



Manual Dresser (New-ETD)

Instruction Manual

Please read this manual before using KYOKUTOH'S manual dresser (New-ETD)



REVISION

Revision history

Version	Date	Contents
First edition	06.23.2011	First edition issue
Revised edition	03.05.2019	Change Contacts page Change of address in China
Revised edition	May.2019	Format change

ATTENTION TO SAFETY

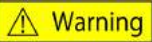

Please be sure to read **ATTENTION TO SAFETY** before using New-ETD

■ FEATURES



This manual dresser “New-ETD” is intended for reshaping deformed tip spot face due to resistance welding in manufacturing line. This product is not to be used in any manner other than that which is specified within. We will not be held responsible for damage or injury caused as a result of misuse of this product.

■ SYMBOLES

This following symbols “Warning” and “Caution”, are used indicate possible hazards and to prevent their occurrence.











 Warning	Be careful to follow directions as specified, as an error could lead to possible injury or death.
 Caution	Be careful to follow direction as specified, as an error could lead to malfunction and serious damage.


■ The following symbols are explained below.

	This symbol indicates operations that should not be done.
	This symbol indicates operation that should be done.

※After reading, please the manual to the place where you can check the manual.

 Warning

<p> Absolutely never disassemble or reconfigure this machine or its parts.</p> <p>○ This could result in operation malfunction, ignition, or injury.</p>	<p> Do not insert a finger or hand into gear opening while in operation.</p> <p>○ It may get caught and cause serious injury.</p>
<p> Wear light dresses and do up a cuff and tie so that they won't be sucked in rotating part..</p> <p>○ It may get caught and cause serious injury.</p>	<p> Stop air supply before "exchange parts" or "maintenance".</p> <p>○ This could result in serious injury.</p>
<p> Stop air supply for installation or uninstallation of air pipe.</p> <p>○ This will result in serious injury.</p>	<p> Do not use acidic or chlorine detergents for maintenance purposes.</p> <p>○ Poisonous gas may be generated from the detergents, causing a possible health risk.</p>
<p> Remove alcohol or thinner properly after maintenance.</p> <p>○ The flying sparks can cause fires or explosion.</p>	<p> Do not operate a dresser near dangerous objects which catch fire, for instance gasoline, gas, paint and adhesive.</p> <p>○ Chips splash on highly flammable substances may cause fire.</p>
<p> Please consider safe location for peripheral equipment when you work in manufacturing line.</p> <p>○ Follow the factory rules. This will result in serious injury.</p>	<p> For your safety, please use an eye shield, a hard hat, an earplug, an antidust mask, and safety shoes.</p> <p>○ Follow the factory rules. This will result in serious injury.</p>

 Caution



<p> Please always stabilize a step and work with the right posture. Working with unstable posture is dangerous.</p> <p>○ This could result in injury.</p>	<p> Please do not bring a dresser closer than other worker. Worker's legs may get stuck with hose or hit tools.</p> <p>○ This could result in injury.</p>
---	---

