

**OPERATING INSTRUCTIONS
for the
Polishing unit**

LUKAShine



ENGLISH

Serial number:

Delivery date:

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Foreword

Remarks for the operator

As operators you are responsible for the adherence to all safety notes and for the intended use of this unit.

1. In order to make sure that you operate the unit correctly and you achieve a good result of your work pieces, please read the manual attentively.
2. Be sure that the operating instructions is always legible and available in full at the units location.
3. In particular the operator must ensure that the personnel are regularly instructed in all matters relating to occupational safety and environmental protection and are familiar with the operating manual and in particular the safety instructions in it.
4. The operator must make the manual accessible for the unit operator and make sure that he read and understood these.
5. Ensure that the unit is maintained and repaired only by sufficiently qualified and authorized personnel.
6. Use only perfectly functioning units.
7. The manufacturer does not take over adhesion for damage to the unit or to work pieces, which lead through not paying attention of the following manual.
8. Storage temperature for granulates with the designation H./... amounts to maximally 30°C, the maximum storage time 6 months. If the storage time is too long and/or storage temperature over 30°C, the granulates can get too dry and cause thus problems in the unit.
9. This manual is constituent of the scope of supply.
10. All safety signs and control signs at the unit are to be always held visible and in a well readable status and are not to be removed.
11. Any changing or removing from protection device e.g. limit switches, linings or metal sheets is inadmissibly and the unit may then not be operated. Any modification requires the in any case written agreement of the manufacturer.
12. For the operation of the unit the process water may contain only particles with a size of maximally 10 micrometers.
13. Modifications by technical advancement opposite the data and figures specified in this manual we reserve ourselves.
14. Reproduction, translations and duplications in any form, also in part, require the written agreement of the publisher.

Residuals in the unit

In order to ensure a perfect function of the unit, it is tested with media. This can lead to residual amounts of media in the process-container.

Guidelines, regulations, standards

With the conception and with the building of this unit contents and notes from following guidelines and sets of rules were considered:

- RL 73/23 EWG
- RL 89/336 EWG EMV
- DIN EN 292
- BGV A2

Warranty regulations

The valid warranty regulation is determined in the terms of delivery.

You will have no warranty, if:

- damage occurs after the unit was used against the rules and inappropriate operation developed,
- repairs or manipulations have been made by persons, who are neither authorized nor trained for this,
- media, accessories or spare parts were used, which caused the damage and were neither recommended nor released by Lukadent.

There is no warranty for damages due to wrong power supply. Double check the actual data from the unit identification plate.

Lukadent warranty extends to the original purchaser for the first 12 months or two thousand (2,000) hours, whichever comes first, against defects in materials or workmanship. This warranty excludes normal wear and extends to parts only commencing from delivery date of the unit.

Prerequisite for the claim of warranty is the submittal of the purchase voucher (the invoice) with date and unit number.

There will be no warranty, if:

- Other media, paste or compound beside or instead of the products recommended by Lukadent was used.
- The unit was not operated in accordance with the manual.
- In an LUKAShine unit wet grinding chips were used, which are smaller than 3 mm.
- The unit is damaged through voltage fluctuation or similar influences.
- If the temperature in the process-container goes beyond 60°C (140°F)
- The gap in the wet process container is adjusted smaller than 0.3 mm.

There is no warranty on wear parts such as disc, upper cylinder or bearing assembly.

General safety instructions

Remarks about danger

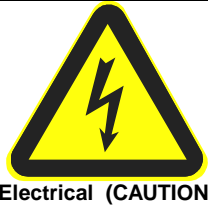
There is no danger for the operator if the unit is used according to the operation manual.

Safety notes in this Operating instructions

The present operating instructions contains the following safety symbols.



This symbol indicates above all danger to the unit, property and the environment, but not to persons. Failure to observe these warnings could result in malfunctions of and damage to the unit and/or damage to property and the environment.



This symbol indicates particular danger to the life and health of persons due to high voltage.



