



Manual For HTG-680 Pro Floor Grinder Polisher

1 Introduction

1.1 Summary

Xingyi machines are used to handle the floor surface. The scope of use of the machine depends on the choice of the tools. 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.

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1.3 Spare parts

Below accessories are included with the grinder. Contact your supplier if anything is missing.

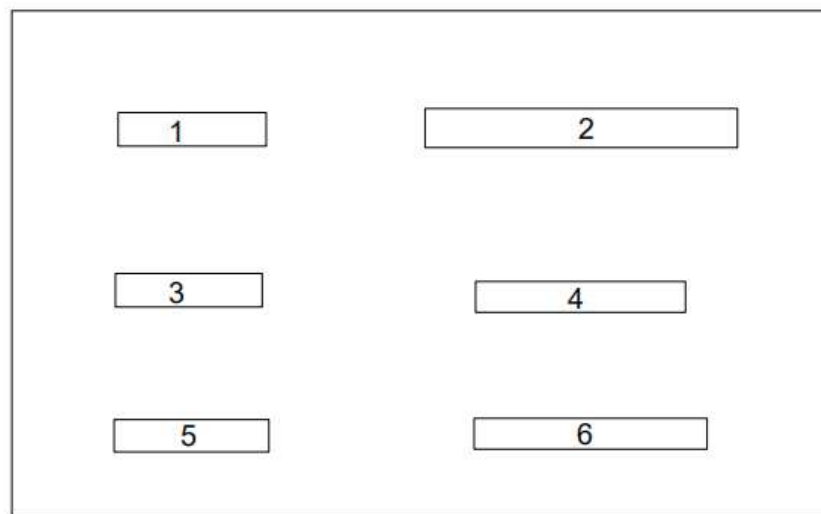
- (1) 1 set of grinding machine
- (2) 1 copy of machine using manual
- (3) 1pcs of socket
- (4) 1pcs of dust skirt
- (5) 1pcs of key of electric control box
- (6) 12pcs of 4" velcro-iron accessories (another 12 are installed on the machine chassis)

1.4 Package acceptance

Check carefully to see if the package or the grinder has been damaged during delivery. If there is any sign of damage, contact your supplier and report it. If the packaging is damaged, report the damage to the shipping company.

Check that the delivery matches the order. If there are any discrepancies, contact your supplier.

1.5 Machine nameplate



1. Model

2. Manufacturing date

3. Power

4. Voltage

5. Weight

6. Rotating speed

1.6 Handling and storage

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

1.7 Warranty items

This warranty covers only manufacturing defects. Xingyi does not assume damage in the transport, unpacking or operation. The manufacturer is not responsible for any damage or defects caused by improper use, corrosion or use of specifications beyond the noted specifications. The manufacturer shall not be responsible 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 retailer may have special warranty terms. If you have any uncertainty about the warranty terms, please contact with your retailer.

2. Risk list

2.1 General safety instructions



Warning: Please read the following contents carefully before using the machine.

1. This manual lists the significant information for machine safety operation. Read the manual carefully before your first operation.
2. This product must not be operated unless the operator has read and understood the contents of the manual.
3. Never rent a machine without the machine's operating instructions .
4. Please comply with local laws and regulations when using this device.
5. All work must be completed by trained and qualified professionals . Operators should ensure safety and prevent dangers during operation .
6. Do not operate this device when you are tired, sick, or under the influence of alcohol or drugs and are in poor physical condition.
7. Keep this device out of the reach of children.

8. This machine only need one person.The equipment should pay attention to the children or unrelated personnel close to the equipment, maintain a certain working distance and keep in mind "one machine one person "
9. Do not modify products without authorization, and do not use illegally modified products. Only personnel designated by Xingyi Company can perform repairs and modifications using accessories only provided by Xingyi Company.
10. Products should be kept clean and ensure you can read markings and labels clearly.
11. Make sure that the products you use are in good condition and undamaged to ensure safe use.

2.2 Operation safety instructions



Warning: Please read the following contents carefully before using the machine.

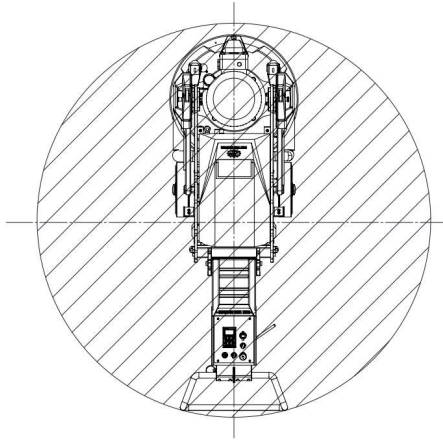
1. Operators should wear protective equipment when using the machine .
2. This machine is only used for floor surface grinding and polishing, please do not use it on other occasions.
3. Xingyi machines can only be used in the ways recommended by Xingyi. Please read and understand the operating instructions in the machine manual. Different models have different accessories and control operations, and incorrect operation methods may cause safety problems.
4. This machine must be operated in places with a slope of less than 20° . Our company does not assume any responsibility for accidents caused by operation when the slope is greater than 20° .
5. When the grinding machine is working, the operator should not leave the machine and ensure that the machine works normally within sight.
6. When leaving this product, press the emergency button and disconnect the power cord.
7. Before operation, ensure that the dust skirt is installed to prevent dust from being inhaled into the lungs and causing damage, and to prevent the soles of the feet from accidentally touching the grinding disc.
8. Do not pull the vacuum hose to prevent the machine from tipping over and causing injury.

9. When operating, ensure that the machine is in a safe and stable position to prevent personal injury during operation.
10. The body, hair, jewelry and loose clothing should be kept away from the moving parts of the machine, otherwise it may cause physical injury.
11. When you find that the machine is working abnormally, such as abnormal vibration, abnormal noise, etc., you should immediately stop using the machine and check whether the machine is damaged and repair it through an authorized dealer or maintenance person.

2.2.1 Personal protective equipment

1. When operating this equipment, be sure to wear standard personal protective equipment to reduce the risk of an accident.
2. Do not wear loose clothes or anything that can grasp things such as scarves, bracelets, rings and so on. When operating the machine, your hair must be tied up to prevent your hair from getting caught in the machine and causing damage.
3. Certified protective glasses must be worn to prevent dust or foreign objects from damaging your eyes.
4. Certified rubber protective gloves must be worn to ensure a secure grip and prevent wet concrete from harming the palms.
5. Certified safety shoes must be worn, with steel toe caps and non-slip soles to avoid slipping and ball-on-foot handling.
6. The machine will produce noise and dust when working. Protective earmuffs and masks must be worn to prevent noise from damaging the ears and dust from being inhaled into the lungs and damaging the respiratory tract.
7. A certified protective helmet must be worn.
8. It is necessary to ensure that there are fire extinguishers, first aid kits and other supplies at the work site to prevent accidents.

2.2.2 Work area safety



1. As shown in the picture above, no one other than the operator is allowed in this area, and operators in this area should be particularly careful during operation.
2. Do not use the machine in other harsh environments such as rain, lightning, dense fog, strong winds, etc.
3. There should be no explosive and flammable materials and steam near the machine when operating. Do not operate this machine near dust, solvents, thinners or other flammable materials.
4. Check the ground area to be ground before equipment work, and remove any hard objects such as bolts and nails that may cause damage to grinding discs and equipment. Hard objects such as steel bars and expansion screws that protrude from the ground should be cut out of the ground using a cutting machine in advance. part cleaned up.

2.3 Electricity safety instructions



Warning: Please read the following contents carefully before using the machine.

1. All circuit repairs can only be carried out by qualified personnel.
2. After the machine is stopped, the line is still energized. Disconnect all power before servicing the machine.
3. The machine is equipped with an overload protection device and it will automatically jump off when the machine is overloaded, to prohibit the machine from running (re-adjust this overload in case of safety).

4. Continue to use the machine in the overloaded situation may cause some other losses even machine can't work normally, then manufacturer's warranty is unavailable.
5. The purpose of installing an inverter in machine is to speed and protect the user and the machine. It is forbidden to modify or adjust the inverter and modify the inverter parameters without the manufacturer's consent. If the unit fails, it is only allowed to replace the defective parts with the accessories provided by the manufacturer (Other loss caused by changing, adjusting or modifying the inverter parameters without the manufacturer's consent, and the machine is not working properly, the manufacturer does not afford warranty).
6. Never modify the parts or lines inside the inverter by yourself.
7. Do not operate the machine when the distribution box is turned on.
8. If the machine current is overloaded, please pay special attention.
9. When the cables are energized or loaded, do not connect or disconnect the wires.
10. Using a damaged power cord may result in electric shock. Do not use a damaged power cord.
11. Cables should be kept away from hot surfaces.
12. The dryness of all electrical equipment should be maintained and the machine should be kept in a dry place.
13. After the power is turned off, before the panel indicator is off, it indicates that there is still high voltage inside the inverter, which is very dangerous. Do not touch the uninsulated electrical equipment.
14. The machine motor and the frequency conversion box are prohibited from entering water; (the other damage caused by the water inflow then the machine is not working properly, the manufacturer does not afford the warranty).
15. The machine must be connected to the qualified wire and voltage, specifications are noted by the manufacturer. (The machine label indicates the power supply specifications).

2. 4 Safety warning signs



Please read and understand the instructions before using this device.



You must wear earmuffs and protective glasses to avoid ear damage from noise and foreign objects.
Eye.



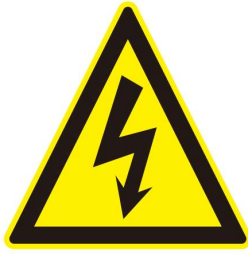
Protective masks must be worn to avoid dust inhalation and damage to the lungs.



Make sure that all parts of the equipment are complete and all screws are tightened, otherwise personal injury may occur.



Insulating rubber shoes must be worn, otherwise there may be a risk of electric shock.



High voltage is dangerous, please do not open it, otherwise it may cause personal injury.



Danger warning, please pay attention to the text description below this icon to avoid danger.



This is the hook.

3.Machine

3.1 Overview

HTG-680PRO is used to treat various types of floors. For grinding (rough grinding, grinding, polishing) concrete, natural stone and terrazzo floors or materials specified in this manual or recommended by Xingyi. It can be used for everything from rough grinding to fine polishing. This unit is intended for use in commercial applications such as hotels, schools, hospitals, factories, offices, etc.

The swing bar and handle can be set in many different tilt positions. When the machine is operated manually, a most suitable position can be selected. The grinding head of this machine can be used with different grinding discs for grinding operations.

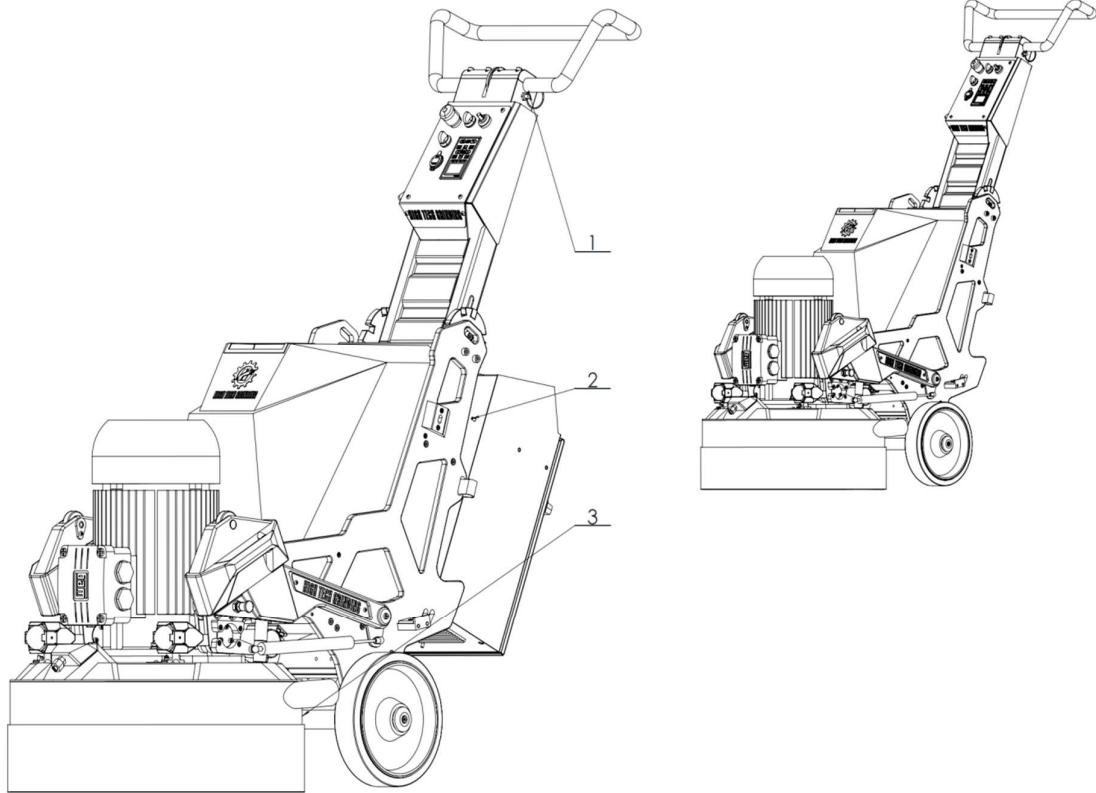
Equipped with a water tank, the machine can not only dry grind, but also water grind.

When dry grinding, make sure a vacuum cleaner is connected to the grinder (it is best to have a vacuum cleaner matched with Xingyi for better results). To prevent dust from being exposed to the air and posing a threat to the health of operators, operators and nearby people. Because inhaling dust is harmful, you should wear a protective mask during operation even if you have a vacuum cleaner to protect your own health.

This machine can use different Xingyi grinding discs, and the grinding discs used in grinding are different depending on the ground material.

