



# ELITE SOLDAmaq 30/40/60 mini User manual



Version May 2023



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# 1. FIRST STEPS

Congratulations on your purchase of the ELITE SOLDAmaq mini welder.

Read this guide before you start.

The ELITE SOLDAmaq mini is a band and strap saw welder that allows a durable and fast welding of the bands as well as the subsequent tempering so that the weld point acquires the same properties and hardness as the rest of the band.

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

In case of any doubt, please contact us directly or one of our authorized distributors.

***Informative Note:** The use described in the manual of this welder may present some variations in use since our machinery is subject to possible constructive modifications, depending on the incorporation of technological advances in our welding equipment.*



## 2. SECURITY

### 2.1. Safety rules

Carefully observe and apply the following safety rules, non-observance of 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 welding machines from the SOLDAmaq 30, 40 and 60 mini model range have been designed for the sharpening of band and 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.



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## 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*** \_\_\_\_\_  
Product type: ***Steel band saw 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 welders described in this manual.

FEATURES			
<b>For sharpening band saws</b>	<b>SOLDAmaq 30 mini</b>	<b>SOLDAmaq 40 mini</b>	<b>SOLDAmaq 60 mini</b>
Band saw width	from 5 to 30mm. (0.2" to 1-1/6")	from 10 to 40mm. (0.39" to 1-1/2")	from 20 to 60mm. (0.79" to 2-1/3")
Band saw thickness	from 0.5 to 1mm. (0.02" to 0.039")	from 0.5 to 1.2mm. (0.02" to 0.047")	from 0.6 to 1.2mm. (0.023" to 0.047")
Max power necessary	4 kW.	4.5 kW.	6 kW.
Weight	35kg	51kg	56kg

All models have exactly the same operating system.

We recommend using the ELITE deburring machine model SOLDAmaq EC for quick removal of the weld seam.



SOLDAmaq EC



## 4. TRANSPORTATION

The ELITE SOLDAmaq 30, 40 and 60 mini are delivered packed in a wooden box.

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



Machine model	Dimensions (cm)	Weight (kg)
SOLDAmaq 30 mini	600x800x500	47
SOLDAmaq 40 mini	600x800x500	60
SOLDAmaq 60 mini	600x800x500	67



## 4.1.Unpacking and assembly instructions

The packaging is fixed to the pallet with fixing stops. Remove them before attempting to move it.



To remove the machine from its packaging, first remove the shears (blue arrow), and then remove the wooden blocking pieces (red arrows).

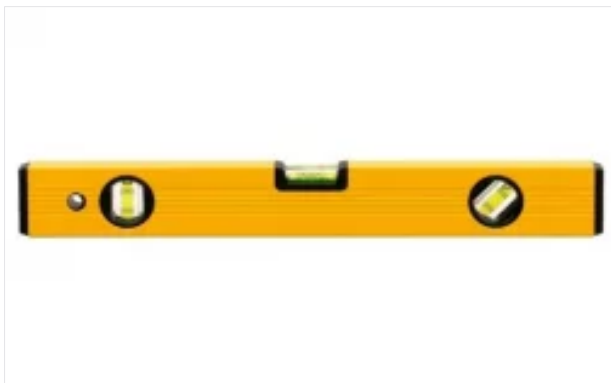




## 5.INSTALLATION

### 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 shod to prevent movement. For its correct leveling it is necessary to use a leveling tool. This control must be carried out both longitudinally and transversally.



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



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



## 5.2. Electrical connection



DANGER HIGH VOLTAGE!

SOLDAmaq mini welding machines must be strictly connected to the voltage indicated in the machine order and on the machine itself. The connection to a voltage other than that indicated may cause a breakdown in the machine and represents a risk for people who use the machine.

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

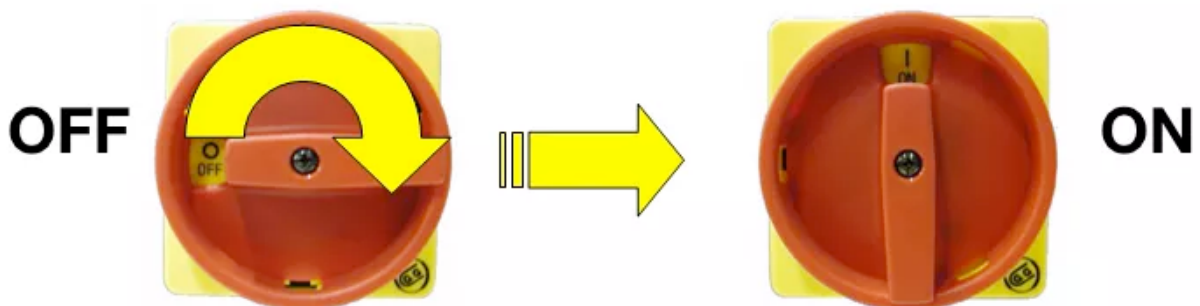
This installation must be carried out by qualified technical personnel and checked with a voltage meter before turning on the machine.