Table of Contents

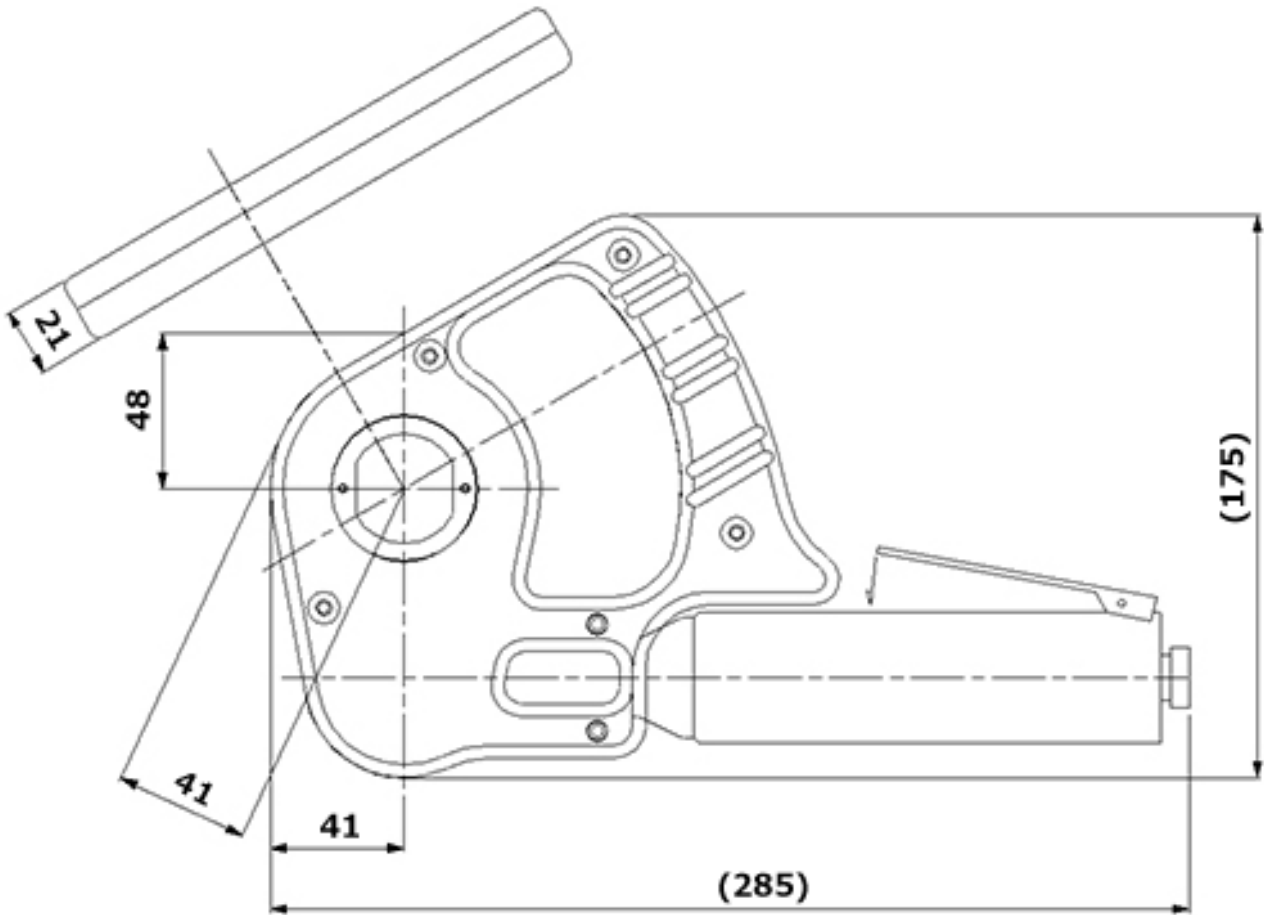
1.	Product Description	_____	2
2.	Precaution	_____	4
3.	How to Use	_____	5
4.	How to Change Cutter	_____	7
5.	Procedure for the Selection Cutter	_____	10
6.	Troubleshooting	_____	11
7.	Consumption Parts List	_____	13
8.	Maintenance	_____	14
	Contact	_____	16

1. Product Description

■ Specification

Power	Air Pressure (0.5MPa ~ 0.68MPa)
Minimum Hose Diameter	Φ8
Fitting Size	PT - 1/4
Weight	2.3kg

■ Exterior Dimension



■ Feature

- **Cutter and holder for simultaneous dressing upper and lower**

(Different from the conventional shape "KTW - * * and KTWH - * *".)

Cutter : ETD - * *

Holder : ETDH - * *

(Ex.) In the case of $\phi 16 - 6 - 8R \bullet \bullet \bullet$

Cutter : ETD - 12

Holder : ETDH - 12

Corresponding gun pressure up to 220 kgf

(Use "one side dressing cutter and case" for pressure over 220kgf.)

- **Pressureless (One side dressing) cutter and case**

(Different from the conventional shape "KM - * *".)

