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SALES:447-902-3857
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EMAIL:INFO@AUTOKATO.COM

WL-70

RIM STRAIGHTENER

Read the entire contents of this manual before using this product. Failure to follow the instructions and safety precautions in this manual can result in serious injury or death. Make sure all other operators also read this manual. By proceeding with setup and operation, you agree that you fully understand the contents of this manual and assume full responsibility for product use.

Please follow the instructions to use

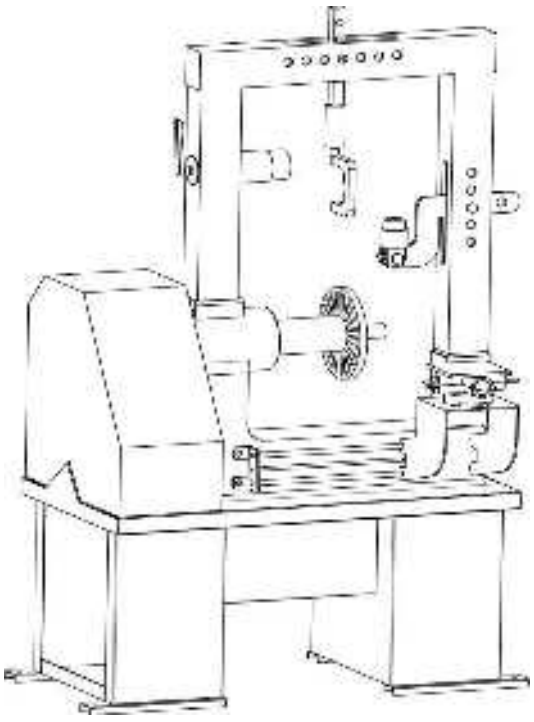
The machine

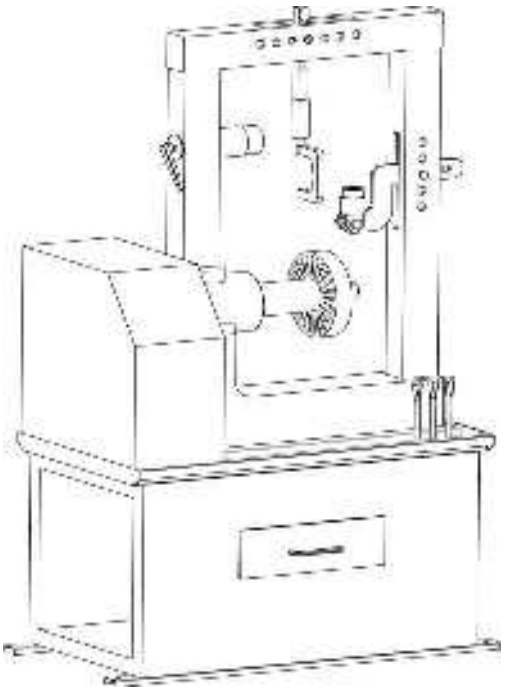
KEEP THE MANUAL NEAR THE MACHINE ALL TIMEAND MAKE SURE ALL USERS HAVE READ THIS

FOLLOW THE INSTRUCTIONSCAREFULLY TOGRANT THE MACHINE A CORRECT FUNCTION AND

Rim Straigtening Machine

**Manufacturer keeps the rights to improve the contents in this manual*





Notice

The manual is a main part of the product. Before using the machine, please carefully study the warnings and instructions mentioned in it, It is important for safe use and maintenance.

Note: This machine is a rim press to repair the defective rims.

The machine must be used only by the functions for which it was expressly designed, Any other use is considered wrong and unacceptable.

IMPORTANT

This machine must be operated only by the trained personnel, Any work on the electrical, hydraulic, pneumatic systems must be conducted only by professionally qualified personnel.

CONTENT

Technical Characteristics

Specification

height……1390mm

length……1400mm

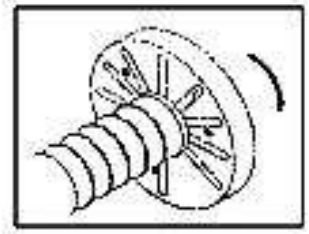
width……900mm

Weight

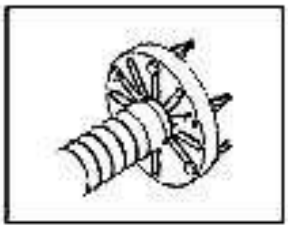
Net weight……330kg

noisy……75db

Machine Description

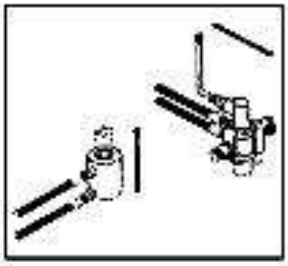


- The flange must rotate in arrow direction



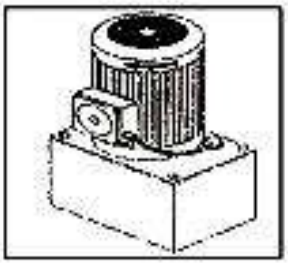
- Rim connecting flange

Theflange is designed to serve different size rims



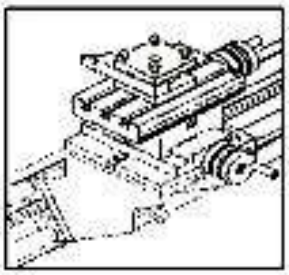
- Controlling unit

This part ia to control the movements of piston.