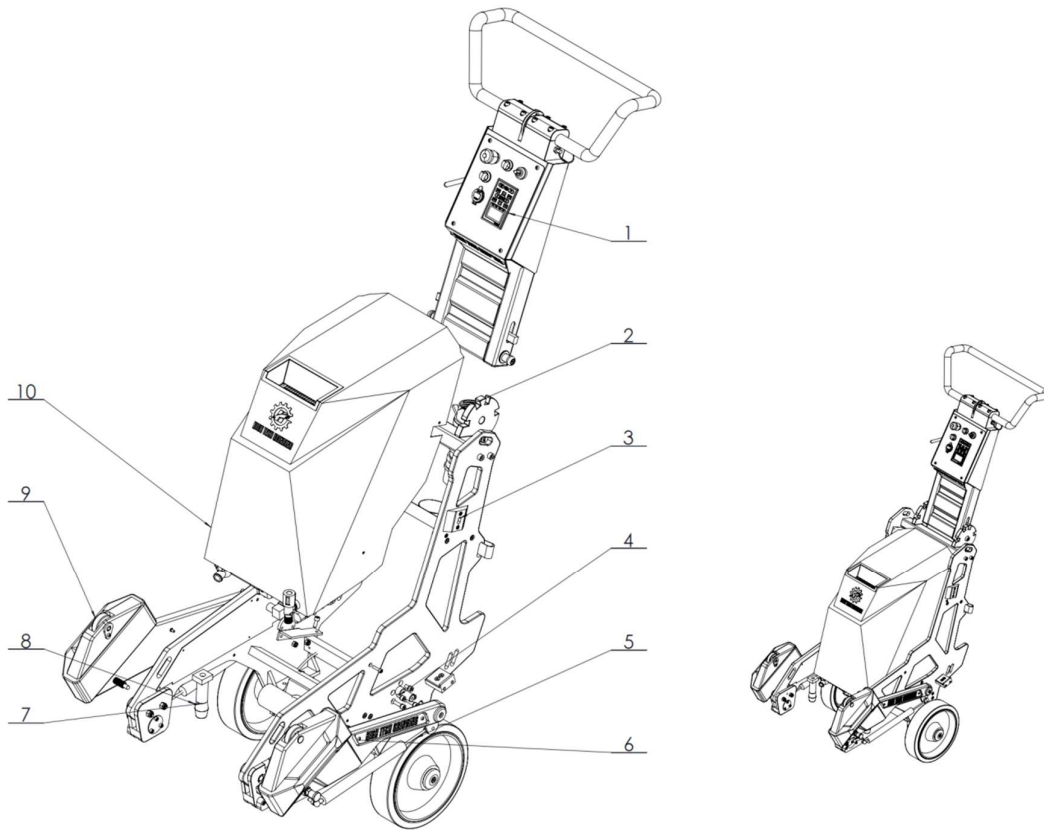
3.2 Exploded view of parts

3.2.1 Grinder assembly



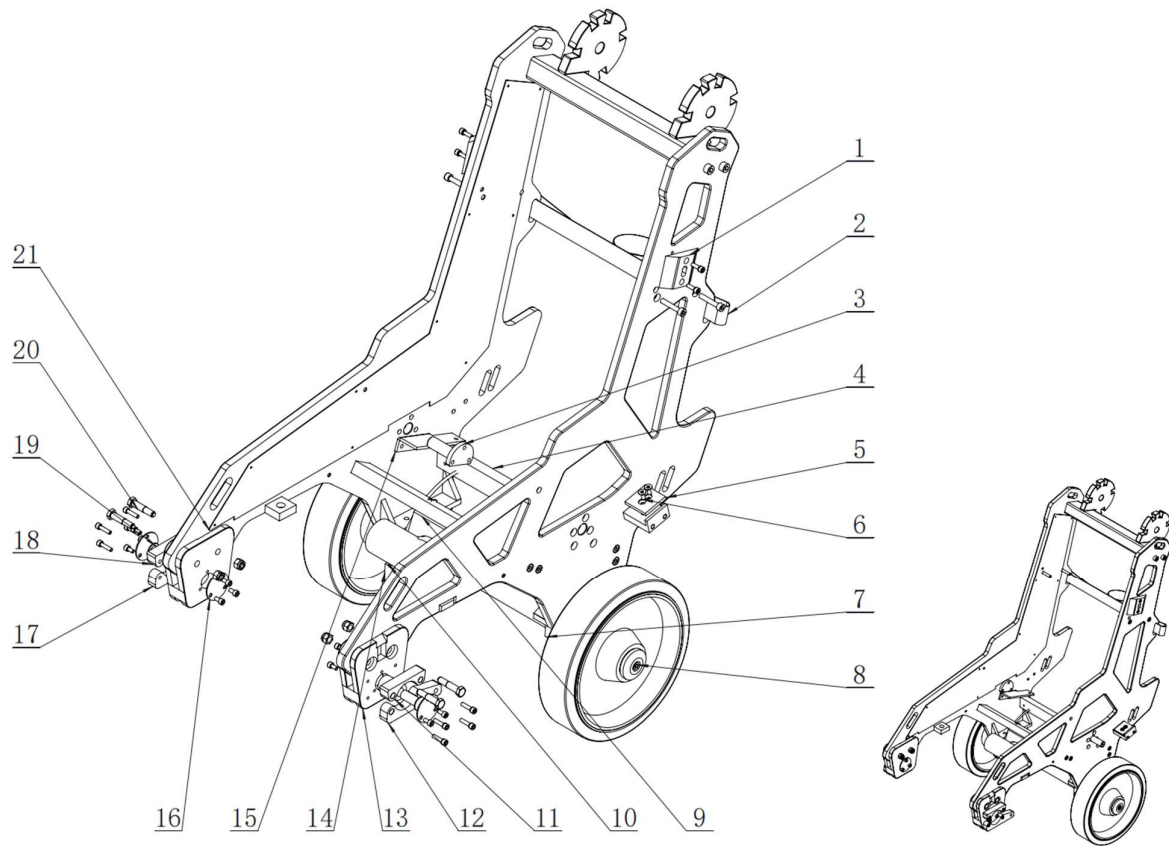
1.11.040.006 HTG680-PRO				
BOM ID	Serial number	Description	Specifications and models	QTY
3	2.12.040.006	gearbox parts	HTG680-PRO/208V11kW (CSA)	1
2	2.13.040.010	Electric control box parts	HTG-680PRO/22KW/CSA	1
1	2.11.040.004	Rack components	HTG680-PRO/Delta inverter	1

3.2.2 Rack components



2.11.040.004 Frame components				
BOM ID	Serial number	Description	Specifications and models	QTY
10	2.41.040.008	Water tank components	HTG680-PRO	1
9	2.41.018.010	Right weighted iron component	HTG680RC	1
8	3.22.117.003	Rubber machine foot pad tapered	36*28*25mm	4
7	4.11.018.001	Machine foot pad support column	HTG-820R/chrome plated	2
6	2.41.018.009	Left weighted iron component	HTG680RC	1
5	3.22.120.013	Gas Spring	LD28/10-525*150*1150N/ball head M10	2
4	4.11.029.076	Spacer - electroplating	Chrome plated HTG-820R	2
3	2.41.040.002	rack components	HTG680-PRO	1
2	2.41.018.011	Quick Connector	HTG680RC	1
1	2.41.040.010	Swing bar assembly	HTG680-PRO/Delta inverter	1

3.3.3 Rack components

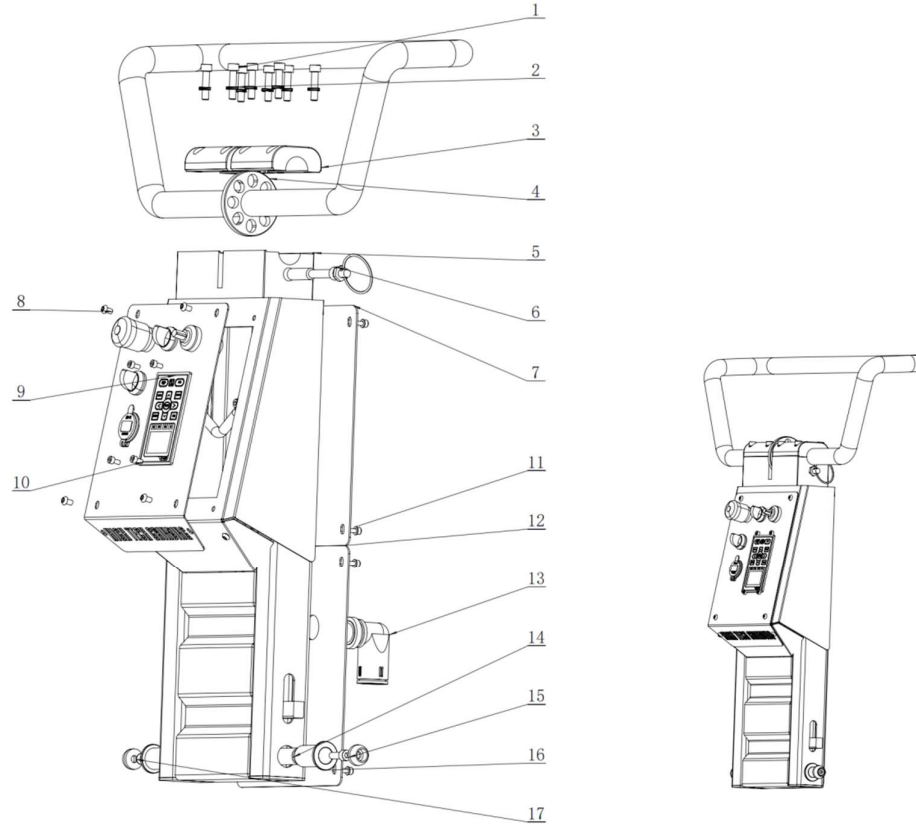


2.41.040.002 Rack assembly

22	4.11.018.089	Lower fixed sheet metal left - painted	HTG680RC/grey corrugated	1
21	4.11.018.073	Rack decorative panel-painted	HTG680RC/China Red	2
20	5.11.101.037	Reamed hole screws - electroplated	External hexagon/M10*50/chrome plated	4
19	4.11.001.048	Dynamic balancing pin - electroplating	Galvanized 777-4A	2
18	4.11.018.092	Weighted iron front fixing block - electroplating	HTG680RC	2
17	4.11.018.017	Right tension gas spring fixed block - electroplating	HTG680RC	1
16	4.11.001.047	Dynamic balancing cover	777-4A	4
15	4.11.018.088	Lower fixed sheet metal right - painted	HTG680RC/grey corrugated	1
14	4.11.040.011	Axle lock-paint	HTG680-PRO/grey corrugated	2

13	4.11.018.104	Ear connection plate - electroplating	Chrome plated HTG-820R	2
12	4.11.018.016	Left side tension gas spring fixed block - electroplating	HTG680RC	1
11	3.22.122.003	Ear hanging rubber sleeve	777-4A 30*15*38.5	2
10	3.21.116.010	LED light	34cm long 12 lamp beads 36W	1
9	3.22.126.014	tee welding	RPG	1
8	2.41.040.001	axle assembly	HTG680-PRO	1
7	4.11.040.009	Rear axle plate-painted	HTG680-PRO/grey corrugated	2
6	5.11.101.081	Stainless steel flat head hexagon socket screws	M6*16/201	4
5	4.11.018.086	Shock absorbing rubber	RPG	2
4	2.21.040.003	Frame welding-painting	HTG680-PRO/grey corrugated	1
3	4.11.018.015	Weighted iron shaft	HTG680RC	2
2	5.11.102.003	Vacuum cleaner hose fixing strap	RPG magic button	1
1	4.11.001.033	Middle fixed block - electroplating	Chrome plated 777-4A	2
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.4 Swing rod assembly

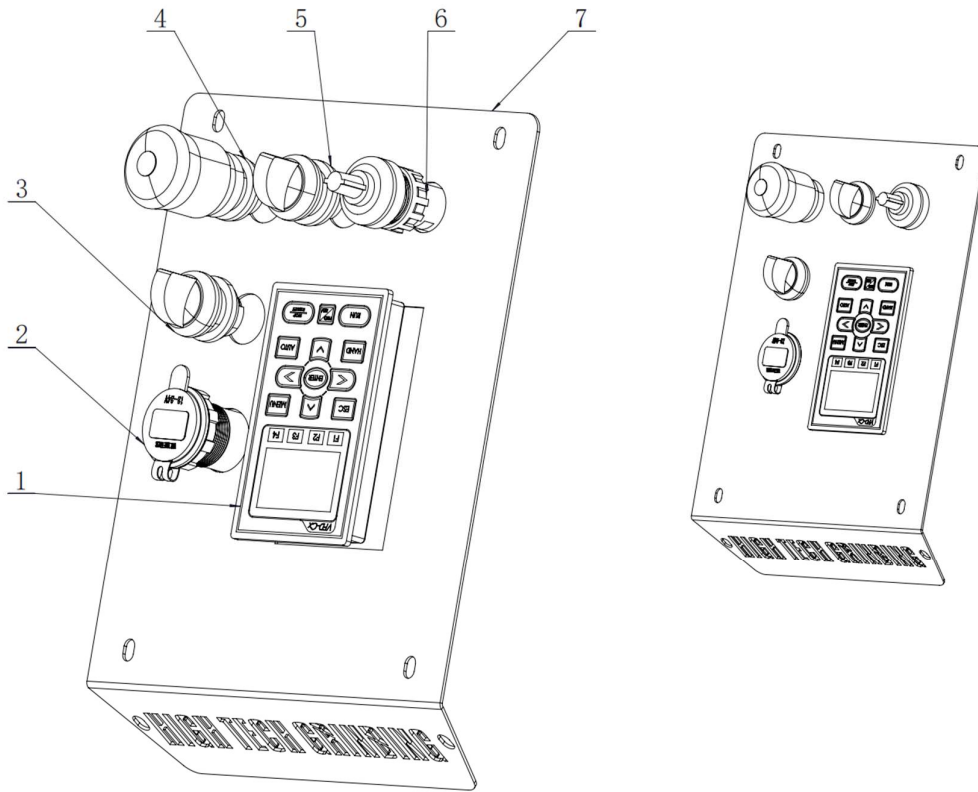


2.41.040.010 Swing rod assembly

17	4.11.001.034	Swing bar decorative cover - electroplating	777-4E/700LE/Chrome plating	2
16	4.11.018.056	Swing rod latch bushing	HTG680RC	2
15	5.11.101.021	Stainless steel hexagon socket screws	M8*25/304/cylindrical head	2
14	4.11.018.055	axis of rotation	HTG680RC	1
13	5.11.110.006	Wire guard	AD28.5 M25*1.5 bent plastic	1
12	4.11.040.015	Swing bar rear cover-painted	HTG680-PRO/grey corrugated	1
11	5.11.109.017	Stainless steel flat pad	M5/201	8
10	5.11.101.006	Stainless steel hexagon socket screws	M5*10/304	8
9	2.41.040.011	Swing bar panel assembly	HTG-680PRO/Delta inverter	1
8	5.11.101.036	Stainless steel hexagon socket screws	Semi-round head/M6*10/201	6