Cutter : ETDS - * *

Case : ETDSH - * *

(Ex.) In the case of $\phi 16 - 6 - 8R \bullet \bullet \bullet$

Cutter : ETDS - 12

Case : ETDSH - 12

2. Precaution

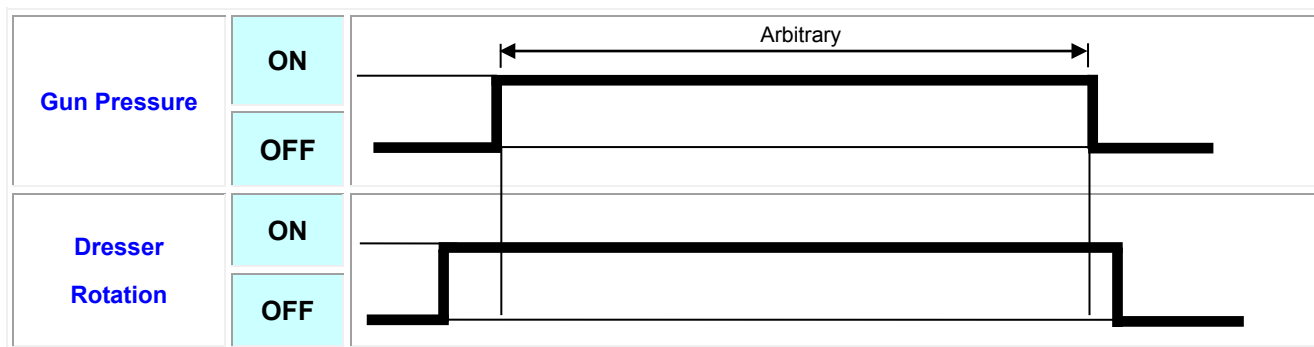
1. Use air hose of enough thickness (more $\phi 8$ inside diameter).
2. Use this product with air pressure 0.5Mpa~0.68Mpa.
It may cause a problem if higher air pressure will be used.
If less, poor performance.
3. Please supply clean and dry air for maintenance.
Using air 3 items (Filter, Regulator and lubricator) are recommended.
4. Refuel periodically, following "8. Maintenance".
5. Before using, be sure that electrodes and cutter shapes are correct.
6. Please make sure electric currency is disconnected during gun pressure.
7. Be sure that the gun pressure is in the range of setting value.
8. Please check cutter and holders are fixed in New-ETD properly.
9. Do not through, drop, or give great shock to this machine.
This could cause trouble and accident.
10. Using the hand dresser without pressure for a prolonged time could cause the dressers abrasion or other damage.
11. After completing the job, please disconnect air hose.

3. How to Use

■ Cutter and holder for simultaneous dressing upper and lower

Timing Chart

ETD type cutter (Only clockwise rotation)



Procedure

- ① Start motor to clockwise before gun press.
 - ② Please set pressure time(Dressing time) arbitrarily.
 - ③ To finish dressing, release the gun pressure while dresser is removing.
- Before operating, make sure that the forms of the cutter and tips are fitting.
The hand dresser and tip face become vertical during pressure time.
 - Set the press power 1470[N] ~ 2450[N] (150kgf~220kgf).
 - In order to remove chip from cap tip face after dressing, open a gun arm and press hand dresser upper and lower cap tips.

■ Pressureless (One side dressing) cutter and case

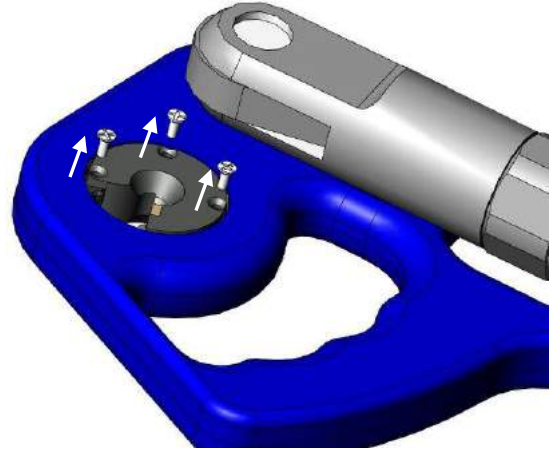
Procedure

- ① Press hand dresser on cap tips.
 - ② Rotate the hand dresser.
- Before starting above operation, make sure that the forms the cutter and tip are fitting.
 - Please do not pressurize the hand dresser. The cutter and cutter case can be broken.
 - Pressurize hand dresser vertically on cap tips.

