

Grinding table

Operating instructions EX-0-922-007

Edition 1, 2024-08-05

THERMACUT[®]
THE CUTTING COMPANY[®]

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1 Identification

These operating instructions describe the grinding table. When used in these operating instructions, the term "product" always refers to the grinding table.

The grinding table is a stationary solution for extracting and collecting the fumes and dust produced during grinding processes.

1.1 Signs and symbols used








In these operating instructions, the following signs and symbols are used:

▶	General instructions.
1.	Steps to be carried out in succession.
-	Lists.
⇒	The cross-reference refers to detailed, supplementary or further information.
A	Caption, item description.

1.2 Classification of the warnings

The warning notices used are divided into four different levels and are printed in front of potentially dangerous work steps.

Depending on the type of danger, the following signal words are used:

 DANGER	
	<p>Describes an imminent danger. Will result in death or serious injuries if not avoided.</p>
 WARNING	
	<p>Describes a potentially dangerous situation. May result in death or serious injuries if not avoided.</p>
 CAUTION	
	<p>Describes a potentially damaging situation. May result in slight or minor injuries if not avoided.</p>
NOTE	
	<p>Describes possible property damage. If the notices is not followed, irreparable damage to the product or equipment can be the result. Work results may be impaired.</p>

1.3 Product label

This product fulfills the requirements that apply to the market to which it has been introduced. A corresponding marking has been affixed to the product, if required.

2 Safety

This chapter describes the essential safety requirements and warns of residual hazards that should be kept in mind, to keep the product safely. Non-observance of the safety instructions may result in risks to the life and health of personnel as well as cause environmental or material damage.

2.1 Intended Use

The product is used for extracting and collecting fumes and dust during grinding and polishing. The product can be used with filter systems or central extraction systems to extract and filter the fumes and dust produced during the machining of steel with an alloy content of nickel and chrome under 30%. The product must not be used for grinding or polishing aluminum.

- ▶ Only operate the product with original THERMACUT spare parts.
- ▶ Do not exceed the maximum load data given in the documents. Excess loads will lead to irreparable damage.
- ▶ Do not make any structural modifications to the product.
- ▶ Use the product only in a closed environment.
- ▶ Do not use or store the product in wet conditions.
- ▶ Only store the product outdoors when sufficiently protected against the influences of the weather.

The product may only be used for the purpose and in the way described in this document. Any other use is considered non-intended. Unauthorized conversion work or modifications to increase performance are not permissible.

2.2 Responsibilities of the Operator

- ▶ Keep non-suitably qualified people out of the work area.
- ▶ Ensure that only suitably qualified personnel perform work on the product or system.

Suitably qualified personnel are:

- those who are familiar with the basic regulations on occupational safety and accident prevention;
- those who have been instructed on how to handle the product;
- those who have read and understood all related documentation;
- those who have been trained accordingly;
- those who are able to recognize possible risks because of their special training, knowledge, and experience.

2.3 Warnings and Information Signs

The following warning, notice and mandatory signs can be found on the product.

These markings must always be legible. They may not be covered, obscured, painted over, or removed.

	▶ Wear a respiratory mask.
	▶ Wear safety goggles.
	▶ Wear a protective suit.
	▶ Wear protective gloves.
	▶ Read and follow the operating manual.
	▶ Do not throw any cigarettes or burning objects into the product.

2.4 Safety instructions

2.4.1 Basic safety instructions

The product has been developed and manufactured in accordance with the latest technology and recognized safety standards and directives. Due to the product design, unavoidable technical residual risks exist to the user, third parties, devices, and other material property. The manufacturer will accept no liability for damage caused by non-observance of the documentation.

- ▶ Please read the documentation carefully before using the product for the first time and comply with the instructions contained.
- ▶ Only operate the product in technically perfect condition and ensure compliance with all documentation.
- ▶ Read the documentation carefully before carrying out specific work, for example, commissioning, operation, transport, and maintenance.
- ▶ Use suitable means to protect yourself and bystanders from the hazards listed in the documentation.
- ▶ Store the documentation within easy reach of the product for reference and enclose all documents when passing on the product.
- ▶ Consult the documentation for the other components used.
- ▶ Observe the local accident prevention regulations.
- ▶ Only trained specialists should commission, operate, and service the device. Qualified personnel are persons who, based on their special training, knowledge, experience and due to their knowledge of the relevant standards, are able to assess the tasks assigned to them and identify possible dangers.
- ▶ Ensure the work area is well lit and keep it neat and tidy.
- ▶ For disposal, observe the local regulations, laws, provisions, standards, and directives.

