

Manual Dresser WPD-U18

Instruction Manual

To use the WPD-U18 correctly, please read through this instruction manual carefully before you use.



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1. Cautions

■Introduction





This product is intended to dress and restore cap tips that become flat while being used in a welding operation.

This product is not to be used in any manner other than that which is specified within.

We do not accept any liability for damage to property and persons that results from improper, non-conformance use of our equipment or from faulty installation or improper maintenance of this product.

※Once you have read this manual, keep in a place where you can find easily.

■Symboles

 Warning	Indicates a content that there is an assumable possibility of death or serious injury sustained if mishandled.
 Caution	Indicates a content that there is an assumable possibility of injury sustained or of property damage only if mishandled.
	This symbol indicates operations that should not be done.
	This symbol indicates operation that should be done.

■Recommended Air Pressure

Check your usage environment before you use.

Recommended air pressure is 0.49 ~ 0.68 MPa.

Excess or deficiency of air pressure may cause low performance.

■ Before Using

Warning

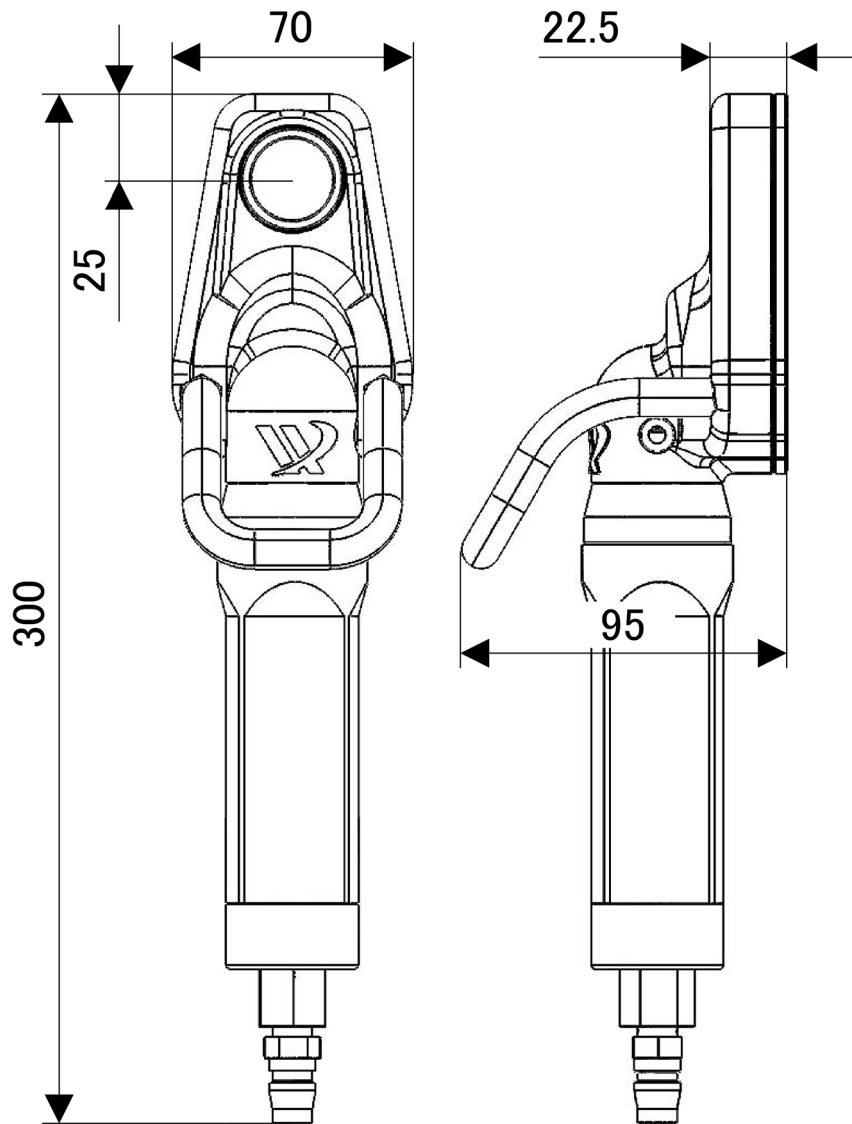
- For your safety, wear proper clothes. Always keep in mind your ties or cuffs never be caught by rotating dresser. Wear an eye shield, a hard hat, an earplug, an anti-dust mask, and a pair of safety shoes.
- Do NOT disassemble or modify this product.
- Do NOT use this product near flammable materials, such as gasoline, gas, painted adhesive.
- Be sure to switch off the air supply during maintenance or parts-replacement
- Do NOT work with a painful or other bad posture. Working with improper posture is dangerous and may cause.