Strong magnetic field
This symbol points out that there is a potential danger for lives and health of persons - beyond there is also a potential danger for things or environment. If these symbols are not considered, then can entail heavy - and also deadly - injuries.



This symbol points out that there is a potential danger for lives and health of persons due to electromagnetic fields, especially for the life and the health of persons, who have a cardiac pacemaker. If these symbols are not considered, then can entail heavy - and also deadly - injuries.



This symbol marks some information which will lead to a better understanding of the unit/process. The information will help you to use the unit in the best possible way.



This sign defines user tips and other particularly useful information.

Safety Instructions

Fehler! Keine gültige Verknüpfung.



Strong magnetic field

Caution! Tapes, magnetic tapes, memories or magnetic stripes on check-cards and badges can be deleted by the magnetic field!



No access for persons
with pacemaker

Persons, who carry a cardiac pacemaker, may not be in the proximity of the magnetic field.

Qualification of the operator

Users of this unit must be instructed over the user special features and into the operation of the system.

The operator of this unit must make the operating instruction accessible for the users and make sure that each user read and understood the operation instructions.

Safety at the place where the unit will be set up

The unit must be set up in such a way that:

- the waste water can get into drains in no case.
- the length of the main power cord is sufficient.
- the main power cord does not obstruct the work routine.
- The unit may not be set up in a surrounding of acid fumes (e.g. galvanic)

Description of the product

Equipment

The LUKAShine consists of a base unit and a process-container. Except the version LUKAShine magnet polisher, the process-container can be taken off / exchanged via a quick release.

With the LUKAShine you can choose between four different versions:

LUKAShine base unit:

For this unit there are three different process-containers, which you can purchase separately.

- Process-container with integrated magnetic polisher
 - Process-container for wet processing
 - Process-container for dry processing
- Equipped with: speed regulation, timer, main power switch, display

LUKAShine magnetic polisher:

This unit can be used only as a magnetic polisher and can not be upgraded to other process-containers.

Equipped with: speed regulation, timer, main power switch.

LUKAShine for wet processing

This unit can be used only for wet processing and can not be upgraded to dry processing or magnet polishing process-containers.

Equipped with: speed regulation, timer, main power switch, connection for dosing pump

LUKAShine for dry processing

This unit can be used only for dry processing and can not be upgraded to wet processing or magnet polishing process-containers.

Equipped with: speed regulation, timer, main power switch

To verify the version of your LUKAShine, please check the delivery note / invoice.

Intended Use

The disc finishing units serve as surface treatment units (abrasive process) for jewelry or fine precision work pieces. Depending on the equipment of the unit it will be done in a wet or dry finishing process.

Description of the Function

The top of the process container is open and the disc at the bottom is designed to rotate. The container wall itself does not rotate.

When the process container is filled with polishing or grinding media and the disc rotates, a whirl like movement is generated, which creates a long frictional path resulting in an extremely efficient processing action on the work pieces.

Magnetic pin polisher

Stainless steel pins as well as water and compound are shifted by a rotary magnetic field in a turbulent motion.

If work pieces are likewise in this turbulence, they are hit permanently of stainless steel pins.

At each of these points the work pieces begin to shine, even in places which are usually difficult to reach, such as undercuts, recesses and slots.

Technical data

Fehler! Keine gültige Verknüpfung.

Basic Volume [l]	Width [mm]	Depth [mm]	Height [mm]	Weight [kg]	Power consumption [KVA / V]
6	380	300	500	25	0.8/230

The unit can be operated with 50/60 Hz.

Position and contents of the unit identification plate

The unit identification plate is located on the back of the unit.

Fillings

Magnetic polisher

max. filling for steel pins	200 grams
max. weight for all work pieces in the process-container	300 grams

Wet processing

max. filling for wet grinding media	3.0 liters, approx. 3kg
max. filling for high gloss porcelain media	3.0 liters, approx. 4 kg
max. weight for all work pieces in the process-container	300 grams
Min. size of wet processing media	At least 0.5 mm larger than the gap between the disc and the upper cylinder.
Min. size of the work pieces	At least 0.5 mm larger than the gap between the disc and the upper cylinder.