- Hydraulic unit

This part can move the piston up and down.



- Lathe unit

This part is to lathe the defective rims after repairing

Instruction

This manual has been prepared for workshop personnel expert in the use of machine and technicians who are responsible for routine maintenance; Read the manual before starting any operation with the rim repairing and packing. This manual includes important information concerning:
•The safety of rim repairing machines
•Personnel safety of operations and maintenance workers.

Packing, Transport, Storage
The pallets must be moved with a lift truck, the equipment chosen must be suitable for safe lifting and moving Bearing in mind the dimensions, weight and fragile pares not to be damaged.
Storage
Packed machinery must always be kept in a covered, protected place at a temperature between-10°Cto+40°Cand must not be exposed to sunlight directly.

Packages Stacking
The type of packing allows the possibility of stacking up to 2 packages, provided they are restrained to Prevent falling, Up to 2 pallets may be stacked one upon the other on truck or in containers if properly positioned and provided they are restrained to prevent falling.
Opening crates
When the crates arrive, check that the machine has not been damaged boring transport and that all the listed parts are present. The crates must be opened using all possible precautionary measures to avoid damaging the machine the machine or its parts. Make sure that parts do not from the crate during opening.

Disposal of crates
The wooden pallets and the packing film may be re-cycled.

Safety

• This machine is designed only fpr10 " -22.5 " rims.
• This machine must be used only for rim repairing operation
• Pay attention to the warning signs on the machine
If the operator hears unusual noises or vibrations or something that may be dangerous, he must immediately button main switch off the main switch and check the section“Causers and possible remedies” in the instructions manual. if the problem is still, please call the service.

• Wearing protection glasses and gloves during operation
• Stand straight during operation

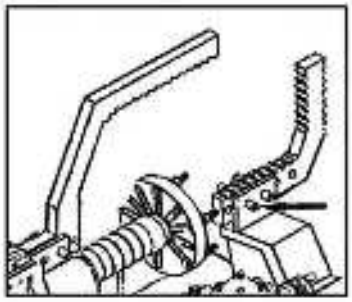
Lighting: All parts of the machine must be uniformly lit with sufficient light to assure that the adjustment areas of shadow, reflected light, glare and avoiding all situations that could give rise to eye fatigue.

• Work in an insulated and clean area
• Switch off the main switch when there is no electricity.
• Work in the safe distance
• The machine must be fixed onto smooth place.

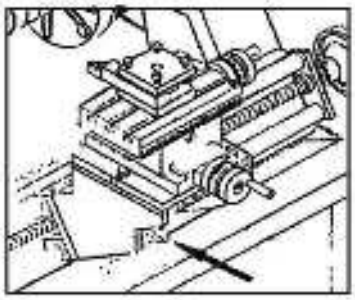
!DO NOT STAND IN FRONT OF THE FLANGE WHEN IT IS RUNING

Safety

- Do not put your hands between the piston and be sure that the rim is well fixed to the flange.
- Do not use the piston on living things



- Be sure that the support pins are mounted and Check that the piston is in canal.



- Tight the fixing handle during lathe operation.
- Do not use the jets of water,steam(high pressurewash units),solvents near the rim repairing machine.
- Unplug or switch off the main switch before startingcleaning the machine.

- Lock nut

- Speed adjustable

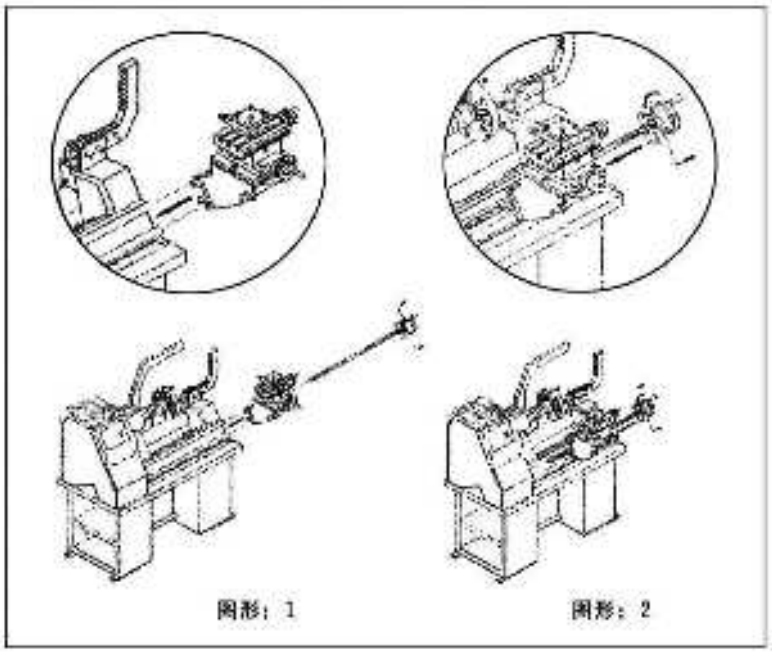


Figure 1: Montage the base cross sliding table to the body by the sliding rows.

Figure 2: Screw the handle to the sliding table and tight back connecting lama to thesliding miles.