2.4.2 Safety instructions for grinding

- ▶ Grinding can damage eyes, skin and hearing. Note that further hazards can occur in connection with other grinding components. For this reason, always wear the mandatory protective clothing in accordance with local laws and directives.
- ▶ All metal vapors, especially lead, cadmium, copper and beryllium, are harmful. Ensure sufficient ventilation or extraction. Do not exceed the applicable occupational exposure limits (OEL).
- ▶ Adhere to the general fire protection regulations and remove flammable materials from the vicinity of the grinding work area prior to starting work. Provide suitable fire extinguishing equipment in the work area.

2.4.3 Safety instructions for personal protective equipment

- ▶ Do not wear any loose clothing or jewelry.
- ▶ Wear a hairnet over long hair.
- ▶ Note local laws and directives concerning protective equipment.
- ▶ Make sure that any third parties in the direct vicinity are wearing personal protective equipment.
- ▶ Wear your personal protective equipment according to the hazard.

2.4.4 Safety instructions for grinding fumes and dust

The product contains harmful dust that can collect on surfaces and penetrate the ambient air as of the first use. They can damage the respiratory system when inhaled.

- ▶ Check and wear your personal protective equipment.
- ▶ Only use the product in rooms which are sufficiently ventilated.
- ▶ Make sure that all the seals on the product are free of dirt.
- ▶ Remove dust deposits in the surrounding area immediately using an industrial vacuum cleaner of dust class H or a damp cloth.
- ▶ The filtration system provided must be used when operating the product.

The extraction of substances and materials which are combustible, aggressive, chemical or contain oil vapors as well as aluminum or magnesium dusts can lead to fire and explosion due to chemical reactions. Serious injuries and irreparable damage to the product can be the result.

- ▶ Only ever use the product as intended.
- ▶ Use a suitable filter system.

2.4.5 Safety instructions for emergencies

- ▶ In an emergency, immediately disconnect all supplies (e.g. electrical power supply, coolant supply, compressed air supply, shielding gas supply).
- ▶ Extinguish burning oil or emulsions using a CO₂ or powder fire extinguisher.

3 Scope of Delivery

The following components are included in the scope of delivery:

- 1 × grinding table
- 1 × operating instructions
- ▶ Order the equipment parts and wear parts separately.
- ▶ The order data for the equipment parts and wear parts can be found in the current order documents.
- ▶ For more information about points of contact, consultation, and orders, visit www.thermacut.com.

Although the items delivered are carefully checked and packaged before dispatch, it is not possible to fully exclude the risk of transport damage.

Goods-in inspection

- ▶ Use the delivery note to check that everything has been delivered.
- ▶ Check the delivery for damage (visual inspection).

Complaints

- ▶ If goods are damaged, contact the final carrier.
- ▶ Keep the packaging for a possible check by the carrier.

Returns

- ▶ Use the original packaging and packing material for returns.
- ▶ If you have questions concerning packaging and safety during shipment, contact your supplier, carrier, or transport company.