Dry processing

max. filling for dry polishing media	3.0 liters, approx. 2,0 kg
max. weight for all work pieces in the process-container	200 grams
max. weight per work-piece if you process several work-pieces at the time	approx. 8 grams
min. size of the work pieces	1 mm

Recommended media

LUKADENT recommends following media:

- LUKADENT ceramic wet grinding media with a max. size 15 mm
- LUKADENT compound with the designation SC...
- LUKADENT high gloss media with the designation ZP 3,0 and stainless steel balls ad=2,4 mm

Suitable Work Pieces

We strongly recommend you examine the work-pieces if they are suitable to be processed in the LUKAShine.

- Work pieces, which are heavier than 8 grams, should be processed individually if they might damage each other.
- Larger items, which could touch each other in the unit and therefore could get damaged, hooked up and thus bent, should be processed individually.
- Do not process work pieces which are smaller than 1mm. They might reach underneath the disc and damage the unit.

Structure and Components

The LUKAShine consists of a base unit and a process-container.

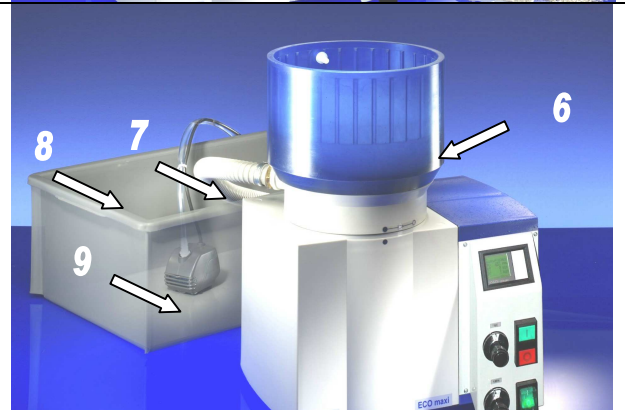
The LUKAShine is available in four different configurations:

Except at the LUKAShine magnetic polisher, the process-container can be taken off by a quick release.

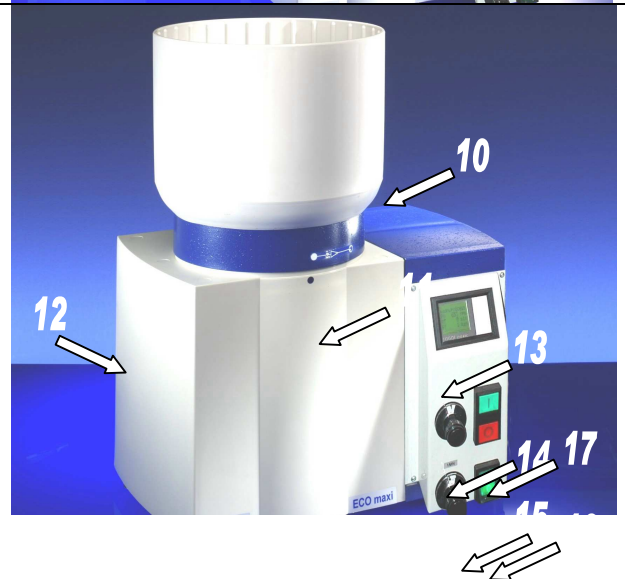
1. lid for magnet polisher
2. process-container for magnet polisher
3. adapter for magnetic polisher
4. compound for magnet polisher
5. stainless steel pins



6. process-container for wet processing
7. waste water hose
8. compound-water container
9. pump with basin



10. process-container for dry processing
11. index mark for quick release
12. base unit LUKAShine
13. display
14. timer
15. speed control
16. main switch
17. Start/Stop



EC - Declaration of Conformity

Manufacturer:

*Lukadent GmbH
Felsenbergweg 2
D- 71701 Schwieberdingen
Germany*

Product:

Disc finishing units

Type of unit:

LUKAShine

The products of the above mentioned type of units were developed, designed and manufactured in accordance with

**98/37 EG
2004/108 EG
2006/95 EG
2001/95 EWG
DIN EN ISO 12100**

The manual belonging to the unit is present. The CE indication was attached.
The safety notes of the provided manual must be considered!
This assertion certifies the agreement with the standards and guidelines mentioned, contained however no warranty of characteristics.