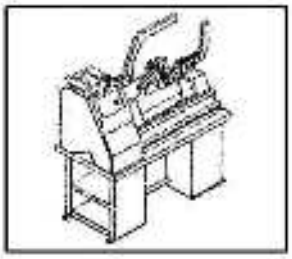
Problems-Causes-Remedies

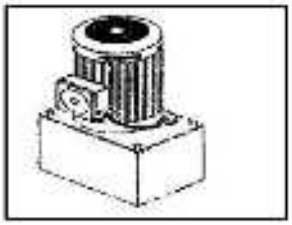
The flange does notrotate in any direction.	1. The main connection is notplugged in. 2. Faulty fuse.The plug is not correctly wired. 3. The main swith is not on	1. Check the correct insertion of the plug and its conmection. 2. Sitch on the mains. 3. Replace the fuse.
The pressure of thehydraulic unit is notenough.	1. The rotation of the hydraulicengine is reverse, 2. There is leak of oil in theconnection. 3. There is leak of oil in thehydraulic engine.	1. Reverse the two wirs in theconnection plug. 2. Check the couplings,changethem if necessary 3. Filing ol to the hydraulic engine.

To fix the machine on the floor

● In order to have a good functioning, the machine must be fixed onto the floor with expansion dowels.

a. Dril the floor with a helical concrete bit with a diameter of 15mm,using the holes in the2. base as a drilling template.
b. Move the rim repair and insert anchor bolts into the drills, then set the machine in theplace to be fixed.
C. Insert into the anchor bolts and use a torgue wrench (setting of 25N/m) to tighten.





Location

Safe distance:

For the safe and ergonomic use of the machine, it is advisable to locate it in order to allow work in conditions of complete safety.

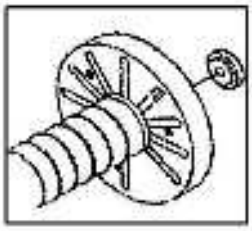
ALL WORK ON THE ELECTRICAL SYSTEM,INCLUDING MINOR OPERATIONSMUST BE CARRIED OUT BY PROFESSIONALLY QUALIFIED PERSONNEL

●Check that the main supply is same as that shown on the registration plate.
●Connecting the cable to plug that confirms with European norms or to the norm of the country inwhich the machine used.
●The plug must have an earth terminal.
●Check that the earth connection is effective.
●The machine must be connected to the mains through a multiple isolating switch which confirmswith European norm and with contact openings of at least 3mm.
●Check that multiple connector on the electrical board is correctly connected.
●When the machine is connected, swith it on and check the correct direction of rotation; this shouldbe as shown by the arrow on the motor unit.
●If the rotation is reversed, reserve the two wires in the connection plug.
●If the machine operates abnormally,immediately press the emergency button and switch off the main swith and check the section of "Causes and possible remedies"in the instruction manual.

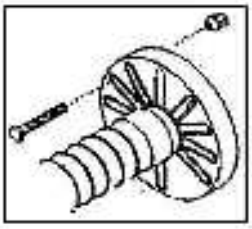
THE MANUFACTURER DOES NOT ACCEPT ANY RESPONSIBILITY FOR THEFALTURE TO OBSERVE THE ABOVE MENTIONED INSTRUCTIONS

Operations and Use

●Connecting to the defective rim to the flansh

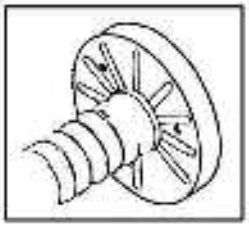


1. Clean the mud and the balance weights from the rim
2. Choose a suitable sized connecting flange for the rim.

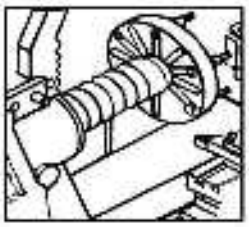


3. Tight the nuts to start repairing
4. Tight the connecting flange and fasten to the suitable canals on the flanges.

●Analysing the defective area

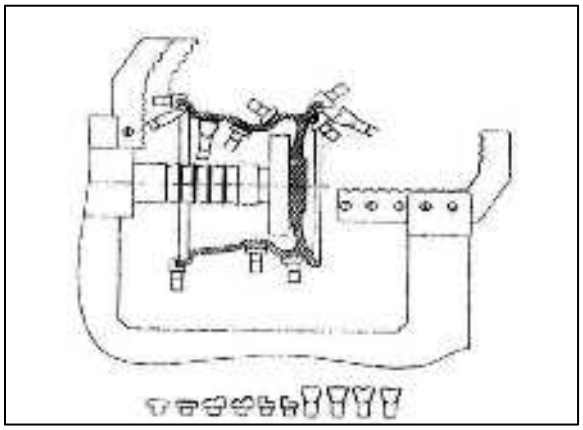


1. Rotate the flange.
2.Locate the defective area by using gauge and mark it.



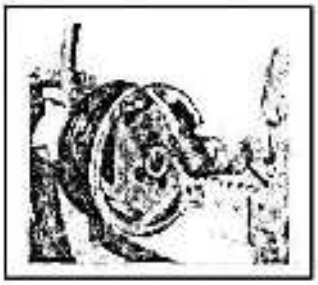
3. Tight the nuts to start reparing
4.Choose a suitable support and repair it.