4 Product Description

4.1 Structure and Function

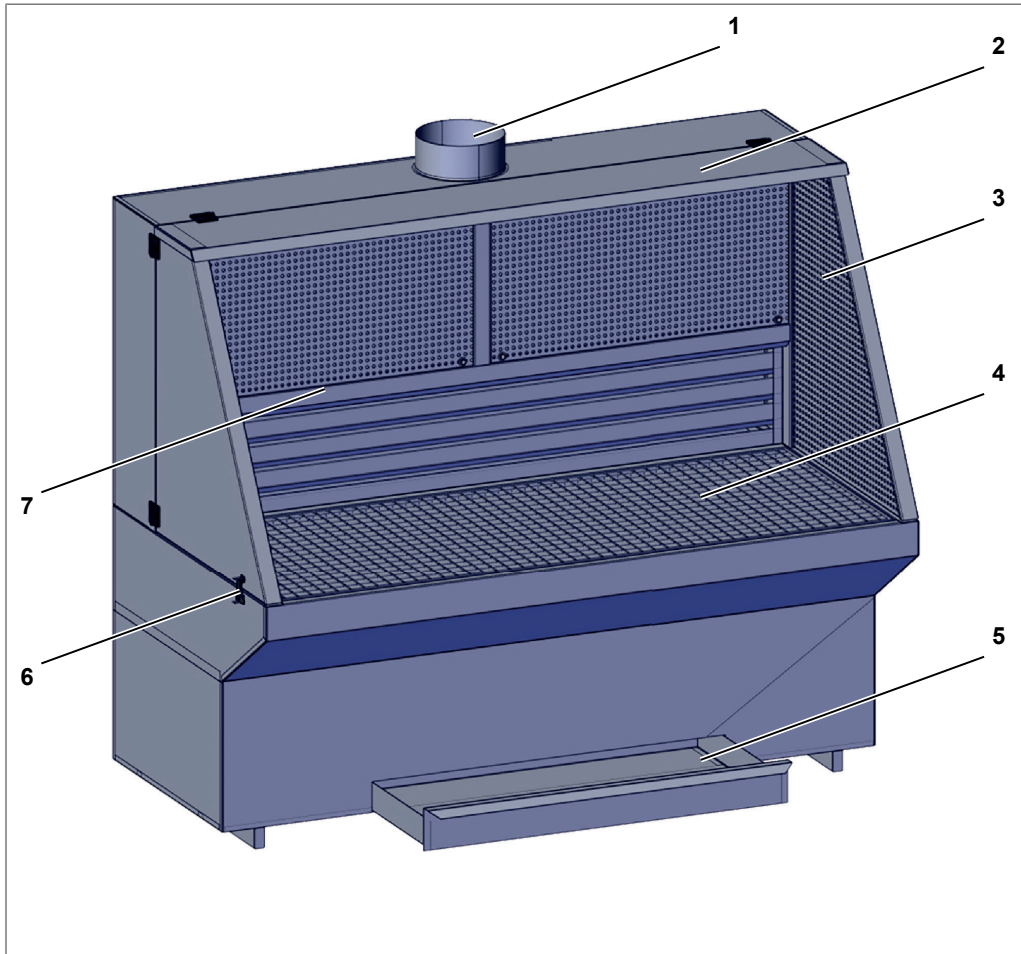


Figure 1 Structure and function

1	Connection piece	2	Top cover
3	Winged door	4	Grating
5	Dust collecting container	6	Tension locks
7	Slats		

During grinding processes, fumes and dust that are hazardous to health are produced, and these can be extracted and collected by the table and a connected filter system.

Fumes and dust are drawn downwards by the extraction section of the table and through the grating and through slats on the rear panel into the exhaust air duct and then into the filter system mounted on the table. During grinding, sparks, metal splatter and coarse dust particles drop downwards and are collected in an extractable dust collecting container.

The table has two winged doors and a top cover for the working area to be enlarged for bulky components.

The following filter systems can be connected to the product:

- HERR filter system, e.g. 880200-40

5 Technical data

5.1 Ambient conditions

Temperature of the ambient air	-10 °C to +40 °C
Relative air humidity	80% non-condensing

Table 1 Ambient conditions for transport and storage

Temperature of the ambient air	+10 °C to +40 °C
Relative air humidity	70% non-condensing

Table 2 Ambient conditions for operation

5.2 Product Data

	EX-0-716-040	EX-0-716-041
Dimensions (L × W × H)	1010 × 1000 × 1700 mm	1510 × 1000 × 1700 mm
Working depth	750 mm	
Weight	220 kg	285 kg
Capacity of dust collecting container	26 l	40 l
Nominal diameter for DN intake piping	Ø 250 mm	
Air volume required	2000 m ³ /h	3000 m ³ /h
Max. load	350 kg with even load per area unit	

Table 3 Product data

6 Transport and Setup

⚠ WARNING**Risk of injury due to improper transport and setup**

Improper transport and setup can cause the product to topple or fall over. Serious injuries can be the result.

- ▶ Check and wear your personal protective equipment.
- ▶ Place the product on a suitable base (flat, solid, dry) on which it will not topple over.
- ▶ Take the weight of the product into account when lifting it. ⇨ 5 *Technical data* (Page 11)
- ▶ Use an appropriate lifting tool with load handling attachment for transport and setup of the product.
- ▶ Avoid jerky lifting and set-down of the product.
- ▶ Do not lift the product over persons or other units.
- ▶ At least two fitters should transport and set the product up.

NOTE**Property damage due to improper transport and setup**

Improper transport or setup can cause the product to topple or fall over. This can result in material damage and irreparable damage to the product.

