

PROMAC®

08-2020

Grinder & Steel Brush

324BP 325BP



CE

France
TOOL FRANCE
9 Rue des Pyrénées, 91090 LISSES,
France
www.promac.fr

CE-Conformity Declaration
CE-Konformitätserklärung
Déclaration de Conformité CE

Product / Produkt / Produit:

Grinder & Steel Brush

324BP / 325BP

Brand / Marke / Marque:

PROMAC

Manufacturer / Hersteller / Fabricant:

TOOL FRANCE

9 Rue des Pyrénées, 91090 LISSES, France

We hereby declare that this product complies with the regulations
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

2006/42/EC

Machinery Directive

Maschinenrichtlinie

Directive Machines

2014/30/EU

electromagne compa bility

elektromagne sche Verträglichkeit

compa bilité électromagné que

2011/65/EU

RoHS directive / RoHS-Richtlinie / Directive RoHS

designed in consideration of the standards

und entsprechend folgender zusätzlicher Normen entwickelt wurde

et été développé dans le respect des normes complémentaires suivantes

EN ISO 12100:2010

EN 62841-1:2015

EN 62841-3-4:2016

EN61000-6-4:2007+A1:2011

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:

Head Product-Mgmt. / Leiter Produkt-Mgmt. / Resp. Gestion des Produits

TOOL FRANCE



2020-08-19 Christophe SAINT SULPICE, General Manager

TOOL FRANCE

9 Rue des Pyrénées, 91090 LISSES, France

Safety Rules for All Power Tools

1. Read and become familiar with the entire instruction manual. Learn the tool's applications, limitations and possible hazards.
2. Earth all tools .If the tool is equipped with a three-prong plug. It must be plugged into a three-contact electric outlet. The third prong is a ground to provide protection against accidental electrical shock. If an adapter is used to accommodate a two-contact outlet, the adaptor's grounding lug must be connected to a known ground. Never remove the third prong on a three prong plug.
3. Check damaged parts. A guard or any other part that is damaged should be checked to ensure that it will operate properly and perform its intended function before the tool is used further. Check for proper alignment of moving parts and for possible broken parts, loose mountings, or any other condition that could affect the tool's operation. A guard or other damaged part should be properly repaired or replaced.
4. Disconnect power before servicing and when changing accessories such as blades, cutters.
5. Keep guards in place and in working order.
6. Protect your eyes from being injured by objects thrown by a power tool. Always wear safety glasses or safety goggles.
7. Wear a face mask or dust mask if the cutting operation produces dust.
8. Don't force the tool. It will give a better and safer performance when used on jobs for which it was designed.
9. Avoid accidental starting. Ensure that the power switch is in the OFF position before plugging in the power cord. Remove the switch when the tool is not being used.
10. Remove adjusting keys and wrenches. Ensure that keys and adjusting wrenches are removed from the tool before turning it on.
11. Drugs, alcohol, and medication. Do not operate tool if you are under the influence of drugs, alcohol, or medication that could affect your ability to use the tool properly.
12. Use recommended accessories. Using improper accessories can be hazardous. If in doubt, check the instruction manual.
13. Never stand on a tool. Falls can result in injury.
14. Never leave a tool running unattended. Turn the power switch OFF. Don't leave the tool until it has come to a complete stop.
15. Always remove the power cord plug from the electric outlet when making adjustments, changing parts, cleaning, or working on the table.
16. Avoid dangerous conditions. Don't use power tools in wet or damp areas or expose them to rain. Keep your work area clean and well lighted. Do not use power tools in areas where fumes from paint, solvents, or flammable liquids pose a potential hazard.
17. Keep visitors and children away. Other people should keep a safe distance from the work area, especially when the tool is operating.