71701 Schwieberdingen, April 2009



Dirk Lukaschewski

Transport

The unit is sent in a packing which can easily be recycled.
Contents of the packing are checked and documented with the Lukadent for quality and completeness of the sections. Please check the delivery for completeness to avoid any inconveniences later.

Set up of the unit



CAUTION

To guarantee a trouble-free operation the unit must stand on an even surface.



CAUTION

The unit may be operated only over an earth-leakage circuit breaker (FI).

Setup of the unit: (only for the LUKAShine with wet process-container)

- Place the compound-water container behind the unit
- Attach the waste water hose to the unit and fix it on the compound-water container
- Put the blue basin to the opposite corner of the waste water hose.
- Put the pump into the blue basin.
- Connect the pump electrically to the unit
- Dental application
Mix 25 liters of fresh water and 0,6 liters compound SC 12 in the compound-water container.
- Connect the unit to the power supply. Be sure to use the proper voltage!



CAUTION

The dosing pump may do never run dry, since otherwise it can be damaged.

Now the unit is ready for use.

Start-up procedure

- Allow the air to circulate through the lattice on the bottom of the unit. Do not block it.
- The unit may not be put into a container otherwise there is the potential danger that water penetrates the electronics.
- Use the unit only with an earth leakage circuit breaker (ELCB, FI).

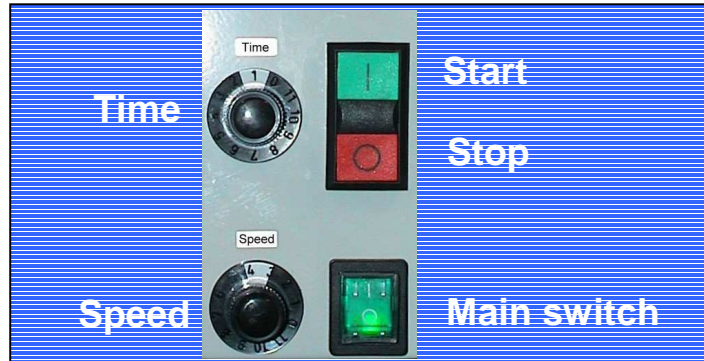


CAUTION

The dosing pump may do never run dry, since otherwise it can be damaged.

Unit Operation

Explanation of the Electrical Switches



- Main switch** Serves to interrupt the power supply in the unit.
- Time** By turning this button you can set the desired process time. The chosen time will be displayed in minutes besides the letters >PT<. While wet processing the pump will start simultaneous with the unit.
- Speed** With this button you can vary the speed in the process-container. The speed will be displayed besides the letters >PV<.
- Start:** Is used to start processing in the respective process container.
- Stop:** Is used to switch off the process container prematurely. If you press *Stop* once, the process container will be stopped and the process will be interrupted (no reset of time). If you press *Stop* for 2 seconds, the time will be set back (reset of time).

Display

- In the upper line the actual process will be displayed.
- PV Display of the speed in 1/min
- RT Display of the already expired time
- PT Display of the chosen process time

Error display

In case you can see the display >motor overheat< the unit got too hot and will switch off automatically.

Maximum speeds:

- | | |
|------------------|------------|
| magnet polishing | 1855 1/min |
| wet process | 350 1/min |
| dry process | 300 1/min |

How to Change a Process-Container

(not possible with the version LUKAShine magnetic polisher)

To remove the process-container :

Switch off the unit.

Turn the process-container about 30° clockwise...



...until the index mark on the lower part of the unit lines up with the right index mark of the process-container.
Now you can remove the process-container.



Caution! The shaft with the release which is now visible might be hot! Do not touch it.

CAUTION

To put back on a process-container :

Lower the process-container with the right index mark of the process-container lining up with the index mark of the lower part of the unit.



