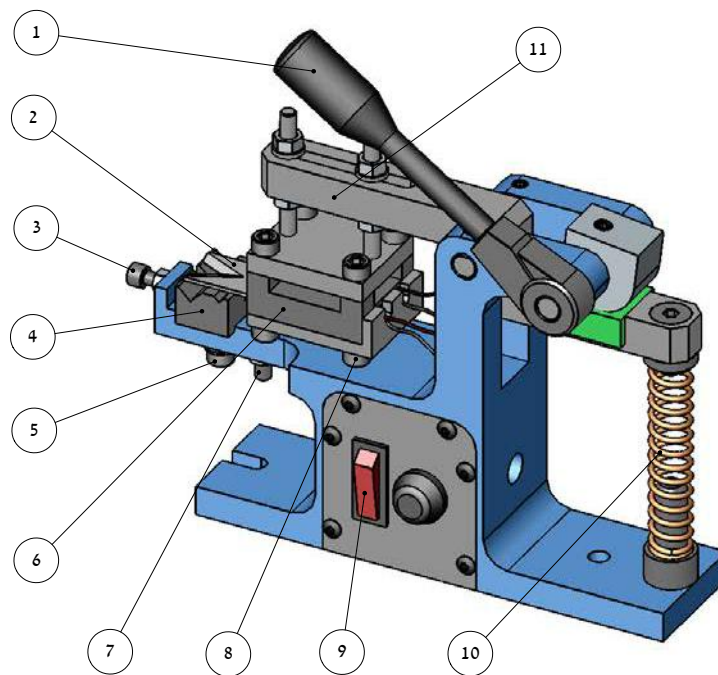


General Safety:

- Ensure that the unit is connected to the correct power source. Do not connect a 220 VAC unit to 110 VAC power or the reverse.
- The unit is fused for safety purposes. Before removing and replacing the fuse ensure that the unit is not connected to power.



Setup

1. Move the handle (1) up to lift the blade.
2. The Belt Plate (4) has two grooves suitable for the different diameters of round belts to be worked with. Select the groove according to the diameter of the belt being trimmed. To change grooves, back the adjusting screw (3) out until it is clear of the Belt Plate. Remove screw (5) and rotate the Belt Plate (4) to the desired groove. Reset screw (5) and finger tighten only. The Belt Plate should be snug but free to slide in its groove.
3. Set the profile to be cleaned in the groove. Return the handle to its forward and down position. The blade will now rest on the belt with the flash in the V of the blade. Using screw (3), position the working surface so that the bottom of the V in the blade is centered over the profile.
4. Tighten screw (5) and raise the handle up lift the blade.
5. Connect the Flash Trimmer to a source of power. Allow 10 minutes for the unit to come to its operating temperature.



NOTE: Do not touch the Blade Housing (6). It will be very hot when the unit is connected to power.

6. Place the belt to be trimmed on the Belt Plate with the flash (excess weld material) in the groove of the work surface. Bring the handle forward and down to lower the blade. Turn the belt a full 360° to clean the flash.

If the flash has been removed and the belt is clean you can continue with other belts.
If not then do one of the following:

The cleaned area is recessed – move the Belt Plate 0.5 mm out (away from the blade).

The cleaned area protrudes – move the Belt Plate 0.5 mm in (towards the blade).

Replacement / Sharpening of the Blade



NOTE: Before performing these steps ensure that the unit is not connected to power.

If you are going to sharpen the blade yourself, use a small sharpening stone and gently stroke the blade.
After sharpening, make sure there are no burrs or rough edges remaining.

The original shape of the V in the blade must be maintained in order to ensure clean and accurate work.

1. Release the spring (10) from the bottom of the arm (11).
2. Raise the arm (11) until it is straight up and the 4 screws (8) in the bottom of the Blade Housing can be reached with an allen wrench.
3. Loosen the 4 screws (8) on the lower section of the Blade Housing. Remove the blade from the Blade Housing.



NOTE: The blade is sharp. Take care when handling to avoid cuts.

4. Replace the blade with either a new blade or the sharpened blade. Push the blade in until it sits home fully.
5. Tighten the 4 screws (8).
6. Lower the arm (11) until it rests on the adjusting screw (7).



NOTE: Screw (7) is set to hold the blade up and prevent it from resting on the work surface. It does not require adjustment. The blade will rest on the profile being cleaned.

7. Set the upper portion of the spring against the bottom of the arm. Ensure that the spring rests over the projection on the bottom of the arm.