18. Use the proper tool. Don't force a tool to do a job for which it was not designed.
19. Keep tools in top condition. Keep them clean and sharp for best and safest performance. Follow the instructions for changing accessories and lubricating.
20. Secure all work. When practical use clamps or a vise to hold work. It is safer than using your hands and prevents round or odd shaped pieces from turning.
21. Don't overreach. Keep proper footing and balance at all times. Wear oil resistant rubber-soled footwear. Keep the floor clear of oil, scrap wood, and other debris.
22. Wear proper clothing and, if necessary, protective hair covering. Loose clothing or jewelry can get caught in moving parts.
23. Make the workshop childproof with padlocks, master switches, or by removing starter keys.

EN - ENGLISH (Original instructions)

Operating Instructions

Dear Customer,

Many thanks for the confidence you have shown in us with the purchase of your new machine. This manual has been prepared for the owner and operators of a PROMAC grinder to promote safety during installation, operation and maintenance procedures. Please read and understand the information contained in these operating instructions and the accompanying documents. To obtain maximum life and efficiency from your machine, and to use the machine safely, read this manual thoroughly and follow instructions carefully.

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1. Declaration of conformity

On our own responsibility we hereby declare that this product complies with the regulations* listed on page 2.

Designed in consideration with the standards**.

2. Warranty

The Tool France guarantees that the supplied product is free from material defects and manufacturing faults.

This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, accidental damage, repair, inadequate maintenance or cleaning and normal wear and tear.

Any warranty details (i.e. warranty period) can be found in the General Terms and Conditions (GTC) that are integral part of the contract. These GTC can be viewed at the website of your dealer or sent to you upon request.

Tool France reserves the right to make changes

to the product and accessories at any time.

3. Safety

3.1 Authorized use

This grinder is designed for grinder metal and a similar grinder only. Machining of other materials is not permitted and may be carried out in specific cases only after consulting with the manufacturer.

The proper use also includes compliance with the operating and maintenance instructions given in this manual.

The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.

The required minimum age must be observed.

The machine must only be used in a technically perfect condition.

When working on the machine, all safety mechanisms and covers must be mounted.

In addition to the safety requirements contained in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of metalworking machines.

Any other use exceeds authorization.

In the event of unauthorized use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

3.2 General safety notes

Metalworking machines can be dangerous if not used properly. Therefore the appropriate general

technical rules as well as the following notes must be observed.



Read and understand the entire instruction manual before attempting assembly or operation.



Keep this operating instruction close by the machine, protected from dirt and humidity, and pass it over to the new owner if you part with the tool.

No changes to the machine may be made.

Daily inspect the function and existence of the safety appliances before you start the machine.

Do not attempt operation in this case, protect the machine by unplugging the power cord.

Before operating the machine, remove tie, rings, watches, other jewelry, and roll up sleeves above the elbows.

Remove all loose clothing and confine long hair.

Wear safety shoes; never wear leisure shoes or sandals.

Always wear the approved working outfit:

- safety goggles
- ear protection
- dust protection



Do not wear gloves while operating this machine.



Install the machine so that there is sufficient space for safe operation and workpiece handling.
Keep work area well lighted.

The machine is designed to operate in closed rooms and must be bolted stable on firm and levelled table surface

Make sure that the power cord does not impede work and cause people to trip.

Keep the floor around the machine clean and free of scrap material, oil and grease.

Stay alert!

Give your work undivided attention.

Use common sense. Do not operate the machine when you are tired.

Keep an ergonomic body position. Maintain a balanced stance at all times.

Do not operate the machine under the influence of drugs, alcohol or any medication. Be aware that medication can change your behavior.



Never reach into the machine while it is operating or running down.



Keep children and visitors a safe distance from the work area.

Never leave a running machine unattended. Before you leave the workplace switch off the machine.

Do not operate the electric tool near inflammable liquids or gases.

Observe the fire fighting and fire alert options, for example the fire extinguisher operation and place.

Do not use the machine in a damp environment and do not expose it to rain.

Always use a suitable dust collection device

Machine only stock which rests securely on the table.

Specifications regarding the maximum or minimum size of the workpiece must be

observed.

Do not stand on the machine.