- ▶ Protect the product against weather conditions, such as rain and direct sunlight.
- ▶ Ensure that the product does not make contact if you pass over edges.
- ▶ Use the product only in dry, clean and well-ventilated rooms.
- ▶ Maintain a minimum distance of 1 m from the wall when setting the product up in order to ensure that the product has sufficient ventilation.
- ▶ At least two fitters should transport and set the product up.
- ▶ Only transport the water pan when it has been emptied.

NOTE**Material damage due to forklifts/pallet trucks driving under the product improperly**

If the forklift/pallet truck drives too far under the product, it can be damaged.

- ▶ Drive under the product carefully and only until the forklift/pallet truck cannot go any further.

NOTE**Material damage due to unsuitable means of transport**

If an unsuitable vehicle is used to drive under the product, the product and dust collecting container can become damaged.

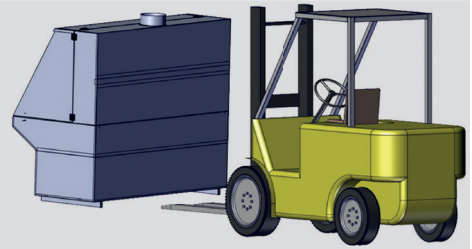
- ▶ Use a suitable forklift truck with a fork width of max. 50 mm.
- ▶ Take the low base height of the product into account.

The product can be transported and set up using a forklift.

- ▶ When transporting the product with a forklift, take the amount of space required by the forklift into account.

6.1 Transporting and Setting Up the Product

1. Drive a forklift with suitable fork length completely under the product.
2. Transport to a suitable setup location and set down.

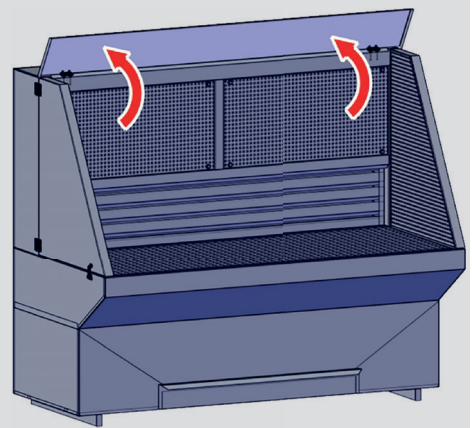


6.2 Modular Extension of the Working Area (optional)

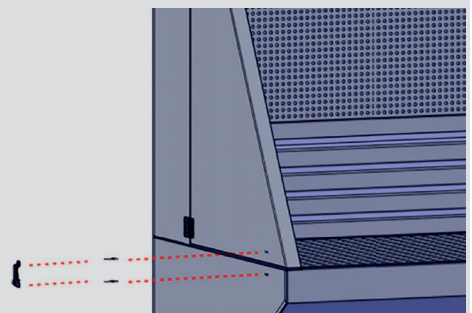
Adding further tables can extend the working area. The winged doors must be dismantled at the connection points for this.

- ▶ Take the space required by the tables into account.

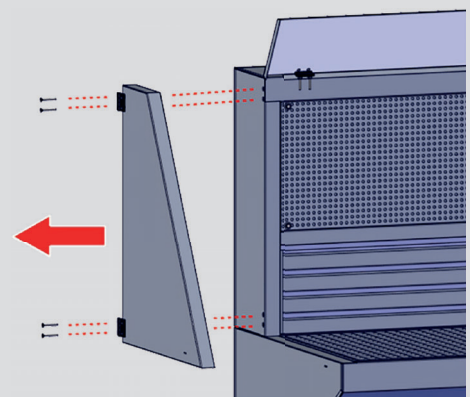
1. Open the top cover of the first product.



2. On the side to be extended, undo the screws of the tension lock and remove the tension lock.

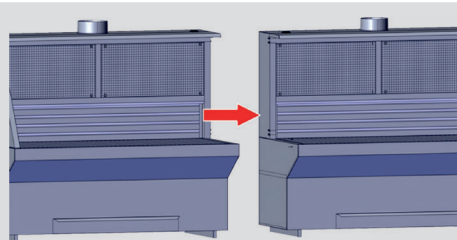


3. Undo the hinge screws on the side of the product and take the winged door off.

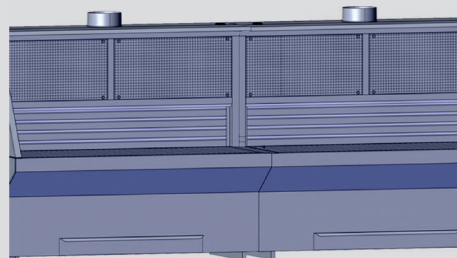


6 Transport and Setup

4. Disassemble the winged door on the other product as well, and place the products next to one another so that a continuous working area is produced.