7	4.11.018.078	Swing bar rear cover - painted	HTG680RC/grey corrugated	1
6	3.31.101.007	Swing bar latch	HTG-680RC	1
5	2.21.040.004	Swing bar welding-painting	HTG680-PRO/grey corrugated	1
4	4.11.022.043	Swing bar handle	777-4E	1
3	4.11.018.076	Clamping cover-painted	HTG680RC/grey corrugated	2
2	5.11.109.009	stop washer	M8	8
1	5.11.101.012	Stainless steel hexagon socket screws	M8*35/304	8
BOM ID	Serial number	Description	Specifications and models	QTY

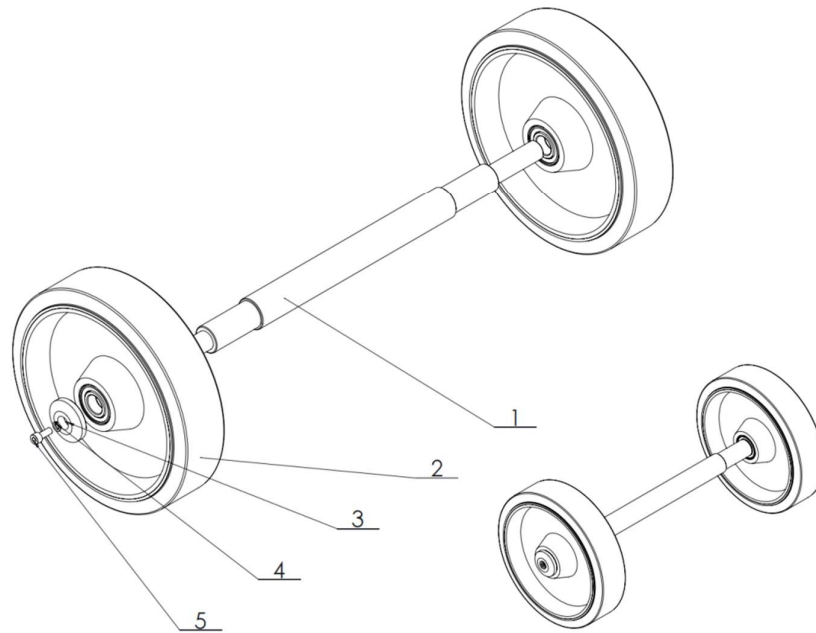
3.2.5.Swing bar panel assembly



2.41.040.011 Swing bar panel assembly

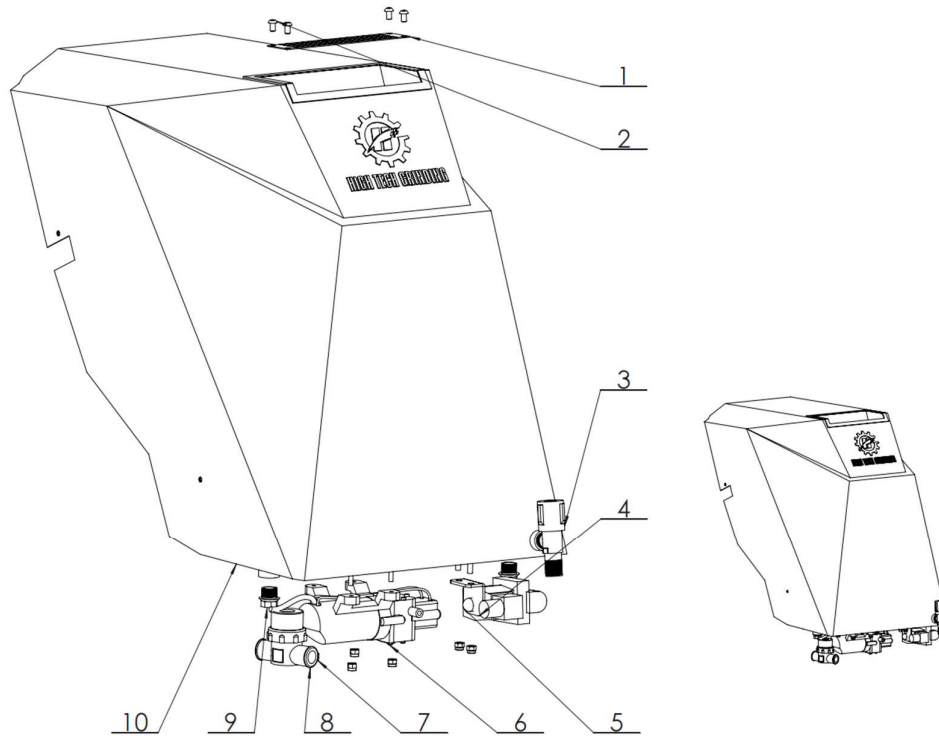
7	4.11.040.036	Operation panel-paint	HTG680-PRO/Delta Inverter/China Red	1
6	3.21.117.007	Integrated potentiometer	Eaton/M22-R4K7	1
5	3.21.114.112	Three gear selector switch	Eaton/M22-WRK3	1
4	3.21.114.098	Emergency stop button head	Eaton/M22-PV	1
3	3.21.114.097	Two-position selector switch	Eaton/M22-WKV	1
2	3.21.118.002	USB interface	With voltage display	1
1	3.12.112.005	Delta inverter digital operator	KPC-CC01/ Applicable to C2000, MS300	1
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.6 Axle assembly



2.41.040.001 Axle assembly				
BOM ID	Serial number	Description	Specifications and models	QTY
5	5.11.101.020	Stainless steel hexagon socket screws	M8*20/304	2
4	5.11.109.004	Stainless steel spring washer	M8/201	2
3	4.11.040.020	Wheel cover - electroplating	800-3P/Chrome plating	2
2	3.22.111.062	Rubber aluminum core wheel	φ 300*76mm(RA300*76*82/2 53-6205-2RS)	2
1	4.11.040.012	Axle-Electroplating	HTG680-PRO	1

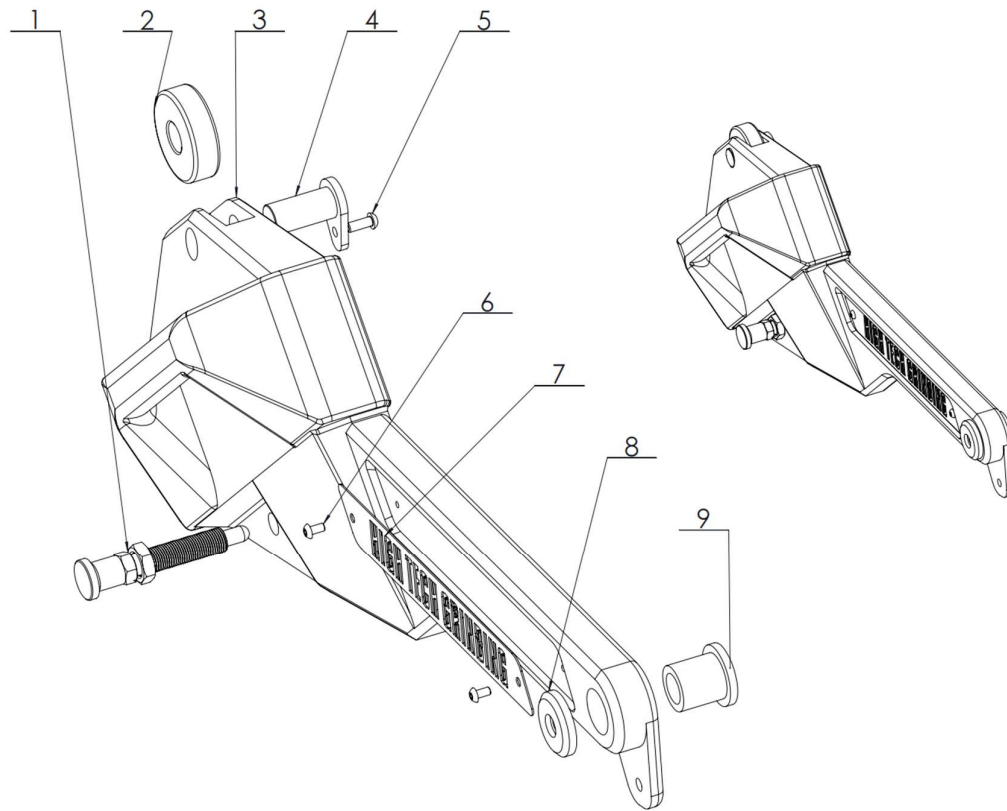
3.2.7 Water tank components



2.41.040.008 Water tank assembly

10	3.15.112.007	Stainless steel water tank	HTG680RC	1
9	3.22.126.001	plug	Quarter Teeth	3
8	3.22.201.005	filter	777-4E	1
7	5.11.106.015	Stainless steel nylon cap	M6/201	6
6	3.11.151.001	Dust pump	FL-2202A 24V pressure 70psi flow 4.0 liters	1
5	3.12.161.001	The electromagnetic valve	777-4E 2W-025-08 DC24V	1
4	4.11.017.001	Solenoid valve fixed seat	777-4E/HTG460	1
3	3.15.113.001	Water switch-with cap	For stainless steel water tank	1
2	5.11.101.036	Stainless steel hexagon socket screws	Semi-round head/M6*10/201	4
1	4.11.018.042	water tank filter	HTG680RC	1
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.8 Weighted iron components

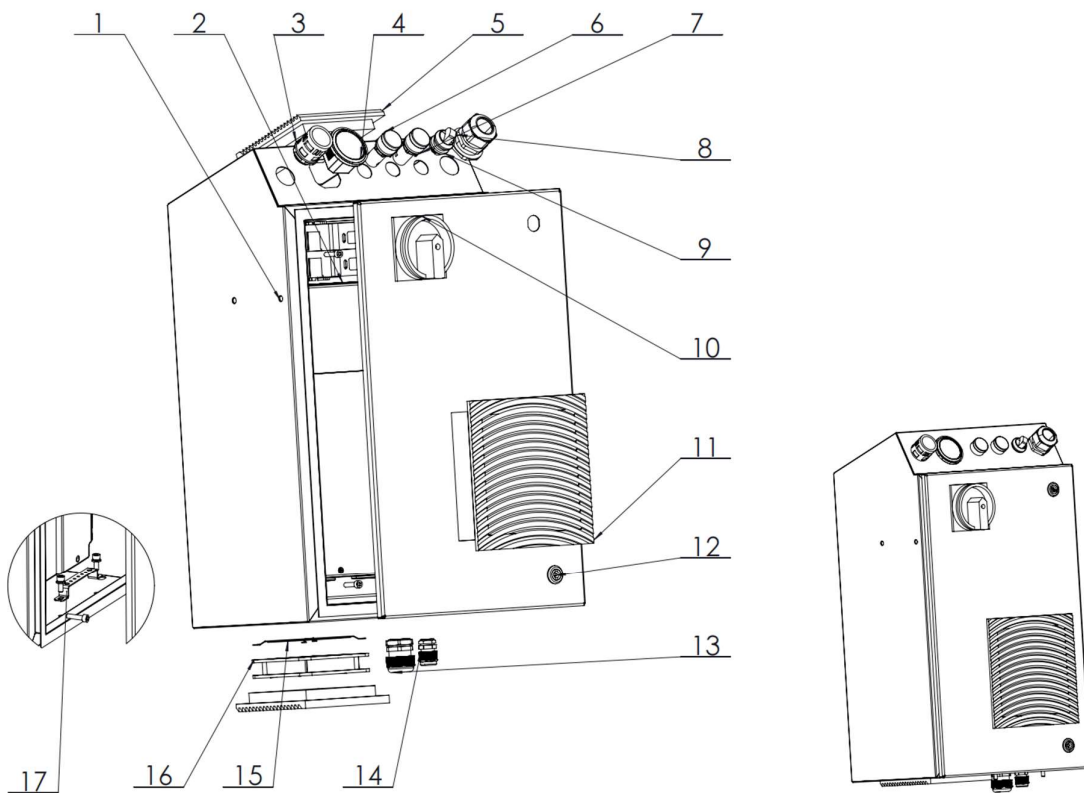


2.41.018.009 Left weight iron assembly (distinguish between left and right)

9	3.22.112.078	Flanged oil-free copper sleeve	40*5/30*20*35	1
8	4.11.022.061	Weighted iron shaft cover - electroplating	BD999LE/chrome plated	1
7	4.11.029.081	Left weighted iron nameplate	HTG-820RC/stainless steel wire drawing	1
6	5.11.101.138	Stainless Steel Flat Head Screws	Hexagon socket/M5*10/201	2
5	5.11.101.011	Stainless steel hexagon socket screws	Semi-round head/inner hexagonal/201/M6*16	1
4	4.11.018.101	Weighted Iron Pin- Electroplating	HTG-680RC/chrome plated	1
3	4.11.018.071	Left weighted iron - paint (distinguish between left and right)	HTG680RC/ gray corrugated	1