Connection and repair work on the electrical installation may be carried out by a qualified electrician only.



Have a damaged or worn power cord replaced immediately.

Make all machine adjustments or maintenance with the machine unplugged from the power source.



3.3 Remaining hazards

When using the machine according to regulations some remaining hazards may still exist.

Thrown workpieces and workpiece parts can lead to injury.

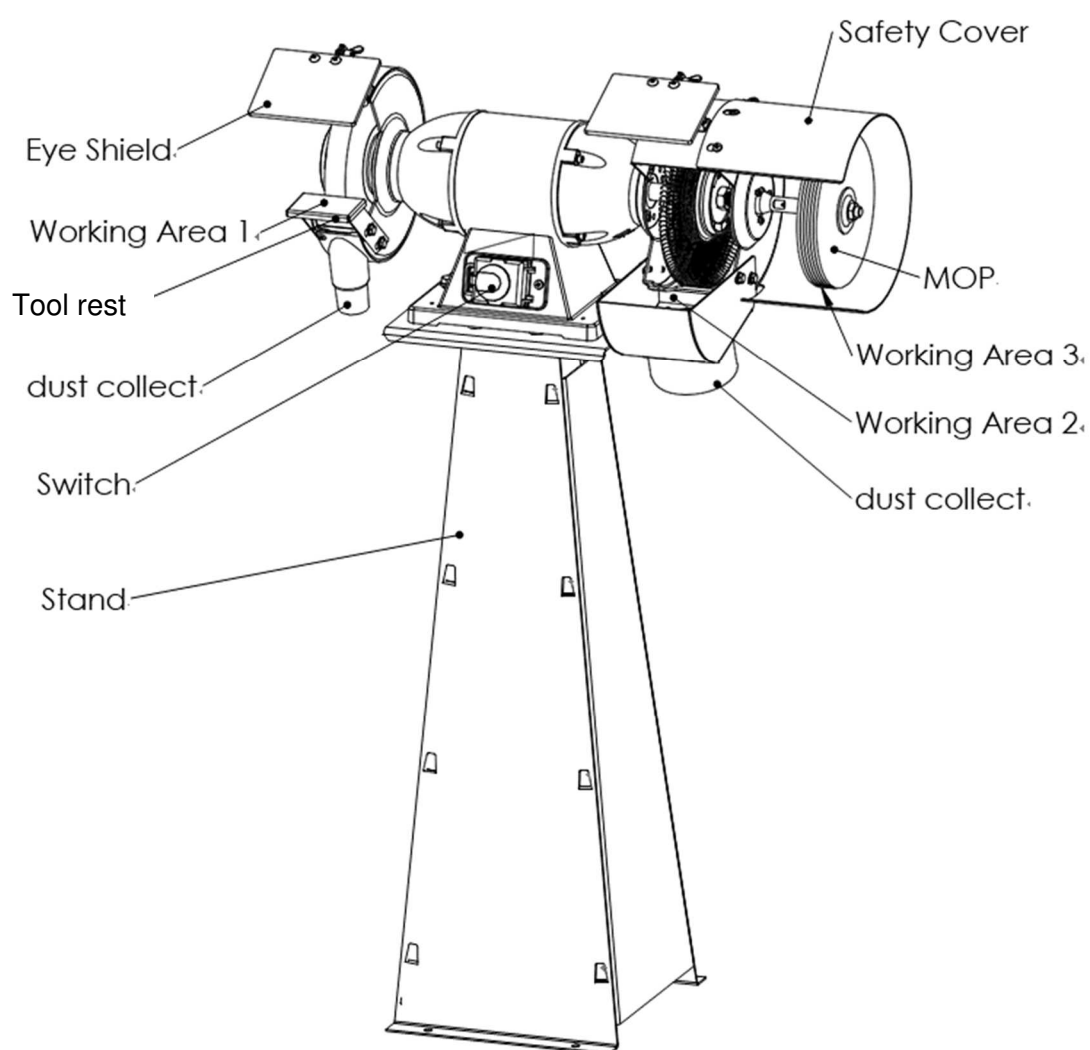
Dust and noise can be health hazards. Be sure to wear personal protection gear such as safety goggles and dust mask. Use a suitable dust collection system.