Turn the process-container about 30° counterclockwise until the index mark on the lower part of the unit lines up with the left index mark of the process-container.



How to Proceed while Processing

Processing with the Magnetic Polisher



Strong magnetic field

Caution! Tapes, magnetic tapes, memories or magnetic stripes on check-cards and badges can be deleted by the magnet polisher!



No access for persons
with pacemaker

Persons, who carry a cardiac pacemaker, may not be in the proximity of the work container of the magnet polisher.

How to Proceed while Magnetic Polishing

- Attach the process-container of the magnet polisher to the unit
- Fill about 0,1 liter compound into the process-container
- Fill fresh water into the process-container until about 9 cm underneath the upper rim
- Add the stainless steel pins
- Add your work pieces
- Cover the process-container with the lid
- Choose the desired process time and the desired speed, and then start the unit.



TIP

After approximately 16-20 hours the compound-water mixture in the container has to be changed. Otherwise the cut off of the chips and the work pieces will be pushed back into the surface of the work pieces. The result would be a bad quality of the finished product.

Processing with the Wet Process-Container

How to Proceed while Wet Grinding

- Attach the process-container for wet processing to the unit
 - To make the unit ready for use, proceed like described in chapter SET-UP OF THE UNIT. Mix 25 liters of fresh water and 1,25 liters compound SC 13 in the compound-water container.
 - Fill wet grinding media (e.g. 3kg KX 10/PX 10) into the process-container
-



TIP

Caution! Chips are getting smaller while processing. Add chips always when the amount is decreasing too much.

- Fill about ¼ liter water-compound mixture into the process-container and start the unit immediately by choosing the process time. Like this you will have immediately foam in the process-container.
 - Choose the desired process time and the desired speed, and then start the unit.
 - Adjust the amount of water-compound mixture.
 - Add the work pieces as the last step.
-



To get a feeling for the right parameters you can find some more information in the chapter: >Process examples<



TIP

Depending on the amount of cut off from the chips in the water-compound mixture after some time, it has to be replaced. Otherwise the result would be a worsened quality of the finished product.

Polishing with Porcelain Chips

This process is especially suitable for hard metals like NEM or for skeletons, crowns and bridges.

- Attach the process-container for the wet processing to the unit



TIP

Do not use the dirty wet process container. The waste of the chips will influence the result !
For wet polishing we recommend to use a separate, clean process-container.

- To make the unit ready for use, proceed like described in chapter SET-UP OF THE UNIT, but fill the compound-water container with 25 liter freshwater and 0,6 liter compound SC 4.
- Fill ceramic grinding media (e.g. 3kg) into the process-container.
- Fill about ¼ liter water-compound mixture into the process-container.
- Choose the desired process time and then start the unit. Like this you will have immediately foam in the process-container.



To get a feeling for the right parameters you can find some more information in the chapter: >Process examples<

- Choose the speed.
- Adjust the amount of water-compound mixture.
- Add the work pieces as the last step.



TIP

After approximately 16-20 hours the compound-water mixture in the container has to be changed. Otherwise the cut off of the chips and the work pieces will be pushed back into the surface of the work pieces. The result would be a bad quality of the finished product.

Processing with the Dry Process-Container



The finer the granule, the worse will be the movement in the process-container. Fill the container only to a level, where you still have a sufficient flow.

How to Proceed while Dry Grinding

- Attach the dry process-container to the unit
 - To make the unit ready for use, proceed like described in chapter SET-UP OF THE UNIT
 - Fill dry grinding media (e.g. 2,2 kg H2/100) into the process-container
-



TIP

Do not use the same process-container for the dry grinding and for the dry polishing. The residuals of the dry grinding paste will contaminate the dry polishing granule and therefore the mirror shining will not be achieved.

- Add always after approx. four hours of processing about one tea-spoon dry grinding paste SP 26.
 - Choose the desired process time.
-



To get a feeling for the right parameters you can find some more information in the chapter: >Process examples<

- Choose the desired speed.
- Start the unit.
- Add the work pieces as the last step.