2	4.11.022.076	weighted iron wheels	BD999LE/black nylon	1
1	3.22.121.001	Reset indexing pin	M16 fine teeth/VCN244-BNK-M16	1
serial number	coding	name	Specifications and models	quantity

3.2.9 Electric control box parts

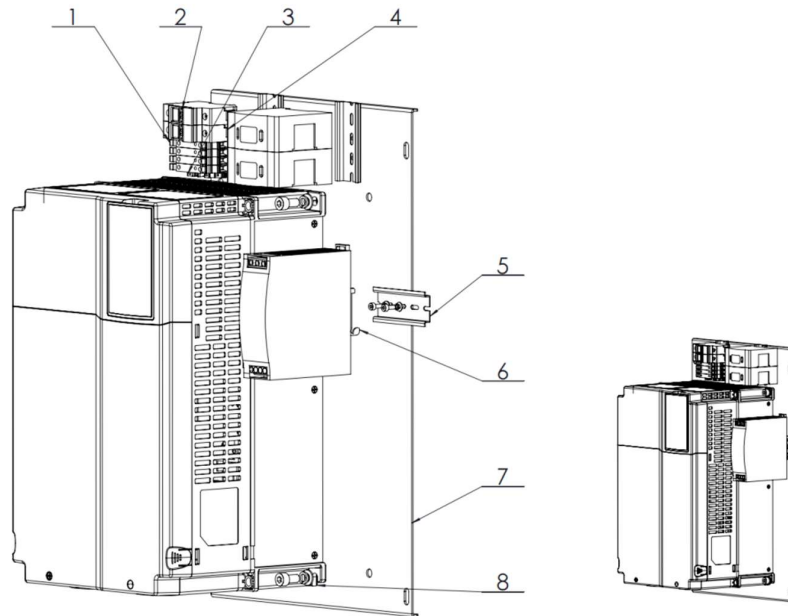


2.13.040.010 Electric control box components

17	3.21.201.023	Ground row	7 hole floor row	1
16	3.21.115.008	fan	DC24V0.35A/120*120*25mm / LK12025H24B	1
15	3.21.115.004	fan cover iron mesh	120*120mm hole spacing 105*105	1
14	5.11.110.001	Wire guard	PG11/black/plastic	1

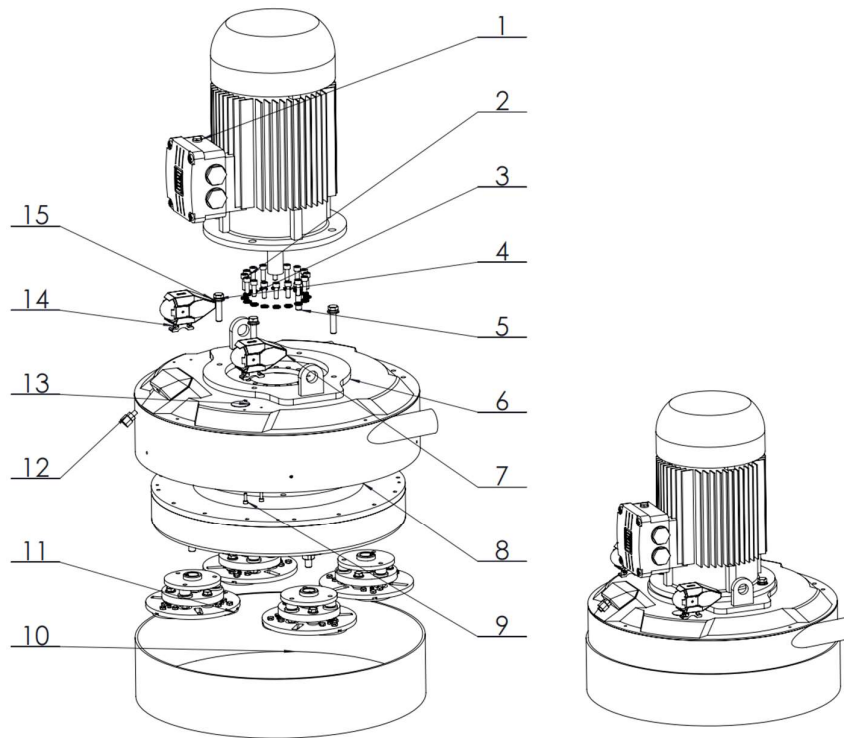
13	5.11.110.002	Wire guard	PG25/black/plastic	1
12	3.22.123.001	Turn tongue lock	705 with big key	2
11	3.21.115.003	Outlet filter (fan cover)	200*200/FK8923/300	1
10	3.21.114.115	Isolating switch	Eaton/P3-63/EA/SVB	1
9	3.21.114.097	Two-position selector switch	Eaton/M22-WKV	1
8	5.11.110.012	Wire guard	PG29/black/plastic	1
7	3.21.116.002	Green indicator light	Siemens/24v AD16-22D/SG	1
6	3.21.116.001	red indicator light	Siemens/24v AD16-22D/SR	1
5	3.21.115.002	Outlet filter (fan cover)	FK6622.300	2
4	3.21.119.001	timer	DC10-80V	1
3	5.11.110.008	Wire guard	AD28.5 M25*1.5 straight plastic	1
2	2.42.040.008	Electrical installation components	HTG-680PRO/22KW/CSA	1
1	2.21.040.008	Electric control box welding-painting	HTG-680PRO/22KW/CSA/grey corrugated	1
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.10 Electrical installation components



2.42.040.008 Electrical installation components				
8	3.12.111.055	Delta inverter	220V 22kW VFD220C23A-21	1
7	4.11.040.043	Electrical device mounting plate-baking paint	HTG-680PRO/22KW/CSA/grey corrugated	1
6	3.21.111.004	MEAN WELL switching power supply	WDR-120-24	1
5	3.23.116.001	guide	C45 1.2 thick	3
4	3.21.201.048	BUSSMANN fuse base	JT60060 (without fuse indicator light)/CSA	2
3	3.21.123.001	terminal fixture	CLIPFIX 35-5	1
2	3.21.201.041	fuse base	Schneider/DF101/1P32A/690VAC/10*38mm	2
1	3.21.123.050	fuse terminal	TB 4-HESI(5X20)1	4
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.11 Gear box components

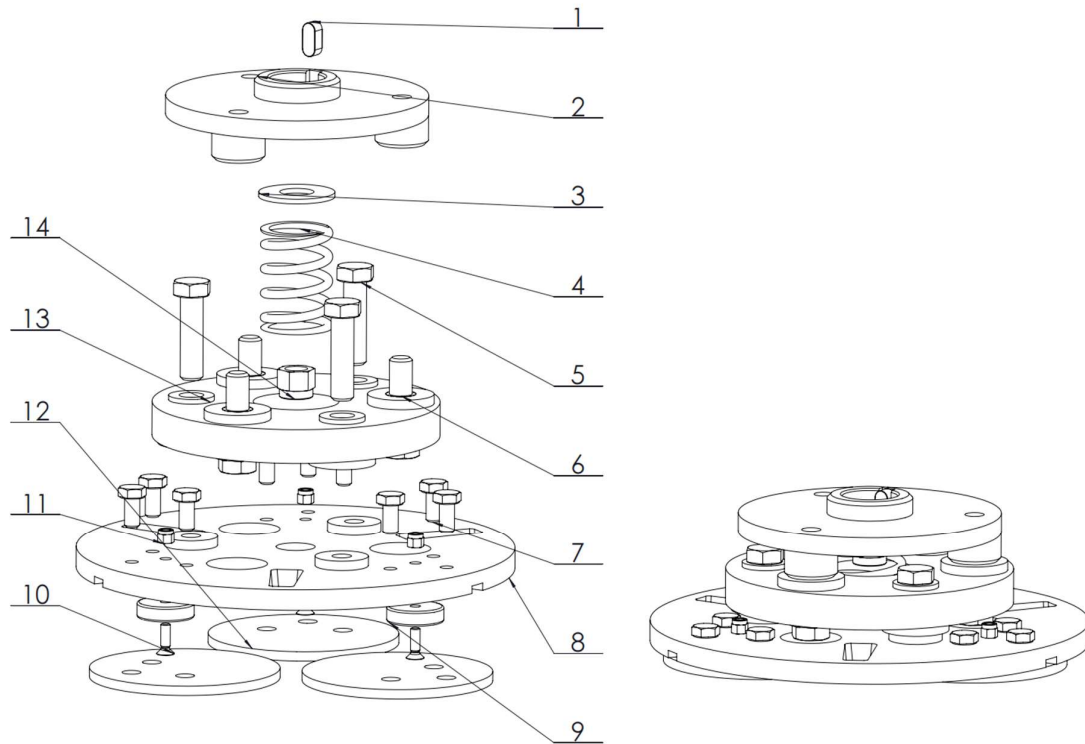


2.12.040.006 Gearbox component HTG680-PRO (CSA)

15	5.11.109.001	Stainless steel flat pad	M14/201	4
14	5.11.106.015	Stainless steel nylon cap	M6/201	4
13	3.22.163.021	oil cap	Small Φ 45 English	1
12	2.41.017.005	sprinkler head assembly	HTG460 virtualware	1
11	2.41.018.002	Grinding disc components	HTG680RC	4
10	3.22.124.032	Dustproof tape-sewing	2350MM/black/sticky cloth 60MM	1
9	5.11.101.080	Stainless steel hexagon socket screws	M6*20/201	4
8	3.13.112.006	Gearbox	666-4	1
7	3.21.116.011	LED light	External u7-double white light white angel eyes	2
6	3.13.113.021	Gearbox cover welding-painting	HTG680RC/grey corrugated	1
5	5.11.101.084	Stainless steel external hexagonal screws	M14*60/304	4

4	5.11.109.002	Stainless steel spring washer	M14/304	4
3	5.11.109.006	stop washer	M10	16
2	5.11.101.005	Stainless steel hexagon socket screws	M10*30/304	16
1	3.11.111.045	WEG motor	11kW/38*90/CE UL CSA EAC certification	1
BOM ID	Serial number	Description	Specifications and models	QTY

3.2.12 Grinding disc components



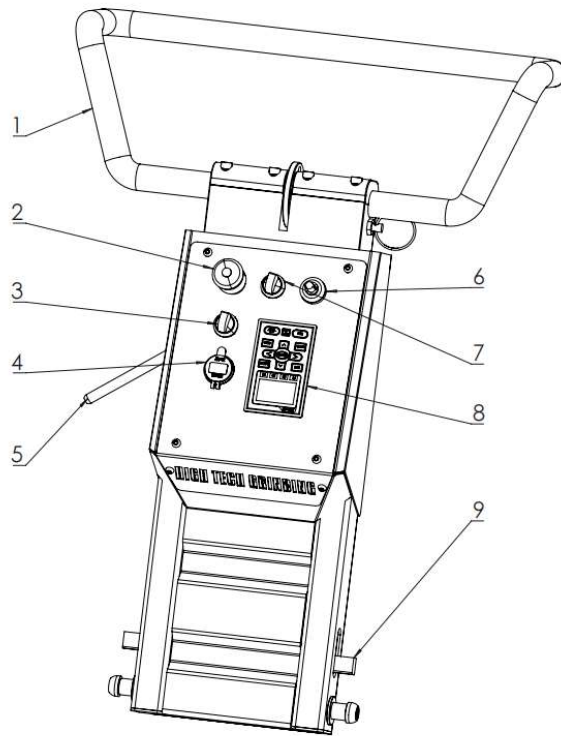
2.41.018.002 Grinding disc assembly

14	5.11.106.021	Stainless steel nylon cap	M12/201	1
13	5.11.109.014	Stainless steel flat pad	M12/201	6
12	3.22.115.003	100 conversion block-glu	Colorful/777-4A	3
11	5.11.106.006	stainless steel nut	M5/201	3
10	5.11.103.003	Stainless Steel Flat Head Screws	Cross/M5*16/201	3
9	3.22.114.001	magnet	φ30*8	3
8	3.14.112.005	Round grinding disc - electroplating	X7/666-4φ230	1
7	5.11.101.001	Stainless steel external hexagonal screws	M8*16/304	9
6	3.22.117.033	Rubber mat	680PRO/black hole sleeve/outer diameter 151*23, center hole small hole 12, center distance 110	1
5	5.11.101.050	Stainless steel external hexagonal screws	M12*45/304	6

4	3.22.120.006	Grinding disc spring	X3X6X7/600E/galvanized 4.5*37*53	1
3	4.11.017.015	Large washer	18*40*2.5	1
2	3.22.116.006	Upper flange - electroplating	29*12 666-4	1
1	3.22.118.004	key strip	8*7*18mm	1
BOM ID	Serial number	Description	Specifications and models	QTY

3.3 Swing rod assembly

3.3.1 Overview

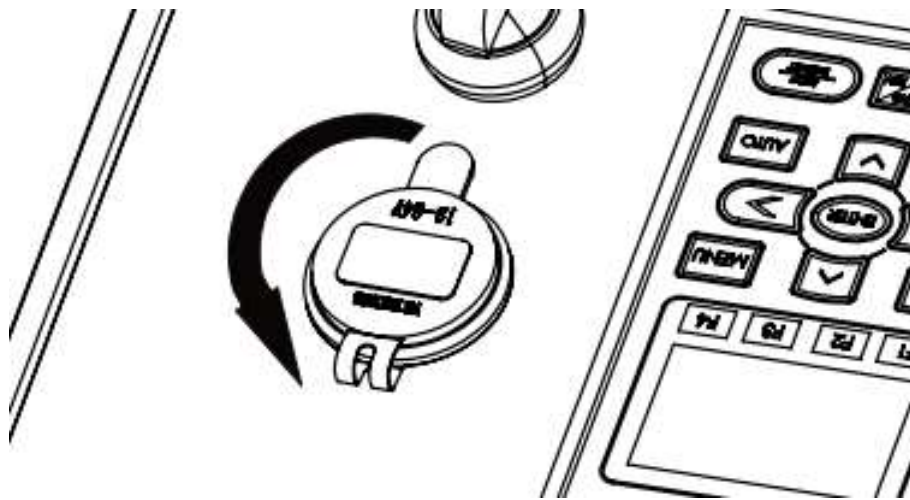


1. Operating handle: The position where the user places his hands during operation.
2. Emergency stop switch: When the equipment is in a dangerous state or needs to stop working, press the emergency stop switch to cut off the power and stop the equipment operation to protect the safety of people and equipment.
3. LED light switch: Control the switch of LED light.
4. USB interface: can be used for charging, such as mobile phone charging.
5. Swing rod angle adjustment handle: Use the handle to adjust the angle of the swing rod, and there will be a corresponding position under the corresponding working state.
6. Speed regulator: Mainly used to adjust the rotation speed of the motor.
7. Forward and reverse rotation switch : This switch has three gears. Rotate to turn on the emergency stop switch and change the direction of the switch. If the switch is turned to the left, the motor will rotate forward ; in the middle gear, the motor will not rotate ; if it is rotated to the right, the motor will rotate reversely.

