



说明书材质要求：105g 有光铜版纸	说明书成品尺寸： 105*143mm
第一：专色用6级防晒油墨+CMYK油墨要求： 1.PANTONE137C专色油墨(专色用6级防晒油墨)： 如果自己配色，油墨配比为：酒联中黄(防晒)2000g 酒联金红(防晒)225g 2.C色油墨：酒联天蓝墨 3.M色油墨：酒联金红墨 4.Y色油墨：pantone123C专色油墨 5.K色油墨：酒联黑墨	第二：特别注意： 1.印刷时看样请参考我司提供的实物样品颜色。不得偏色 2.137C的专色不得参考C=0,M=35,Y=90,K=0对应的四色 色谱颜色来看样印刷 Pantone 137C Black（两色印刷）
折叠方式： 风琴折 (20P以下用风琴折) / 骑马钉 (20P以上用骑马钉) 特殊情况：16P/20P：风琴折 + 对折	备注：

特别注意：此页内容不印刷

风琴折 + 对折 页面顺序

16P 页面顺序

9	10	11	封面
12	13	14	封底

1	2	3	4
5	6	7	8

20P 页面顺序

11	12	13	14	封面
15	16	17	18	封底

1	2	3	4	5
6	7	8	9	10

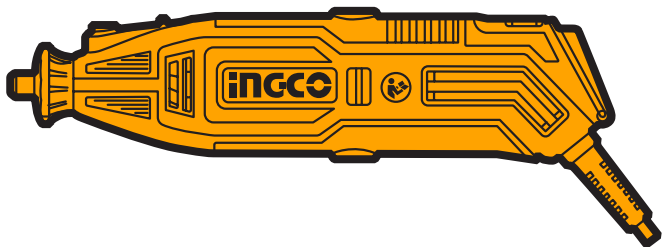
更改记录	删除附件做通用说明书， 内页加货号MG133281			说明书改双色， 模版更新同步修改		
	0124.V07	2024.1.3	QQY	1125.V08	2025.11.11	LYD
	版本号	日期	设计师	版本号	日期	设计师

INGCO

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**PRODUCT
MANUAL**

MINI GRINDER



MG13328, UMG13328
MG13328xy, UMG13328xy

x (blank, 1, 2, 3, 4, 5, 6, 7, 8, 9, E, S, A, M,P)
y (blank, -1, -2, -3, -4, -5, -6, -7, -8, -9, E, S, A, M,P)



GENERAL POWER TOOL SAFETY WARNINGS

⚠ WARNING! Read all instructions Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. The term "power tool" in all of the warnings listed below refers to your mains operated (corded) power tool or battery operated (cordless) power tool.

SAVE THESE INSTRUCTIONS**1) Work area**

- a) **Keep work area clean and well lit.** Cluttered and dark areas invite accidents.
- b) **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- c) **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

2) Electrical safety

- a) **Power tool plugs must match the outlet. Never modify the plug in any way.** Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) **Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c) **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d) **Do not abuse the cord.** Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
- e) **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.

3) Personal safety

- a) **Stay alert, watch what you are doing and use common sense when operating a power tool.** Do not use a power tool while you are tired or

under the influence of drugs, alcohol or medication. *A moment of inattention while operating power tools may result in serious personal injury.*

- b) **Use safety equipment. Always wear eye protection.** *Safety equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.*
- c) **Avoid accidental starting. Ensure the switch is in the off position before plugging in.** *Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.*
- d) **Remove any adjusting key or wrench before turning the power tool on.** *A wrench or a key left attached to a rotating part of the power tool may result in personal injury.*
- e) **Do not overreach. Keep proper footing and balance at all times.** *This enables better control of the power tool in unexpected situations.*
- f) **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** *Loose clothes, jewellery or long hair can be caught in moving parts.*
- g) **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** *Use of these devices can reduce dust related hazards.*

