

Operating Instructions

HV 262

Universal Belt Grinding Unit



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Universal Belt Grinding Unit HV 262

Manufacturer

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Documents for the machine operator

Operating Instructions

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1. Important notes

1.1 Foreword

This operator's manual is meant to make it easier to get to know the Universal Belt Grinding Unit and to use it properly for the intended purpose.

The operator's manual contains important instructions on how to operate the Universal Belt Grinding Unit safely, properly and cost-effectively. Observance of these instructions helps to avoid dangers, repair costs and downtimes, and increases the reliability and service life of the Universal Belt Grinding Unit.

The operating instructions must always be accessible at the place of use of the Universal Belt Grinding Unit.

The operating instructions must be read and used by all persons entrusted with working on the Universal Belt Grinding Unit, e.g. those entrusted with

- Transport, installation, commissioning
- Operation, including troubleshooting in the process flow, as well as
- Servicing (maintenance, repair).

In addition to the operating instructions and the binding accident prevention regulations applicable in the country and place of use of the machine, the generally acknowledged rules of technology with regard to safe and professional work practices are to be observed.

1.2 Warnings and symbols in the operating instructions

Heeding the following safety alert symbols/designations used in the operating instructions is absolutely necessary:



The hazard triangle with the signal word "CAUTION" is used as a work safety indication for all work which could result in death or physical injury.

Special care and caution must be taken when carrying out such jobs.



The signal word "ATTENTION" is used to call attention to hazards which could result in damage and/or destruction of the grinding machine or its environment if special attention is not paid while carrying out particular jobs.



The signal word "NOTE" calls attention to tips on use and useful information.

1. Important notes

1.3 Figure and item numbers in the operating instructions

If a component of the machine that is shown in a figure is described in the text, it is followed by a figure or item number in brackets.

Example: (7-2/1) denotes figure number 7-2, item 1.

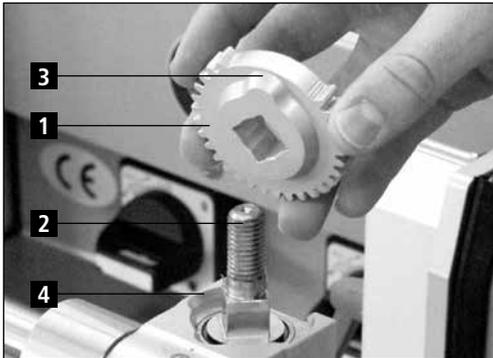


Figure 7-2 Inserting the function disk

Place the function disk (7-2/1) on the locating bolt (7-2/2).

This can be done in two different ways:

For linear cutter knives, the rotation of the function disk is prevented by a contour (7-2/3). The untoothed region is then facing in the direction of the operator.

Insert the contour (7-2/3) in the groove (7-2/4).

2. Safety

2.1 Basic safety instructions

2.1.1 Observe notes in the operating instructions

The basic prerequisite for the safe handling and uninterrupted operation of this Universal Belt Grinding Unit is knowledge of the basic safety instructions and regulations.

- These operating instructions contain important notes on how to operate the Universal Belt Grinding Unit safely.
- All persons carrying out work on the Universal Belt Grinding Unit must follow these operating instructions, in particular the safety notices.
- In addition, the accident prevention rules and regulations applicable at the place of use of the machine must also be observed.

2.1.2 Operator's duty

The operator is obliged to allow only those persons to work on the Universal Belt Grinding Unit, who

- are familiar with the basic occupational safety and accident prevention regulations and have been trained and instructed in the handling of the Universal Belt Grinding Unit,
- have read the operating instructions, particularly the "Safety" section, and have read and understood the warning notes. They have given a signed confirmation of this in writing.

It is also checked at regular intervals as to whether the worker is fulfilling his employee obligation to observe safety at work.

2.1.3 Obligations on the part of the personnel

All the personnel working on the Universal Belt Grinding Unit shall be obliged, before starting work, to

- observe the basic occupational safety and accident prevention regulations,
- read the operating instructions, particularly the "Safety" chapter, and the warning notes. They shall give a signed confirmation of this in writing.

2.1.4 Hazards associated with the handling of the Universal Belt Grinding Unit

The Universal Belt Grinding Unit has been built to the latest technological standards and the acknowledged rules of technical safety. In spite of that, its use presents inherent risks which could result in bodily harm or even death of the user or third persons, or impairment of the Universal Belt Grinding Unit or other property.

The Universal Belt Grinding Unit may be used only:

- for the intended purpose, and

2. Safety

- in faultless condition with regard to safety-relevant aspects.

Faults that could impair safety must be eliminated immediately.