8. Display: displays some parameters, such as voltage, current, motor speed, overload fault prompt, etc.
9. Swing lever lock lever: adjust the position of the swing lever.

3.3.2 USB interface

There is a charging (USB interface) device on the control panel. Turn the cover up and we can see the USB interface, which is mainly convenient for users to charge the device.



Notice:

When operating the grinder, be sure to close the lid and do not open it to expose the USB to prevent dust from running in and blocking the USB interface.

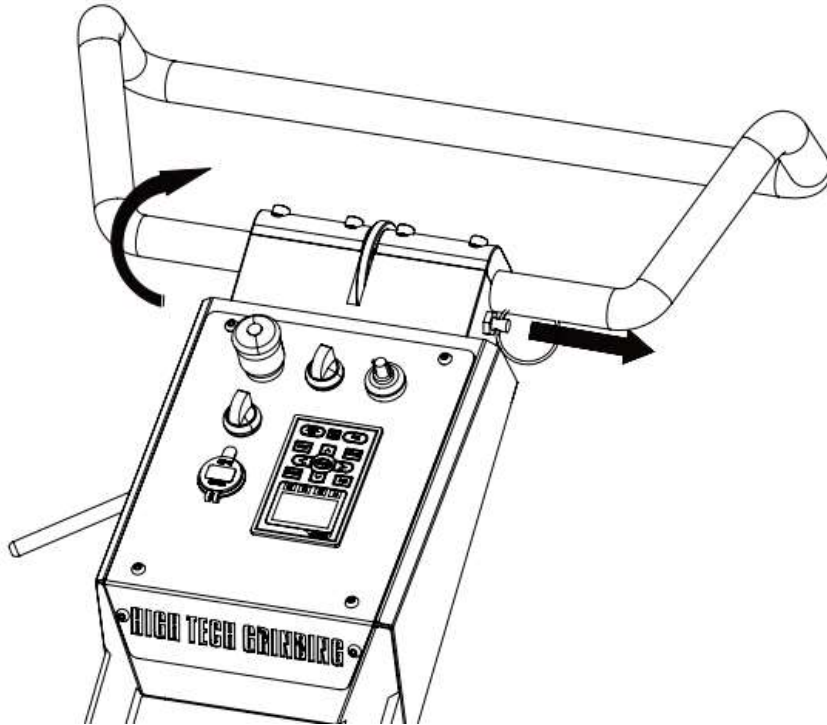
When you don't use the USB port for charging, remember to cover it to prevent dust from falling into the USB port.

Note: The voltage will be displayed on the cover;

3.3.3 Handle

The adjustment pin on the handle can adjust the handle to different positions by positioning

different round holes to meet the different needs of users. Hold the armrest with one hand, pull out the adjusting pin with the other hand, and then loosen the adjusting pin when it is rotated to the appropriate position.



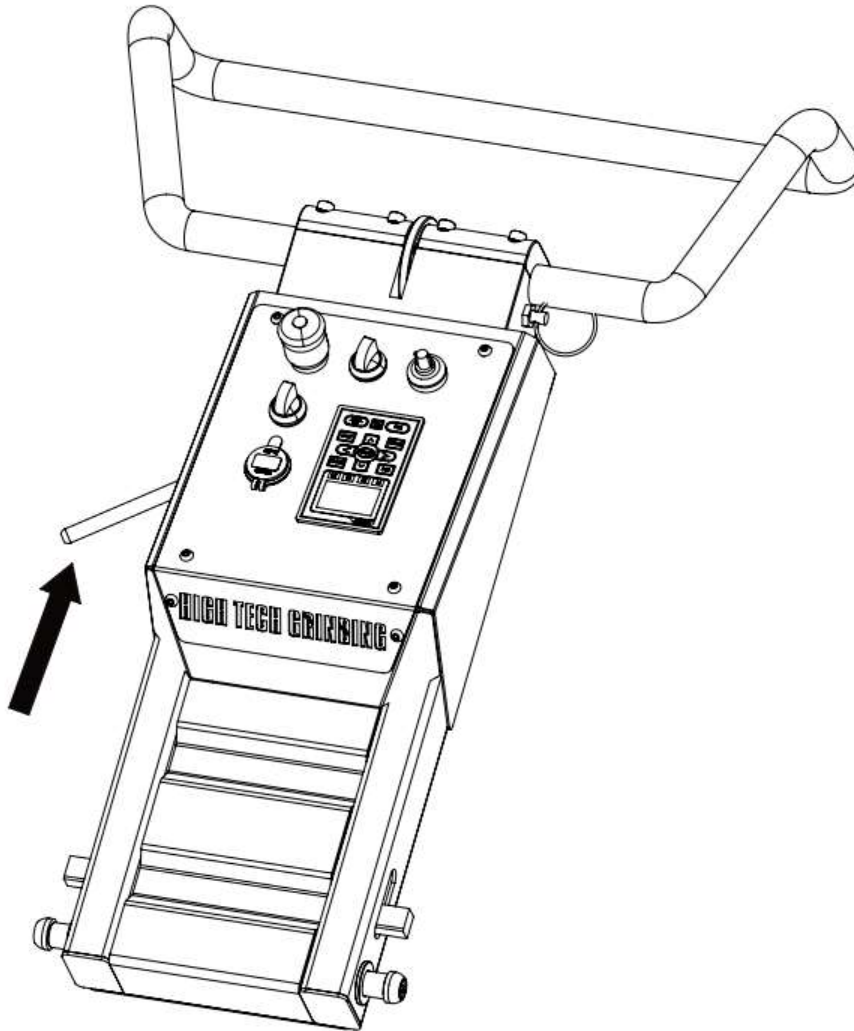
Notice:

1. When pulling out the handle adjustment latch, it sometimes gets stuck. In this case, you need to pull out the latch while shaking the handle.
2. When the handle adjustment pin automatically resets, the holes may not be aligned. Just rotate it up and down.
3. When adjusting the handle position, be sure to check whether the handle adjustment pin has been automatically reset before operating the machine.

3.3.4 Swing rod angle adjustment

The swing rod adjustable device relies on the handle to control the different positions of the swing

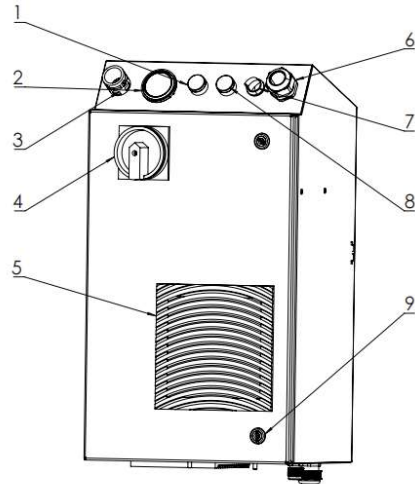
rod to adapt to the conversion of the machine placement in different states. Hold the handle with one hand to support the swing rod, and pull the handle upward with the other hand to keep it still. Rotate the swing rod to the required position according to the hole position on the sector board, and then release the handle.



Careful :

- 1、 After adjusting the position of the swing rod, you need to check whether the swing rod has been limited before operating the equipment .
- 2、 The swing rod is heavy, so hold it steady with one hand!

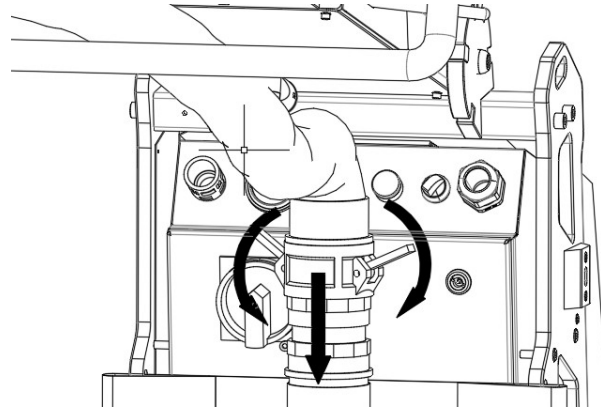
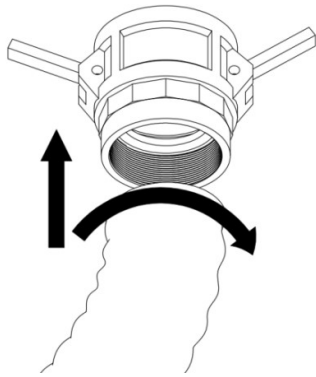
3.4 Electrical control box components



- 1、 Red indicator light: lights up to indicate a fault.
- 2、 Timer: Displays the total running time of the machine.
- 3、 Bellows interface: An interface used to connect wires.
- 4、 Isolating switch: used to cut off the circuit.
- 5、 Fan filter: plays the role of heat dissipation to prevent the internal temperature of the inverter box from being too high, which may cause the components inside the inverter box to be burned out.
- 6、 Wire protection cover: used to connect lines and protect cables.
- 7、 Two-position selector switch: controls the water pump.
- 8、 Green indicator light: lights up during normal operation.
- 9、 Frequency converter box key lock: The frequency converter box can be locked with a key.

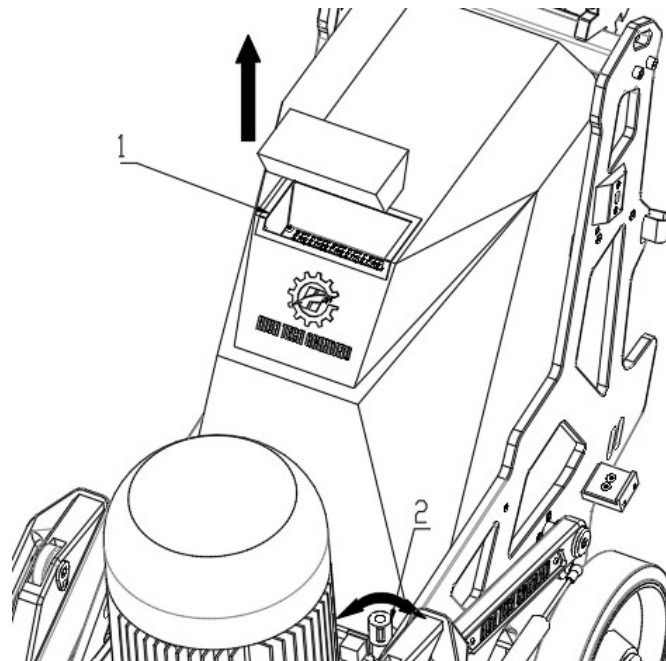
3.5 Quick connector

The quick connector consists of a front part and a rear part (as shown below). The front part is assembled with the dust suction pipe mouth of the grinder (screw the front part into the dust suction pipe interface through the thread and tighten it), and the rear part is connected with the dust suction pipe. Fit (screw the copper wire vacuum tube into the rear and tighten it).



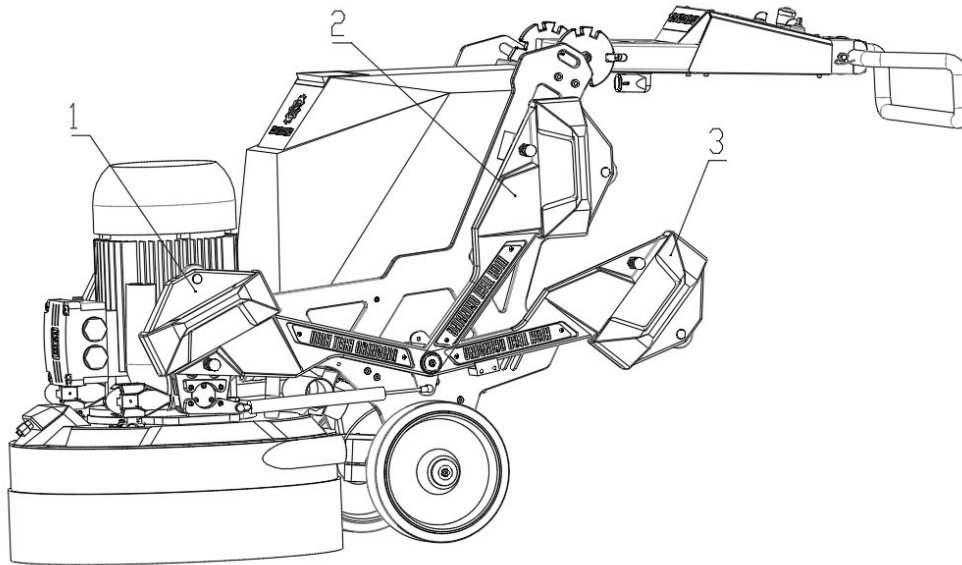
3.6 Water tank

There is a water tank cover on the water tank. After removing the water tank cover, there is a water filling port. The water tank can be filled with water. When the equipment needs to perform water grinding work, turn the water switch clockwise to perform water grinding work. After the water grinding work is completed, turn the water switch counterclockwise to end the water grinding work.