4) Power tool use and care

- a) **Do not force the power tool. Use the correct power tool for your application.** *The correct power tool will do the job better and safer at the rate for which it was designed.*
- b) **Do not use the power tool if the switch does not turn it on and off.** *Any power tool that cannot be controlled with the switch is dangerous and must be repaired.*
- c) **Disconnect the plug from the power source before making any adjustments, changing accessories, or storing power tools.** *Such preventive safety measures reduce the risk of starting the power tool accidentally.*
- d) **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** *Power tools are dangerous in the hands of untrained users.*
- e) **Maintain power tools. Check for misalignment or binding of moving parts,**

breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use. *Many accidents are caused by poorly maintained power tools.*

- f) **Keep cutting tools sharp and clean.** *Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.*
- g) **Use the power tool, accessories and tool bits etc., in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed.** *Use of the power tool for operations different from intended could result in a hazardous situation.*

5) Service

- a) **Have your power tool serviced by a qualified repair person using only identical replacement parts.** *This will ensure that the safety of the power tool is maintained.*

THE SYMBOLS IN INSTRUCTION MANUAL

	Double insulated for additional protection
	Read the instruction manual before using.
	CE conformity.
	Safety alert. Please only use the accessories supported by the manufacturer.
	Wear safety glasses, hearing protection and dust mask.
	Waste electrical products should not be disposed of with household waste. Please recycle where facilities exist. Check with your Local Authority or retailer for recycling advice.

ADDITIONAL SAFETY WARNING

Grinder safety warning

Safety instructions for all operations

Safety warnings common for grinding, sanding, wire brushing, polishing, carving or abrasive cutting-off operations:

- a) **This power tool is intended to function as a grinder, sander, wire brush, polisher, carving or cut-off tool. Read all safety warnings, instructions, illustrations and specifications provided with this power tool. *Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.***
- b) **Do not use accessories which are not specifically designed and recommended by the tool manufacturer. *Just because the accessory can be attached to your power tool, it does not assure safe operation.***
- c) **The rated speed of the grinding accessories must be at least equal to the maximum speed marked on the power tool. *Grinding accessories running faster than their rated speed can break and fly apart.***
- d) **The outside diameter and the thickness of your accessory must be within the capacity rating of your power tool. *Incorrectly sized accessories cannot be adequately controlled.***
- e) **The arbour size of wheels, sanding drums or any other accessory must properly fit the spindle or collet of the power tool. *Accessories that do not match the mounting hardware of the power tool will run out of balance, vibrate excessively and may cause loss of control.***
- f) **Mandrel mounted wheels, sanding drums, cutters or other accessories must be fully inserted into the collet or chuck. *If the mandrel is insufficiently held and/or the overhang of the wheel is too long, the mounted wheel may become loose and be ejected at high velocity.***
- g) **Do not use a damaged accessory. Before each use inspect the accessory such as abrasive wheels for chips and cracks, sanding drum for cracks, tear or excess wear, wire brush for loose or cracked wires. If power tool or accessory is dropped, inspect for damage or install an undamaged accessory. After inspecting and installing an accessory, position yourself and bystanders away from the plane of the rotating accessory and run the power tool at maximum no-load speed for one minute. *Damaged accessories will normally break apart during this test time.***