How to Proceed while Dry Polishing

- Attach the dry process-container to the unit
- To make the unit ready for use, proceed like described in chapter SET-UP OF THE UNIT
- Fill dry polishing media (e.g. 2,2 kg H1/100) into the process-container
-



TIP

Do not use the same process-container for the dry grinding and for the dry polishing. The residuals of the dry grinding paste will contaminate the dry polishing granule and therefore the mirror shining will not be achieved.

-
- Add always after approx. 4 hours of processing about one tea-spoon dry polishing paste (e.g. P 6).
 - Choose the desired process time.



To get a feeling for the right parameters you can find some more information in the chapter: >Process examples<

-
- Choose the desired speed.
 - Start the unit.
 - Add the work pieces as the last step.

Dosing Pump

The dosing pump delivers the water-compound mixture from a compound-water container to the process-container.



The dosing pump may do never run dry, since otherwise it can be damaged.



The waste water may not arrive into drains.

- the waste water has to be cleaned either by a suitable waste water clarification system
 - or
 - a qualified company must be assigned for disposal.
-

Adjust the flow rate at the valve of the hose directly at the process-container, that a small jet of water flows into the process. (about 5 liter/hour)

Speed while Processing

The process speed has effects on following parameters while processing:

- Process time
- Surface quality
- Rounding of the edges
- Heat development



Following rule of thumb apply while processing:

- The bigger and heavier the work pieces, the slower the speed has to be.
 - The smaller and lighter the work pieces, the more you can speed up the unit.
-

After having chosen the speed, add as much media into the process-container that the movement still is acceptable.

Process Examples

Processing of skeletons

- Reinigen im Nadelbad (Magnetpolierer) für ca. ½ Std.
Media: Edelstahlstifte M 4/7 und 3%igen Mischung aus Wasser und SC 4
Geschwindigkeit: ca. 1800 1/min
- Vorschleifen für ca. 4 Std.
Media: Mischung (1:1) aus Keramikschleifkörpern DS 6/10 und DZS 4/4 und einer 2-3%igen Mischung aus Wasser und SC 13
Geschwindigkeit: ca. 280 1/min
Wasserzulauf: ca. 5 Liter/Std.
- Polieren für ca. 1 Std.
Media: Porzellanpolierkörper ZSP 3/5 und einer 5%igen Mischung aus Wasser und SC 13
Geschwindigkeit: ca. 280 1/min
Wasserzulauf: ca. 5 Liter/Std.

Problems and Remedy while Processing

Problem: When processing with ceramic grinding media, a very thick foam, which does not disappear, builds up in the waste-water container.

Cause: There is too little compound in the water or rather the compound is used up.

Remedy: Increase the concentration of the compound.

Maintenance, Servicing and Repairs

Maintenance

Please keep your unit clean. Pollution at the unit, e.g. rests of polishing pastes or process water, can cause damage to mobile sections or the paint of the unit. Keep the unit free by empty containers, bags or similar items.

To operate a clean unit also surely makes more fun.

In order to ensure the perfect function of the unit on long time, please absolutely adhere to the following intervals maintenance routine.

Servicing the Magnetic Polisher

Daily maintenance routine

- Check the unit for unusual noise or unbalance.

Weekly maintenance routine

- Check the process-container for wearout, cracks and leakage and exchange it if applicable.

Servicing the Wet Process-Container

Daily maintenance routine

- Check the unit for unusual noise or unbalance.
- Ensure that the water supply and the waste water outlet are guaranteed.

Weekly maintenance routine

- Clean the compound-water container.
- Check the gap. Minimum size is 0.3 mm (see detailed instructions below)



With the feeler gauge which came with the unit you can check the size of the gap. When the 0.3 mm feeler gauge (it is written "30" on it) just slides into the gap between the disc and the upper cylinder, the gap is correct.



In case the gap is larger or smaller, you can simply change its size with the adjustment screw for gap-setting. Opening the hose clip (counter clock wise rotation of the screw driver) will make the gap larger
Closing the hose clip (clockwise rotation of the screw driver) will make the gap smaller.