2.1.5 Malfunctions

If safety-relevant malfunctions occur in the Universal Belt Grinding Unit, or if the processing behaviour indicates that such malfunctions may have occurred, the Universal Belt Grinding Unit must be stopped immediately and until such time as the malfunction has been found and eliminated.

Allow only authorised technical staff to eliminate the malfunctions.

2.2 Proper use

The Universal Belt Grinding Unit is meant for grinding linear and sickle-shaped flat knives only. It is suitable for attachment to KNECHT grinding machines from the S 200 series and to USK 230. All the knives must be clamped onto matching grinding plates.

Before starting work on a flat knife, it must be checked whether the knife fits on the grinding plate. Only then may the knife be clamped onto the grinding plate to prevent damage to the knife.

Any other use is considered improper use. KNECHT Maschinenbau GmbH does not assume any liability for damages resulting from improper use. The user alone bears the risk in such cases.

Use as intended includes the observance of all the instructions in the operating instructions.

The Universal Belt Grinding Unit is being used improperly, if, e.g.,

- it is attached to grinding machines other than KNECHT S 200 and USK 230,
- the knife was clamped incorrectly onto the grinding plate,
- attachments are not fastened properly.
- knives are ground in opposite direction of the cutting edge on the wet-grinding belt.

2.3 Warranty and liability

Warranty and liability claims in case of personal injuries or property damage are excluded if such damage is attributable to one or more of the following causes:

- improper use of the Universal Belt Grinding Unit,
- improper transportation, commissioning, operation and maintenance of the Universal Belt Grinding Unit and its attachments,

2. Safety

- operating the Universal Belt Grinding Unit with defective safety devices, or improperly attached or malfunctioning safety and protective equipment,
- ignoring the operating instructions with regard to transportation, commissioning, operation, maintenance and repair of the Universal Belt Grinding Unit.
- unauthorised structural alterations to the Universal Belt Grinding Unit,
- insufficient monitoring of machine parts that are exposed to wear.
- use of unapproved replacement and wear parts

Use only original replacement and wear parts. If parts are purchased from external suppliers, it cannot be guaranteed that they will be constructed and manufactured to withstand the stresses and provide the required level of safety.

2.4 Safety regulations

2.4.1 Organisational measures

All the existent safety devices must be checked regularly.

Observe prescribed intervals for recurring maintenance work or as specified in the operating instructions.

2.4.2 Protective devices

Before commissioning the Universal Belt Grinding Unit, it must be ensured that all protective equipment is properly mounted and in functional condition.

Protective equipment may be removed only after the machine has stopped and has been secured against accidental restarting of the Universal Belt Grinding Unit.

If sub-components are supplied, the protective equipment must be correctly attached by the operator according to the instructions.

2.4.3 Informal safety measures

The operating instructions must be permanently available at the place of use of the Universal Belt Grinding Unit. In addition to the operating instructions, the generally applicable as well as the locally relevant accident prevention regulations must also be made available and observed.

All the safety alert symbols and danger warnings on the Universal Belt Grinding Unit must be complete and clearly legible.

2. Safety

2.4.4 Selection and qualifications of the personnel

Only trained and instructed personnel may work on the Universal Belt Grinding Unit. The minimum legal age for employment must be observed.

The responsibilities of the personnel must be clearly assigned, i.e. commissioning, operation, maintenance and repair, etc.

Personnel still in the training or instruction phase may only be allowed to work on the Universal Belt Grinding Unit under the permanent supervision of an experienced person.

2.4.5 Operation

Only adequately instructed and trained personnel are authorised to operate the grinding unit in connection with the machine.

2.4.6 Safety measures in normal operation

Refrain from any method of working which may pose a risk to safety. Only operate the Universal Belt Grinding Unit if all the safety devices are installed and fully functional.

Check the Universal Belt Grinding Unit for external signs of damage and correct operation of the safety devices at least once every shift.

Report any changes (including operating behaviour) immediately to the competent department/person. If required, put the grinding machine out of operation immediately and secure against restarting.

Before using the Universal Belt Grinding Unit, ensure that no one is exposed to any risk from the start-up of the machine.

Immediately put the Universal Belt Grinding Unit out of operation and secure against restarting in case of any malfunctions. Have the faults eliminated immediately.

2.4.7 Particular hazard areas

In the area of the grinding wheel, wet-grinding belt and flap brush, there is a hazard of pinching and being drawn in (e.g. clothing, fingers and hair). Suitable personal protective equipment must be worn.

2.4.8 Servicing (maintenance, repair) and fault rectification

Maintenance work is to be carried out on schedule by trained personnel. Inform operating personnel before starting repair work. The responsible supervisor is to be named.

For all service work, the grinding machine is to be disconnected from the power supply and secured against accidental restarting. Pull out the mains plug. Cordon off the servicing area, as far as possible.