It is absolutely essential that the cross-section of the connection cable is as required, that the machine has a dedicated socket protected against overloads and that it is as close as possible to the socket.

In case of an inadequate section of the cable, not enough current will reach the machine at the time of welding, causing a defective and extremely fragile weld. This is one of the most important points since a very high number of possible welding problems is due to this problem.

We reject any responsibility for a wrong connection.

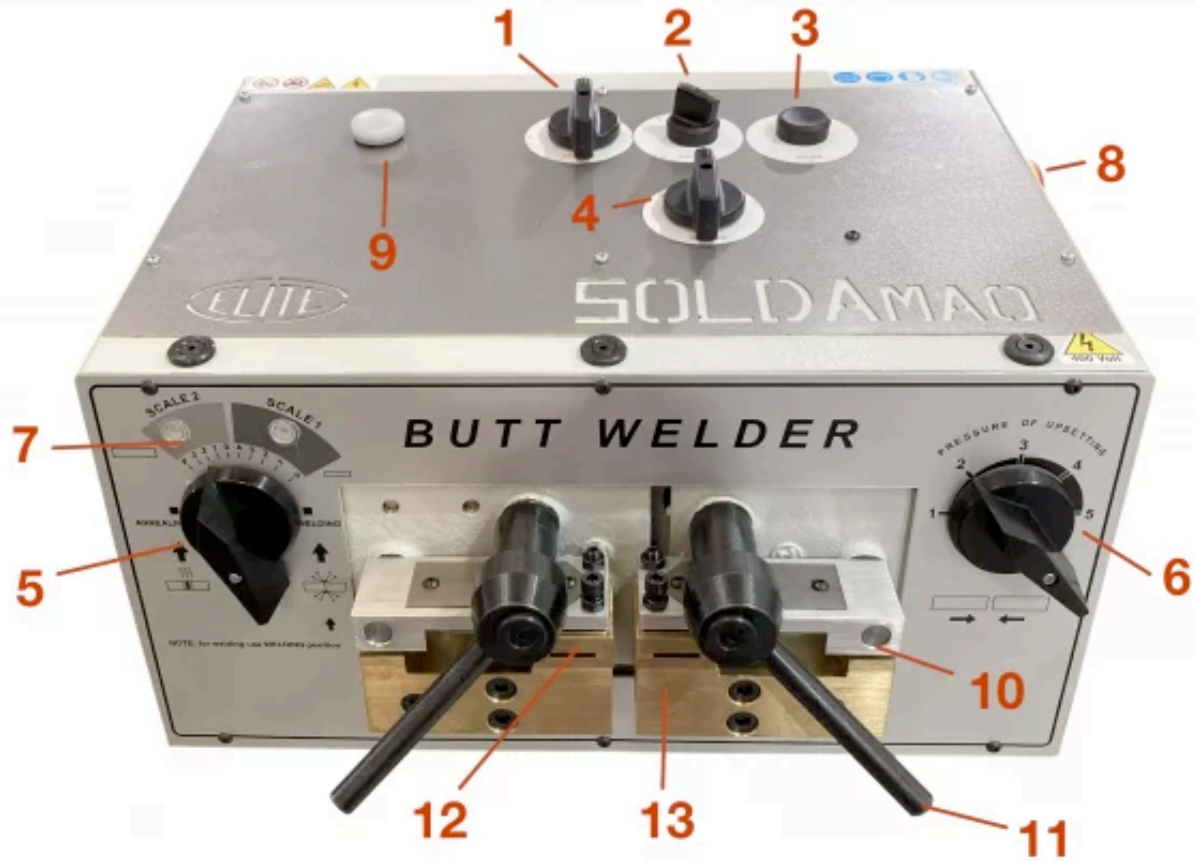
Once the connection has been made and checked, turn the main ON/OFF switch to the ON position.



Check before start-up that the soldering iron voltmeter indicator is at the selected voltage value with a difference of no more than 5%, and that this value is stable.



### 5.3. Main components of the machine



- 1 Welding power
- 2 Welding scale selector
- 3 Welding button
- 4 Annealing current knob
- 5 Welding or tempering path selector
- 6 Welding pressure
- 7 Scale selected indicator
- 8 General ON/OFF switch (Right side of the welder)
- 9 Machine ON Indicator Light
- 10 Jaw
- 11 Clamp lever
- 12 Upper electrode
- 13 Lower electrode





[www.elite.es/en/support/manuals/soldamaq-30-40-60-mini-user-manual](http://www.elite.es/en/support/manuals/soldamaq-30-40-60-mini-user-manual)

**For more updated information and helpful videos on how to operate the machine, check our website [www.elite.es](http://www.elite.es)**