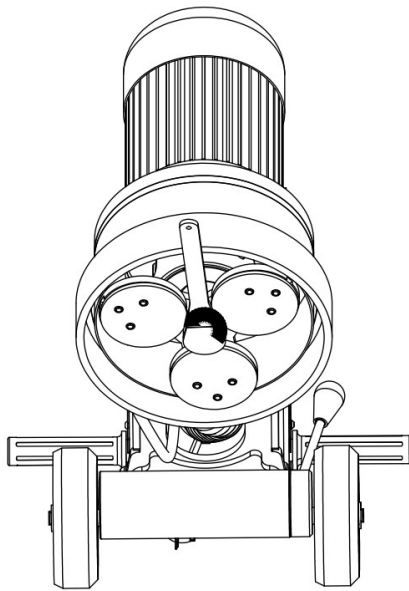
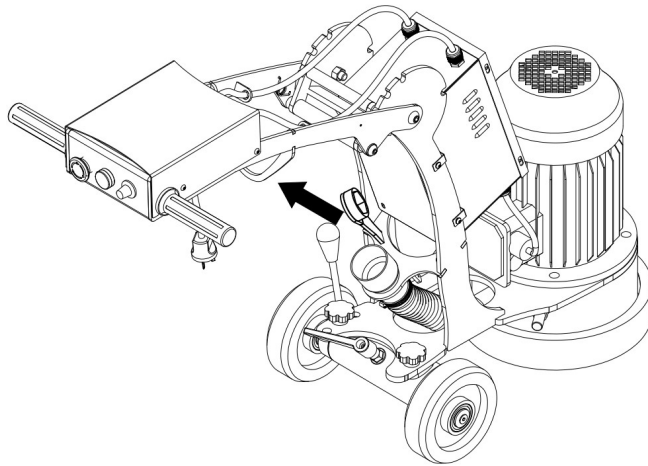






#### **4.6 Replace the diamond tools**

When you need to remove the disc, remember to remove the wrench with the machine, while pressing the disc lock lever to lock the disc, so that it does not turn, while wrench with the wrench on the disc removed. Specific operation as shown below.



#### **4.7 The best grinding route**

When grinding the ground, it should be in accordance with the # word to grind the ground, so the effect will be better. And according to # to grinding ground, it should make the grinding direction is to make the wire more and more farther away so that you can further avoid the interference of the wire to the normal work of the grinding machine.

Note: The above picture machine model can be ignored, only for reference grinding method and winding method.

## **5 Equipment maintenance**

### **5.1 Overview**

We recommend that the grinding machine be checked regularly to extend the service life of the grinder. note:

During the maintenance and repair process, the power of the grinder must be disconnected.

Use protective equipment such as safety shoes, protective gloves, protective masks, etc.

### **5.2.Day check**

#### **5.2.1 Check the switch**

The emergency switch along the rotation of the switch above the spin up, press the start button to start the machine to see whether the machine starts.

Turn on the grinder and press the emergency stop switch to see if the machine stops.

For safety reasons, it is highly recommended that when stop the machine, you press the emergency stop switch, more safe.

When starting the machine, it is recommended to press the handle, so that the machine slightly upward, reduce the disc pressure, reduce friction between the disc and the ground, for that motor is not overloaded when start the machine.

#### **5.2.2 Check the disc cover**

In the condition of much dusk, more easy to cause blocking at the nozzle of suction hose on the disc cover of grinder, flashlight with a flashlight nozzle to see if there is dust jam, if necessary, to clean up. (Add page number after layout).

### **5.3.3 Check the disc**

When the grinder work so long or grind much dust,, the grinding disc part may be stained with dust,too much dust and no timely cleaning will lead to bad connection between the grinding disc and grinding head, cause the bad impact of grinding efficiency , More seriously, it will lead to abrasive fall, cause the accident, if necessary, remember to clean up. (Add page number after layout)

#### **Note:**

For maintenance checks, remember to use protective equipment such as protective gloves, protective masks, insulated shoes, etc.