2. Safety

After completion of the maintenance work and fault rectification, install all the safety devices and check whether they are fully functional.

2.4.9 Structural alterations to the Universal Belt Grinding Unit

Modifications, retrofitting or rebuilds of the Universal Belt Grinding Unit are not allowed without the permission of the manufacturer. This also applies to the installation and adjustment of safety devices.

No alterations may be carried out without prior written permission from KNECHT Maschinenbau GmbH.

Immediately replace machine parts which are not in perfect condition.

Use only original replacement and wear parts. If parts are purchased from external suppliers, it cannot be guaranteed that they will be constructed and manufactured to withstand the stresses and provide the required level of safety.

2.4.10 Cleaning the Universal Belt Grinding Unit

Cleaning agents and materials used must be handled properly and disposed of in an environmentally friendly way.

Ensure that wear and replacement parts are disposed of in a safe and environmentally friendly way.

2.4.11 Oils and greases

When handling oils and greases, follow the safety instructions for the product. Observe special instructions for the foodstuffs sector.

2.4.12 Relocation of the Universal Belt Grinding Unit

Even when moving the grinding machine with the HV 262 Universal Belt Grinding Unit a short distance from its site, disconnect it from all external power supply sources. Before restarting the machine, connect it properly to the current supply.

When loading or unloading, only use hoisting and load lifting equipment with sufficient load-bearing capacity. Appoint a qualified banksman (signaller) for the lifting process.

No persons other than those entrusted with this work may be present in the loading and installation area.

Only lift the grinding machine correctly with a suspension device in accordance with the operating instructions (attachment points for load suspension devices, etc.). Only use suitable transport vehicles with sufficient load-bearing capacity. Attach the load securely. Use suitable attachment points. When putting in operation again, proceed only as instructed in the operating instructions.

3. Description

3.1 Use as intended

The HV 262 Universal Belt Grinding Unit is used to grind sickle-shaped and linear cutter knives. The unit is attached to KNECHT grinding machines from the S 200 series and to USK 230.

3.2 Technical specifications

- Height _____ approx. 650 mm
- Width _____ approx. 550 mm
- Depth _____ approx. 760 mm
- Weight _____ 18 kg
- Maximum grinding radius _____ 380 mm
- Minimum grinding radius _____ 55 mm
- Possible knife sizes* _____ 45 - 750 ltr.

*) The grinding radius must lie within the specified range.

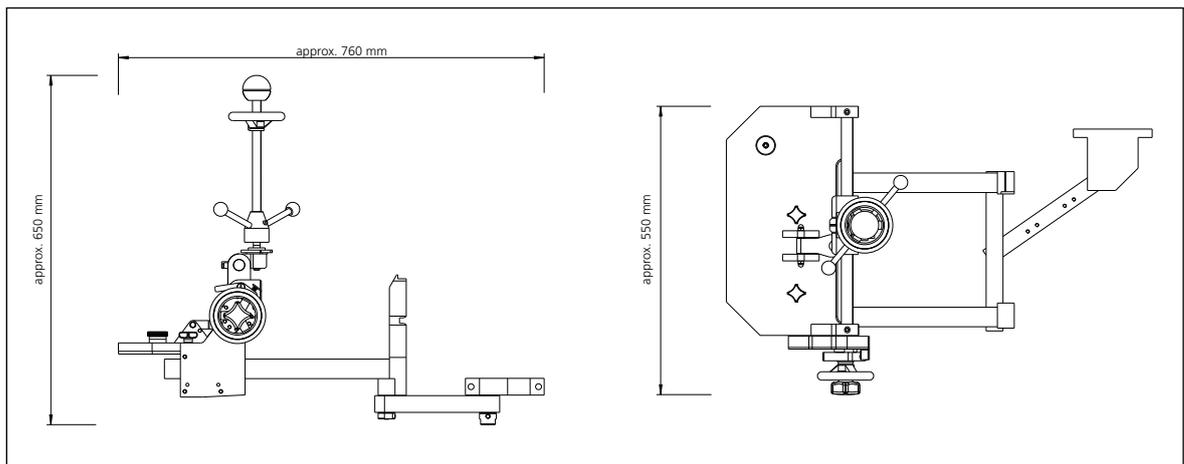


Figure 3-1 Dimensions in mm

3. Description

3.3 Functional description

The HV 262 Universal Belt Grinding Unit is used to grind sickle-shaped and linear cutter knives. The unit is attached to KNECHT grinding machines from the S 200 series and to USK 230.

For grinding of linear knives, the carriage is moved to and fro over a shaft. The movement is limited by an end stop. For grinding of sickle-shaped knives, the carriage is fixed by locking it in position with a fork.

The admission shaft is locked or made rotatable by changing the position of the function disk. This is required for grinding knives with linear and sickle-shaped blades.