Caution

- Supply clean, dry, oil-free compressed air.
Triad of air items (Filter, Regulator, and lubricator) is recommended.
- Use air hose that has enough thickness. (more $\phi 8$ inside dia.)
- Performance may decrease if oil, sputter, or chips are remaining.
- Air-motor or gear may have light fixation when you use for the first time or not be used for a long time.
Move the Output Gear with your hand to release the fixation.
- Do NOT use at place where spatter or water might contact the dresser.
- Stop air supply for installation or de-installation of air pipe. After completing the job, please disconnect air hose.
- Before you use, be sure that electrodes and cutter shapes are correct.
- Make sure that the Cutter is attached to the Holder properly and the screw is tightened before you use.
- Prolonged use without load running can cause abrasion or other damages to the dresser.
- Do NOT use for any other purposes or excess beyond ability.
- If you use alcohol, paint thinner or other volatile lubricants for maintenance purpose, make sure to wipe out before you use.
- After use, plug the air intake to prevent dust from entering.
- After completing the job, please disconnect air hose.
- Do not throw, drop, or shock physically. This could cause troubles or accidents.

2. Dimensions & Spec

■Dimensions

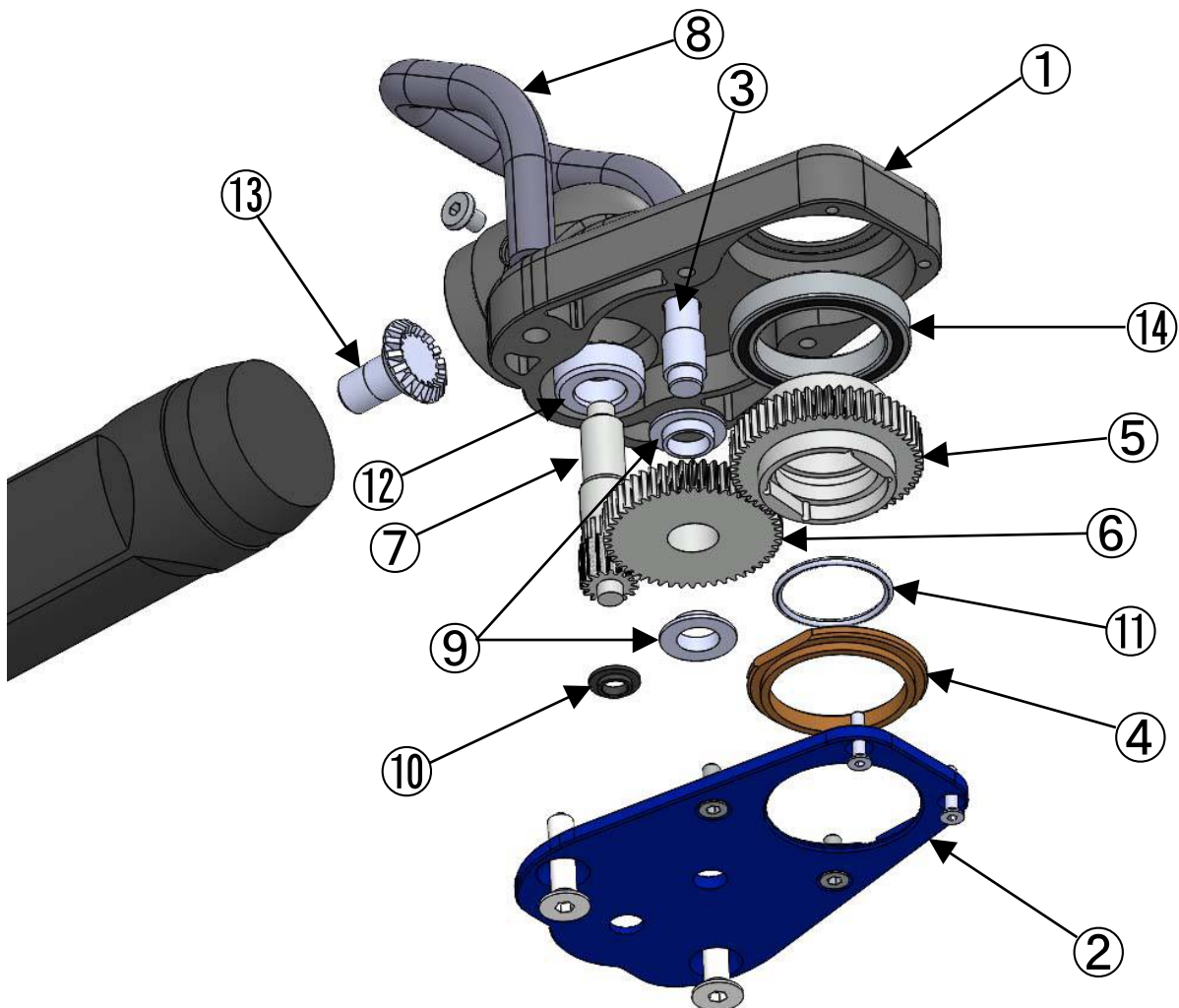


■Spec

Power	Air Pressure (0.49MPa~0.68MPa)
Minimum Hose dia.	φ8
Fitting Size	PT-1/4
Weight	1.92kg

3. Parts List

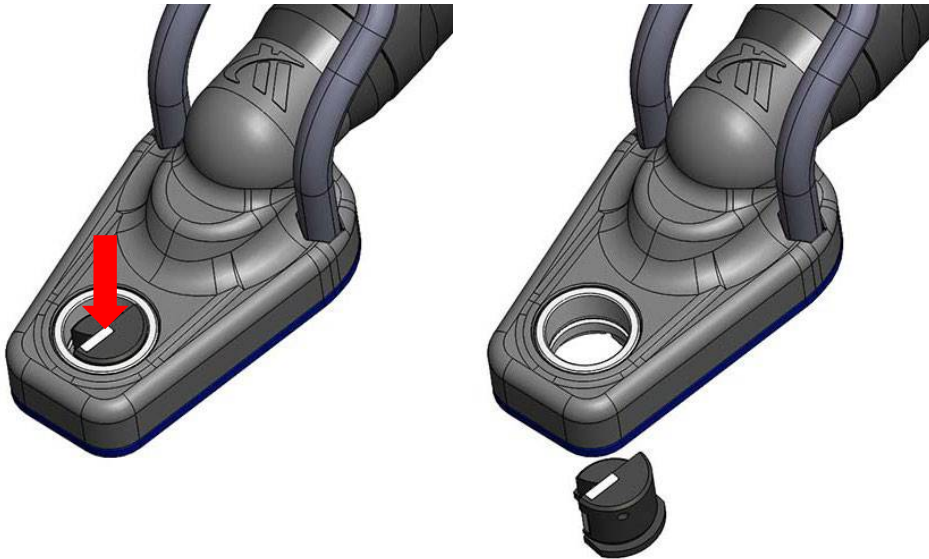
No.	Name	Model	QTY	Notes
1	WPD Body	WPD-BD-001	1	
2	WPD Bottom Cover	WPD-BC-001	1	
3	Shaft	WPD-GA-M08-SH-001	1	
4	Bush	WPD-GB-A-BS-001	1	
5	Gear A	WPD-GA-M08-A-001	1	
6	Gear B	WPD-GA-M08-B-001	1	
7	Gear C	WPD-GA-M08-C-001	1	
8	Arm	WPD-AM-001	1	
9	Resin Bush A	GFM-1012-04	2	
10	Resin Bush B	GFM-0608-04	1	
11	O-ring	CO 0519-A0	1	
12	Spindle Gear	WPD-GA-SPG-001	1	
13	Pinion Gear	WPD-GA-PNG-001	1	
14	Bearing	6806 LLB	1	