●Rim repairing positions



Operation and Use

Some examples of repairing



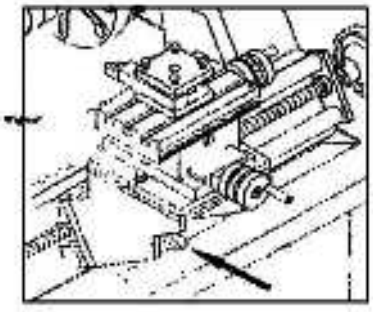
- If the defect is on the front surface to the outer side of rim.
  If the defect is from inner to outer side of rim.

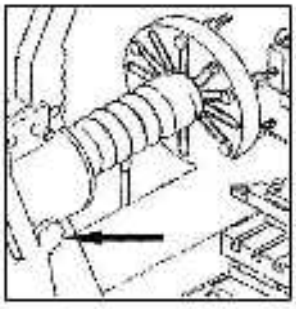
- If the defect is from outer to inner side of rim.

Operation and Use
When repairing iron rims use also the manual handle plus to the pressing.
Before the pressing operation, some rims need to be heated (especially aluminum rims)This procedure is for:

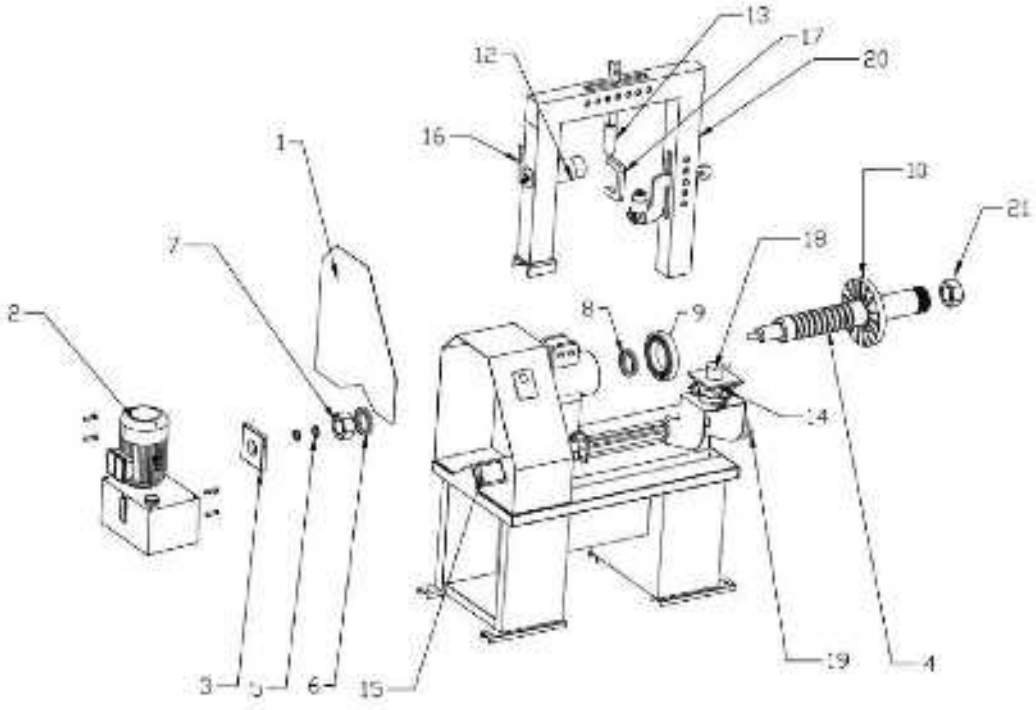
1.Avoiding cracks and faults on the rim,
2. Piston's safety.
3.Your personnel safety
lf the rim is defected much, first mend it with the lever and then it with pressing.

Lathe Operation





Tight the fixing handle during lathe operation Untight the nuts durinf la the operation



1 partition
2 hydraulicpump
3 spindlepartition
4 spindle
5 gasket
6 bearing(32016)
7 nut
8 bearing(32016)
9 bearingpartition
10 turntable
11 cylinder
12 cylinder
13 cylinder
14 lathe
15 inverter
16 locknut
17 tensionwrench
18 lathetool
19 handwheel
20 gantry
21 nut

Daily Maintenance

To guarantee the efficiency of the machine and for its correct functioning is essential tocarry out the routine cleaning and maintenance.
Routine maintenance must be carried out by the user according to the maket's instruction.Before starting any cleaning or maintenance, switch off the main switch and remove the
main plug from socket.
Every day
Clean and grease the flange and lathe
Every mouth
Check the oil level of the hydraulic unit.
Every 6 months
Grease the bearings and make a general checkEvery year
General check: Visual inspection of all structural parts and mechanisms to guarantee thatthere are no problems.
Electric plant. Skilled edectricians should test the electric plant.

Storage

Periods of in activity	Permanent Storage
The machine is temporarily stored orWhenever the machine is not in use,Remove the plug from the mains	If it is decided to store the machine longterm, lt is advisable to make it inoperativeby removing the mains cable after havingunplugged it from the mains.

THECHNICAL ASSISTANCE AND SPARE PARTS
● The machine is guaranteed (1 years); The ralevant certificate of guarantee issupplied with the machine.
● For any machine of functions, consult the section*Causes and Possible RemediesAny other functions must be checked by professional qualified personnel.
● In all cases contact the assistance service of Xi'an Sedi.For prompt assistance it isimportant at the time of call to specify the machine model, the production No.(plsfind it on the registration plate) and type of trouble.