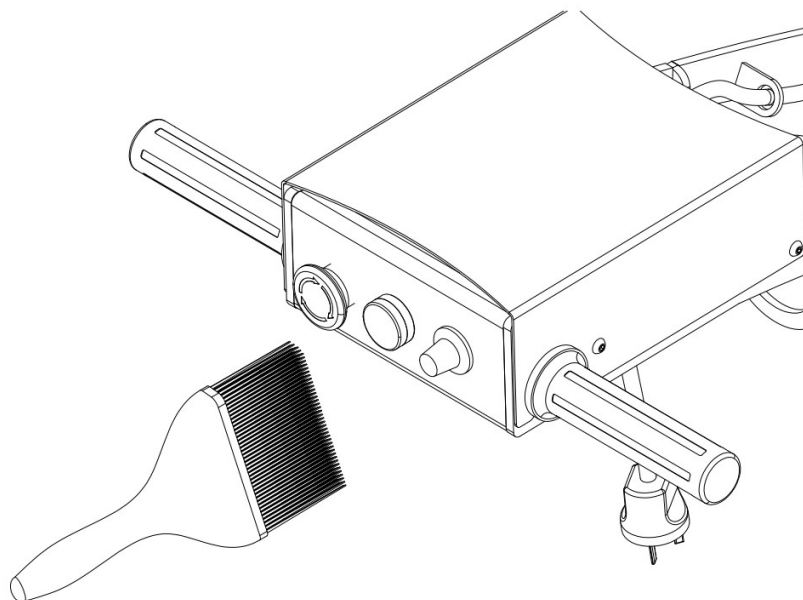
Check the maintenance must be in the emergency stop, unplug the power state can be carried out.

After the machine is in the operating position, remember to see if the machine is stable and then check the operation of the disc.

## **5.3 Cleaning**

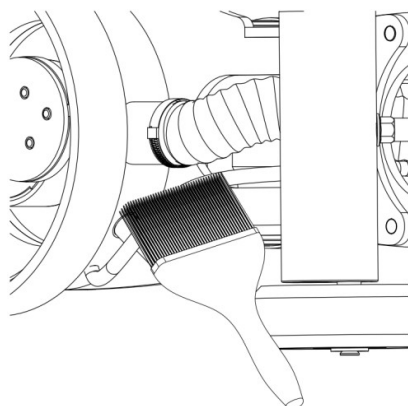
### **5.3.1 Clean the switch**

Working for a long time on the site , the dust will inevitably run into the switch so after each operation of the work, you should check the switch part whether there is dust blocking or not, resulting in switch failure.



### **5.3.2 Clean the disc cover**

Remove the vacuum tube connection, with a flashlight to illuminate the dust nozzle, with a brush to clean the dust nozzle. So that it will not block in the dust nozzle to impact the dust collection efficiency.





### **5.3.3 Clean up the disc conversion block**

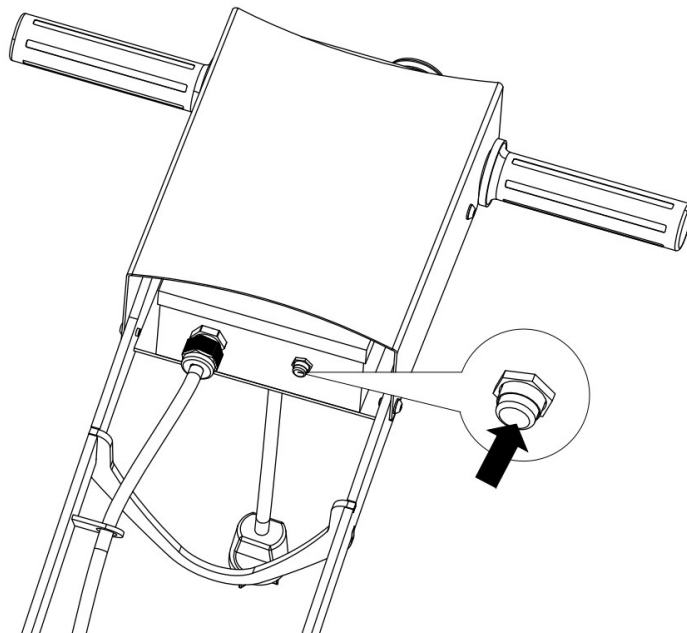
The machine will be raised, take off the diamond tools, use shovel take off dust.

### **5.3.4 Attention**

- 1, Be sure to remove the plug from the outlet and then clean, maintain or assemble it.
- 2, Be sure to clean the entire equipment after the end of the day. Do not use a high pressure cleaner to clean the machine directly.

### **5.4 Overload protection**

Any maintenance that may require repair must be serviced by Xingyi Service Center staff and using Xingyi original parts and accessories for repair. If your machine requires repairs, please contact your retailer.