The use of incorrect mains supply or a damaged power cord can lead to injuries caused by electricity.

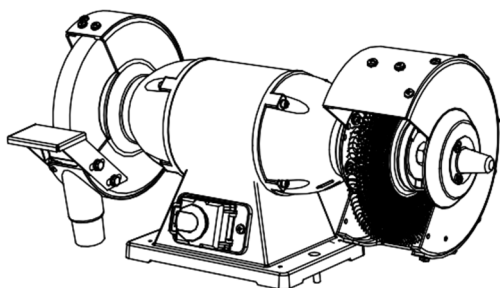
4. Machine specifications Technical data

Model.....	324BP.....	325BP
Power	230 / 50 / 1	400 / 50 / 3
Grinding Wheel Size	200 x 25 x 20	200 x 25 x 20
Steel Brush Size	200 x 19 x 16	200 x 19 x 16
Polish Size	177 x 24 x 12	177 x 24 x 12
Dust Collection Hole Size.....	36 + 100	36 + 100
Speed (RPM).....	2850	2850
Overall Dimension	690 x 310 x 340	690 x 310 x 340
Gross Weight (kg).....	23	23

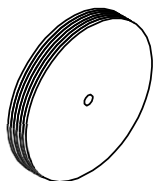
Machine Introduction



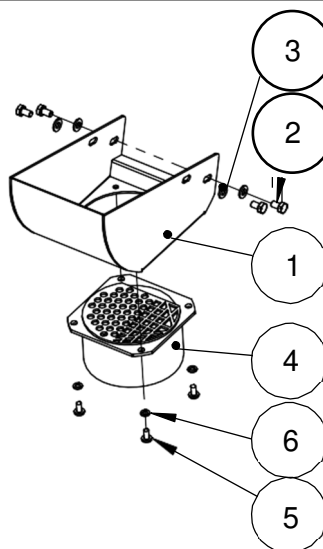
5. UNPACKING AND CHECKING LIST



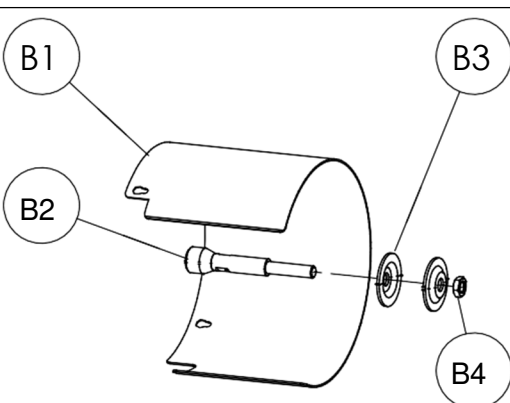
GRINDER ASSEMBLY