3. Description

3.4 Description of the assemblies

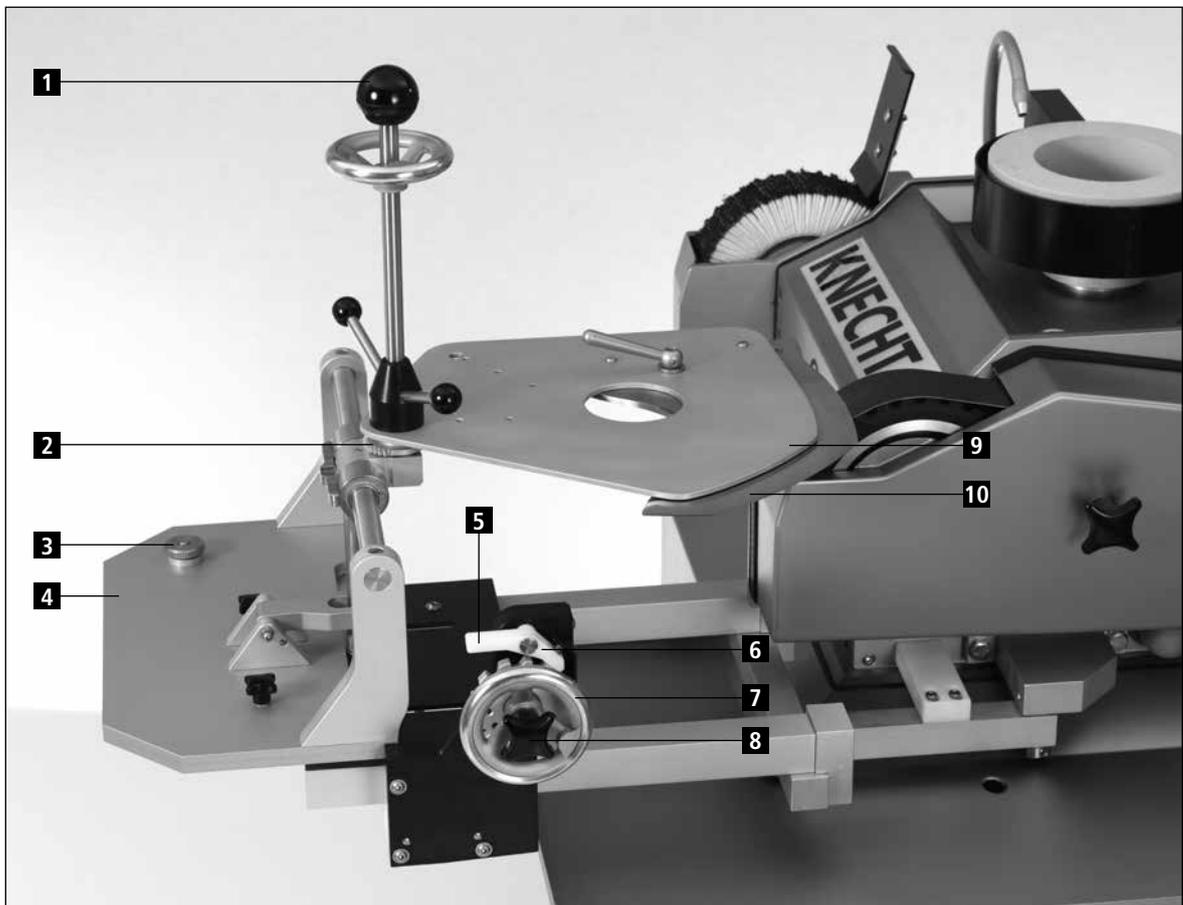


Figure 3-2 General view of the Universal Belt Grinding Unit

- 1 Grinding lever
- 2 Function disk
- 3 Spacer disks for grinding angle adjustment
- 4 Base plate
- 5 Locking lever
- 6 Locking disk
- 7 Hand wheel
- 8 Star knob of the locking disk
- 9 Grinding plate
- 10 Knife

4. Transport



For transporting the machine, the locally applicable safety and accident prevention regulations must be observed.

4.1 Transport aids

Only use adequately dimensioned transport aids for transporting and setting up the Universal Belt Grinding Unit.

4.2 Transport damage

If damage is detected following unloading after acceptance of the delivery, inform KNECHT Maschinenbau GmbH and the freight forwarder about it immediately. If required, consult an independent expert immediately.

Remove the packaging and shipping straps. Remove the shipping straps on the Universal Belt Grinding Unit. Dispose of the packaging in an environmentally friendly way.

4.3 Transport to another installation site

For transportation to another installation site, ensure that the space requirements are fulfilled (see Chapter 3.2).