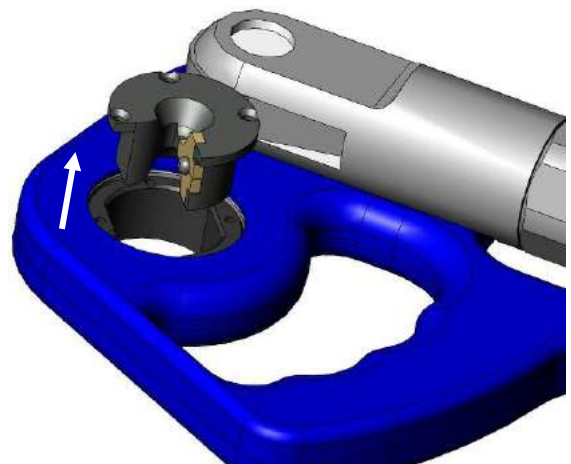
4. How to Change Cutter

■ Cutter and holder for simultaneous dressing upper and lower

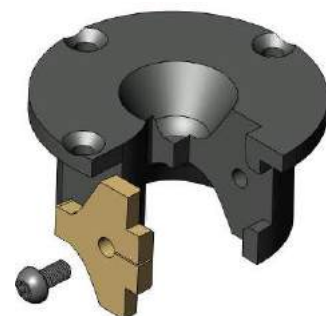
1. Remove M3 screw from the cutter holder.



2. Remove the cutter holder from the dresser.



3. To remove the cutter from the cutter holder, loosen the M3 torque screw.
(With a torque wrench T-10)



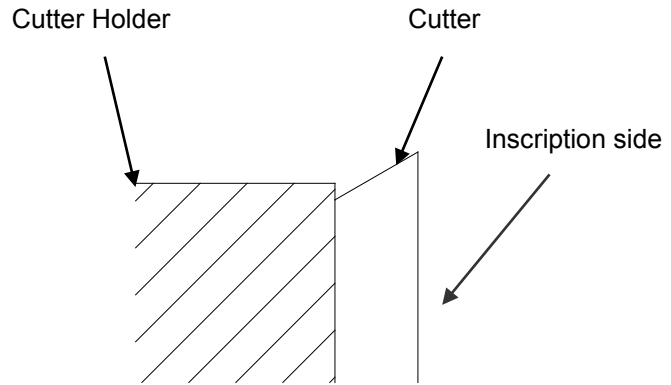
4. Replace a new cutter.

Confirm cutter is replaced in the proper direction.

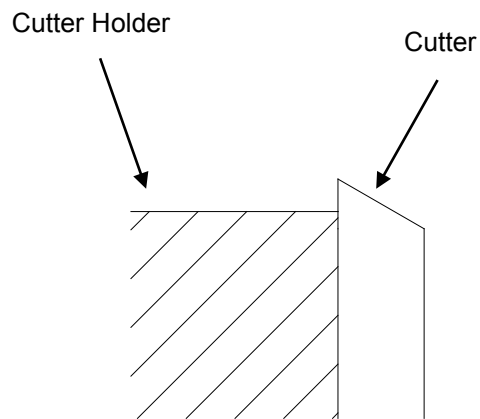
Please install the angle narrow on the side where touches the holder (Inscription side).

(Recommended torque for M3 screw is to 10~12Kgf • cm)