## **5.5 Maintenance Items**

### **5.5.1 Daily Maintenance of machine:**

Timely replacement when the machine work abnormal, in order to avoid secondary damage, or greater losses.recommended daily implementation

Use only Xingyi parts and accessories, For your own safety, The Safety of others and the life of your machines

1. After finished work, please carry out routine cleaning of the equipment, mainly on the waterproof cover, disc on the sticky ash to clean up, to avoid the impact of the next use and improve the efficiency of the next day.

2. Check the received wires, plugs, sockets are connected or damaged? Whether the received wire meets the dimensions

3. Checking all switches if there are not damage or not

4. Checking the rack to see if it work properly or not?

5. Cleaning the tank to avoid sand in the water tank and checking if the water tank and water switch is normal or not.

6. Checking the dust cover to see if it is damaged or not.

7. Checking all screws if they are loose or not (recommended monthly tightening again, check screws of plate whether they are loose or not).

8. Checking the gear box cover if it is deformed or not.

9. Checking the flatness of gridning disc, and whether screws are loose or not.

10. Checking the cushion to see if it is damaged or not?

11. Checking the gear box whether it is oil spill or not

12. Checking the bottom of the gear box whether it accumulate dust or not.

13. Checking the tire and drive if it is normal or not(such as with drive);

14. Checking before each operation, Check the floor any steel, and such as voltage instability, abnormal sound, suddenly stop, please stop the machine, and feedback error code and take pictures, to avoid secondary damage, it is best to have video of problems.

### **5.5.2 Weekly maintenance**

1. Repeat 1-14 items for routine checking
2. With air gun to clean the dust of the inverter refrigerating fan every week.

Note: Any service to repair must be serviced by Xingyi training staff of Xingyi service center and use the original machine parts by Xingyi. If your machine need to repair ,please contact with your retailer.

### **5.5.3 Monthly maintenance**

1. Repeat daily and weekly routine checking
2. As process to change gear oil, new machine normally use 500 hours or 6 month to change the gear oil first time, after that every year or 1000 hours change one time.
3. Clean decompressor hole if have.
4. Machine should be maintained by professional technical and specialist, and might be registering what you maintained.
- 5) Using the oil rod which Xingyi provide to Measure the amount of gear oil every month, The amount of oil should be higher than the scale 5 on the rod position, If not, Please add more until the amount of oil reaching to 5 scale.

### **5.5.4 Yearly maintenance**

1. Repeat the daily, weekly, monthly routine checking.
2. Changing gear oil, cushion sponge, bearing, oil seal.
3. Machine should be maintained by professional technical and specialist and recording what you maintained.

**Note:**

Any maintenance that may require repair must be serviced by Xingyi Service Center staff and using Xingyi original parts and accessories for repair. If your machine requires repairs, please contact your retailer.

## 6. Frequently Asked Questions and Solutions

This chapter describes some of the possible failures and how to handle them. If you still can not resolve or have an error, please contact your nearest retailer.

Problem	Potential cause	Solution
The machine does not start	The emergency stop switch is pressed	Open the emergency stop switch
	overloading	Unplug the power plug directly and insert again.
	Power and power cables are damaged	Contact licensed electrician
	The switch knob of machine is damaged	Make sure the wires are properly connected to the rear button, check the contacts with the ignition button
	Output voltage does not match	Adjust match-able voltage
	Improper wiring	Check the wiring and terminal of power input
	The Inverter is damaged	Repair or replace the inverter
	The motor is damaged	Repair or replace the motor
The machine uttered a low buzz when turn on and turn off	There is dust in the motor impeller	Contact licensed electrician
	Motor burnt out	Contact licensed electrician or Check whether the input p
	Phase loss input, currently only two phase inputs. Turn	Contact licensed electrician or Check whether the input power is

	off the machine to avoid burning the motor	three-phase
The machine is difficult to control or the motor current is consumed	The machine below the diamond is too small or the wrong tool type is applied	Use xingyi recommend numbers of diamonds to reduce the stress on the grinder and the operator
Machine beating unevenly	Diamond may not be properly installed or highly different	Properly install diamonds with the same height
	The chassis is flat or not	Adjust the installed chassis
Machine forward, backward out of control	machine clutch key is break or there is no clutch	change or install new clutch key
	check the PLC is running or not	contact with factory to repair
	cable is loose or not	Contact licensed electrician
	wheel or drive connector key is damage or not	check and contact with factory to repair and change the key
The speed of machine can't be adjusted	1. Error setting of inverter parameter 2.Speed control potentiometer is damaged 3. Short-circuits or open circuits of connection control line	1.Reinstall inverter parameters 2.Replace potentiometer 3.Replace control line
The machine has abnormal sound during working	1.The rubber pad of machine is damaged which causes the collision of grinding plate 2. The lack of lubrication oil 3. The bearing or drive shaft of machine is damaged	1. Replace new rubber pads 2. Add lubrication oil 3. Replace the bearing or drive shaft