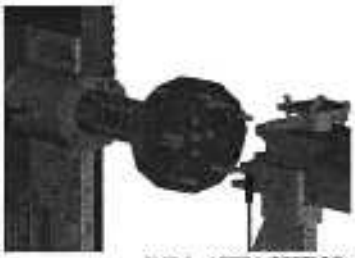
WARNING

Any work on the electrical, hydraulic and pneumatic systems must be carried out ony by PROFESSIONALLY QUALIFIED PERSONNED.

The motors are not under guarantee.

WARNINGS
Use only original parts of machine.
We do not take responsibility of non-original parts

PARTS OF THE MACHINE



Rim Flange is designed for different sizes and kinds of rims.

RIM ATTACHING FLANGE

Lathe unit is designed to correct defected rims.

LATHE UNIT

It enables us to control the piston.

PISTON CONTROL UNIT

It enables us to push piston up and down.

HYDRAULIC UNIT

SAFETY

- Piston should fit exactly onto rims and supports.
  Be sure that your clothes will not wrap around flanges.
  (ties, shirts cuffs, coat buttons, etc.)

- Do not put your hands between rim and piston during operation.
- Fit the piston exactly onto supportive canals. If not it may slide and injure you.

- Do not direct the piston onto living creatures.
- Check that supportive pins are in their place.
- Fasten fixing nuts while levelling, loosen the nuts while lathing.
- Electrical and Hydraulic failures should be handled by experienced and competent technicians.

TECHNICAL SERVICE

- In case of defection or problems, see " HELP " section ofthis booklet.

-Ifyou fail to solve the problem, contact technical service ofthrough "HOW TO CONTACT US " section.

-In order to solve your problem immediately please notify us serial number ofthemachine.
-This machine has 1 (one)YEAR-GUARANTEE,

-GUARANTEE covers all units without any exceptions.

-Hydraulic Unit should only be serviced by factorytechnicians.

- In hydraulic unit SHELL, TELLUS 27 type of oil should be used.

-Use original parts in your machine. Manufacturer has no responsibility for negativeresults of by-products.

ORDERING OF SPARE PARTS:

- Call and inform us the model, serial number, production year of the machine.

- Company name, address, and telephone numbers,

- Code, name and quantity of required spare parts through " HOW TO CONTACT US" section.

RIM STRAIGHTENING PROCCESS

-Cean soil on rim and remove leads.

-Select proper spangle for rim hole.

- Put the spangle onto the center of fange and fasten withnuts.

- Special nuts are designed for Renault rims, So use thesenuts for Renault rims.

- Rim is attached by means of center spangles and rim revolves at c

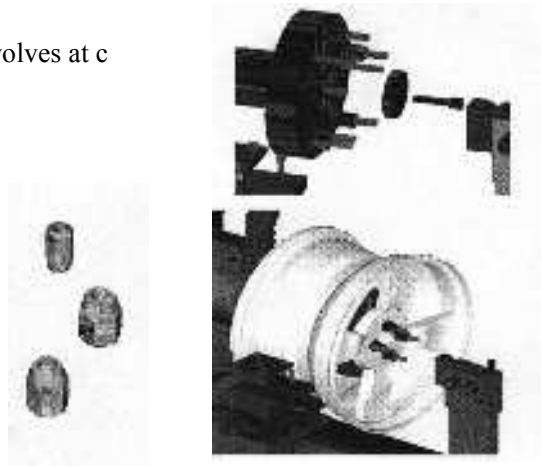
- Select proper wrench for rim wrench hi

- Fasten the rim by using proper tools.

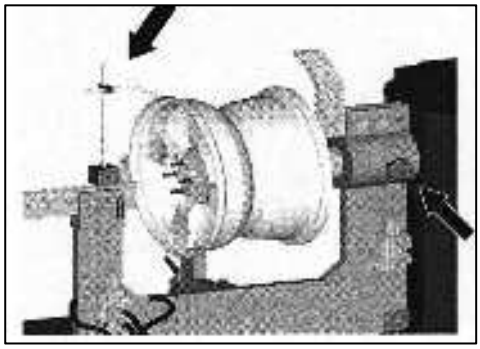
- Loosen nuts which fx flanges.

- Attach magnetic metal pointer (muven;

-Turntherimbyhand.

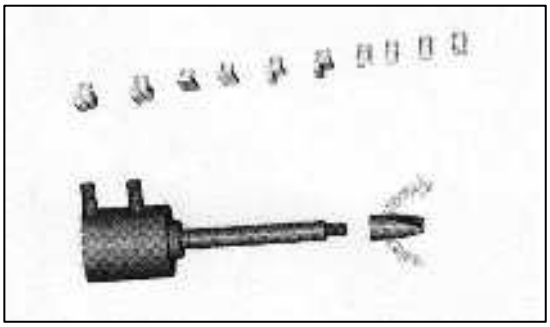


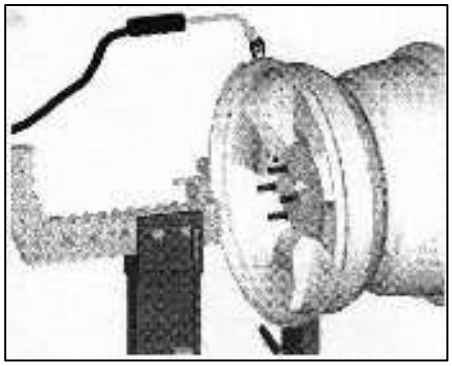
RIM STRAIGHTENING PROCESS



- Determine defected section and mark it by help of metal pointer.
- When you turn the rim onto the defected part where it is pressed, fasten flange fixing nut.
- Start hydraulic motor.