5. Add further products in the same way if necessary.



7 Putting Into Operation

WARNING



Fire hazard due to improper use

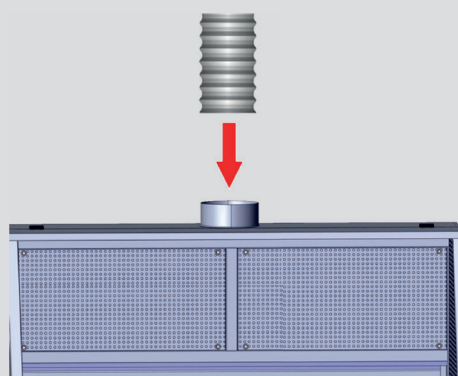
Improper use of the product can cause a fire. Serious burns can be the result.

- ▶ Do not use the product in areas subject to dust or gas explosion hazards.
- ▶ Do not use the product to extract dust that results from grinding oil-wetted parts.
- ▶ Do not use the product to extract flammable substances and liquids.

7.1 Mounting the Piping at the Connection Piece

The filter system or central extraction system must be attached to the connection piece of the product using piping (not included in the scope of delivery). We recommend mounting a spark trap between the connection piece and the piping in addition.

1. Use suitable fasteners to attach the filter system to the connection piece on the product and seal using sealing tape.



7.2 Carrying Out Functional Test

1. Switch on the customer-side filter system or central extraction system.
2. Make sure that the piping to the product is open and air flow can take place.
3. Check whether a draft can be felt at the product, both at the slats and at the grating.
4. If necessary, carry out a grinding test using an angle grinder and check sparking.

8 Operation

⚠ WARNING**Health risk through inhalation of harmful grinding fumes and dust**

The grinding process produces fumes with harmful dust particles which can settle on the surface and get into the ambient air. They can damage the respiratory system when inhaled.

- ▶ Check and wear your personal protective equipment.
- ▶ Only use the product in rooms which are sufficiently ventilated.
- ▶ Make sure that all the seals on the product are free of dirt.
- ▶ Remove dust deposits in the surrounding area immediately using an industrial vacuum cleaner of dust class H or a damp cloth.

⚠ WARNING**Fire hazard due to improper use**

Improper use of the product can cause a fire. Serious burns can be the result.

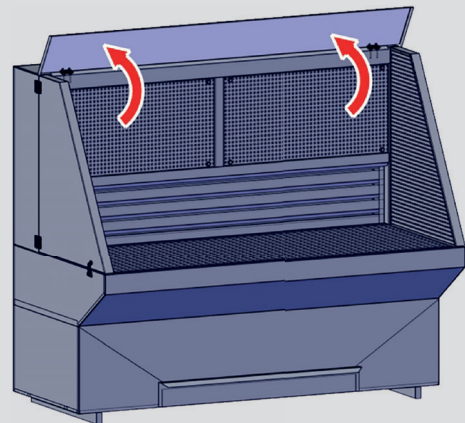
- ▶ Do not use the product in areas subject to dust or gas explosion hazards.
- ▶ Do not use the product to extract dust that results from grinding oil-wetted parts.
- ▶ Do not use the product to extract flammable substances and liquids.

- ▶ Switch on the connected filter system or central extraction system.
- ▶ Consult the documentation of all components used.

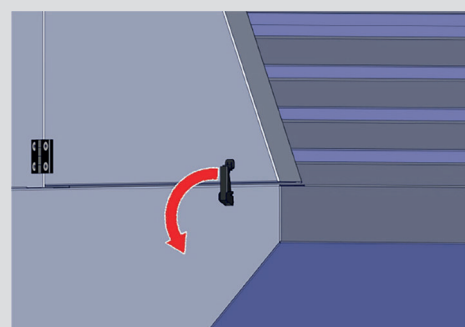
8.1 Opening the Winged Doors

The top cover and winged doors can be opened for the machining of long or bulky workpieces.

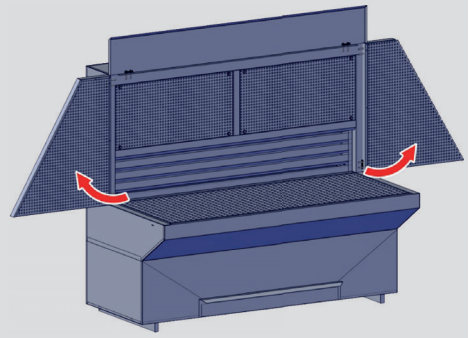
1. Open the top cover.



