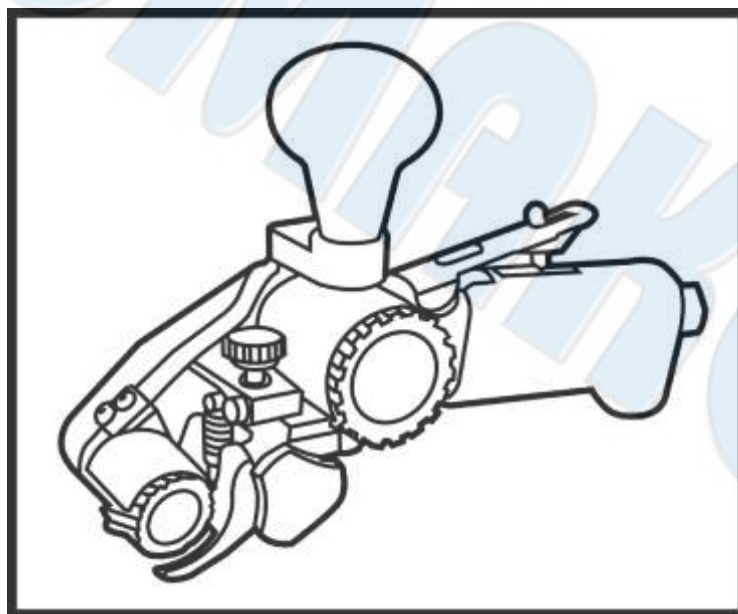




# SUMAKE *PNEUMATIC TOOLS*



## Weld-Bead Cutter W/Roller Cutter (SA-RC112) ST-CT400-2

### Specification:

Free Speed	10,000 r/min
Roller Cutter	Φ27x20mm
Spindle Size	Φ12.7
Motor	0.25HP (187W)
Air Consumption	17 CFM (480 L/min)
Measurement	L230 x H145mm
Air Inlet (PT)	1/4" (6.35 mm)
Air Hose (I.D.)	3/8" (10 mm)
Air Pressure	90 psi (6.3 bar)
Net Weight	2.65 lbs (1.2 kg)

### Noise and Vibration:

Vibration EN ISO 28927-4	Noise EN ISO 15744	Remark
Load: 0.9 m/s <sup>2</sup>  Uncertainty K= 1.5 m/s <sup>2</sup>	Sound Pressure Level No load: 89 dB(A)	Please always wear ear protector at environment noise level > 80 dB(A) due to risk of impaired hearing!
	Sound power level No load: 100 dB(A)	
	Uncertainty K= 3dB	

SUMAKE INDUSTRIAL CO., LTD

4F,NO.351,Yangguang St.,Neihu District TAIPEI, TAIWAN, ZIP:114-91

ST-CT400-2-S-2306A-KMF



## EC DECLARATION OF CONFORMITY

We: **SUMAKE INDUSTRIAL CO., LTD.**

**4F, No. 351, Yangguang St., Neihu District, Taipei City, Taiwan**

declare in sole responsibility that the equipment

Equipment : **WELD-BEAD CUTTER W/WROLLER CUTTER(SA-RC112)**

Model/ Serial No. : **ST-CT400-2**

to which this declaration applies, complies with these normative documents:

- Machinery Directive: 2006/42/EC

and conforms to the following EN standard,

- EN ISO 12100: 2010
- EN ISO 11148-7:2012

Name and Signature/Position



Mike Su – Managing Director

Date and Place

2022/12/1

Taipei, Taiwan

ST-CT400-2-D-2306A-KMF

**Application:**

Ideal for cleaning casting, foundries, smoothing welds in forge shops, and smoothing applications in fabrication shops.

**Wheel guard usage:**

1. Always use the recommended wheel guard and check that it is not damaged to reduce of risk of injury from broken grinding wheel parts.
2. If a guard has withstood a wheel breakage do not continue to use it. It may be damaged.
3. Position the guard between the grinding wheel and the operator.
4. Use barriers to protect others from wheel fragments and grinding sparks.

**Preparations before using the grinder:**

1. Do not manipulate speed of grinder.
2. The maximum permissible speed as marked on the machine must not be exceeded.
3. The free speed of the machine shall be checked every day and whenever the machine has been serviced. The check should be carried out with the grinding equipment detached.
4. Use a pressure regulator to avoid excessive air pressure which many cause overspeed.