- h) **Wear personal protective equipment.** Depending on application, use face shield, safety goggles or safety glasses. As appropriate, wear dust mask, hearing protectors, gloves and workshop apron capable of stopping small abrasive or workpiece fragments. *The eye protection must be capable of stopping flying debris generated by various operations. The dust mask or respirator must be capable of filtering particles generated by your operation. Prolonged exposure to high intensity noise may cause hearing loss.*
- i) **Keep bystanders a safe distance away from work area.** Anyone entering the work area must wear personal protective equipment. *Fragments of workpiece or of a broken accessory may fly away and cause injury beyond immediate area of operation.*
- j) **Hold power tool by insulated gripping surfaces only, when performing an operation where the cutting accessory may contact hidden wiring or its own cord.** *Cutting accessory contacting a "live" wire may make exposed metal parts of the power tool "live" and could give the operator an electric shock.*
- k) **Always hold the tool firmly in your hand(s) during the start-up.** *The reaction torque of the motor, as it accelerates to full speed, can cause the tool to twist.*
- l) **Use clamps to support workpiece whenever practical.** Never hold a small workpiece in one hand and the tool in the other hand while in use. *Clamping a small workpiece allows you to use your hand(s) to control the tool. Round material such as dowel rods, pipes or tubing have a tendency to roll while being cut, and may cause the bit to bind or jump toward you.*
- m) **Position the cord clear of the spinning accessory.** *If you lose control, the cord may be cut or snagged and your hand or arm may be pulled into the spinning accessory.*
- n) **Never lay the power tool down until the accessory has come to a complete stop.** *The spinning accessory may grab the surface and pull the power tool out of your control.*
- o) **After changing the bits or making any adjustments, make sure the collet nut, chuck or any other adjustment devices are securely tightened.** *Loose adjustment devices can unexpectedly shift, causing loss of control, loose rotating components will be violently thrown.*
- p) **Do not run the power tool while carrying it at your side.** *Accidental contact with the spinning accessory could snag your clothing, pulling the accessory into*

your body.

- q) **Regularly clean the power tool's air vents.** *The motor's fan will draw the dust inside the housing and excessive accumulation of powdered metal may cause electrical hazards.*
- r) **Do not operate the power tool near flammable materials.** *Sparks could ignite these materials.*
- s) **Do not use accessories that require liquid coolants.** *Using water or other liquid coolants may result in electrocution or shock.*

Further safety instructions for all operations

Kickback and related warnings:

Kickback is a sudden reaction to a pinched or snagged rotating wheel, backing pad, brush or any other accessory. Pinching or snagging causes rapid stalling of the rotating accessory which in turn causes the uncontrolled power tool to be forced in the direction opposite of the accessory's rotation at the point of the binding.

For example, if an abrasive wheel is snagged or pinched by the workpiece, the edge of the wheel that is entering into the pinch point can dig into the surface of the material causing the wheel to climb out or kick out. The wheel may either jump toward or away from the operator, depending on direction of the wheel's movement at the point of pinching. Abrasive wheels may also break under these conditions.

Kickback is the result of power tool misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below.

- a) **Maintain a firm grip on the power tool and position your body and arm to allow you to resist kickback forces.** *The operator can control kickback forces, if proper precautions are taken.*
- b) **Use special care when working corners, sharp edges etc. Avoid bouncing and snagging the accessory.** *Corners, sharp edges or bouncing have a tendency to snag the rotating accessory and cause loss of control or kickback.*
- c) **Do not attach a saw chain woodcarving blade.** *Such blades create frequent kickback and loss of control.*
- d) **Always feed the bit into the material in the same direction as the cutting edge is exiting from the material (which is the same direction as the chips are thrown).** *Feeding the tool in the wrong direction causes the cutting edge of the bit to climb out of the work and pull the tool in the direction of this feed.*
- e) **When using rotary files, cut-off wheels, high-speed cutters or tungsten**

carbide cutters, always have the work securely clamped. *These wheels will grab if they become slightly canted in the groove, and can kickback. When a cut-off wheel grabs, the wheel itself usually breaks. When a rotary file, high-speed cutter or tungsten carbide cutter grabs, it may jump from the groove and you could lose control of the tool.*

Additional safety instructions for grinding and cutting-off operations

Safety warnings specific for grinding and abrasive cutting-off operations:

- a) **Use only wheel types that are recommended for your power tool and only for recommended applications. For example: do not grind with the side of a cut-off wheel.** *Abrasive cut-off wheels are intended for peripheral grinding, side forces applied to these wheels may cause them to shatter.*
- b) **For threaded abrasive cones and plugs use only undamaged wheel mandrels with an unrelieved shoulder flange that are of correct size and length.** *Proper mandrels will reduce the possibility of breakage.*
- c) **Do not "jam" a cut-off wheel or apply excessive pressure. Do not attempt to make an excessive depth of cut.** *Overstressing the wheel increases the loading and susceptibility to twisting or snagging of the wheel in the cut and the possibility of kickback or wheel breakage.*
- d) **Do not position your hand in line with and behind the rotating wheel.** *When the wheel, at the point of operation, is moving away from your hand, the possible kickback may propel the spinning wheel and the power tool directly at you.*
- e) **When wheel is pinched, snagged or when interrupting a cut for any reason, switch off the power tool and hold the power tool motionless until the wheel comes to a complete stop. Never attempt to remove the cut-off wheel from the cut while the wheel is in motion otherwise kickback may occur.** *Investigate and take corrective action to eliminate the cause of wheel pinching or snagging.*
- f) **Do not restart the cutting operation in the workpiece. Let the wheel reach full speed and carefully re-enter the cut.** *The wheel may bind, walk up or kickback if the power tool is restarted in the workpiece.*
- g) **Support panels or any oversized workpiece to minimize the risk of wheel pinching and kickback.** *Large workpieces tend to sag under their own weight. Supports must be placed under the workpiece near the line of cut and near the*

edge of the workpiece on both sides of the wheel.

- h) **Use extra caution when making a "pocket cut" into existing walls or other blind areas.** *The protruding wheel may cut gas or water pipes, electrical wiring or objects that can cause kickback.*

Additional safety instructions for wire brushing operations

Safety warnings specific for wire brushing operations:

- a) **Be aware that wire bristles are thrown by the brush even during ordinary operation. Do not overstress the wires by applying excessive load to the brush.** *The wire bristles can easily penetrate light clothing and/or skin.*
- b) **Allow brushes to run at operating speed for at least one minute before using them. During this time no one is to stand in front or in line with the brush.** *Loose bristles or wires will be discharged during the run-in time.*
- c) **Direct the discharge of the spinning wire brush away from you.** *Small particles and tiny wire fragments may be discharged at high velocity during the use of these brushes and may become imbedded in your skin.*

RESIDUAL RISKS

Even when the power tool is used as prescribed it is not possible to eliminate all residual risk factors. The following hazards may arise in connection with the power tool's construction and design:

- a) Health defects resulting from vibration emission if the power tool is being used over longer period of time or not adequately managed and properly maintained.
- b) Injuries and damage to property to due to broken accessories that are suddenly dashed.

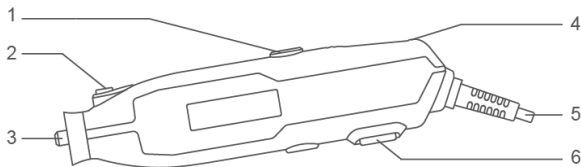
WARNING!

This power tool produces an electromagnetic field during operation. This field may under some circumstances interfere with active or passive medical implants. To reduce the risk of serious or fatal injury, we recommend persons with medical implants to consult their physician and the medical implant manufacturer before operating this power tool.

INTENDED USE

This power tool is intended to function as a grinder, sander, wire brush, polisher, carving or cut-off tool.

SPECIFICATIONS



Components

- | | |
|------------------------|-------------------|
| 1. Carbon brush holder | 4. Speed selector |
| 2. Spindle lock button | 5. Power cable |
| 3. Collet nut | 6. On/Off switch |

Technical specifications

Model No.	MG13328 MG13328xy	UMG13328 UMG13328xy
Rated input power	130W	130W
Rated voltage	220-240V~50/60Hz	110-120V~50/60Hz
No-load speed	10000-35000/min	10000-35000/min
Max collet diameter	3.2mm	1/8"
Max. grinding disc diameter	35mm	1-3/8"
Protection class	□ / II	□ / II

Model No. NOTE: x (blank, 1,2,3,4,5,6,7,8,9,E,S,A,M); y (blank, -1,-2,-3,-4,-5,-6,-7,-8,-9,E,S,A,M)

- Due to our continuing program of research and development, the specifications herein are subject to change without notice.