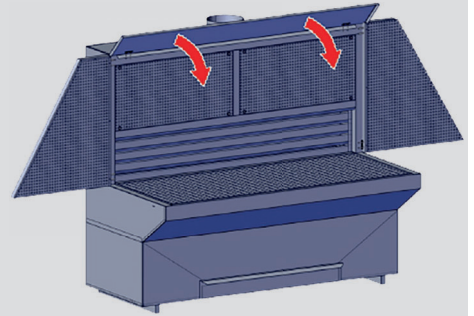
2. Undo the tension locks on the winged doors on both sides.



3. Open the winged doors.



4. Close the top cover.



9 Putting Out of Operation

- ▶ Switch off the connected filter system or central extraction system.
- ▶ Consult the documentation of all components used.

10 Maintenance and Cleaning

Regular maintenance and cleaning are prerequisites for a long service life and perfect function. The maintenance interval is determined by the working environment and operating time of the products. If the product is operated for longer than 8 hours per day, the maintenance interval should be adapted according to requirements.

WARNING



Health risk through inhalation of harmful grinding fumes and dust

The grinding process produces fumes with harmful dust particles which can settle on the surface and get into the ambient air. They can damage the respiratory system when inhaled.

- ▶ Check and wear your personal protective equipment.
- ▶ Only use the product in rooms which are sufficiently ventilated.
- ▶ Make sure that all the seals on the product are free of dirt.
- ▶ After cleaning and maintenance work check all screwed joints for a tight fit, leaks, chafing points. Tighten any loosened screwed joints. Correct any faults found immediately.
- ▶ Remove dust deposits in the surrounding area immediately using an industrial vacuum cleaner of dust class H or a damp cloth.

WARNING



Risk of crushing

Limbs can be crushed if product components are improperly installed or uninstalled.

- ▶ Do not reach into the danger zone.
- ▶ Check and wear your personal protective equipment.


- ▶ Consult the documentation of all components used.


10.1 Maintenance and Cleaning Intervals

The given intervals are for guidance and refer to one-shift operation. We recommend documenting the checks. At least the test date, the defects found and the name of the tester should be documented.

Interval	Job
If necessary	<ul style="list-style-type: none"> ▶ Check the fill level in the dust collecting container and empty if necessary. ⇒ 10.3 Emptying and Cleaning the Dust Collecting Container (Page 21)
Weekly	<ul style="list-style-type: none"> ▶ Check the product for outer signs of damage. ▶ If installed, check the connection hoses and connections for a tight fit and damage, replace if necessary. ▶ If installed, check the potential equalization cable for a tight fit and damage, replace if necessary. ▶ Check all connection points of the piping and connectors for dust escape.
Yearly	<ul style="list-style-type: none"> ▶ If installed, check the ground connections of the product and filter system for damage. ▶ If installed, open the piping inspection flap, and check the piping for dust deposits.

10.2 Cleaning the Grating and Interior

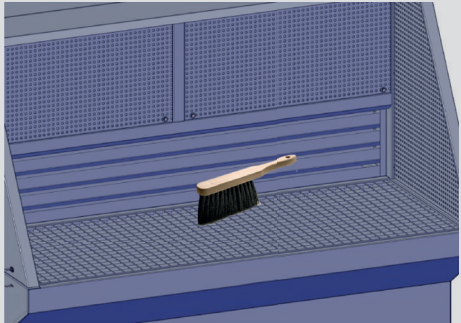
 **WARNING**

	<p>Risk of injury due to sharp edges</p> <p>The edges of the grating are very sharp. Cutting injuries can be the result.</p> <ul style="list-style-type: none"> ▶ Wear protective gloves. ▶ Use at least 2 people for removal and insertion of the grating.
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To extract swirling dust particles directly, the connected filter system or extraction system should be switched on during cleaning of the grating.

1. Switch on the connected filter system or central extraction system.

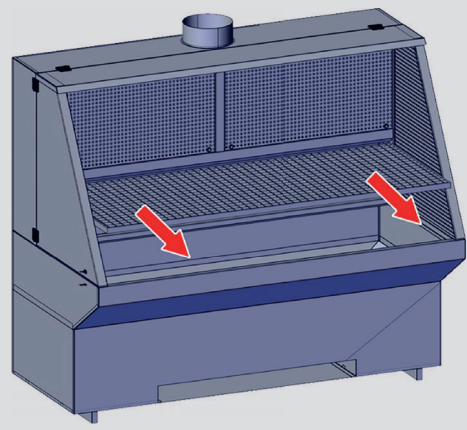
2. Clean the slats and grating with a hand brush.