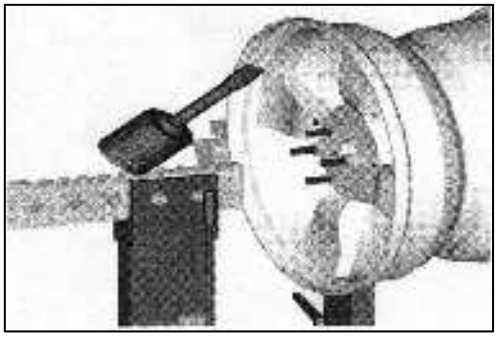
- Select proper press tip for the section to be straightened,
-After selecting support axis for the tips, place the selected axis/tip into the piston.



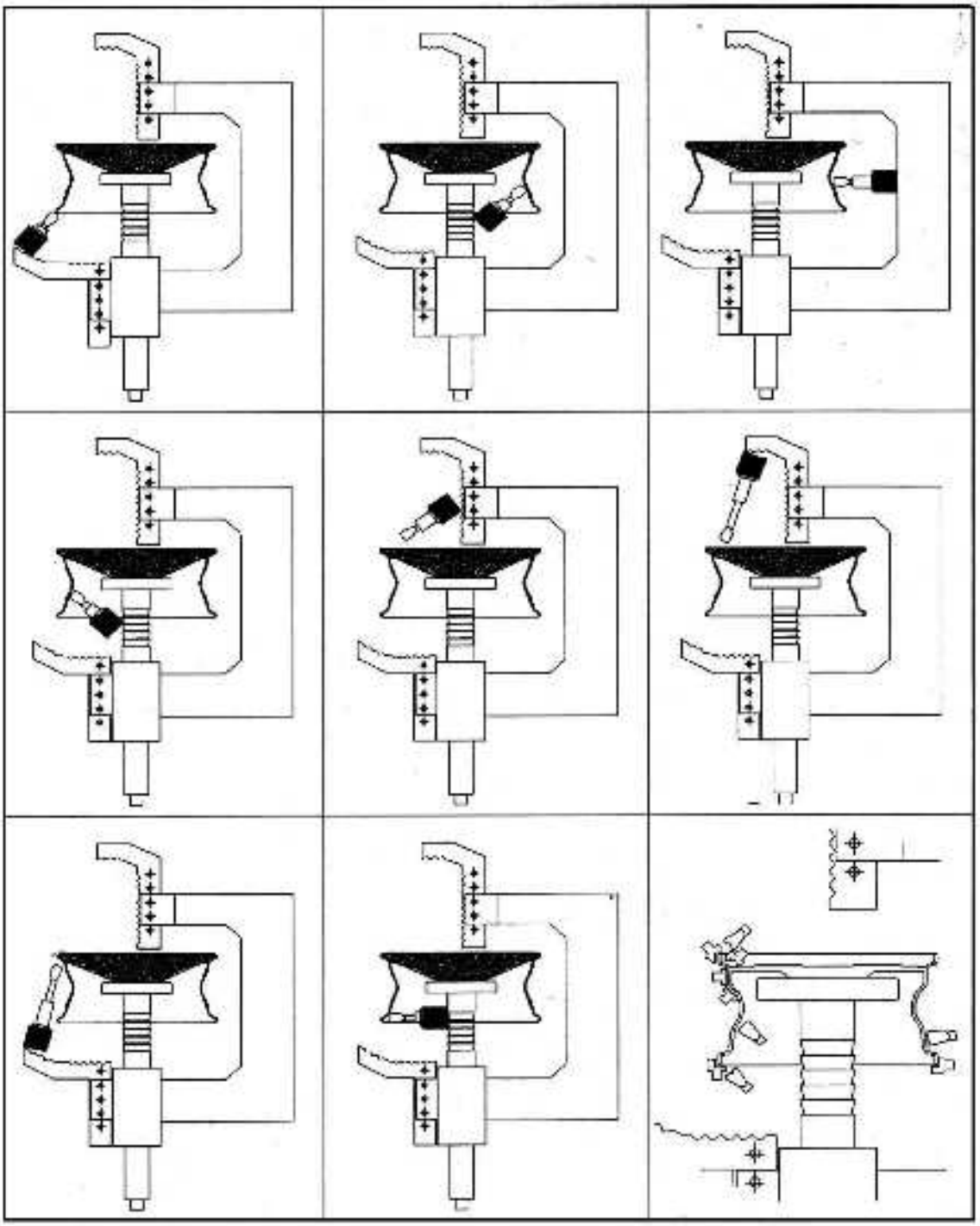


- Defected part is mildly heated with blow torch,.
- Heated defected part is corrected by applyingpressure.
- After applying enough pressure, straighteningis checked by metal pointer.
- Same process is applied until rim completelylevelled.

- After this procedure continue lathingprocess if necessary.