The Universal Belt Grinding Unit must be adequately secured against toppling during transportation.

5. Installation

5.1 Selection of qualified personnel



It is advisable to have trained KNECHT personnel perform the installation work on the Universal Belt Grinding Unit.

We assume no liability for damage caused by improper installation.

5.2 Installation site

When determining the installation site, bear in mind the space requirement for installation, maintenance and repair work on the Universal Belt Grinding Unit (see Chapter 3.2).

5.3 Settings

The various components are adjusted by KNECHT Maschinenbau GmbH before delivery.

ATTENTION

Unauthorised changes to set values are not permitted and may damage the Universal Belt Grinding Unit

5.4 Initial commissioning of the Universal Belt Grinding Unit

Completely install and check the safety devices before commissioning

The Universal Belt Grinding Unit is only suitable for attachment to KNECHT grinding machines from the S 200 series and to USK 230



Have all the protective devices checked for proper functioning by authorised specialists before initial operation of the machine.

5. Installation

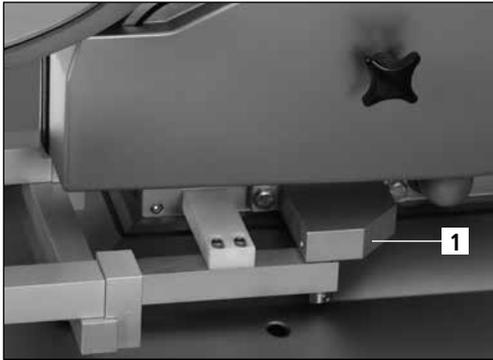


Figure 5-1 Mounting the Universal Belt Grinding Unit

The mounting plate (5-1/1) of the Universal Belt Grinding Unit is fastened onto the side wall of the grinding machine with two M10 screws.

The tapped boreholes are provided in the S 200 series and in USK 230 in versions made from 1991 onwards.

If the machine was constructed before 1991, drilling templates must be requested from KNECHT Maschinenbau GmbH.

Boreholes can be drilled in the right side wall with the help of these templates.

ATTENTION

Before drilling, the contact disk on the grinding machine must be removed.

6. Commissioning



All work on the machine may only be performed by trained personnel.

The locally applicable safety and accident prevention regulations must be observed.

There is a risk of hands, hair and clothes getting caught in the grinding machine while the machine is on.

This can result in serious injuries. Personal protective equipment must be worn.

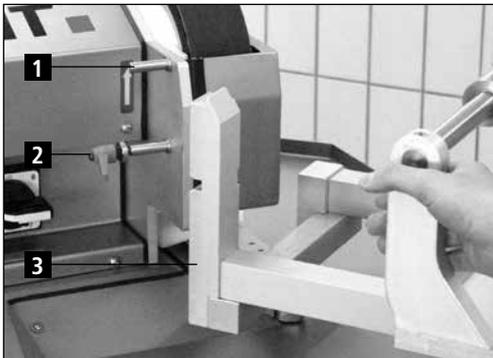


Figure 6-1 Swivelling the Universal Belt Grinding Unit to working position

To save space, it is possible to swivel the HV 262 Universal Belt Grinding Unit (6-1/3) to the side.

To bring it to working position, push it onto the pins (6-1/1) and clamp it tight with the clamping lever (6-1/2).

The clamping lever (6-1/2) and the pins (6-1/1) can be requested from KNECHT Maschinenbau GmbH.



Figure 6-2 "Units ON/OFF"

Turn the "Units ON/OFF" switch on the grinding machine to "ON" position. Wet-grinding belt, flap brush and grinding disk start rotating.

7. Operation

7.1 General principles of grinding technology

If a blade has become blunt, material must be removed from its surface to restore it to its original sharpness.

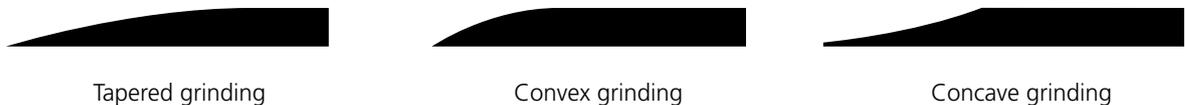
For that, the knife in question is ground to produce its cutting edge. If, in the process, a burr appears on the blade, then the grinding process was successful and can be concluded. Now, before the final sharpness is achieved, the burr must be removed in a further step. This is done with a flap brush.

As it is not only the sharp cutting edges but also the long service lives that define a blade, the cutting angle is another important indicator of a blade's performance. The smaller the cutting edge angle, the higher the theoretical service life. In practice, however, the cutting edge breaks off and is therefore no longer sharp when the cutting edge angle is too small.