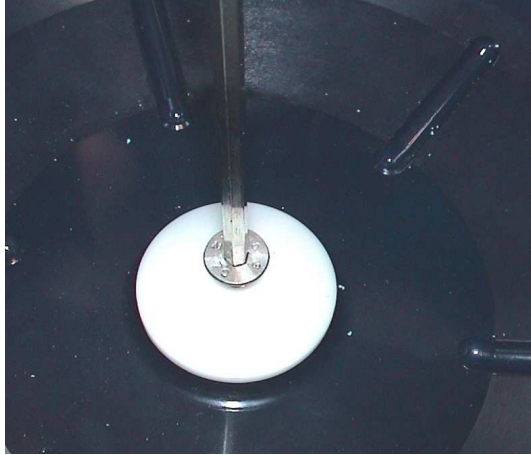


CAUTION

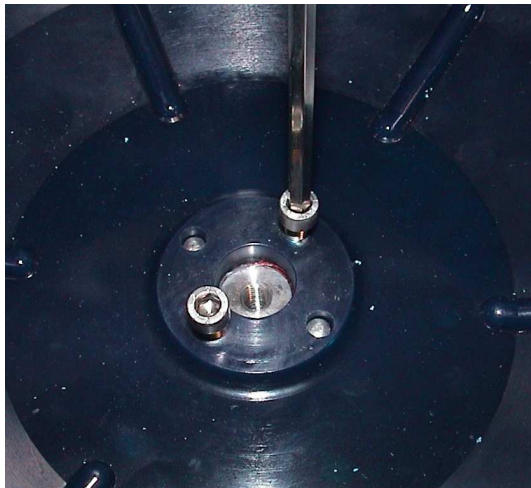
Never adjust the gap while the unit is running. This will lead to damage of the disc and the upper cylinder.

Monthly maintenance routine

- Clean the area underneath the disc. (see detailed instructions)



Remove the screw with the allen key size 5 mm which came with the unit. Remove now the cone.



Insert the two screws M 6x30 which came with the unit. Turn them alternately clockwise into the disc until it comes loose. Then remove the disc.



Clean the area underneath the disc and check/clean if necessary the waste water outlet.

Servicing the Dry Process-Container

Daily maintenance routine

- Check the unit for unusual noise or unbalance.

Monthly maintenance routine

- Clean the area underneath the disc with a brush. To do so remove the disc from the unit. When you insert the disc again, pour about one teaspoon fine walnutshell granule (H1/500) under the disc, to avoid a too big friction of the disc to the container.



CAUTION

DO NOT BEND THE DISC!

Repairs

When servicing the unit you must observe the following safety instructions in order to avoid lethal injury, damage to the unit and other material or environmental damage.

- Switch off all voltage sources and secure them against being inadvertently switched on again.
- Depressurize all pressurized units.
- Read the chapter "General safety instructions"

While maintaining:



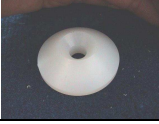


- The maintenance schedule prescribed in the manual is to be executed within the prescribed period.

Before executing the maintenance routine, please respect following:

- Exchange all defect unit parts immediately.
- After termination of the maintenance work and before starting the unit the following points are to be considered:
 - check again all screwed joints loosened before, if they are really tightened
 - check whether all safety devices removed before, covers, lids, filters, are again inserted correctly.

Spare Parts

Spare Parts List

Designation		Lukadent order number	
Disc for wet process-container		E006-01-002	
Container for magnetic polisher		E006-40-001	
Fixation for disc		E006-01-011	
Speed button (potentiometer)		E000-09-023	
Carrier bolt		E006-01-003	
Fuse	1,0 A medium fast	E000-09-030	
	6,3 A medium fast	E000-09-029	
Dosing pump 230 Volt		E006-03-002	

How to order Spare Parts

Our units are subject to constantly technical innovations. In order to give to you the correct spare part and the appropriate fitting instructions, we absolutely need the serial number (>Gerätenummer<) on the unit identification plate.



