

ELITE SOLDAmaq HF

User manual



Version May 2024



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1. FIRST STEPS

Congratulations on your purchase of the ELITE SOLDAmaq HF high frequency generator welder.

Please read this guide before you begin.

ELITE SOLDAmaq HF is specially designed for the saw blade producer or grinding shop with high demands for saw blade tip repair.

This manual introduces you to the main functions of the welding machine in order to avoid risks to your health or that may cause breakdown or premature wear of the machine.

If you have any questions, please contact us directly or one of our authorized distributors.

***Informative Note:** The use manual of the circular saw sharpener described therein may present some variations in use as our machinery is subject to possible construction modifications, depending on the incorporation of technological advances in our sharpening equipment.*



2. SAFETY

2.1. Safety regulations

Carefully observe and apply the following safety rules, not respecting these rules may cause personal injury or damage to the machine itself.

The installation and maintenance of the machine described in this manual must be carried out only by operators who are familiar with its operation and have sufficient technical knowledge.

The ELITE SOLDAmaq HF welding machine has been designed for the repair of circular saws, excluding any other type of operation.



DANGER HIGH VOLTAGE



DANGER OF ACCIDENT



DANGER DUE TO SPARK PROJECTION



WEAR PROTECTIVE SHOES



DANGER FROM SHARP TOOLS



USE HEARING PROTECTORS

These warnings do not include all possible risks that improper use of the machine could cause. For this reason, the operator must proceed with prudence and observing the rules.



2.2. Use and storage of the instruction manual

This instruction manual must be read and understood by all personnel who come into contact with the machine.

This manual is for:

- Indicate the correct use of the machine according to the type of work to be carried out.
- Provide the necessary instructions for the transport, adjustment and maintenance of the machine.
- Facilitate the ordering of spare parts and information of risks.

Limits of use of the manual:

The machine is intended for professional use and therefore the experience of the operator is required and of vital importance.

Importance and conservation of the manual:

This manual must be considered part of the machine and must therefore be attached to it until the end of its use.

Additional information and clarifications:

The user, owner or maintenance person can contact the manufacturer to request any additional information on the use of the machine and possible modalities for maintenance and repair intervention.

Expiration of responsibility:

The manufacturer is considered exempt from any liability in the event of:

- Improper use of the machine.
- Use of the machine by untrained persons.
- Serious failures in scheduled maintenance.
- Unauthorized interventions or modifications.
- Use of non-original spare parts.



2.3. Declaration of conformity

The company hereby **Elite Sharpening Machines, SLU**
C/Joan Oró, 27
ES-08635 Sant Esteve Sesrovires

declares that the product indicated below, based on its conception and construction, as well as the version put on the market by our company, complies with the mandatory basic health and safety requirements of the CE directive.

This declaration loses its validity in the event of unauthorized modifications to the product.

Product name: ***ELITE SOLDAmaq HF***
Product type: ***High frequency generator welding machine***
Serial No.: _____

EC Directive Competences:

- **EC Machinery Directive (2006/42/EC)**
- **European directive on electromagnetic compatibility (2014/30/EU)**
- **The protection purposes of the CE low voltage directive (2006/95/CE) were fulfilled according to annex I, nr. 1.5.1 of the machinery directive 2006/42/EC**

The technical documentation was compiled by Legal representative of the documentation:

Sergi Valls Gramunt
Joan Oró, 27
ES-08635 Sant Esteve Sesrovires

Date / manufacturer - Signature: _____

Signatory data: Sergi Valls Gramunt, manager



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3. TECHNICAL DATA

In the following information table, find the list of technical specifications of the sharpener described in this manual.

TECHNICAL DATA	SOLDAmaq HF
Saw blade diameter	From \varnothing 150 to 850 mm (5.9" to 33.5")
Saw blade hole	From \varnothing 20 to 130 mm (0.78" to 5-1/9")
Welding angle	From -20 to +25°
Installed power	4 kilowatts

AVAILABLE VERSIONS		
Model	Packaging size	Weight
SOLDAmaq HF basic	1600 x 1150 x 2070 mm.	340 kg.
SOLDAmaq HF with pyrometer	1600 x 1150 x 2070 mm.	370 Kg.



4. TRANSPORT

The ELITE SOLDAmaq HF is delivered packed in a wooden box.

During all transportation and transfer, the machine must be kept in its original vertical position; any variation in this position may lead to the loss of the warranty.



Model	Packaging size	Gross weight
SOLDAmaq HF basic	1600 x 1150 x 2070 mm.	340 kg.
SOLDAmaq HF with pyrometer	1600 x 1150 x 2070 mm.	370 kg.



4.1. Unpackaging and assembly instructions

Be especially careful when lifting the load: the load may not be centered!

To lift or move the load, use a forklift with blades long enough to support the machine, taking into account the width and depth of the machine when calculating the weights to be lifted.

To unpack, remove the front panel and any wooden locks or fixing screws from the base of the machine.



Once the machine has been moved to its final work destination, you must secure the machine to the ground using the 4 screws placed on the base support of the machine. If this is not done, there is a high risk of the machine falling and causing serious injury to personnel and the machine itself.

Once the machine is in its final location, the protective film and other component protections, which secure and prevent the machine from moving, can also be removed.