1. Water tank filling port 2. Water switch

3.6 Weighted iron



1. Working position 2. Transport position 3. Lifting position

The weighted iron has three different positions, corresponding to the transportation position, lifting position, and working position on the machine. The adjustment of the position of the weighted iron mainly relies on the spring latch to cooperate with the limit device on the frame to achieve the purpose of limiting.



Notice:

1. The weight kit is very heavy, so be sure to handle it with care, otherwise personal injury or machine damage may occur.
2. Please hold the handle of the weight for adjustment. Improper movement of the weight may cause pinching of hands or personal injury.

4. Machine operation

4.1 Overview

The following sections describe the different positions of the grinder, its main operations and how to install and replace grinding discs.



Precautions:

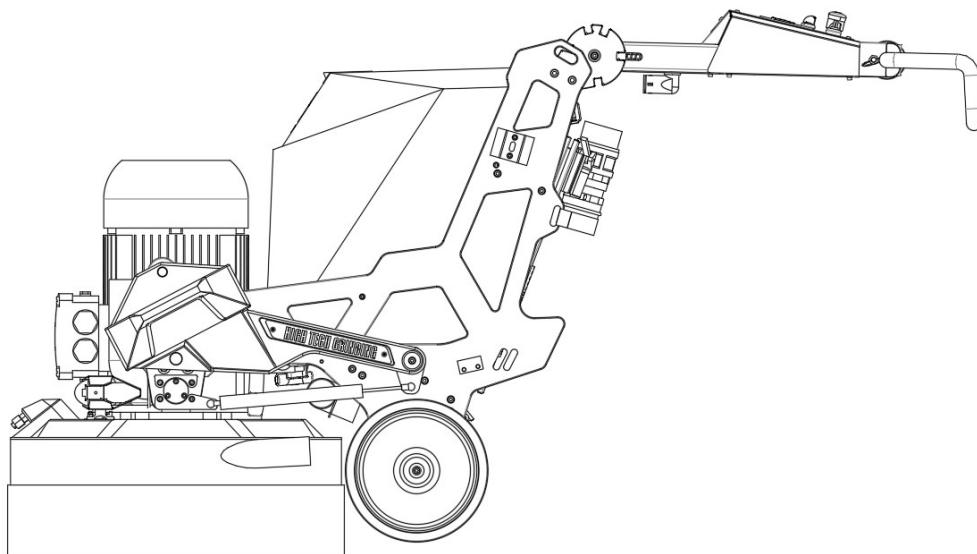
1. The grinder can only be used or repaired by personnel who have received necessary theoretical and practical training and have carefully read the user manual.
2. Protective equipment, such as protective gloves, protective masks, work clothes, hard hats, insulating shoes, etc., must be used when operating the grinder.

4.2 Machine location description

4.2.1 Machine working position

When the grinder is working, gently lower the weighted iron to the appropriate position and adjust the position of the handle and swing rod to achieve

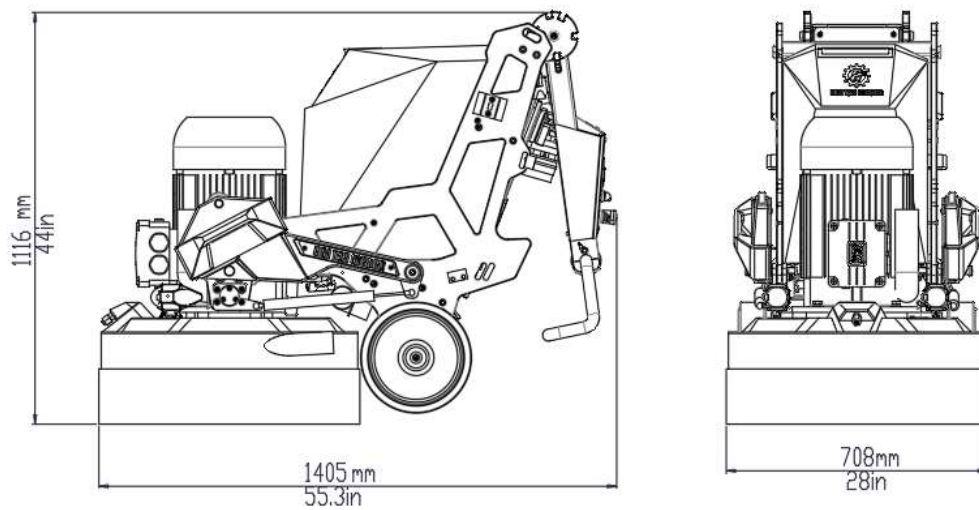
The most suitable working position.



4.2.2 Machine transport position

When packaging or moving the machine, the position of the swing rod handle can be adjusted to reach the lower position. The minimum packaging size is as follows, depending on the

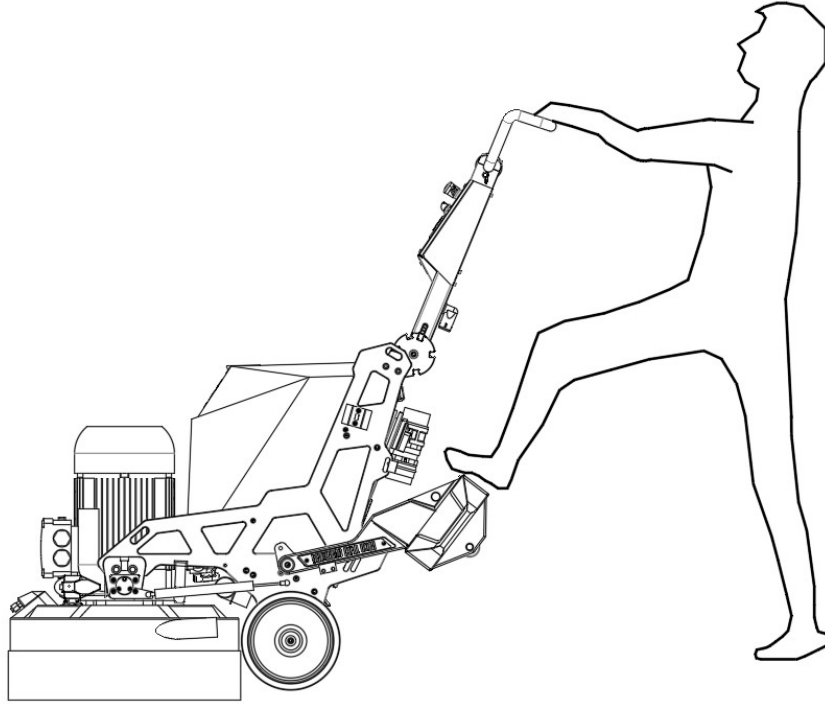
Pack according to its size.



4.2.3 Machine lifting position

Adjust the position of the weighted iron so that the weighted iron is in the tilted position, and adjust the position of the handle and swing rod to the machine's tilted position. (Recommended optimal lifting position)

Hold the handle tightly with both hands, place one foot on the weighted iron, and press the machine down with force.



To put the machine down, you need to hold the handle tightly with both hands, place your feet on the weighted iron, balance the machine with its own gravity, and slowly put it down to protect the grinding head. When putting down the machine, pay attention to your own strength, act within your ability, and operate with caution to ensure the safety of the machine and people. Our company does not assume any responsibility for machine losses and personal injuries caused by improper operation.

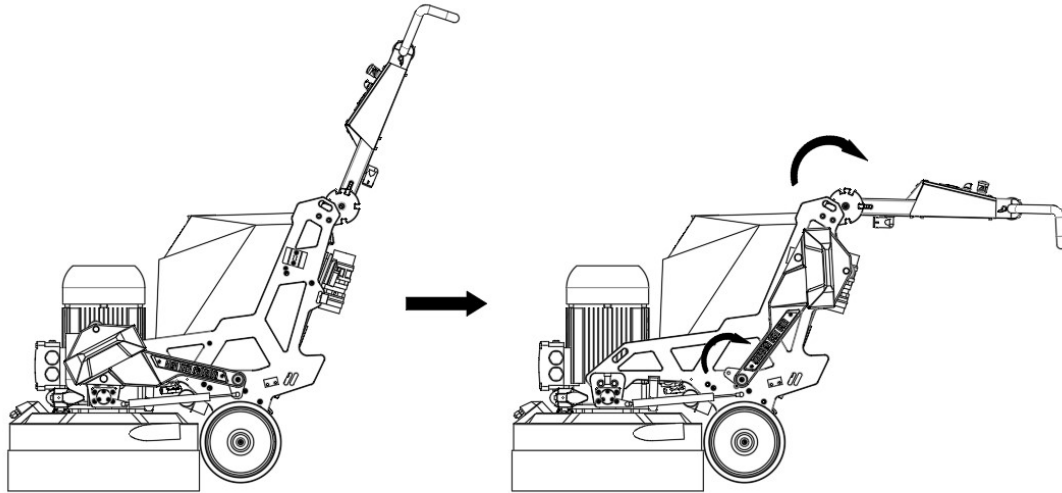


Notice :

After lifting, remember to stand next to the grinding head and press the grinding head gently to see whether the machine is stable and whether there is a threat of tipping ahead to ensure your own personal safety.

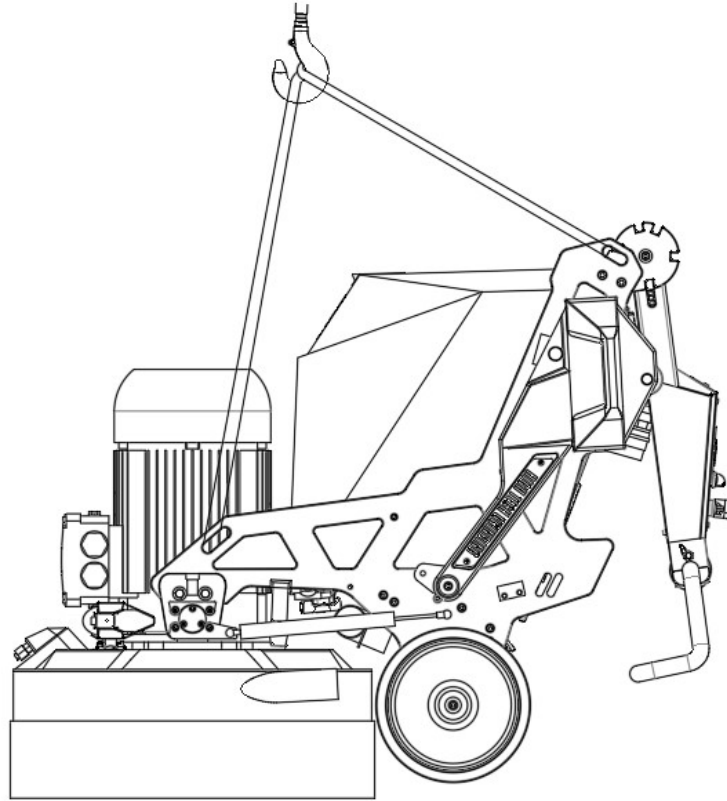
4.2.4 Machine transportation position

During the transportation of the machine, the weights need to be adjusted to the transportation position, and the swing rod needs to be adjusted so that it is also in the transportation position to facilitate transportation.



4.2.5 Lifting the machine

When lifting the machine, fasten the lifting strap to the two lifting lugs on the frame next to the motor and the two lifting lugs on the frame near the swing rod to lift the machine. (Note: Two ropes that can withstand 500 kilograms are required to bind the machine)



Notice:

1. When lifting the machine, it may cause personal injury or damage the machine or surrounding objects. Identify the danger zone and then check to make sure no one is in the danger zone while lifting.
2. When the strap is fixed to the lifting hole, check whether it is firmly fixed.
3. Two straps need to be connected diagonally to the lifting port.

4.2.6 Precautions



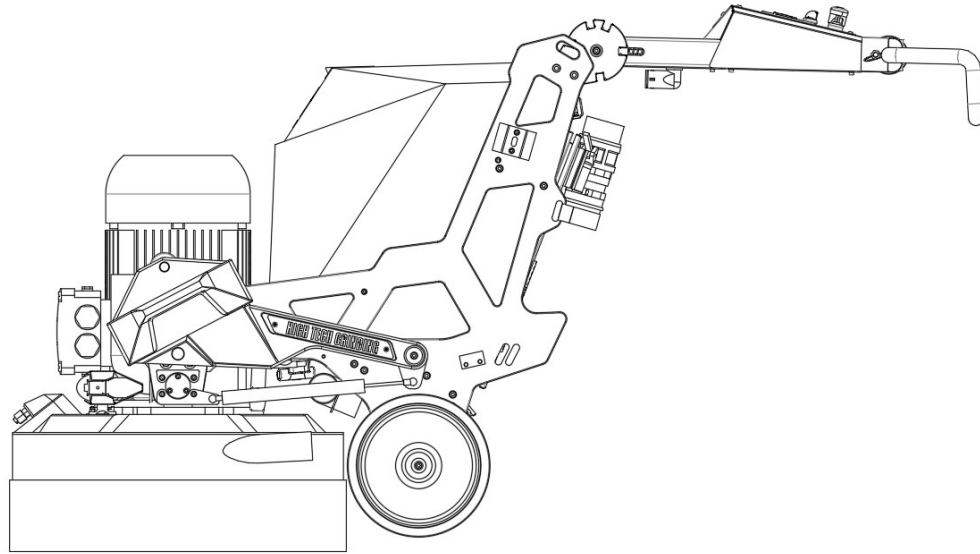
Please read the following content carefully, otherwise unnecessary harm may occur.