Model No.	MG13328-9 (INMETRO Plug)	UMG13328-9 (INMETRO Plug)
Rated input power	130W	130W
Rated voltage	220-240V~60Hz	127V~60Hz
No-load speed	10000-35000/min	10000-35000/min
Max. collet diameter	3.2mm	1/8"
Max. grinding disc diameter	35mm	1-3/8"
Protection class	□ / II	□ / II

Model No. NOTE: x (blank, 1,2,3,4,5,6,7,8,9,E,S,A,M); y (blank, -1,-2,-3,-4,-5,-6,-7,-8,-9,E,S,A,M)

- Due to our continuing program of research and development, the specifications herein are subject to change without notice.

Noise/Vibration information

The noise emission, measured in accordance with EN60745-2-23:

Sound pressure level	L_{pA}	73.0 dB (A)
Sound power level	L_{wA}	84.0 dB (A)
Uncertainty	K	3.0 dB (A)

Wear hearing protection!

The vibration total value and its uncertainty determined according to EN60745-2-23

Vibration emission value	a_h	16.7 m/s ²
Uncertainty	K	1,5 m/s ²

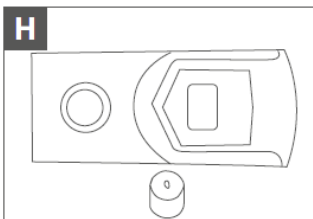
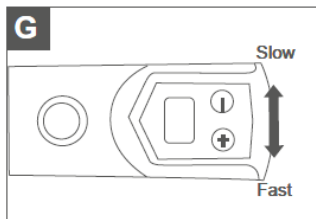
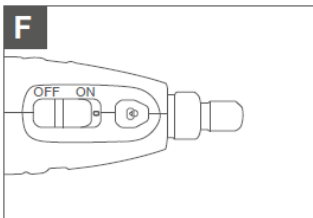
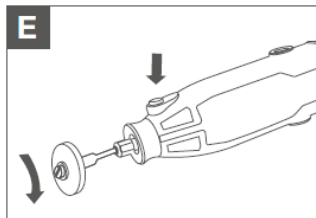
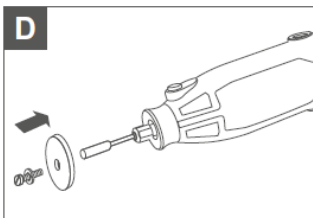
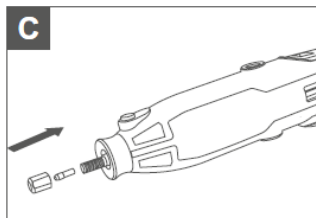
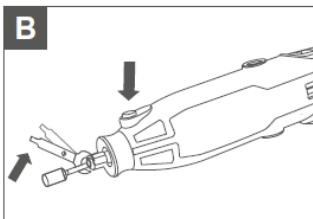
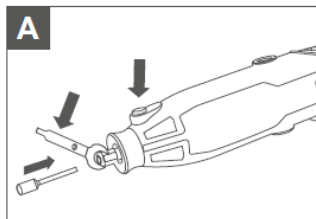
That the declared vibration total value has been measured in accordance with a standard test method and may be used for comparing one tool with another.

That the declared vibration total value may also be used in a preliminary assessment of exposure.

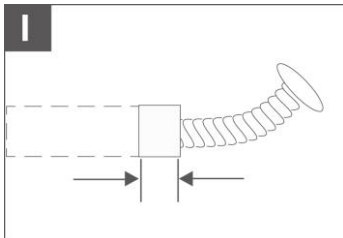
** WARNING!**

- That the vibration emission during actual use of the power tool can differ from the declared total value depending on the ways in which the tool is used;
- Identify safety measures to protect the operator that are based on an estimation of exposure in the actual conditions of use (taking account of all parts of the operating cycle such as the times when the tool is switched off and when it is running idle in addition to the trigger time).