5.INSTALLATION

5.1.Machine placement

Before any work, make sure that the machine is well aligned and does not oscillate at any of its ends, in which case it must be chocked to prevent movement. For correct leveling it is necessary to use a leveling tool. This control must be carried out both longitudinally and transversely.



A poor leveling of the machine can cause unwanted vibrations and premature wear of the linear guides.



WARNING: The machine must not be used under any circumstances by unqualified or unauthorized personnel.



5.2. Electrical connection



DANGER HIGH VOLTAGE!

SOLDAmaq welding machines must be strictly connected to the voltage indicated in the machine order and on the machine itself. Connecting to a voltage other than that indicated may cause damage to the machine and represents a risk to the people who use it.

For connection to the electrical network, the machine only requires two phases and a ground connection.

This installation must be carried out by qualified technical personnel and checked with a voltmeter before turning on the machine.

ELITE Sharpening Machines, rejects all responsibility for a poor connection, which in addition to causing the machine to malfunction can damage people, animals, and material objects.

Remember: Before connecting the machine, remove any protections that the machine may have to protect the components during transport.



5.3.Cooling circuit water connection

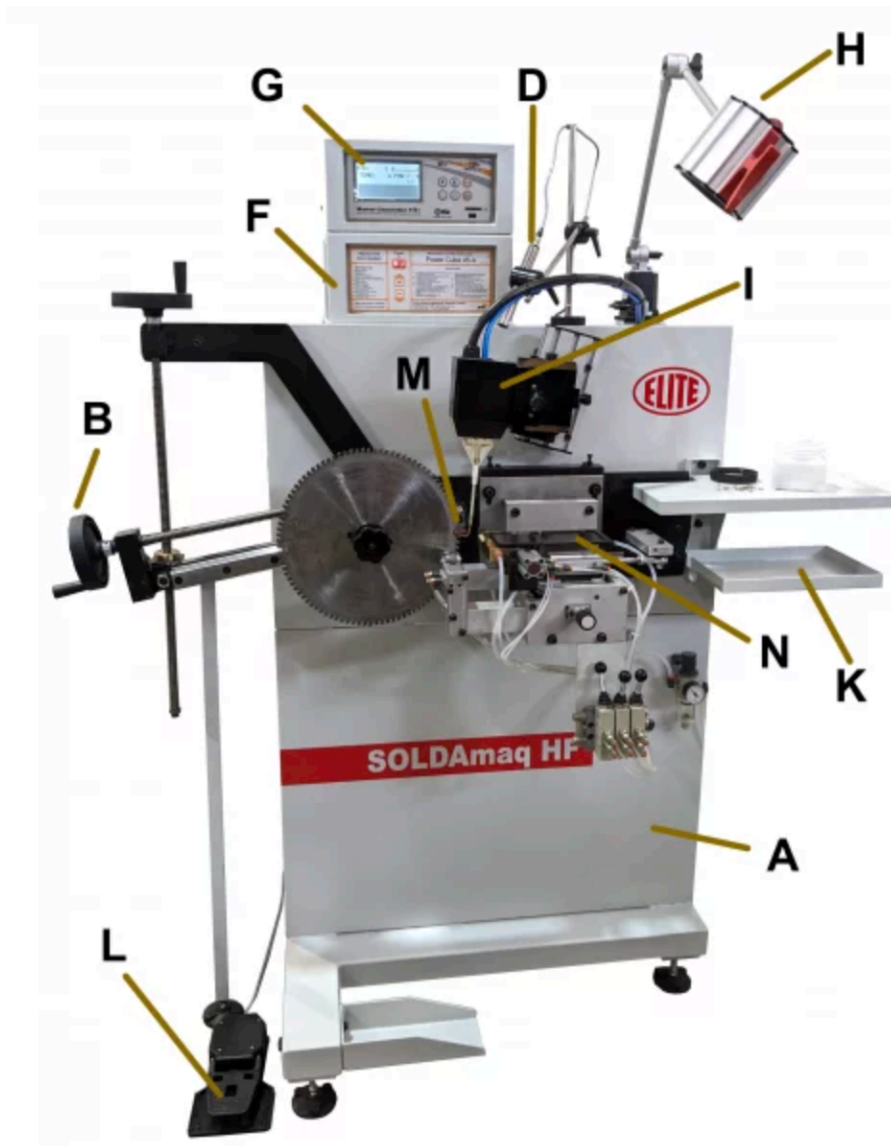


The ELITE welding equipment model SOLDAmag HF comes pre-wired with cooling tubes. You must check the coolant level upon receiving the welder and fill exclusively with water for the cooling circuit in the upper caps indicated for this purpose.

PERIODIC CHECKING OF THE COOLANT LEVEL IS ABSOLUTELY ESSENTIAL.



5.4. Main components of the machine



- A: Machine base
- B: Saw holder support
- C: (Reserved)
- D: Pyrometer
- F: Generator main unit
- G: Pyrometer control unit
- H: Lamp
- I: Inductor coil support head
- K: Tool tray
- L: Weld activation pedal
- M: Inductor coil
- N: Tungsten carbide insert magazine



For sections 6 to 8 of this manual, as well as for more up-to-date information and useful videos on the operation of the machine, please refer to our website

www.elite.es



www.elite.es/en/support/manuals/soldamaq-hf

For more up-to-date information and useful videos on how to operate the machine, see our website www.elite.es