**Correct function of grinder:**

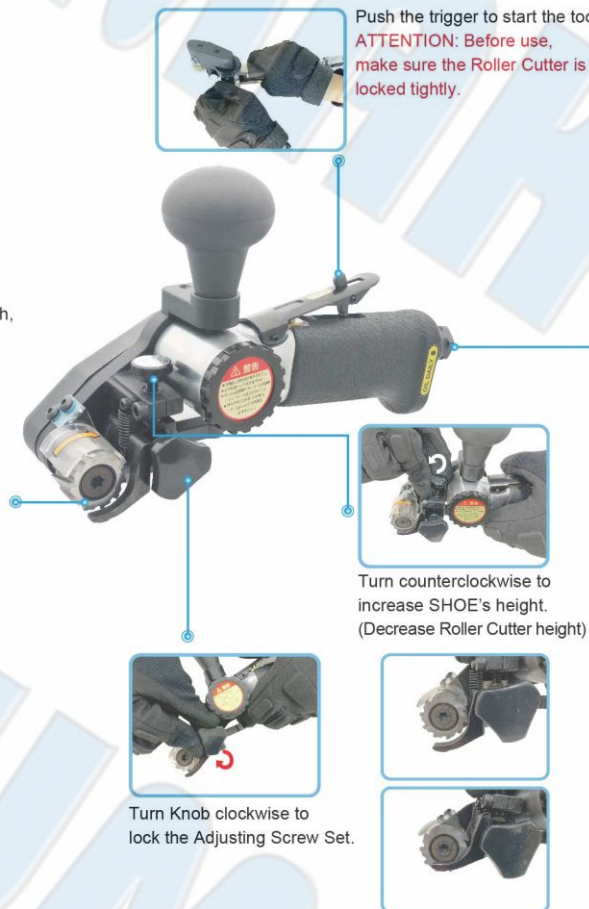
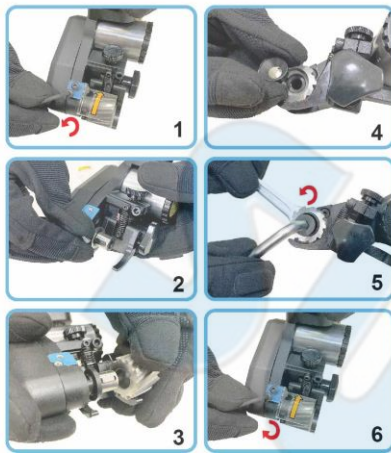
**WARNING** Overspeed can result in serious injury or death

► Do not manipulate speed of grinder

► The maximum permissible speed as marked on the machine must not be exceeded. The free speed of the machine shall be checked every day and whenever the machine has been serviced. This check should be carried out with the grinding equipment detached.

Install a Roller Cutter to grind the work piece.

1. Remove the wheel cover. Use a hex wrench to loosen the screws on the wheel cover counterclockwise.
2. Install a Key into the groove of Driver Shaft.
3. Put the Roller Cutter into the Driver Shaft.
4. Put Conical Washer into Roller Cutter.
5. Hold the Fix Driver Shaft with an open-end wrench, then tighten the screw counterclockwise with a Torx Key.
6. Replace the wheel cover. Tighten the screws on the wheel cover with a hex wrench.



Please add lubricant  
ISO VG-32(SAE 10)  
about 3c.c daily.



Connect the Regulator  
with air inlet.  
\*Use regulator to adjust  
speed .

