

# USER MANUAL

## FUSION-DIAMOND ULTRAHARD

### CUTTING DISK AND CUTTING & GRINDING DISK

(OUTER DIAMETER < 400MM)

1. This product is designed for grinding the grey cast iron and ductile cast iron.
2. When the linear velocity reaches 80 meters per second, the grinding efficiency can be optimized.
3. While working, the operator should wear protective equipment such as mask and protective glasses, and should be proficient in the process requirement of the workpiece.
4. While working, ensure that the workpiece is fixed and its position conforms to the cutting direction to avoid abnormal cutting. Please feed cutting steadily and do not force lateral pressure or do curve cutting to avoid impactive contact between the cutter edge and the workpiece to avoid the product damaging or the workpiece flying out and causes accident.
5. The cumulative use time of the product should not be more than 30 hours to prevent the steel substrate from fatigue flaw or even crack.
6. While working, check whether the steel substrate has any flaw or not every 2 hours. If the phenomenon of abnormal noise, vibration or rough surface occurred, the operator must stop and check immediately to avoid accident.
7. This product adopts advanced fusion-diamond technology. The diamonds have high exposure and are not easy to fall off. This product has a long life span. It is a normal phenomenon that the grinding efficiency turns from high to low until the end of life span.