Please ask for toolkits and aids which help you exchanging spare parts in the unit.

How to Install Spare Parts

A detailed fitting instruction for spare parts is attached to the spare parts delivery. If not, please give us a call and we will send it immediately by email.

+49 (0) 7150 32955

Email: info@lukadent.de

Trouble Shooting

Technical Problems and Remedy

Problem: The disc jams.

Cause: The gap between the disc and the work-container is too narrow, the disc is badly worn or there are chips/work-pieces jammed in underneath.

Remedy: Remove the chips or the work-pieces and check the disc wear. If necessary, replace the disc.

Fuses in the unit



The rated amperage of the exchanged fuse must correspond to the rated amperage indicated in the wiring diagram. It may NEVER be larger!

Withdrawal from Service

Temporary Withdrawal from Service

- Disconnect the unit from the power supply if you will not use it for a longer period of time, e.g. on the weekend or longer.
- Empty the process-containers.
- Flush the wet process-container with several liters of water-compound mixture if you will not use it for a longer period of time, e.g. on the weekend or longer.
- Before you start reusing the unit after a longer period of time, first turn the disc by hand. Like this you avoid damage to parts of the unit, in case some components are glued together by compound, paste or media.

Final Withdrawal from Service and disposal

When its useful life has ended, the unit may be dismantled and eliminated. In this case, the operation must be carried out according to local legislation on the disposal of such unitary, in addition to the procedures foreseen by Community laws for environmental protection.

EEC Directive 75/442 relative to the disposal of general waste.

EEC Directive 78/319 relative to the disposal of toxic and harmful waste

SALE

If the unit is sold, the purchaser has the right to be informed on all intervention performed on the unit, to be instructed on its use and maintenance and to receive all of the relevant documentation together with the declaration of conformity.

Optional equipment




	Order number	
Process-container for magnetic polisher	A006-01-003	
Process-container for wet processing	A006-01-002	
Process-container for dry processing	A006-01-001	
Ringholder for dry processing of heavy objects, such as e.g. rings	A006-08-001	
Manual screening unit diameter 4mm (for dry processing)	A004-10-002	
Manual screening unit diameter 14mm (for wet processing)	A004-10-003	

Chart to convert from metric to...and reverse

Kilogram (Kg)	1 KG = 1000gr	35.27 ounces 2.205 pounds
Liter (l)	1 l	0.035 cubic foot 61.02 cubic inches 0.220 gallon (Imp.) 0.264 gallon (US) 1.76 pints (Imp.) 2.205 pounds
Millimeter (mm)	1 mm	0.03937 inch
μ (micron)	0,001 mm = 1 μ	0.00003937 inch
Inches	1 inch	25.4 mm
Foot	1 foot = 12 inches	304,8 mm
Cubic foot	1 cubic foot = 1728 cubic inches	28 l
Cubic yard	1 cubic yard = 27 cubic feet	765 l
Gill	1 gill	0,142 Liter
Pint	1 pint = 4 gills	0,57 l
Quart	1 quart = 2 pints	1,136 l
Gallon	1 gallon = 4 quarts	4,546 l
US liquid gill	1 US liquid gill	0,118 Liter
US liquid pint	1 US liquid pint = 4 gills	0,473 Liter
US liquid quarts	1 US liquid quarts = 2 pints	0,946 Liter
US gallon	1 US gallon = 4 quarts	3,785 Liter
Hundredweight	1 hundredweight (or short hundredweight) = 100 pounds	45,36 kg
Grain	1 grain	0,0648 g
Drachm or dram	1 drachm or dram = 27.34 grains	1,77 g
Ounce	1 ounce = 16 drachms	28,35 gr
Pound	1 pound = 16 ounces	435,6 gr
Stone	1 stone = 14 pounds	6,348 kg
Quarter	1 quarter = 28 pounds	12,7 kg
Hundredweight	1 hundredweight = 112 pounds	50,8 kg
Kilo Watt	1 KW	1,34 HP
Horse Power	1 HP	0,746 KW