The cutting edge angles must therefore lie between 15° and 35°. If the cutting edge angles are less than 15°, the blade becomes so unstable that it breaks at the slightest resistance. If the cutting edge angle is greater than 35°, the blade is extremely stable, but service life will not be as long.

One more criterion for judging the properties of a cutting edge is the cutting edge profile.

There are three different ground profiles:



Convex ground profiles can mostly be found on cutter blades and hand knives. Tapered and concave ground profiles are predominantly found on circular knives and blades.

In general: Adhering to the profiles and the cutting edge angles specified by the manufacturer is required

7. Operation



There is a risk of hands, hair and clothes getting caught in the grinding machine while the machine is on.

This can result in serious injuries.

7.2 Grinding linear cutter knives on the wet-grinding belt

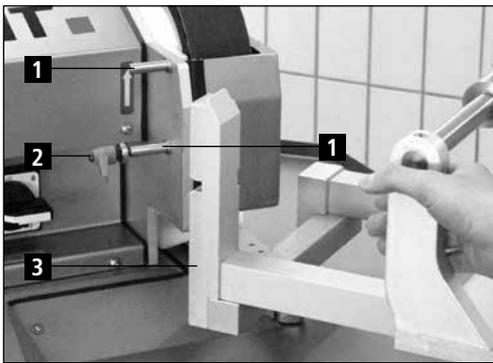


Figure 7-1 Swivelling the Universal Belt Grinding Unit to working position

Swivel the Universal Belt Grinding Unit (7-1/3) to working position by pushing it onto the pins (7-1/1) and clamping it tight with the clamping lever (7-1/2).

7.2.1 Inserting the function disk



Figure 7-2 Inserting the function disk

Place the function disk (7-2/1) on the locating bolt (7-2/2).

This can be done in two different ways:

For linear cutter knives, the rotation of the function disk is prevented by a contour (7-2/3). The untoothed region is then facing in the direction of the operator.

Insert the contour (7-2/3) in the groove (7-2/4).

7. Operation

7.2.2 Setting the grinding angle



Figure 7-3 Spacer disks for adjusting the grinding angle

For setting the desired grinding angle, insert the matching spacer disc (7-3/1) on the locating pin (7-3/2).

Spacer disks for 25° and 27° are located on the base plate (3-2/4).

7.2.3 Mounting the grinding plate

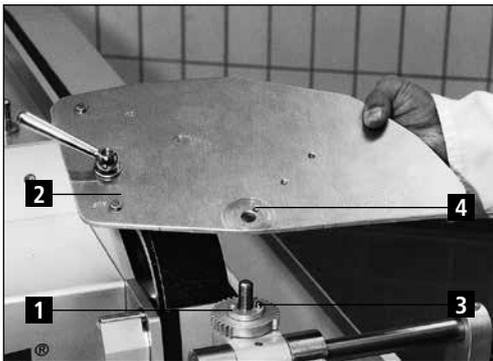


Figure 7-4 Mounting the grinding plate

The grinding plate (7-4/1) is placed on top of the spacer disc (7-4/2).

The cylinder pin (7-4/3) of the spacer disk (7-4/1) must engage in the borehole (7-4/4) of the grinding plate.



Figure 7-5 Fix grinding plate with locking lever

Using the locking lever (7-5/1), the grinding plate (7-5/2) is fixed to the carriage.

For that, turn the locking lever (7-5/1) on the locating pin (7-5/3) in clockwise direction.

7. Operation

7.2.4 Clamping the cutter knife

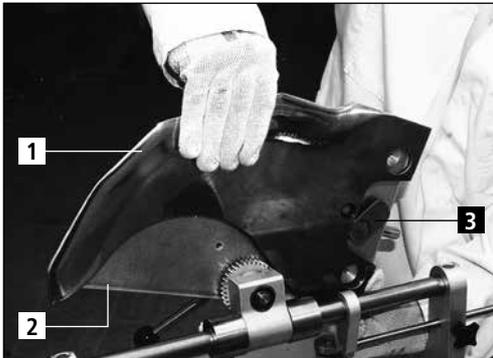


Figure 7-6 Clamping the cutter knife onto the grinding plate

For clamping the knife (7-6/1), swivel back the grinding plate (7-6/2) along with the mounted locking lever (7-5/1).

The knife (7-6/1) is clamped onto the grinding plate (7-6/2) by inserting the knife base in the knife holder of the grinding plate. The knife is locked in position with a counter-clockwise rotation of the grinder (7-6/3).

Once the knife is clamped, swivel the complete unit forward again.



This can result in serious cut injuries.

Wear protective gloves.

7.2.5 Grinding the cutter knife



Figure 7-7 Turning the hand wheel to last locking position

Turn the hand wheel (7-7/1) counter-clockwise until the lock lever (7-7/2) engages in the first locking position of the locking disc (7-7/3).