OPERATION PICTURE



OPERATION PICTURE



OPERATION

Assembly

⚠ WARNING!

Always be sure that the tool is switched off and unplugged before adjusting or checking function on the tool.

Accessory or replacing the collet.

Fitting an accessory (see Figure A, B)

- Keep the spindle lock button depressed.
- Use the spanner to slacken the collet nut.
- Insert the shaft of the accessory into the collet nut.
- Use the spanner to lightly tighten the collet-nut (do not over tighten).

Replacing the collet (see Figure C)

When using an accessory with a smaller or larger shaft, i.e.: drills, you will need to change the collet as detailed below:

- Keep the spindle lock button depressed.
- Use the spanner to slacken the collet nut.
- Remove the collet nut and old collet.
- Locate the new collet.
- Restore the collet nut.
- Release the spindle lock button.

Fitting a cutting/sanding disc (see Figure D, E)

- a) Use the discholder.
- b) Locate mandrel as detailed earlier.
- c) Unscrew small screw on top of holder.
- d) Insert screw through disc and screw into mandrel, do not over tighten, otherwise the disc may crack.

Operation

Power supply

The tool should be connected only to a power supply of the same voltage as indicated on the nameplate.

Switching On and Off (see Figure F)

⚠ CAUTION! Set to slowest speed before switching on.

To switch the tool on, set on/off switch to position "I".

To switch the tool off, set on/off switch to position "O"

Speed adjustment (see Figure G)

The tool has a variable speed control for precise speed adjustment. High performance is achieved by correct speed setting and not high pressure. Set the speed selector to the require speed.

NOTE: Choose a low speed when working with wood, plastics and polishing.

Generally speaking, use the small tools at high speed and the larger tools at slower speed.

Holding the tool

For milling or engraving hold the tool like a pen, take care not to cover the ventilation slots.

⚠ WARNING!

- The tool gets warm during normal operation. Observe the rated operating time.
- Observe the rated operating time.

MAINTENANCE&MALFUNCTIONS

Cleaning

CAUTION!

- **Always be sure that the tool is switched off and unplugged before cleaning or performing any maintenance.**
- **Never use gasoline, benzine, thinner, alcohol or the like. Discoloration, deformation or cracks may result.**

Ventilation openings and switch levers must be kept clean and free of foreign matter. Regularly clean the tool's air vents or whenever the vents start to become obstructed. The tool may be cleaned most effectively with compressed dry air.

WARNING!

- **Always wear safety goggles when cleaning tools with compressed air.**
- **Do not attempt to clean by inserting pointed objects through openings.**

Maintenance

CAUTION!

- **Always be sure that the tool is switched off and unplugged before attempting to perform inspection or maintenance.**
- **Preventive maintenance performed by unauthorized personnel may result in misplacing of internal wires and components which could cause serious hazard.**

Only use original spare parts / accessories from the manufacturer or authorized and qualified workshops.

Repairs should only be carried out by qualified technicians or by an authorized service center. Qualified technicians must have relevant training and experience, be familiar with the design and construction requirements of the product and understand and follow the safety regulations.

Replacing the carbon brushes (see Figure H, I)

The carbon brushes must be checked on a regular basis.

There are two brushes on the tool, (see Figure H), and they must be replaced in pairs. Remove the carbon brush holders, using a small flat blade screwdriver and check the brushes. If the length of brush less than 6mm, replace both brushes, let the machine run at no load for 15 minutes. (see Figure I).

Use only the correct type of carbon brushes.

Protecting the Environment



Separate collection. Products marked with this symbol must not be disposed of with normal household waste. Products contain materials that can be recovered or recycled reducing the demand for raw materials. Please recycle electrical products according to local provisions.

Transportation of the power tools

WARNING!