Q'TY:1



MOP/BUFFER
Q'TY:1

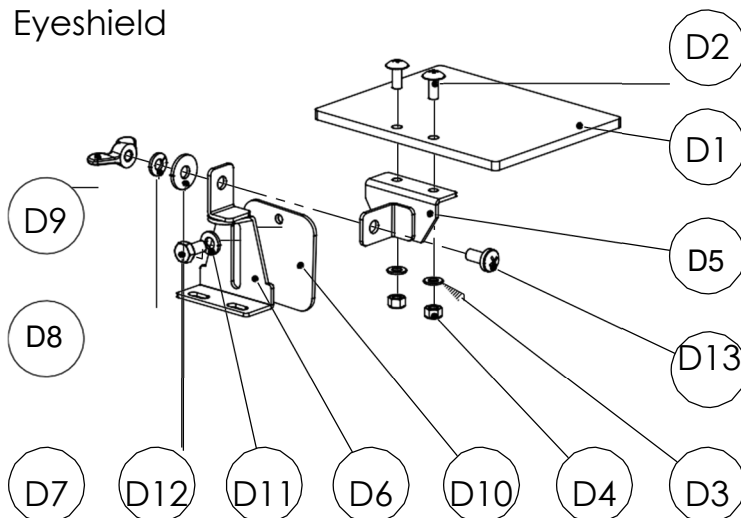


Ref. No	Description	Q'ty
1	Dust Collector	1
2	Hex.Bolt	4
3	Washer	4
4	Chip Outlet	1
5	Screw	4
6	Spring Washer	4

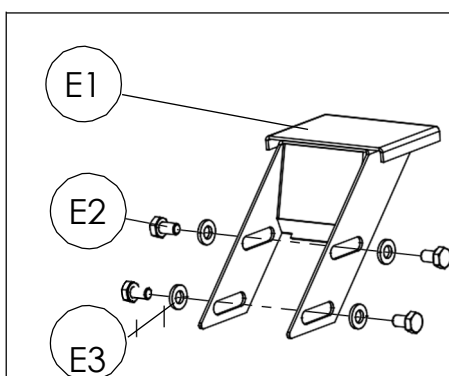


Ref. No.	Description	Q'ty
B1	Safety Cover	1
B2	Adaptor	1
B3	Disc Washer	2
B4	Nut	1

Eyeshield



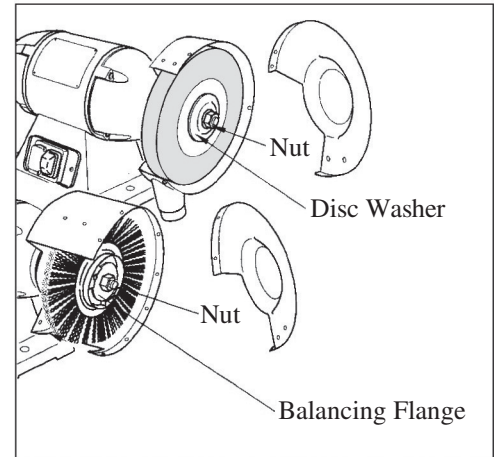
Ref. No.	Parts Name	Q"ty
D1	Eye Shield	2
D2	Screw	4
D3	Washer	4
D4	Hex. Bolt	4
D5	Support Plate	2
D6	Bracket	2
D7	Washer	2
D8	Spring Washer	2
D9	Wing Nut	2
D10	Spark shielding	2
D11	Washer	2
D12	Hex. Bolt	2
D13	Hex. Bolt	2



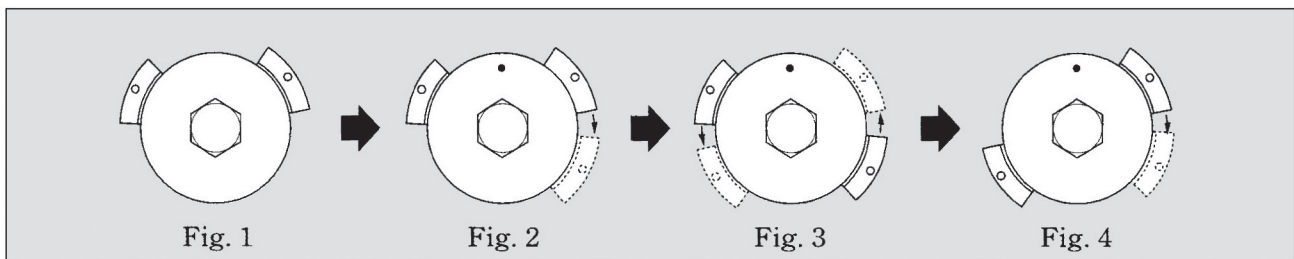
Ref. No.	Description	Q'ty
E1	Toolrest	2
E2	Hex.Bolt	4
E3	Washer	4

[REPLACEMENT OF WHEEL]