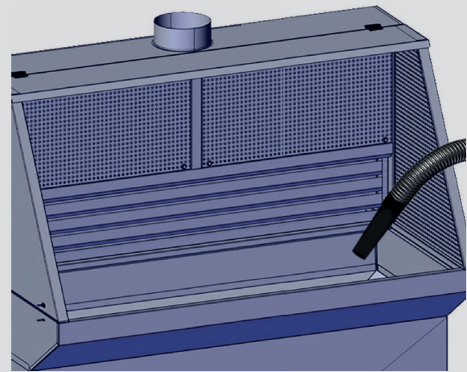
3. Switch off the connected filter system or central extraction system.

10 Maintenance and Cleaning

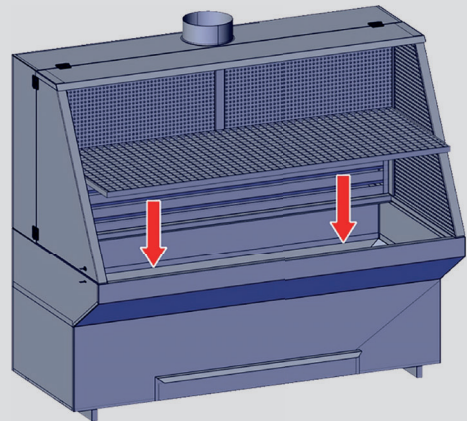
4. Have 2 people carefully lift and remove the grating.



5. Vacuum out the interior of the product using an industrial vacuum cleaner of dust class H.

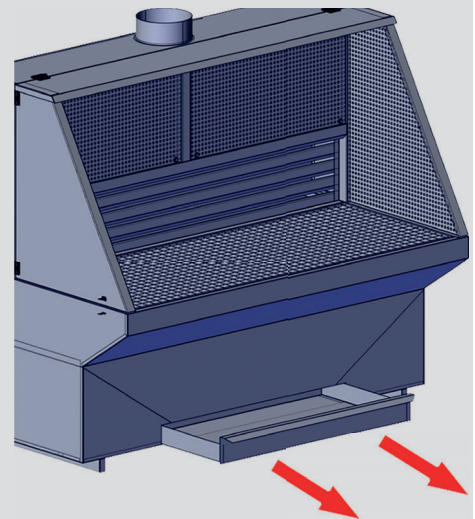


6. Have 2 people carefully insert the grating.



10.3 Emptying and Cleaning the Dust Collecting Container

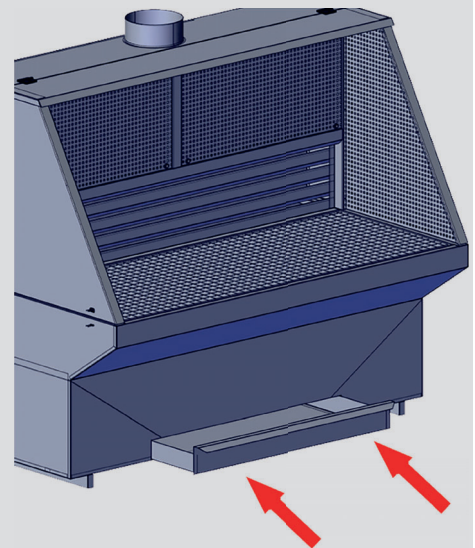
1. Pull the dust collecting container out.





2. Empty the dust collecting container and vacuum out using an industrial vacuum cleaner of dust class H if necessary.

3. Dispose of the dust in accordance with local laws and directives. ⇨ 13 Disposal (Page 25)

4. Insert the dust collecting container.



11 Faults and their Correction

 WARNING	
	<p>Health risk through inhalation of harmful grinding fumes and dust</p> <p>The grinding process produces fumes with harmful dust particles which can settle on the surface and get into the ambient air. They can damage the respiratory system when inhaled.</p> <ul style="list-style-type: none"> ▶ Check and wear your personal protective equipment. ▶ Only use the product in rooms which are sufficiently ventilated. ▶ Make sure that all the seals on the product are free of dirt. ▶ Remove dust deposits in the surrounding area immediately using an industrial vacuum cleaner of dust class H or a damp cloth.