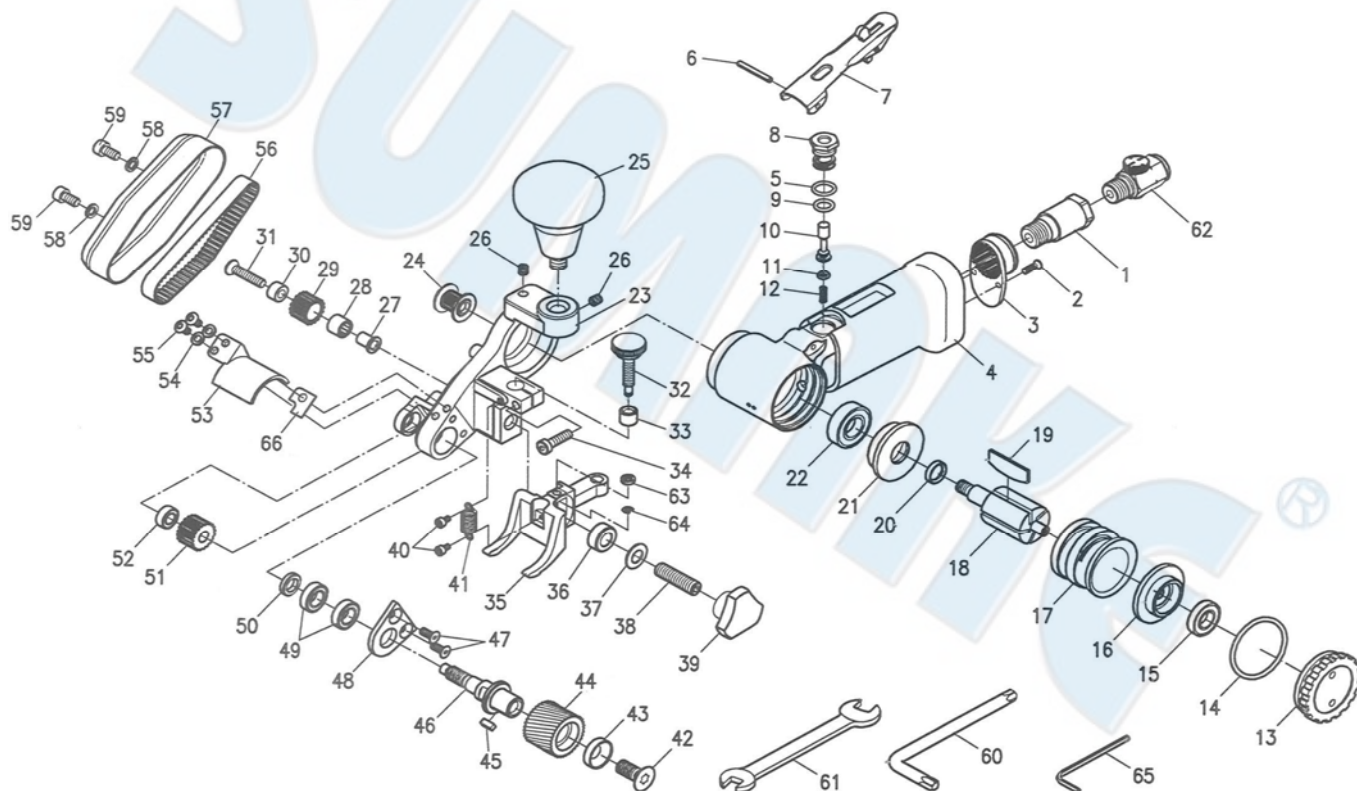


Connect the air fitting to  
the tool.

Event	Appearance	Possible Cause	Solution
Not operating	Air is coming from the air inlet	Blades broken or worn out	Replace blades
		Ball bearing damaged	Replace ball bearing
		Rusty motor or clogged with objects	Disassemble and repair
	No air coming from the air inlet	Regulator is not open	Adjust regulator
		No air flow	Check air system and connections
		Valve set damaged or broken	Disassemble and repair
Low efficiency	Low revolution rate	Not enough air pressure	Check air pressure
		Regulator valve is not set properly	Adjust regulator valve
	Motor running abnormal or unusual noises occur	Not enough lubrication, ball bearing, front or end plate, cylinder, rotor, blade damaged	Lubricate or replace parts
Motor keeps running	Trigger does not bounce back or does not bounce back correctly	Trigger set has other objects stuck on it or the spring is broken, deformed or rusty	Disassemble and repair
	Trigger function normally	Trigger worn out or valve set damaged or broken	Disassemble, repair and replace parts
Wrong size of roller cutter	Roller cutter can't be used	Wrong size for driver shaft	Change roller cutter