1. Remove toolrest and eyeshield or dust collector unit for wheel cover by taking off bolts and screws.
2. Take off screws to allow removing wheel cover as figure.
3. Remove nut, disc washer or balancing flange and waste wheel
4. Put new wheel and every parts back in reverse order. It's important to make a good adjustment of balancing before assembling wheel covers. This message could be learned
5. For your safety, check all screws and bolts. Make sure they are all well fixed before switch on.
6. The distance between wheel, spark arrestor and toolrest table should be always remained at about 2~3mm to get the better spark arresting effect and good grinding performance.
7. When this distance was changed due to the wearing of wheel, you need to do adjustment.



[ADJUSTMENT OF WHEEL BALANCE]



This job can be started when shaft nut of wheels were tightened.

The balancing adjustment was done through one particular parts of balancing blocks on balancing flange. It requires repeated testing by moving positions of two balancing blocks on balancing flange.

How to adjust

1. Put two balancing blocks in position shown in figure 1. Make first test run and check the balancing result.
2. Switch off if the balancing was no good. Start our first adjustment. Turn wheel to the original position as figure 1 by hand. Mark on Wheel

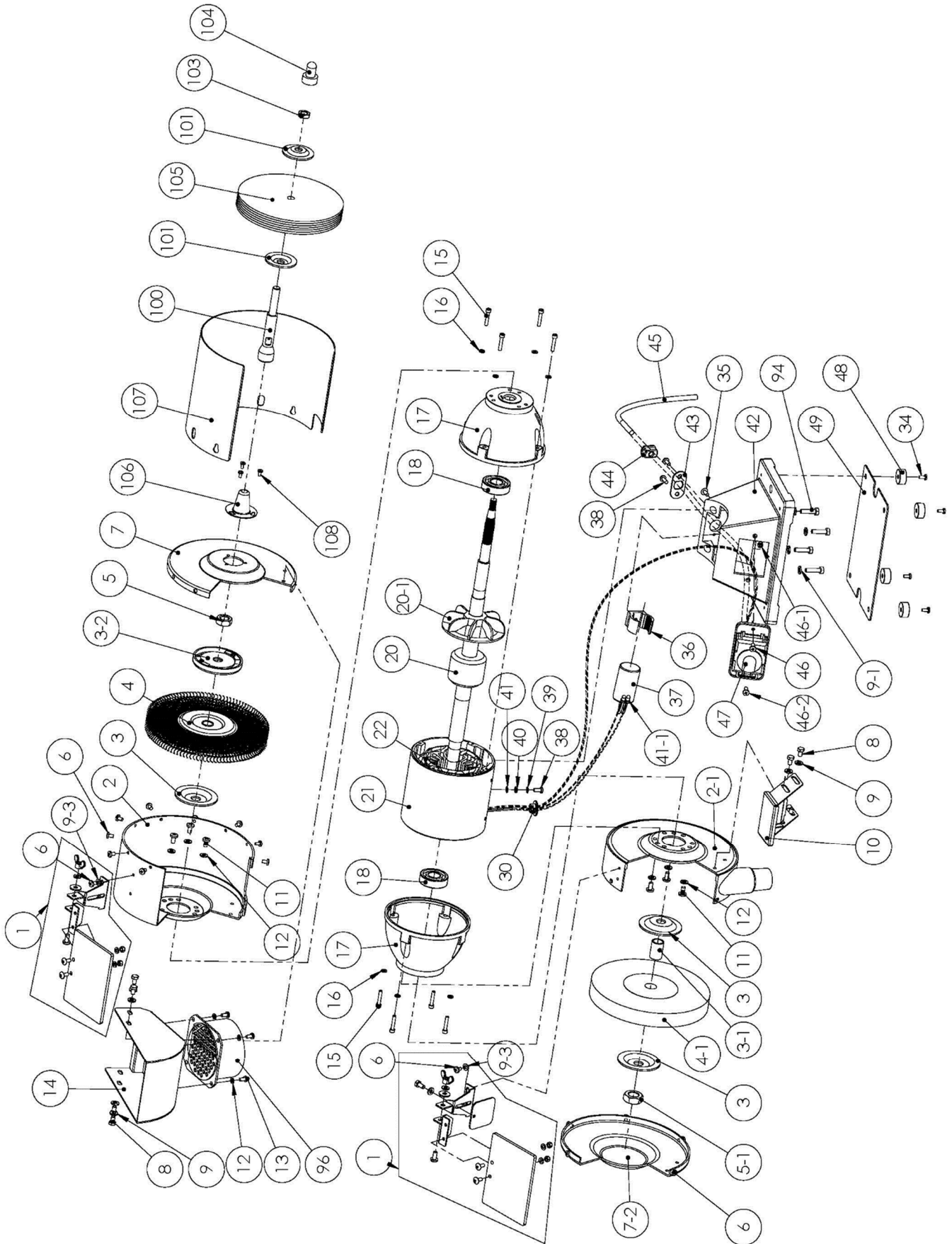
as figure 2. Move the right hand balancing block clockwise to new position, and tighten it. Make the second test run and check again.