OK



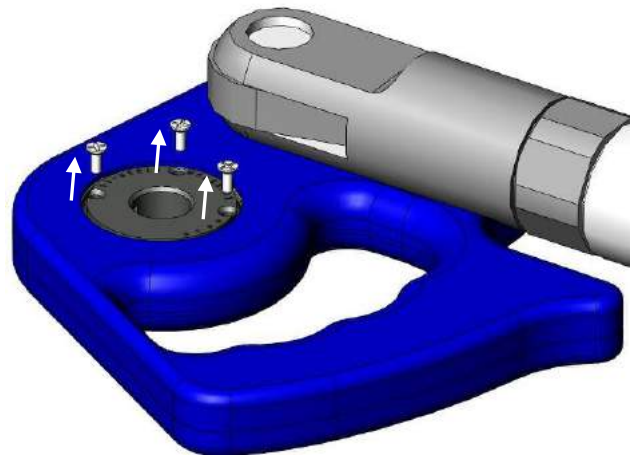
NG



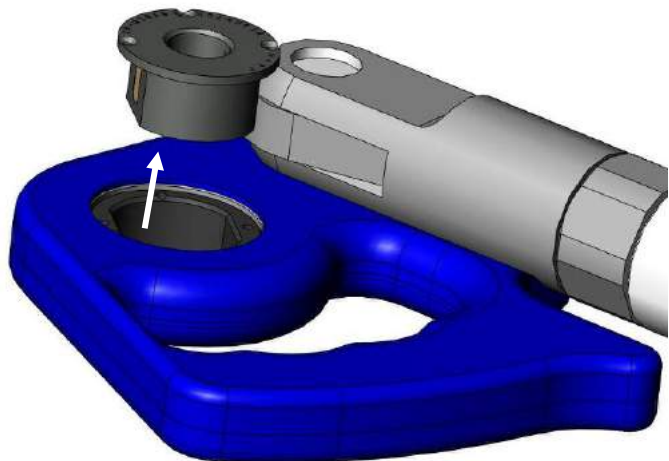
5. To install the cutter holder to the dresser. Please do the reverse order from 1 to 2.

■ **Pressureless (One side dressing) cutter and case**

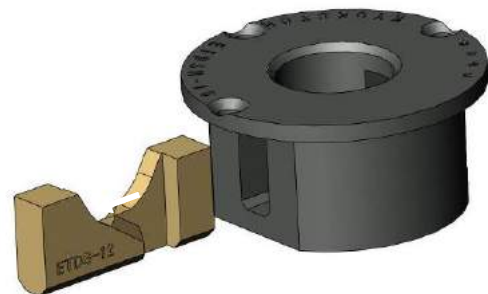
1. Remove M3 screw from the cutter case.



2. Remove the cutter case from the dresser.

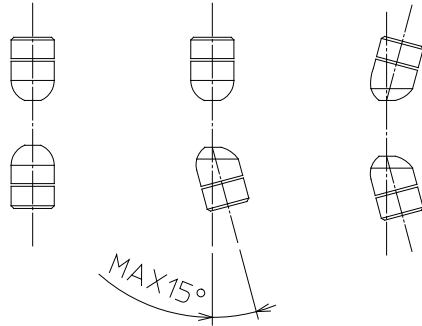


3. Remove the cutter case from the dresser.

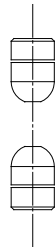


4. Do the reverse order from 1 to 3.

5. Procedure for the Selection Cutter



Cutter and holder for simultaneous dressing upper and lower			
Upper	Lower	Cutter	Holder
Φ6×R8	Φ6×R8	ETD - 12	ETDH - 12



Pressureless (One side dressing) cutter and case			
Upper	Lower	Cutter	Case
Φ6×R8	Φ6×R8	ETDS - 12	ETDSH - 16

※Please inquire us for the other tip spot shape.

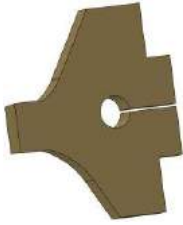

6. Troubleshooting

Abnormal Condition	Cause and Countermeasure
Dresser does not rotate.	<ul style="list-style-type: none"> * The regulation air pressure is not secured. → Check the air pressure. * The Gun pressure is higher than specified by our company. (Simultaneous dressing) → Set the pressure under 2,450 N (220Kgf). * Motor is broken. → Need repair to replace the motor. * The shapes of the cutter and the cap tip are not fitting, and cling each other. → Check the cutter shape and replace it if necessary.
The motor is running, but the cutter does not rotate.	<ul style="list-style-type: none"> * Gear in the gear box is broken. → Need repair to replace the gear.
The diameter of the dress cap tip is different from the setting.	<ul style="list-style-type: none"> * Dressing time is too short. → Set the dressing time longer. * The cutting capability of the cutter has deteriorated or the cutter has been damaged. → Replace the cutter and check the gun pressure. * Dressing point is not proper. → Pressurize hand dresser vertically on cap tips for dressing. * The cutter is not suitable for the cap tip. → Check the cutter shape and replace it if necessary. * Gear in gear box is broken. → Need repair to replace the gear. * The screw which fastens the cutter to the holder is loosen. → Tight the screw.
Abnormal sound during dressing	<ul style="list-style-type: none"> * Dressing point is not proper. → Pressurize hand dresser vertically on cap tips for dressing. * The cutter has been damaged. → Replace the cutter and check the gun pressure.