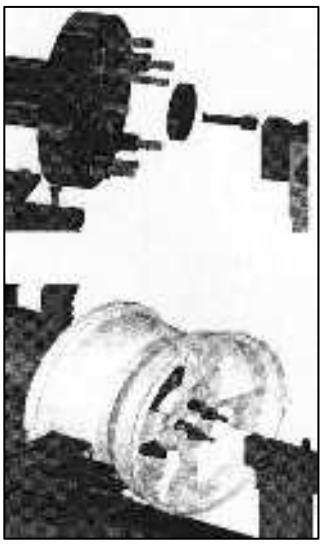


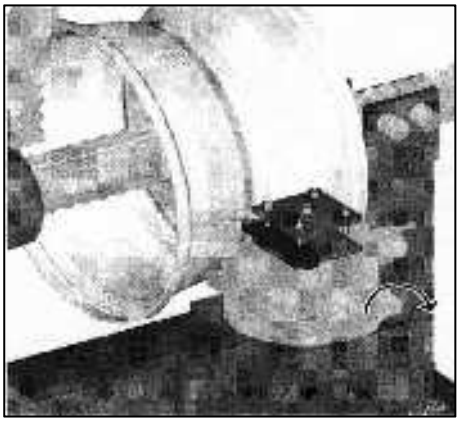
PISTONand END POSITIONS .fF RIMSTRAIGHTENING



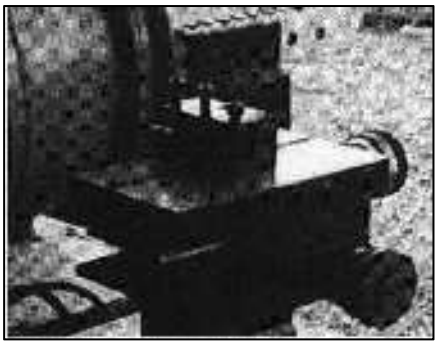
RIM LATHING PROCESS

- Clean soil and dirt on the rim and remove leads.
- Select proper centering spangle for rim hole.
- At the center of flange, put centering spangle and fasten it with its nuts.
-Use special fixing nuts for Renault rims.
- By means of centering spangles, rim is fixed a tflange and turns at its center.
- Select proper wreneh for the holes of rim.
- Fasten the rim with proper wrench.
- Flange fixing nut is loosened.





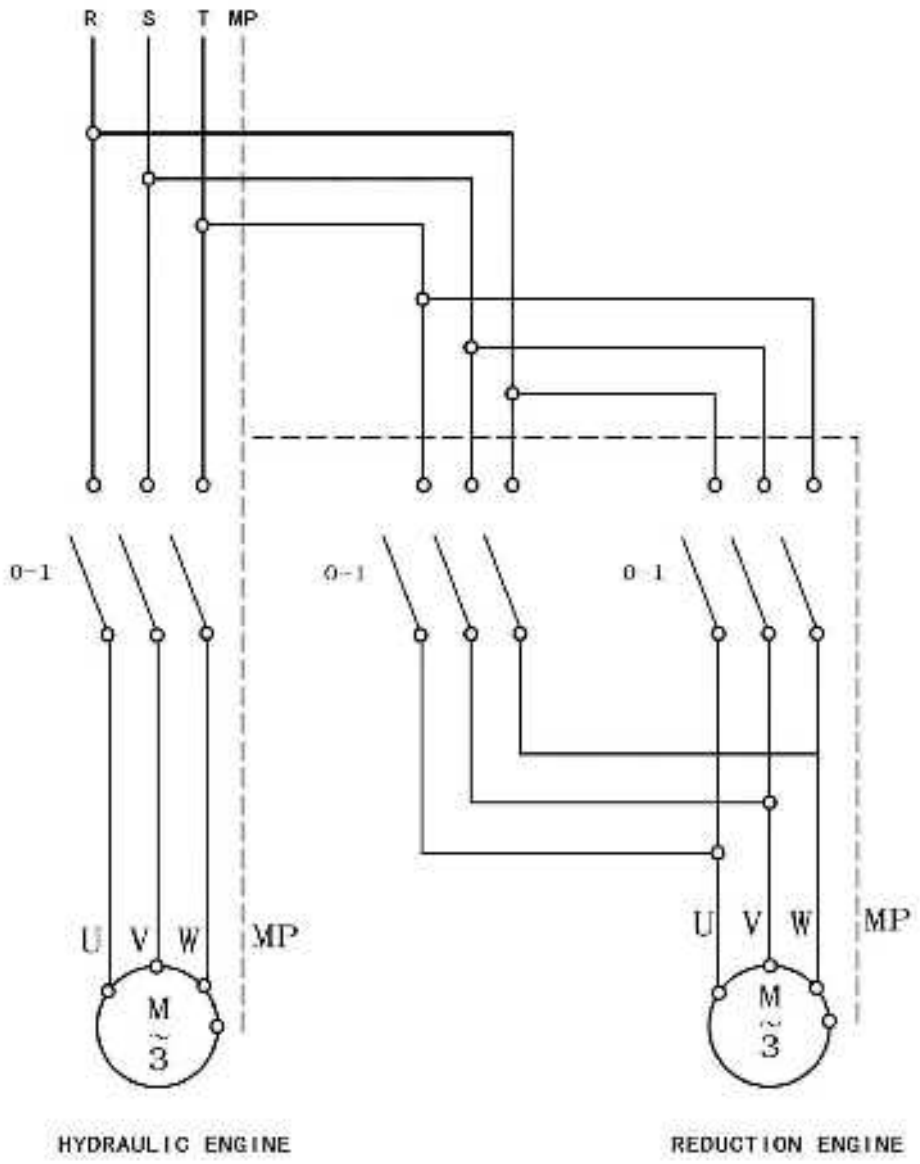
- Lathe base is positioned accordingly and base fixing nut is fastened.