3. Switch off if it's still not satisfied. Return balancing block to original position. Move the left hand balancing block counterclockwise to new position as figure 3. Make test run again.
4. If this is still no good, stop machine and turn to new position as figure 4.
5. Please note that you should not adjust too much movement for balancing blocks in every step of mentioned above, and you will be easy to understand its characteristic and make the machine to be your hand.

Safety advice on the mounting of new grinding wheels

1. Before mounting the wheel, brush it clean and examine it for damage. The soundness of a new wheel can be further checked by suspending it vertically and tapping it with a light non-metallic implement; it should ring. Do not use it if it sounds dead (cracked).
2. Flange size is normally not smaller than 1/3 of wheel diameter.
3. Do not force the wheel onto the machine or alter the center hole diameter of the wheel.
4. Tighten the nut on the flanges only sufficiently to ensure that they drive the wheel. Hand pressure on a standard spanner is enough; excessive force may damage the wheel.
5. Adjust the balancers of flanges.
6. Wheel of newly mounted must be tested on free run for at least one minute. Do not stand directly in front of the wheel while test run or when adjusting the balancers.
7. Ensure that the wheel guard is in position.
8. After finishing the mounting of new wheel, you may proceed to work, but please do not grinding at the side part of straight type wheels or with incompatible workpiece.