Skewing during operation	<ol style="list-style-type: none"> <li>1. The moving wheel is not parallel with the grinding disc</li> <li>2. Grinding disc is not at the same level</li> <li>3. Different abrasives specifications or height differences between abrasives</li> </ol>	<ol style="list-style-type: none"> <li>1. Set the moving wheel at the same level</li> <li>2. Set the grinding disc at the same level</li> <li>3. Replace the same specification and same height abrasives</li> </ol>
Shaking during operation	<ol style="list-style-type: none"> <li>1. The moving wheel is not parallel with the grinding disc</li> <li>2. Grinding disc is not at the same level</li> <li>3. Different abrasives specifications or height differences between abrasives</li> <li>4. Looseness of box mounting bolts</li> </ol>	<ol style="list-style-type: none"> <li>1. Set the moving wheel at the same level</li> <li>2. Set the grinding disc at the same level</li> <li>3. Replace the same specification and same height abrasives</li> <li>4. Tighten the box mounting screws at a appropriate state</li> </ol>
Machine plumbing barrier	<ol style="list-style-type: none"> <li>1. Water switch is damaged</li> <li>2. Some dirt in the water pipe and water tank</li> <li>3. Warping of water pipe</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace the water switch</li> <li>2. Clean up the water pipe and water tank</li> <li>3. Replace the water pipe</li> </ol>
Leakage of machine body	<ol style="list-style-type: none"> <li>1. Error wiring</li> <li>2. The electric control box is wet</li> <li>3. The motor is wet which cause low insulation ability</li> </ol>	<ol style="list-style-type: none"> <li>1. Check if the ground wire is connected</li> <li>2. Keep the electric control box dry</li> <li>3. Seek professional for help</li> </ol>
The abrasives break away from the grinding disc easily	<ol style="list-style-type: none"> <li>1. The abrasives do not match the grinding disc</li> </ol>	<ol style="list-style-type: none"> <li>1. Install the right abrasives</li> <li>2. Replace the sticky disk or the</li> </ol>

	<p>2.The grinding disc is old and has no adhesion</p> <p>3.Poor flatness of the construction ground and the speed of machine is too fast</p>	<p>gluing of sticky disc</p> <p>3.Adopt magnet grinding disc or tighten the abrasives and slow down the speed</p>
Poor dust collecting during wet polishing	<p>1.Dust collection tube is damaged</p> <p>2.The dust cover is damaged or in improper installed which causes the loss of vacuum</p>	<p>1.Replace the dust collection tube</p> <p>2.Replace the dust cover and make sure the right installation</p>
Oil leakage on transmission shaft	<p>1. The bearing is damaged</p> <p>2..The sealing element is old or damaged</p> <p>3.Something in the transmission shaft</p>	<p>1.Replace the bearing</p> <p>2.Replace the sealing element 3.Pay attention to maintenance and remove the sundries</p>
Different consuming of abrasives	<p>1. The rubber cushion is old or damaged</p> <p>2. The grinding discs are not at the same level</p> <p>3.The cushioning spring is damaged</p>	<p>1.Replace the rubber cushion 2.Set the grinding discs at the same level</p> <p>3.Replace the cushioning spring</p>
Great calorification of motor	<p>1. Unstable input voltage</p> <p>2.Incorrect wiring</p> <p>3.Looseness of connection</p>	<p>1.Adjust to a stable input power</p> <p>2.Replace match-able wiring</p> <p>3.Fastening terminal</p>
Malfunction of emergency stop button	<p>1.The emergency stop button is damaged 2.Short-circuits or open circuits of connection cable</p>	<p>1.Replace the emergency stop button</p> <p>2.Replace the connection cable</p>

Polishing pads easy to come out	the bolt which connect with grinding plate and conversion block is broken	Changing the bolt which connect grinding plate with conversion block, in the same time, the segment do not stick foreign things.
---------------------------------	---	--