- ▶ Consult the documentation of all components used.
- ▶ Contact your retailer or THERMACUT in the event of questions or problems.

Fault	Cause	Troubleshooting
Insufficient extraction capacity	The filter system or central extraction system connected is not switched on.	▶ Switch on the filter system or central extraction system.
	The filter system or central extraction system connected is not set correctly.	▶ Set the extraction capacity in accordance with the legal requirements.
	The connected piping system is blocked.	▶ Eliminate blockage.

Table 4 Faults and troubleshooting

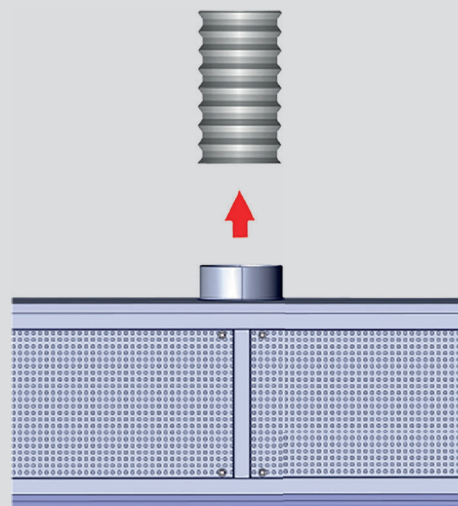
12 Disassembly

 **WARNING**
**Risk of injury due to sharp edges**

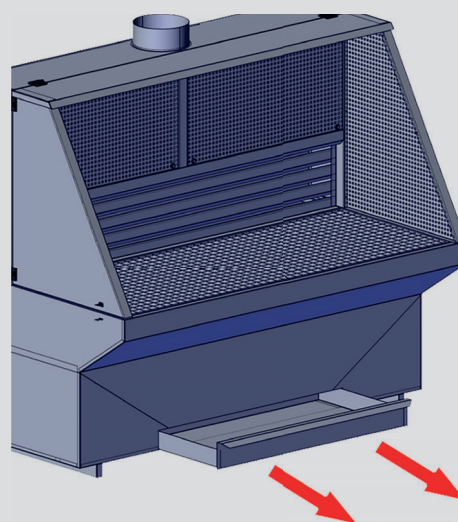
The edges of the grating are very sharp. Cutting injuries can be the result.

- ▶ Wear protective gloves.
- ▶ Use at least 2 people for removal and insertion of the grating.

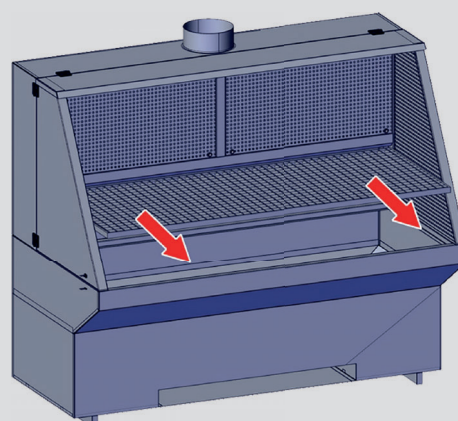
1. Disassemble the filter system or central extraction system piping at the product connection piece.



2. Pull the dust collecting container out.



3. Have 2 people carefully lift and remove the grating.



13 Disposal

13.1 Disposing of Grinding Dust

The disposal of grinding dust is subject to special waste regulations. Grinding dust must not be allowed to get into the sewage system or be disposed of together with household waste.

- ▶ Heed local laws and directives on disposal.

13.2 Disposal of materials

This product is mainly made of metallic materials that can be melted in steel and iron works and are thus almost infinitely recyclable. The plastic materials used are labeled in preparation for their sorting and separation for later recycling.

- ▶ Heed local laws and directives on disposal.

13.3 Disposal of consumables

Oil, greases and cleaning agents must not contaminate the ground or enter the sewage system.

- ▶ Store, transport and dispose of consumables in suitable containers.
- ▶ Dispose of contaminated cleaning tools (brushes, rags, etc.) in accordance with the information provided by the consumables' manufacturer.
- ▶ Observe the local laws and regulations on disposal provisions in the safety data sheets of the consumables manufacturer.

13.4 Disposing of packaging

THERMACUT has reduced the transport packaging to a minimum. The ability to recycle packaging materials was always considered during their selection.

- ▶ Heed local laws and directives on disposal.

14 Addresses and contacts

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