NOTICE

Press with the thumb on the locking lever (7-7/2) to move to the first locking position. Turn the hand wheel (7-7/1) counter-clockwise with the remaining four fingers.

Tighten the star knob (7-7/4) to be able to move the locking disk.

7. Operation

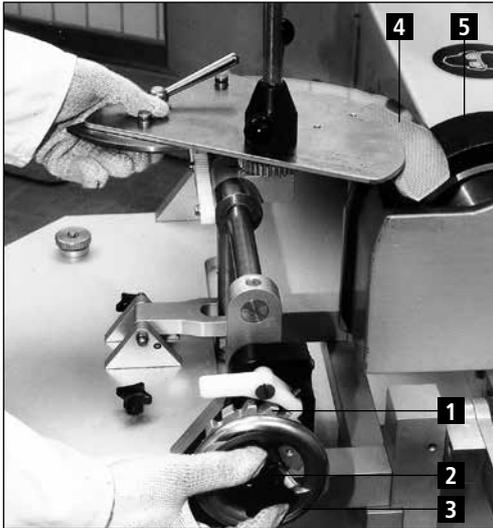


Figure 7-8 Making the locking position inactive

Make the locking disk (7-8/1) inactive by turning the star knob (7-8/2) in counter-clockwise direction by approx. 1/4th of a rotation.

Turn the hand wheel (7-8/3) in clockwise direction until the cutter blade (7-8/4) touches the grinding belt (7-8/5).

Tighten the star knob (7-8/2) back again.



Figure 7-9 Turning the hand wheel to second locking position.

Turn the hand wheel (7-9/1) to the second locking position of the locking disc (7-9/2).

NOTICE

Press with the thumb on the locking lever (7-9/3) to move to the second locking position. Turn the hand wheel (7-9/1) in clockwise direction with the remaining four fingers.

Before switching on the grinding machine, swivel back the grinding lever with grinding plate and knife (7-6).

7. Operation



Figure 7-10 Grinding the knife

Switch on the units and the coolant pump on the grinding machine.

Push the locking lever forward with the right hand and move the knife along the cutting edge with the left hand until burr has been formed over the entire length of the cutting edge.

Now move the tool with the hand wheel to the next locking position. The knife moves in the direction of the belt. Execute five strokes in this direction (one stroke = grinding from a knife tip to knife base).

Then move to the next locking position and execute five strokes again until the entire curvature of the knife is ground.

Finally, move back to locking position 2 and align the next knife edge.

NOTICE

The lock lever must not be pressed when moving back to locking position 2. All the locking positions up to locking position 2 can be skipped by turning the hand wheel.

Switch off the units and the coolant pump on the grinding machine after completing the grinding operation.

7. Operation

7.3 Grinding sickle-shaped cutter knives on the wet grinding belt

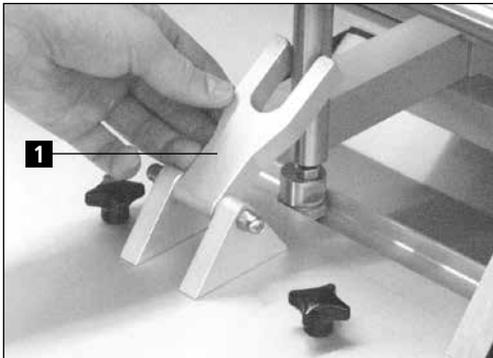


Figure 7-11 Swivelling the fork forward

Swivel the fork (7-11/1) forward before starting the grinding operation for sickle-shaped cutter knives. The carriage stops in this position.

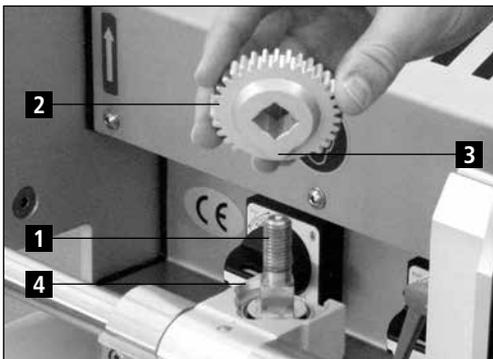


Figure 7-12 Inserting the function disk

Place the function disk (7-12/2) on the locating bolt (7-12/1).

For sickle-shaped cutter knives, however, rotation is merely restricted by the contour. The function disk can be moved to the left and right. The untoothed region is then facing away from the operator.

Position the contour (7-12/3) on the side of the groove (7-12/4).

The toothing on the function disk (7-12/2) ensures that the grinding plate remains fixed in position during knife change.



Figure 7-13 Inserting the function disk

The function disk (7-13/1) should be inserted so that the entire knife blade can be ground.