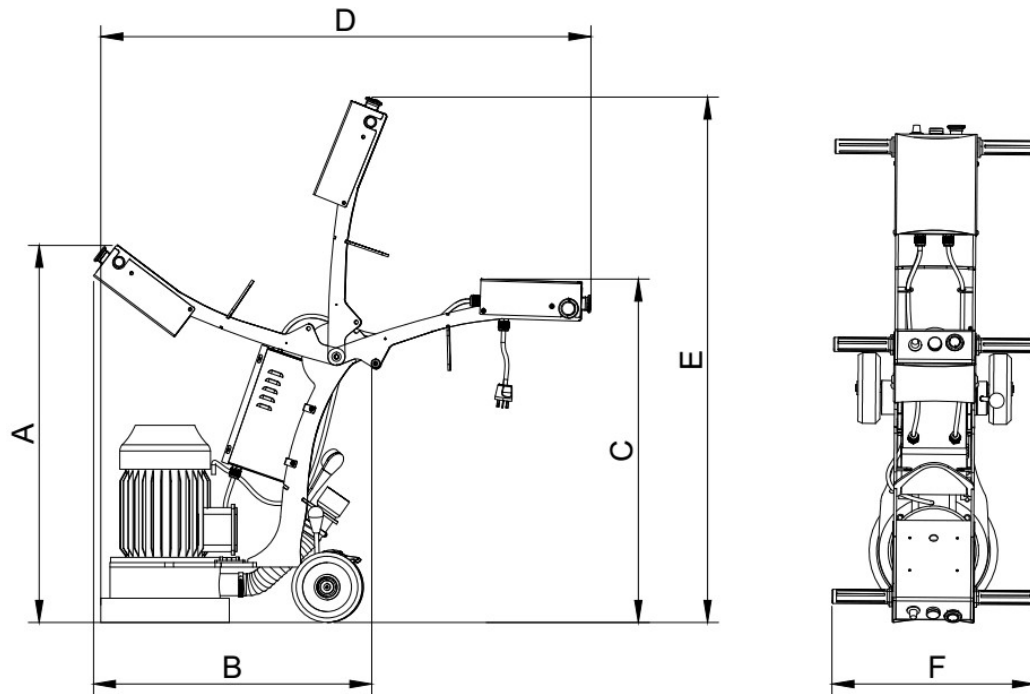
## 7 Technical data

The table and picture show the technical data and dimensions of the grinder

	250 01201706-24	250 01201706-25
Engine power	Performance 2.2KW/2.95hp	
Rated voltage	single phase 220V	
Rated current	13.75A	
Enter Hertz	50HZ	60HZ
Inverter	3.7 KW/5HP	
Grinding width	292mm/11.50in	
Working width	250mm/9.84in	
Rotating speed	1735 r/min	1440 r/min
Size (from Alice position) Length x Width x Height	780 × 460 × 1180mm/30.71 × 18.11 × 46.46in	
Size (working position) length x width x height	1060 × 460 × 880mm/41.73 × 18.11 × 34.65in	
Packing size length x width x height	690 × 460 × 780mm/27.17 × 18.11 × 30.71in	



The longest x the widest x the highest	1108 × 460 × 1188mm / 43.62 × 18.11 × 46.77in
Total Weight	69.5kg
Wire type	1.5mm <sup>2</sup>
storage temperature	-20 ~ +60°C / -4 ~ +140°F
Operating temperature	-10 ~ +40°C / +14 ~ +104°F
humidity	95%below(no condensation)



## 8 Warranty and CE mark

### 8.1 Warranty

Warranty includes only manufacturing defects. Xingyi does not bear the occurrence of damage or occurs in the transport, out of the box or use. In no event shall the manufacturer, under any circumstances, be liable for damage and defects caused by improper use,

Use only Xingyi parts and accessories, For your own safety, The Safety of others and the life of your machines

corrosion or use of specifications beyond the specified specifications. The manufacturer shall not be liable for any indirect damage or expense under any circumstances. For complete information on the manufacturer's warranty period, please refer to the current warranty terms of Xingyi.

Local distributors may have special warranty terms for the terms of sale, delivery and warranty. If you have any uncertainty about the warranty terms, please contact your retailer.

## **8.2 CE mark**

CE mark the product to ensure its free activities in the EU region in accordance with EU regulations. The CE mark also ensures that the product meets a variety of instructions (EMC directives and other possible requirements in so-called directives, new procedures, in accordance with these regulations). The unit has a low voltage command in accordance with CE (LVD), mechanical instructions and electromagnetic compatibility instructions. Electromagnetic compatibility instructions, electronic equipment shall not interfere with the surrounding electromagnetic interference environment, must also be immune to the surrounding electromagnetic interference.

Please refer to the manufacturer's Declaration of Conformity, indicating that the machine is in compliance with the EMC Directive.