- Fasten lathing pen.
- Fasten with proper wrench.
- Start mechanic motor.
- Apply lathe knife at the place of fillings.
- When finished counter clean lathe unit.
- Machine is not used for different purposes, Produced to level the rims only

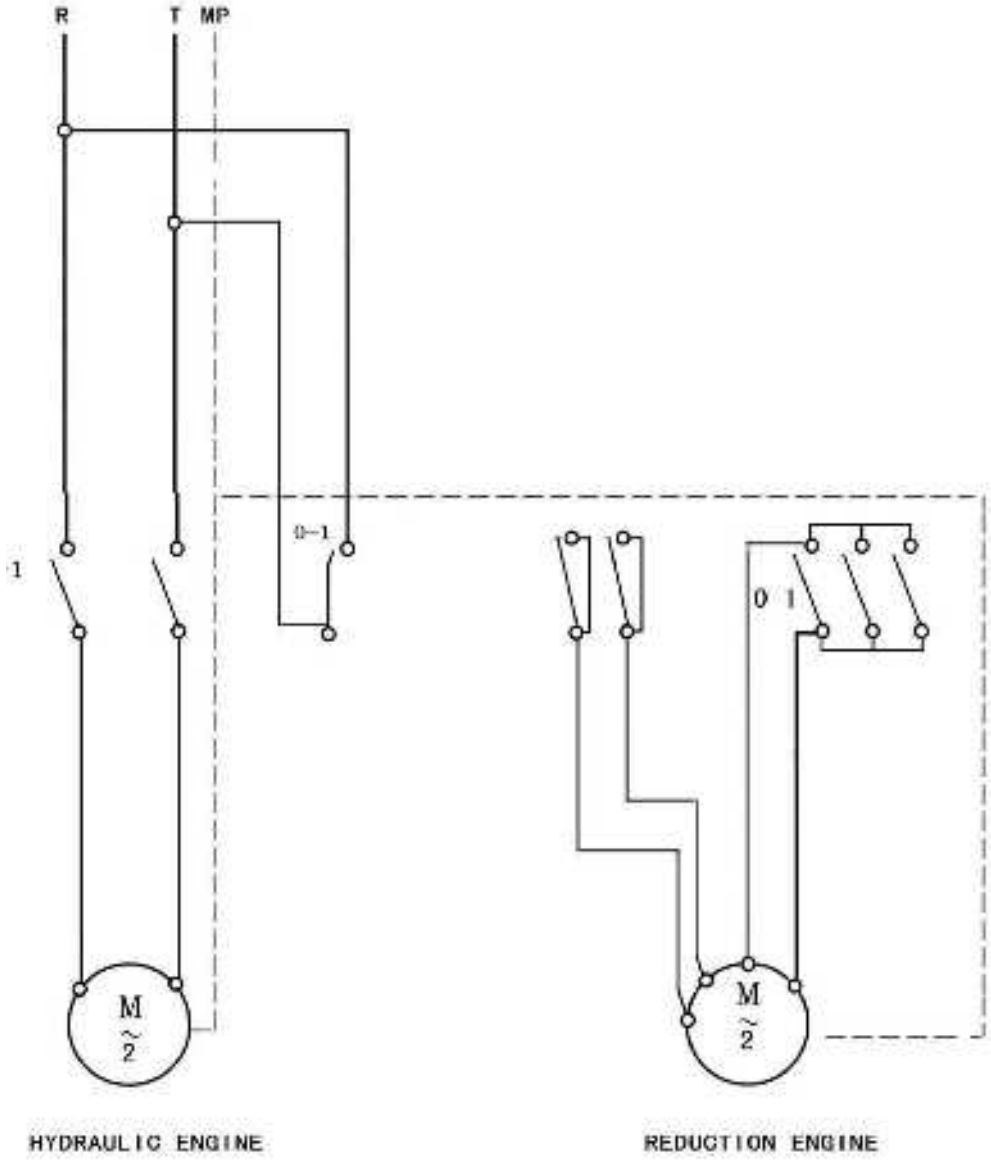
Electric layout

POWER SUPPLY：3x380V AC+PE 60Hz



Electric layout

POWER SUPPLY：1x220V AC+PE 50Hz+60Hz



Packing list Rim Stagtening Machine				
Serial No.	Des	Specificatio	number	Remark
1	Center positioning	1#	1	
2	Center positioning	2#	1	
3	Center positioning	3#	1	
4	Center positioning	4#	1	
5	Main axle	Special	1	
6	Locking nut	Special	1	
7	Magnetic meter socket	Special	1	
8	The gasket	Special	2	
9	The lathe tool	Special	2	
10	Knife table Loking wrench	Special	1	
11	Steel Wheel fixed faceplate	Special	1	
12	Center positioning bolt	? 12	5	
13	Center positioning nut	M12	5	
14	Plug	Special	5	
15	Big supportor	Special	1	
16	Small supportor	Special	1	
17	Plan-pin	Special	1	
18	Supporting head	Special	10	
19	Supporting axle	Special	5	
20	Sleeve	? 22	1	
21	Handwheel	Special	1	