Categorically not to drop any mechanical impact on the packaging during transport. When unloading / loading is not allowed to use any kind of technology that works on the principle of clamping packaging.

Optional accessories

CAUTION!

Accessories or attachments are recommended for use with your tool specified in this manual. The use of any other accessories or attachments might present a risk of injury to persons. Only use accessory or attachment for its stated purpose. If you need any assistance for more details regarding these accessories, ask your local Authorized Service Center.

NOTE: Some Accessories or attachments may be included in the tool package as standard accessories. They may differ from country to country

The chart below lists the description, use speed and scope for some of the small articles supplied together with the tool by category. To achieve best performance of the tool, it is strongly recommended that you read it prior to operation, failure to adhere to this may cause accessories to fail.

WARNING!

- **Always: Wear eye protection.**
- **Insert the shaft fully into the collet.**

Use only up to the speed's stated below.

Tool	Description	Speed	For use on
	Grinding stones various head styles, on shafts	Full speed 30,000/min	Metal mild steel
	Diamond bits. Various head styles	Full speed 30,000/min	Wood, zinc, plastic, nickel, copper, mild steel, aluminium, metal
	Polishing wheel mounted to polishing wheel holder	Half speed 15,000/min	Metal, mild steel
	Sanding/Cutting discs. Mounted to tool holder. NOTE: Do not over tighten screw	Half speed 15,000/min	Metal mild steel wood
	Sanding drum mounted on drum holder	Full speed 30,000/min	Metal mild steel
	NOTE: To fit the drum, firstly loosen the small screw on top of the drum holder this will allow the rubber to relax. Slide the sanding drum onto the holder. To secure, simply tighten the screw and the rubber drum will swell, gripping the sanding drum.		
	Use to lock flexible shaft when loosening or tightening collet nut of flexible shaft		

MAINTENANCE&MALFUNCTIONS

Possible malfunctions and methods of their eliminations

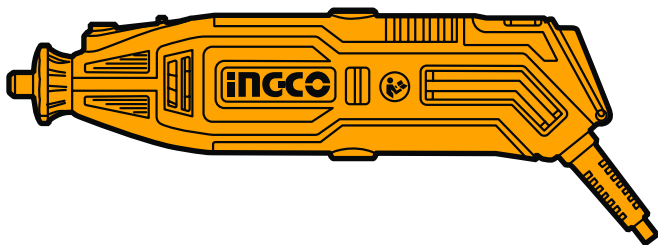
Malfunction	Probable causes	Actions
When the machine is turned on, the electric motor does not work.	● Switch failure ● The power cord or wiring is broken, power cord plug malfunction; ● No brush contact with the collector; ● Wear/damage of brushes	Disconnect the machine from the mains and contact a qualified specialist.
Formation of a circular fire on the collector	● Brush wear/damage of the brush holder; ● Malfunction in the armature coil	Disconnect the machine from the mains and contact a qualified specialist. Please don't repair the machine by your own.
When working, smoke or the smell of burning insulation appears from the ventilation openings.	● Malfunction in the electric motor coil; ● Malfunction of the electrical part of the tool.	
Increased noise in the gearbox	● Wear/breakage of gears or bearings	
When the machine is turned on, the spindle does not rotate	● Gearbox failure.	

Critical state criteria

Critical state criteria	Probable causes	Actions
Cracks on the surfaces of bearing and housing parts	Fatigue deformation of metal	Disconnect the machine from the mains and contact a qualified specialist. Please don't repair the machine by your own.
The power cord or plug is damaged	Overload or breakage	
Excessive wear or damage to the motor or reductor mechanism, or a combination of signs	Fatigue deformation of metal	

Critical state criteria

List of critical failures	Actions
Electric motor sparking	It is necessary to contact a qualified specialist
The appearance of extraneous noise	It is necessary to contact a qualified specialist
If the above malfunctions are detected, it is necessary to disconnect the machine from the mains and contact a qualified specialist	



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