1. If the operation is careless, the grinder will fall over, causing damage to the machine and personal injury.
2. When pulling out the handle adjustment latch, it sometimes gets stuck. In this case, you need to pull out the latch while shaking the handle.
3. When adjusting the handle position, be sure to check whether the handle adjustment pin has been automatically reset before operating the machine.
4. After adjusting the position of the swing rod, you need to check whether the swing rod has been limited before you can operate the machine.
5. When the grinder is adjusted to the transportation or packaging position, there is a risk of crushing injury, so please be careful.
6. When lifting and lowering the machine, you must pay special attention to your own safety to avoid injury and damage to the machine.

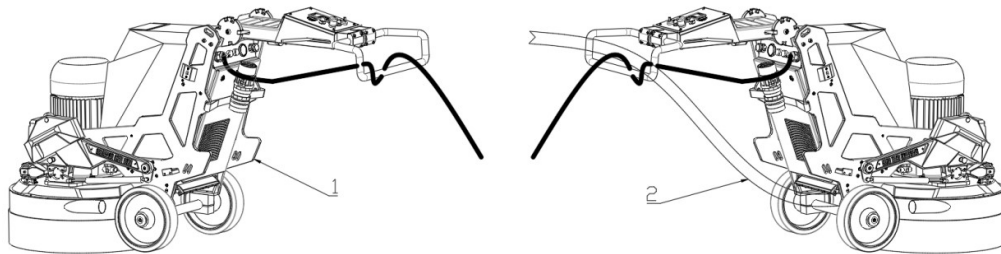
4.3 Starting and stopping the grinder

4.3.1 Start the grinder

(1) First adjust the swing rod, handle and weights to the corresponding working position (as shown in the figure below after adjustment).

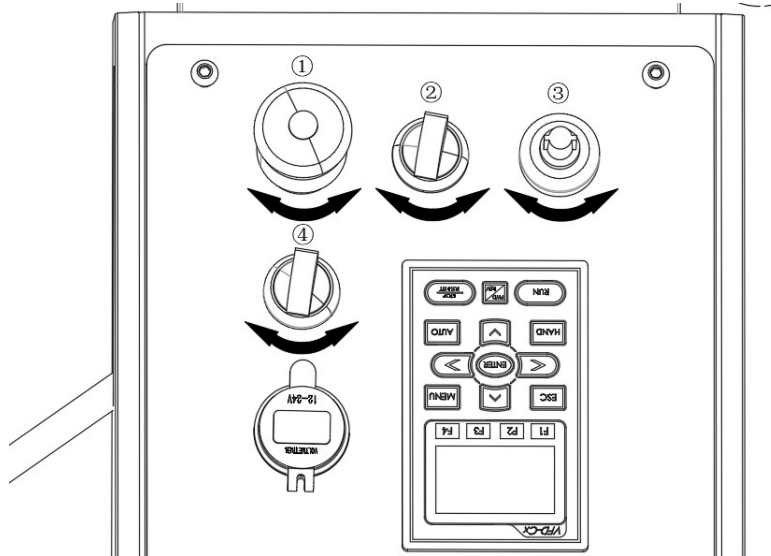


(2) Plug in the power cord (Before this, make sure the emergency stop is pressed and all switches have been reset); if it is dry grinding, connect the vacuum cleaner (if the vacuum cleaners manufactured by Xingyi are equipped with quick The connector can be quickly connected to the vacuum cleaner. For wet grinding, the water tank needs to be filled with water.

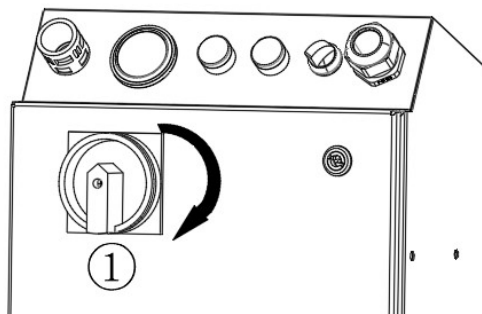


1. Water grinding 2. Dry grinding

(3) First turn on the isolation switch on the inverter, then turn on the emergency stop switch on the control panel, turn the speed regulator to adjust the rotation speed of the motor, turn the forward and reverse switch, and turn the switch to the left to make the motor rotate forward (Turn to the right and the motor will reverse), and you can start the equipment for grinding (if you are doing water grinding, you need to fill the water tank with water and then turn on the water switch. For If the machine is operated in a weak light environment, you can turn on the LED light switch according to your own needs.



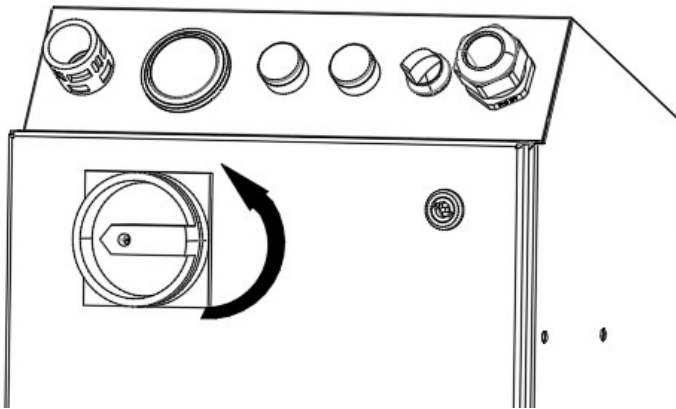
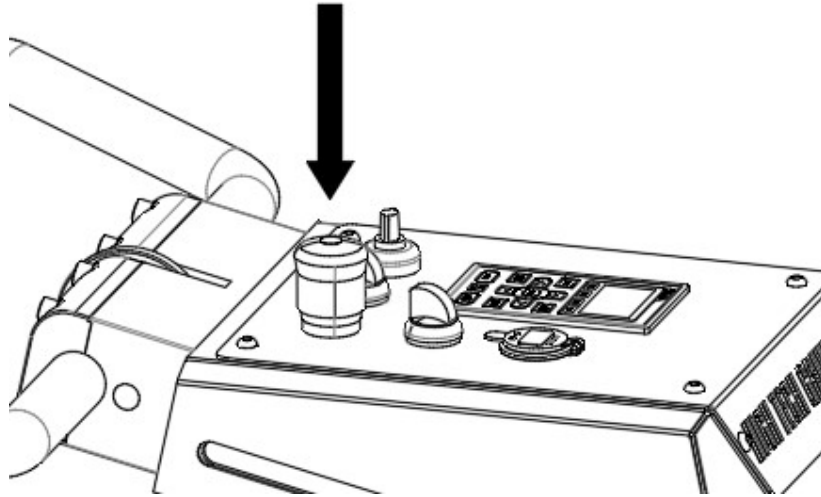
① Emergency stop switch ② Forward and reverse switch ③ Speed regulator ④ LED light switch



① Isolating switch

4.3.2 Turn off the grinder

Stop the grinder: Press the emergency stop switch to stop the equipment (remember to reset the speed regulator and motor forward and reverse switches , and unplug the power plug) , and then turn off the isolation switch .

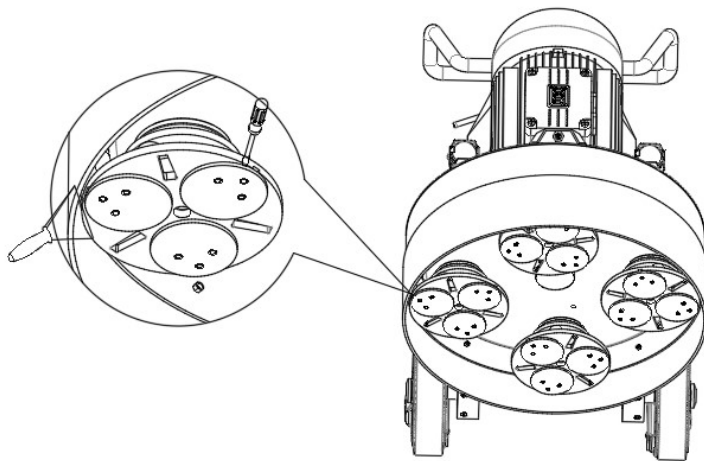
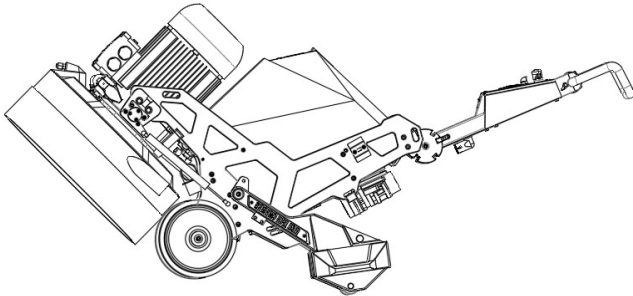
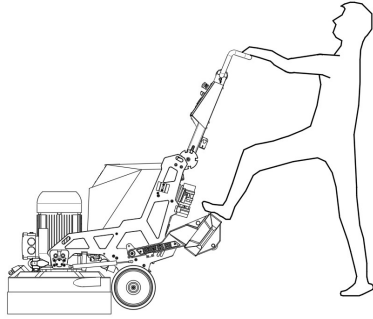


Note: When stopping the machine, it is recommended to unplug the power supply for safety reasons.

The emergency stop switch can only be rotated and pressed downward according to the direction of rotation on the emergency stop switch, and cannot be pulled upward.

4.4 Replace grinding disc

When replacing the grinding disc, adjust the machine to the tilting position, then tilt the machine and carefully lay the machine flat. After leveling the machine, stand next to the machine and check that the machine is stable. Use a flat-blade screwdriver and a spatula to sharpen the blade.



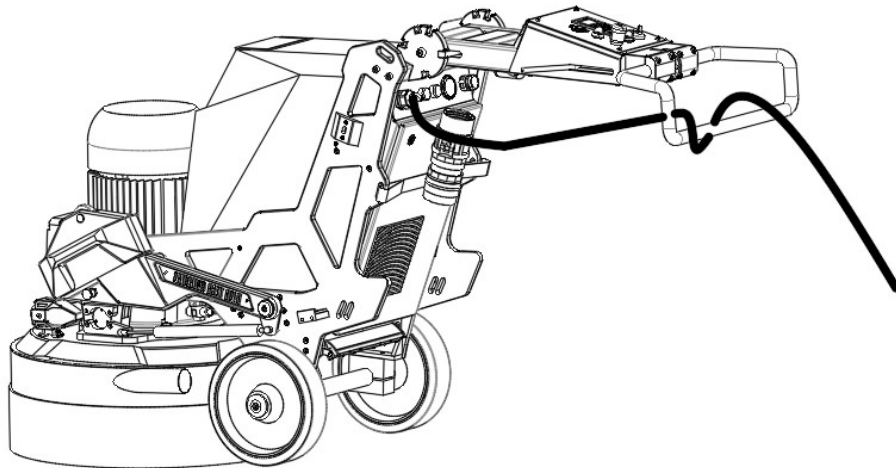
careful:

1. Please ensure that the machine does not tilt forward before replacing the abrasive;
2. When the machine runs for a period of time, the abrasives, grinding discs, and gear boxes will generate high temperatures. Please be careful when replacing the abrasive to avoid burns.
3. Make sure the power is unplugged and the emergency stop is pressed before replacing the grinding disc.

4.5 How to wind machine cables

When the machine is working, the winding method of the wire is particularly important, which can greatly improve your work efficiency and improve your safety. The specific operation methods are as follows:

1. Plug in the external power supply;
2. Pass the power cord through the swing rod handle;
3. Wrap the power cord around one side of the handle at least twice;
4. Pull the power cord with slight force to ensure that the power cord has enough friction to firmly fix the power cord on the handle.



Precautions:

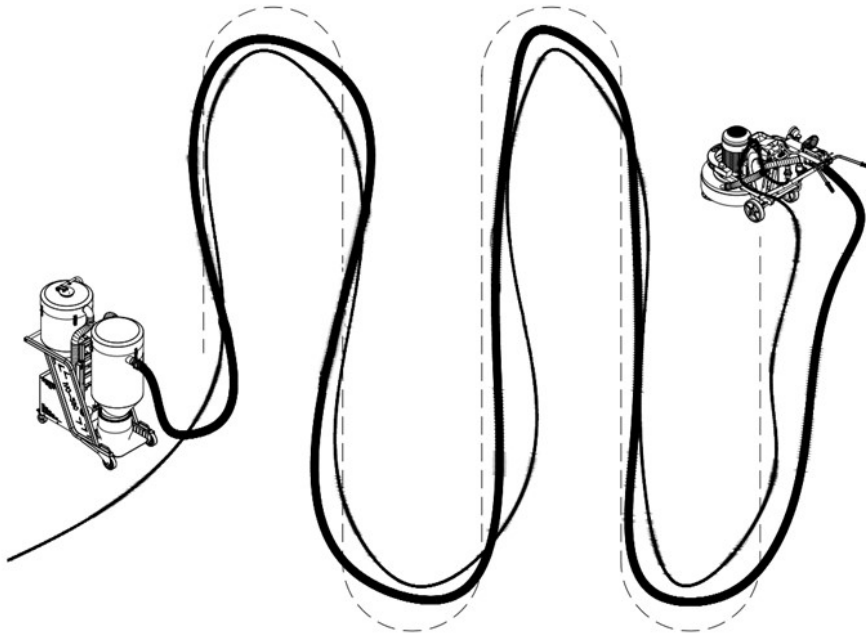
1. Make sure the power plug and socket are firmly connected;
2. Before plugging in the power plug, make sure the emergency stop has been pressed and other switches have been reset;

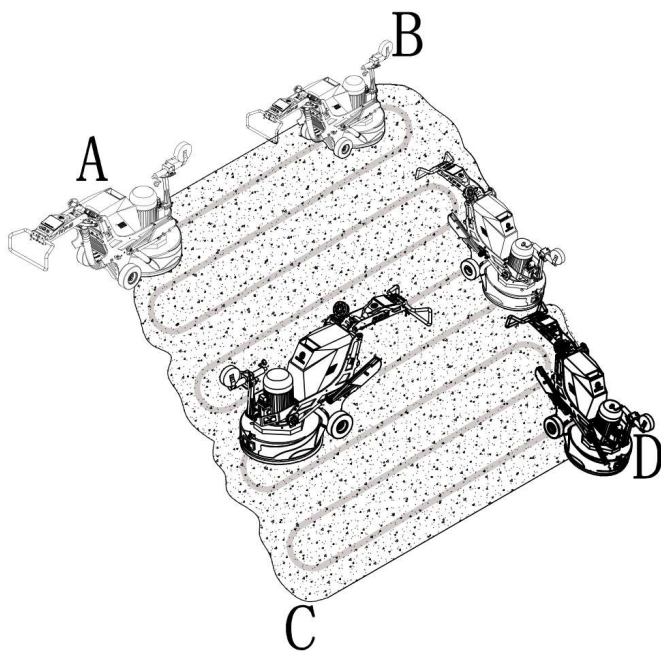
3. Please use the power cord according to the minimum specification of the wire (add page number after typesetting) ;

4. Please use the correct power supply.

4.6 Best grinding route

When grinding the ground, you should grind the ground according to the # word, so that the grinding effect will be better. When grinding the ground according to #, the grinding direction of the grinder should be such that the wire is pulled farther and farther away, so as to further prevent the wire from interfering with the normal operation of the grinder.