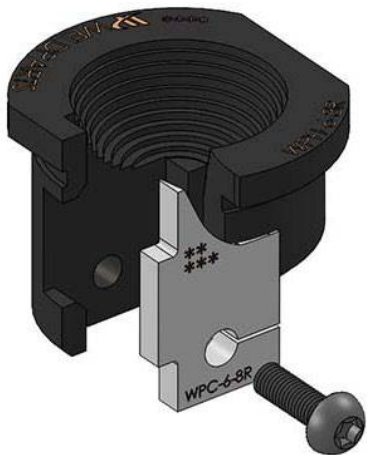
4. How to Change the Cutter / Holder

■Procedure

1. Remove the Holder. (Holder is fixed by "O-ring". Push the Holder.)



2. Remove the M3 torque screw from the Cutter / Holder and change the Cutter.



3. Attach the Holder to the dresser by doing reverse procedure.

Mind the orientation. Do NOT attach upside-down.



5. Maintenance

■Procedure

1. Every time before you use a manual hand dresser, please pour oil from air inlet (#60 spindle oil) 0.5cc.



2. Run the dresser without pressure for 3~5 sec to lubricate.

6. Troubleshooting

Abnormal Condition	Cause and Countermeasure
Dresser does not rotate.	<p>* The air pressure is too low or not supplied. →Check the air supply. →Check the air pressure and adjust it. (Recommended:0.49~0.68MPa)</p> <p>* Motor is broken. →Need repair to replace the motor.</p> <p>* 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.</p>
The motor is running but the cutter does not rotate.	<p>* Gear in the gear box is broken. →Need repair to replace the gear.</p>
The diameter of the dressed cap tip is different from the setting.	<p>* Dressing time is too short. →Increase the dressing time.</p> <p>* Cutter has been exhausted or damaged. →Check the time for replacement and replace the cutter.</p> <p>* Dressing point is not proper. →Check the position the cap tip and make sure if it is being vertical to the dresser when dressing.</p> <p>* The cutter is not suitable for the cap tip. →Check the cutter shape and replace it if necessary.</p> <p>* Gear in the gear box is broken. →Need repair to replace the gear.</p>
Abnormal sound during dressing.	<p>* Dressing point is not proper. →Check the position of the cap tip and make sure if it is being vertical to the dresser when dressing.</p> <p>* The cutting capability of the cutter has deteriorated or the cutter has been damaged. →Check the time for replacement and replace the cutter.</p>

<p>Dresser leaves burr on the cap tip.</p>	<p>* The shapes of the cutter and the cap tip are not fitting. →Check the cutter shape and replace it if necessary.</p> <p>* The cutting capability of the cutter has deteriorated or the cutter has been damaged. →Check the time for replacement and replace the cutter.</p> <p>* The Cutter fixing screw is loosened. →Tighten the screw.</p>
<p>The tip diameter is not at the center or the designated position.</p>	<p>* Dressing point is inappropriate. →Check the position the cap tip and make sure that it is being vertical to the dresser when being dressed.</p>
<p>Dressing does not complete in the set time.</p>	<p>* Cutter has been exhausted or damaged. →Check the time for replacement and replace the cutter.</p> <p>* Holder exhausted. →Replace with a new Holder.</p>

 Caution

◆ Be sure that the air-supply is completely disabled when you are checking or replacing the parts such as the Cutter.

◆ When the dresser is out of order, please contact us immediately.

Do not take the dresser apart. We will not repair if you disassemble it.

7. Replacement Parts List

	<p>Name : WPC/WPH set Model : WPSET-6-8R ◆QTY : 1set (Holder:1 pc、Cutter:3 pcs、Screw:3 pcs …included)</p> <p>Name : WPC Cutter ◆Changing Cycle : 10,000 times</p> <p>Name : WPH Holder ◆Changing Cycle : 30,000 times</p>
	<p>Name : Gear A Model : WPD-GA-M08-A-001 ◆QTY : 1 ◆Changing Cycle : 30,000 sec</p>
	<p>Name : O-ring Model : CO 0519-A0 ◆QTY : 1 ◆Changing Cycle : Attaching & detaching: 300 times</p>
	<p>Name : Bearing Model : 6806 LLB ◆QTY : 1 ◆Changing Cycle : 30,000 sec</p>

Contact

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



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