- ST-CT400 WELD-BEAD CUTTER (W/O ROLLER CUTTER)
- ST-CT400-1 WELD-BEAD CUTTER W/ROLLER CUTTER(SA-RC111)
- ST-CT400-2 WELD-BEAD CUTTER/ROMOVER W/ROLLER CUTTER(SA-RC112)
- ST-CT400-3 WELD-BEAD CUTTER/ROMOVER W/ROLLER CUTTER(SA-RC113)
- ST-CT400-4 WELD-BEAD CUTTER/ROMOVER W/ROLLER CUTTER(SA-RC114)



#### PARTS LIST

No.	Parts No.	Description	Q'ty
1	CT400-01A	Air Inlet Bushing (PT19)	1
	CT400-01B	Air Inlet Bushing (NPT18)	1
2	CT400-02	Tap Screw (M3x6L)	2
3	CT400-03	Deflector	1
4	CT400-04	Motor Housing Ass'y	1
5	CT400-05	O-Ring (S10)	1
6	CT400-06	Spring Pin (Φ3x25L)	1
7	CT400-07	Safety Throttle Lever	1
8	CT400-08	Valve Pin Sleeve	1
9	CT400-09	O-Ring (P8)	1
10	CT400-10	Valve Stem	1
11	CT400-11	O-Ring (S4)	1
12	CT400-12	Spring	1
13	CT400-13	Motor Nut	1
14	CT400-14	O-Ring (S36)	1
15	CT400-15	Ball Bearing (626ZZ)	1
16	CT400-16	B-Bearing Case	1
17	CT400-17	Cylinder	1
18	CT400-18	Rotor	1
19	CT400-19	Rotor Blade	5
20	CT400-20	Spacer	1
21	CT400-21	F-Bearing Case	1
22	CT400-22	Ball Bearing (6000ZZ)	1
23	CT400-23	Frame	1
24	CT400-24	Motor Pulley	1
25	CT400-25	Knob	1
26	CT400-26	Screw (M5x6L)	2
27	CT400-27	Idler Shaft	1
28	CT400-28	Needle Bearing (HK0709)	1
29	CT400-29	Idler Pulley	1
30	CT400-30	Conical Washer	1
31	CT400-31	Screw (M5x25)	1
32	CT400-32	Adjusting Screw Set	1
33	CT400-33	Adjusting Nut	1
34	CT400-34	Cap Screw (M5x18)	1
35	CT400-35	Adjusting Shoe	1

No.	Parts No.	Description	Q'ty
36	CT400-36	Washer	1
37	CT400-37	Washer (Φ8.2xΦ16x0.5t)	1
38	CT400-38	Set Screw (M8x30L)	1
39	CT400-39	Knob	1
40	CT400-40	Cap Screw (M3x5)	2
41	CT400-41	Spring	1
42	CT400-42	Flat Screw	1
43	CT400-43	Conical Washer	1
44	SA-RC111	Φ27x20mm Roller Cutter 36 Flutes (HSS)	1
	SA-RC112	Φ27x20mm Roller Cutter 36 Flutes (Tungsten Steel)	1
	SA-RC113	Φ27x20mm Roller Cutter 25 Flutes (Tungsten Steel)	1
	SA-RC114	Φ27x20mm Roller Cutter 10 Flutes (Tungsten Steel)	1
45	CT400-45	Key	1
46	CT400-46	Driver Shaft	1
47	CT400-47	Flat Screw (M4x10)	2
48	CT400-48	Cap	1
49	CT400-49	Ball Bearing (689ZZ)	1
50	CT400-50	Spacer	1
51	CT400-51	Drive Pulley	1
52	CT400-52	Ball Bearing (686-2RS)	1
53	CT400-53	Wheel Cover	1
54	CT400-54	Spring Washer (M4)	2
55	CT400-55	Screw (M4x6)	2
56	CT400-56	Belt (S3M-201-10)	1
57	CT400-57	Belt Cover	1
58	CT400-58	Spring Washer (M5)	2
59	CT400-59	Cap Screw (M5x10L)	2
60	CT400-60	Wrench (T40)	1
61	CT400-61	Spanner (10mm)	1
62	CT400-62	Regulator Assembly	1
63	CT400-63	Washer	1
64	CT400-64	Retaining Ring (E2.5)	1
65	CT400-65	Hex. Wrench (2.5mm)	1
66	CT400-66A	Packing (0.5mm)	1
	CT400-66B	Packing (1.0mm) (Option)	1