Note: The machine model in the above picture can be ignored, it is only for reference of grinding route and winding method.

4.7 Precautions



Please read the following content carefully, otherwise unnecessary harm may occur.

1. During the grinding process, be sure to pay attention to the working conditions reflected by the working indicator light on the electronic control at all times.
2. When grinding, pay attention to observing the wire while grinding to prevent the wire from being compressed.
3. During the grinding process, be sure to pay attention to obstacles nearby to avoid machine damage and personal injury.
4. The safety of the working area should be checked before grinding. For details, see.

5. Equipment maintenance

5.1 Overview

We recommend regular inspections of the grinder to extend the life of the grinder.

Notice:

During maintenance and repairs, the grinder must be disconnected from the power supply.

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

5.2 Daily inspection

5.2.1 Check switch

Connect to the power supply and detect the emergency stop, machine start, speed adjustment and other functions of the control panel.

Notice:

For safety reasons, it is strongly recommended to remember to press the emergency stop switch when stopping the machine and reset all switches, which is safer.

5.2.2 Check the grinding disc cover

When there is a lot of dust, it is easy to cause dust to clog the suction nozzle on the grinding disc cover. Use a flashlight to illuminate the suction nozzle to see if there is dust blockage and clean it if necessary.

5.2.3 Check the grinding disc

When the grinder works for a long time or there is a lot of grinding dust, the conversion block part of the grinding head may be stained with dust. If too much dust is not cleaned in time, the grinding head and the conversion block will not fit well, affecting the Grinding efficiency, more serious may cause accidents caused by the abrasive falling, remember to clean it when necessary.

5.2.4 Note



Remember to use protective equipment such as protective gloves, protective masks, insulated shoes, etc. when performing maintenance inspections.

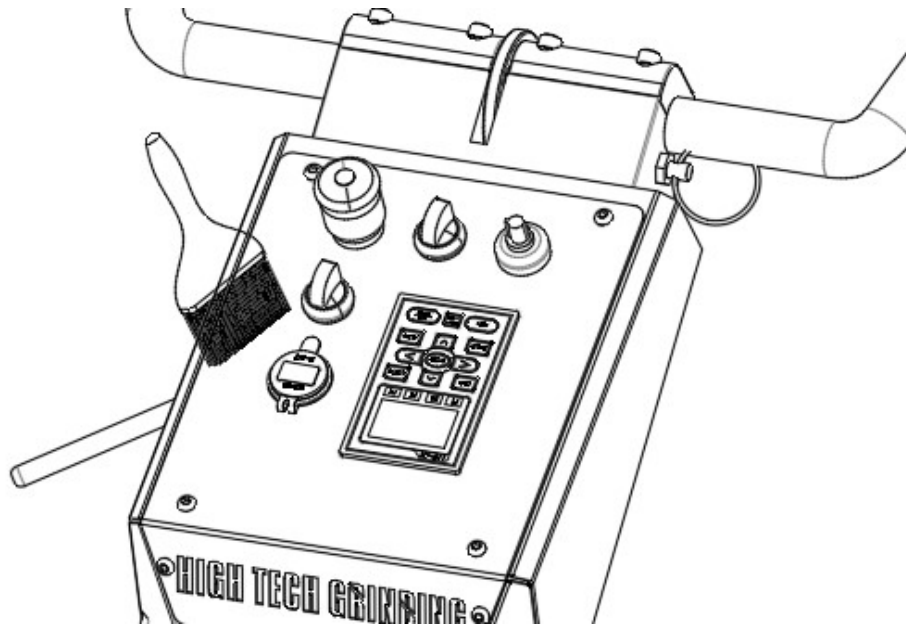
Inspection and maintenance can only be carried out after pressing the emergency stop and unplugging the power supply.

When tilting the machine, remember to try to see if the machine is flat before inspecting the grinding disc.

4.8 Cleaning

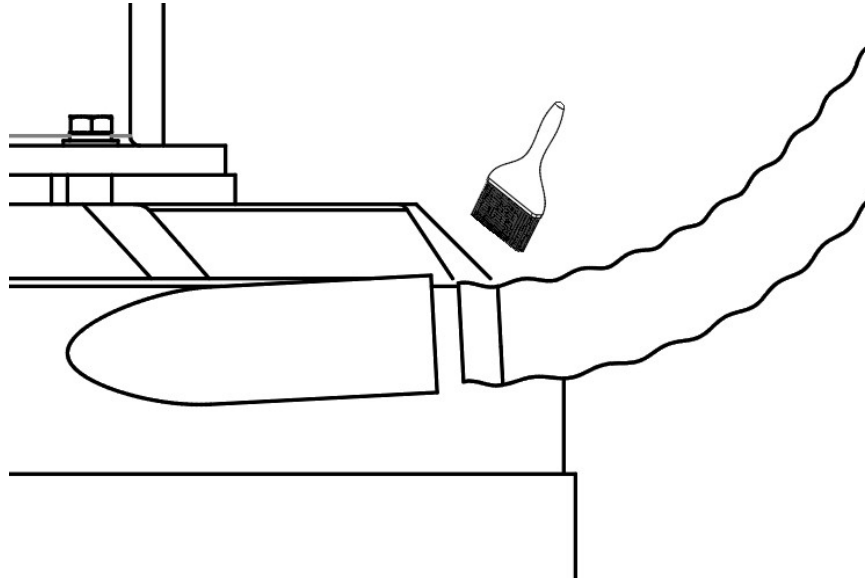
5.3.1 Cleaning the switch

When the grinder is working on the construction site for a long time, dust will inevitably run into the switch. Therefore, after each operation of the grinder, you should check whether the switch part is blocked by dust, which may cause the switch to malfunction.



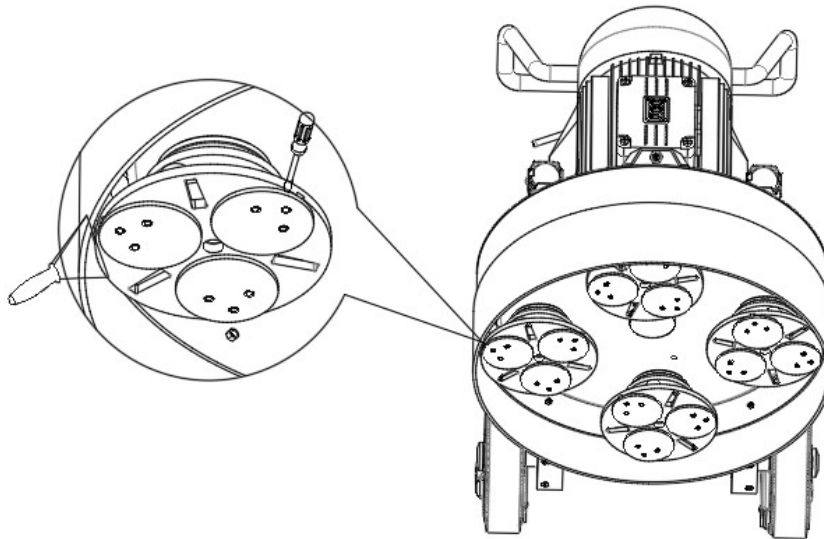
5.3.2 Clean the grinding disc cover

Remove the vacuum hose interface, use a flashlight to illuminate the vacuum nozzle, and use a brush to clean the dust at the vacuum nozzle. This prevents it from clogging the vacuum nozzle and affecting the efficiency of vacuuming.



5.3.3 Clean the grinding disc adapters

Tilt the equipment, use a flathead screwdriver to remove the grinding disc, and use a brush to remove the dust. If it is not cleaned in time, the grinding discs may not be firmly bonded and the grinding discs may fly during the grinding process, causing equipment damage and personal safety threats.



5.3.4 Note



1. Be sure to unplug the plug from the socket before cleaning, maintenance or assembly.

2. Be sure to clean the entire machine after every day's work. Do not use a pressure washer to clean the machine directly.

5.3.5 Overload protection

The inverter of this equipment is equipped with overload protection. When the equipment is overloaded, the display on the control panel will show that the equipment is overloaded. At this time, it is necessary to cut off the power, reduce the load, and let the machine stop working for 10-30 minutes (depending on the heat of the motor) (determined) and then start the machine again.

5.3.6 Maintenance

Any repairs that may be required must be performed by Xingyi service center trained service personnel and using Xingyi original parts and accessories. If your device requires service, please contact your retailer.

5. Frequently asked questions and solutions

This chapter describes some possible failures and how to deal with them. If this cannot be resolved or an error occurs, please contact your nearest retailer.

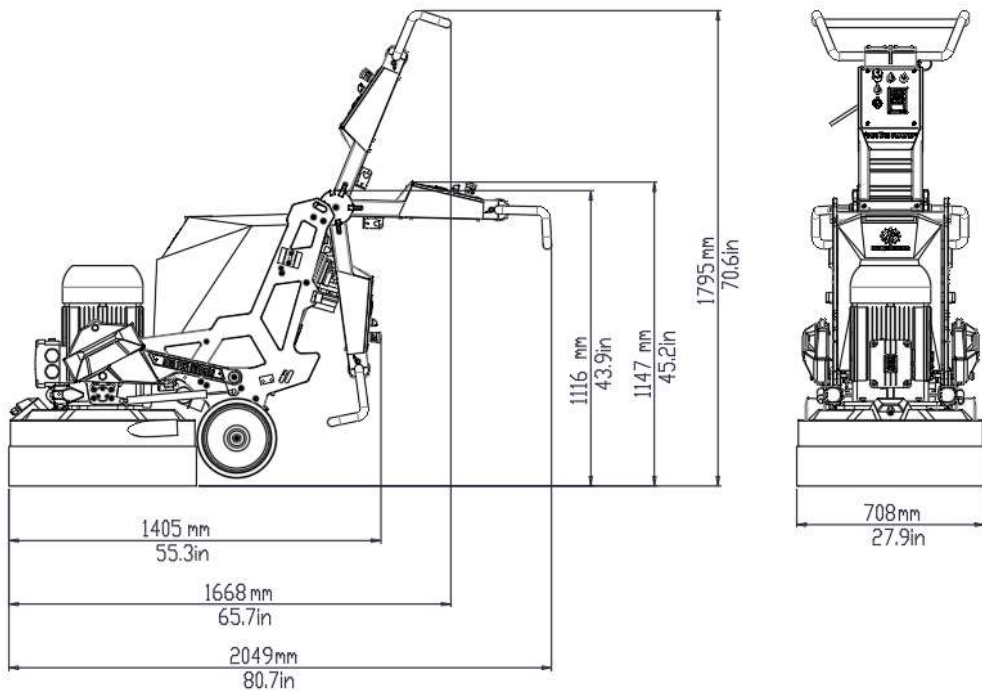
question	possible reason	Solution
Machine does not start	The emergency stop switch is pressed	Turn on emergency stop switch
	overload	After reducing the load, try starting again
	Damaged power supply and power cables	Contact a licensed electrician
	There is a problem with the motor start switch	Replace the start switch
Machine starts and then stops	overload	After reducing the load, try starting again
The machine is difficult to control or the motor consumes large current	Too few diamonds under the machine or wrong type of tool applied	Use recommended abrasive specifications and quantities
Machine beats	The abrasive may not be installed correctly or be at a different height	Correct installation of abrasives with the same height
	Is the chassis flat?	Adjust and install the chassis

7. Technical Parameters

	HTG680PRO
Motor Power	11KW /15HP
Rated voltage	1P208V
Rated current	52.9A
Enter Hertz	50HZ/60HZ
Inverter power	22KW/15HP
grinding width	678 mm/26.7in
Grinding disc size	Φ 230mm/Φ9.1in
Grinding speed	350 – 1950 r/min
Grinding (weighted iron first)	266kg _
Grinding (weighted iron in the middle)	194.5KG
Grinding and pressing (weighted iron comes after)	175.5KG _ _
Dimensions (warped position) length × width × height	1668×708×1795mm/65.7×27.9×70.6in
Dimensions (working position) length × width × height	2049×708×1147mm/80.7×27.9×45.2in
Dimensions (packaging position) length × width × height	1405×708×1116mm/55.3×27.9×43.9in
longest × widest × tallest	2049×708×1795mm/80.7×27.9×70.6in
Total Weight	472KG
Wire model	3*10awg+1*12awg
storage temperature	- 20 ~ +60° C / - 4 ~ +140° F

Operating temperature	-10 ~ +40° C / +14 ~ +104° F
humidity	Below 95% (no condensation)

The technical data and dimensions of the device are as follows :



8. Warranty

Warranty regulations

Xingyi does not bear the cost of machine damage caused by improper transportation, unpacking and improper use. Local distributors may be subject to specific warranty terms, please contact with your local distributor for specific warranty terms.