Abnormal Condition	Case and Countermeasure
The cap tip face has barr after dressing.	<ul style="list-style-type: none"> * Wrong control approach <ul style="list-style-type: none"> → Open the gun arm while the dresser is operating and stop using the dresser. (For using simultaneous dressing) * The shaps of the cap tips and the cutter are not matched. <ul style="list-style-type: none"> → Check the cutter shape and replace it if necessary. * Cutter has been damaged. <ul style="list-style-type: none"> → Replace the cutter, or check the gun pressure. * The screw which fastens the cutter to the holder os loosen. <ul style="list-style-type: none"> → Tighten the screw.
The tip diatemer is not at the center or the desinated location.	<ul style="list-style-type: none"> * Dressing point is not proper. <ul style="list-style-type: none"> → Pressurize hand dresser vertically on cap tips for dressing.
Dressing does not complete in the set time.	<ul style="list-style-type: none"> * The cutting capability of the cutter has deteriorated or the cutter has been damaged. <ul style="list-style-type: none"> → Replace the cutter and check the gun pressure. * Holder has been consumed. <ul style="list-style-type: none"> → Replace the holder.
<p>(Remarks)</p> <ul style="list-style-type: none"> ◆ Please be sure the switch is off when you are checking or replacing parts or the cutter. ◆ When the dresser is out of order, please contact us immediately. Do not take the dresser apart. It would not be able to repair if you disassemble it. 	

7. Consumption Parts List

■Cutter and holder for simultaneous dressing upper and lower

	<ul style="list-style-type: none"> * Cutter Parts Number : ETD - ** Replacement Qty 1pc * Replacing cycle(In case of a using the gun with 150kgf~200kgf pressurization) 10,000 times when 3 sec./1 dress
	<ul style="list-style-type: none"> * Cutter Holder Parts Number : ETDH - ** Replacement Qty 1pc * Replacing cycle(In case of a using the gun with 150kgf~200kgf pressurization) 30,000 times when 3 sec./1 dress

■Pressureless (One side dressing) cutter and case

	<ul style="list-style-type: none"> * Cutter Parts Number : ETDS - ** Replacement Qty 1pc * Replacing cycle 10,000 times when 3 sec./1 dress
	<ul style="list-style-type: none"> * Cutter Case Parts Number : ETDSH - ** Replacement Qty 1pc * Replacing cycle 30,000 times when 3 sec./1 dress

8. Maintenance

Maintenance place	How to maintenance
Supply oil to air motor	Every time before you use a manual hand dresser, please pour oil from air inlet (#60 spindle oil) 0.5cc and operate hand dresser without pressure for 3~5 sec to blends thoroughly.

MEMO

Contacts

Contact us if there is any damage or machine defects in our products.



KYOKUTOH CO., LTD

181-1, Nakayashiki, Orido-cho, Nisshin, Aichi 470-0115 Japan

TEL +81-561-72-8811 FAX +81-561-72-8821

E-Mail: sales@kyokutoh.com

<http://www.kyokutoh.com>

KANTO SALES OFFICE

TEL +81-49-277-4324 FAX +81-49-277-4325

HIROSHIMA SALES OFFICE

TEL +81-82-569-6227 FAX +81-82-569-6228



CHANGER & DRESSER CORPORATION

1527 ITC Way, Anniston, AL 36207 U.S.A

TEL +1-256-832-4392 FAX +1-256-832-4393

<http://www.changer-dresser.com>



KYOKUTOH CHINA

73 Huagang Street, Xiuquan Town, Huadu District,
GuangZhou City, GuangDong Province, China.

TEL +86-20-86980880 FAX +86-20-86980890

<http://www.kyokutoh.com.cn>



KYOKUTOH THAILAND

339/2 Soi Phattanakarn 69, Phattanakarn Road, Prawet,
Bangkok 10250 THAILAND

TEL +66-272-162-82 FAX +66-272-162-84



KYOKUTOH KOREA

117, Tawon TAKRA II Industry Center, Dongsan-ro 76,
Danwon-gu, Ansan-si, Gyeonggi-do, Korea 15434

TEL +82-31-414-8730 FAX +82-31-414-8731



KYOKUTOH EUROPE

Radlkoferstr. 2 81373 Muenchen, Germany

TEL +49-89-7411-85313 FAX +49-89-7411-85315