This is done before the grinding lever (7-13/2) is locked tight.

The grinding operation has already been described in Chapter 7.2.5

7. Operation

7.4 Increasing the grinding radius

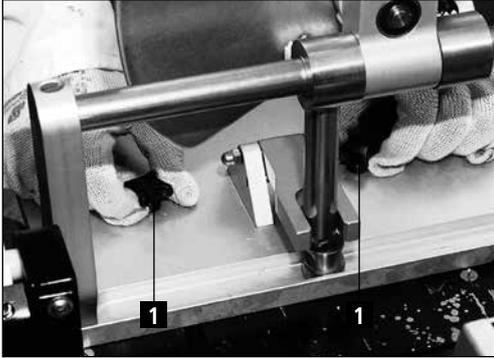


Figure 7-14 Shifting the base plate

The base plate can be moved backward for increasing the grinding radius. For that, loosen both the star knobs (7-14/1).

ATTENTION

Both the star knobs (7-14/1) must always be screwed tight while grinding.

8. Care and maintenance



CAUTION

For all work on the Universal Belt Grinding Unit, the locally applicable safety and accident prevention regulations, as well as instructions in the "Safety" and "Important notes" section of the operating instructions must be observed.

Use only original replacement and wear parts. If parts are purchased from external suppliers, it cannot be guaranteed that they will be constructed and manufactured to withstand the stresses and provide the required level of safety.

8.1 Cleaning

Clean the Universal Belt Grinding Unit after each grinding operation to prevent grinding sludge from drying, hence making it harder to remove.

After cleaning, lightly grease the Universal Belt Grinding Unit with non-corrosive oil (also refer to lubrication schedule in Chapter 8.2).

8.2 Lubrication schedule and lubricant table

Lubricating activity	Interval	OEST	SHELL	EXXON Mobil	DEA
Lubricate the threads of star knobs and clamping levers	4 weeks	Mehr-zweckfett L2	Gadus S2 V100 2	Mobilith SHC 100	Dolon E2
Grease machine parts after cleaning	after each grinding operation	Paraffinum Perliquidum 16 L	Shell Risella 917	Marcol 82	Merkur Weißöl Pharma 40

9. Disassembly and disposal

9.1 Disassembly

All operating materials must be disposed of correctly.

Secure moving parts against slipping.

The disassembly must be carried out by a qualified specialist company.

9.2 Disposal

At the end of the machine service life, it must be disposed of by a qualified specialist company. In exceptional cases and in agreement with KNECHT Maschinenbau GmbH, the machine can be returned.

Operating materials (e.g. grinding disks, grinding belts, flap brushes, etc.) must also be disposed of correctly.

10. Service, spare parts and accessories

10.1 Postal Address

KNECHT Maschinenbau GmbH
Witschwender Straße 26
88368 Bergatreute
Germany

Phone +49-7527-928-0
Fax +49-7527-928-32

mail@knecht.eu
www.knecht.eu

10.2 Service

Service management:

See postal address

service@knecht.eu

10.3 Spare parts

If you need spare parts, please use the spare parts list provided with the machine. Please place your order as shown below.

Please always include the following information: (Example)

Machine type	(HV262)
Assembly designation	(Swivel arm)
Designation of individual part	(Mounting arm)
Item number	(3)
Drawing number	(1000216-8065)
Quantity	(1 pc.)

Please feel free to contact us with any questions.

11. Appendix

11.1 EC Declaration of Conformity

in accordance with the EC Directive 2006/42/EC

- Machinery Directive 2006/42/EC
- Electromagnetic Compatibility Directive 2004/108/EC

We hereby declare that the machine mentioned below fulfils the basic health and safety requirements of the relevant EC Directive by virtue of the machine's construction and design and the version placed by us on the market.

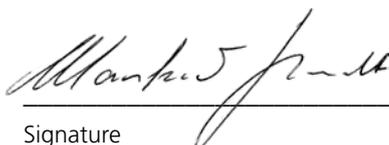
This declaration becomes void if the machine is modified in any way without our consent.

Designation of the machine:	Universal Belt Grinding Unit
Type designation:	HV 262
Applicable harmonised standards, in particular:	DIN EN 12100-1 DIN EN 12100-2 DIN EN 60204-1 ISO 13857 DIN EN 349
Responsible for the documentation:	Peter Heine (Dipl. Ing. Mechanical Engineering BA) Phone +49-7527-928-15
Manufacturer:	KNECHT Maschinenbau GmbH Witschwender Straße 26 88368 Bergatreute Germany

Complete technical documentation is available. The operating instructions document for the machine is available in its original version and in the native language of the user.

Bergatreute, 10 September 2015

Place, date


Signature

Managing Director

Signatory details

KNECHT Maschinenbau GmbH

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