6. 324BP & 325BP Exploded View



7. 324BP & 325BP Parts List

Index No.	Part No.	Description	Size	Qty.
1	PM-322401	Eye Shield	100 x 130mm	2
2	PM-324502	Right Int. Cover (Including #6~9 & #12~14)	4B8 R	1
2-1	PM-324466	Left Int. Cover (Including #2-1, #6 & #7-2)	2B8 L	1
3	PM-320007	Disc Washer	1/2HP-5/8"	3
3-1	PM-320008	Bush	Ø5/8" x 30mm	1
3-2	PM-324503	Balance Flange	Ø83*16	1
4	2136	Wire Brush	8" x Ø5/8"	1
4-1	9340	Grinding Wheel	8" x 1" x 20mm A60L	1
	9399			1
	300X			1
5	PM-320009	Hex. Nut R.	5/8"	1
5-1	PM-315068	Hex. Nut L	5/8" L	1
6	PM-324406	Screw	M5 x 8L	18
7		Right Wheel Cover	4B8 R	1
7-2		Left Wheel Cover	2B8 L	1
8	PM-324408	Hex. Bolt	M6 x 10L	8
9	PM-324409	Washer	M6 x 16 x 2T	11
9-1	TS-1550041	Washer	M6 x 18 x 2.0T	4
9-3	TS-1550031	Washer	M5 x 12 x 1T	4
10	PM-324411	Toolrest	2B8	1
11	PM-320033	Screw	1/4" x 1/2	6
12	PM-320032	Spring Washer	M6(1/4")	12
13		Screw	M6 x 10L	4
14		Dust Collector		1
15	PM-324021	Screw	3/16" x 1.1/4"	8
16	PM-320035	Spring Washer	M5(3/16")	8
17	PM-324023	Support	Ø117 6204	2
18	985483	Ball Bearing	6204zz	2
20	PM-324429	Rotor for 324BP	26 x 544.5L x Ø60	1
	PM-325429	Rotor for 325BP	26 x 544.5L x Ø60	1
20-1	PM-320038	Fan	Ø22.5 x 105mm	1
21/22	PM-324427	Stator Housing & Stator for 324BP	117 x 120	1
	PM-325428	Stator Housing & Stator for 325BP	117 x 120	1
30	PM-320050	Grommet Rubber	3/4"	1
34	PM-320006	Screw	3/16 x 1/2	1
35	PM-320046	Screw	3/16" x 7/16	1
36	PM-320045	Clamp		1
37	PM-324443	Starting Capacitor	16uf/350V	1
38	PM-320004	Screw	3/16" x 3/8"	3
39	PM-320005	Int. Washer	M5	1
40	PM-320146	Copper Set		1
41	PM-320145	Ext. Washer	M5	1
41-1	PM-324041-1	Close-End Wire Connector	C4	2
42	PM-325055	Grinding Base	Ø117	1
43	PM-320003	Fixing Plate		1
44	PM-320002	Cable Strainer	6W3-4R	1
45	200035	Power Cord 230V for 324BP	0.75 x 3P x 1.8M	1
		Power Cord 400V for 325BP	0.75 x 4P x 1.8M	1
46	PM-320054	Screw	M4 x 15L	1
46-1	TS-1541001	Hex. Nut	M4	1

Index No.	Part No.	Description	Size	Qty.
46-2.....	TS-2284121	Screw	M4 x 10L.....	1
47	PM-212055	Switch for 324BP	NVR+ 230V/50HZ	1
.....	PM-371652	Switch for 325BP	JD3+ 400V/50HZ.....	1
48	PM-320061	Pad.....	1
49	PM-324058	Base Plate.....	152 x 217mm.....	1
94	TS-0050051	Screw	1/4" x 1"	4
96	PM-324096	Chip Outlet	4"	1
100	9190.....	Adaptor (Including #100~103)	26 x M12 x 135mm.....	1
101	Disc Washer.....	1/4HP-1/2"	2
103	Hex. Nut	M12.....	1
104	9493.....	Adaptor Cap.....	Ø25 x 36.5	1
105	9339.....	MOP / Buffer	7" x 12mm	1
106	PM-322116	Rotor Shaft Cap	1
107	PM-324117	Safety Cover	1
108	PM-322107	Screw	M4 x 6L.....	3



Environmental protection

Protect the environment.

Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.



This symbol indicates separate collection for electrical and electronic equipment required under the WEEE Directive (Directive 2012/19/EC) and is effective only within the European Union.

Umweltschutz

Schützen Sie die Umwelt!

Ihr Gerät enthält mehrere unterschiedliche, wiederverwertbare Werkstoffe.
Bitte entsorgen Sie es nur an einer spezialisierten Entsorgungsstelle.



Dieses Symbol verweist auf die getrennte Sammlung von Elektro- und Elektronikgeräten, gemäß Forderung der WEEE-Richtlinie (2012/19/EU). Diese Richtlinie ist nur innerhalb der Europäischen Union wirksam.

Protection de l'environnement

Protégez l'environnement !

Votre appareil comprend plusieurs matières premières différentes et recyclables. Pour éliminer l'appareil usagé, veuillez l'apporter dans un centre spécialisé de recyclage des appareils électriques.



Ce symbole indique une collecte séparée des équipements électriques et électroniques conformément à la directive DEEE (2012/19/UE). Cette directive n'est efficace que dans l'Union européenne.