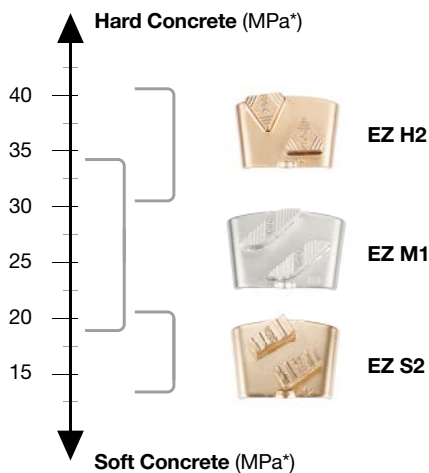


**HTC**  
**Quick guide**  
**Floor grinding**




## Concrete grinding



**OBS!** NB! Soft concrete causes more wear on the tools. Check tools for wear after 10 mins. It takes about 20 to 30 days for newly-laid concrete to harden and attain its full strength. Source: HTC Sweden AB. The values can vary depending on the quality of the concrete.  
\* Mega Pascal

## Coating removal

	 <b>EZ M0</b>	 <b>EZ M1</b>	 <b>EZ T-Rex® Dome II</b>	 <b>Scarifier</b>
<b>Epoxi</b>	● < 1 mm		● 1- 5 mm	● > 5 mm
<b>Adhesive</b>	●		●	✗
<b>Paint</b>	●		●	✗
<b>Self-leveling compound</b>	●		●	● > 10 mm
<b>Seams and irregularities</b>	●		✗	● > 10 mm

## Tool guide

### Mounting tool holders/diamond tools

When mounting tool holders, the following precautions should be taken:

- ✓ Remove any loose weights.
- ✓ The power should be off and HTC recommends that the cord be unplugged.
- ✓ Tip the machine over and detach the old tool holder.
- ✓ The tool holder can also be screwed to the machine if desired.



**The discs and tools may be hot.  
Use protective gloves!**

- ✓ Mount the new tools.
- ✓ Lock the tools. Turn the machine upright and check the splash guard.
- ✓ Make sure the splash guard is lying flat against the floor. An improperly mounted splash guard can cause problems such as poor suction from the vacuum.

### How do I switch EZchange™ tools?

- ✓ Place the tools in the compartment on the holder.
- ✓ Tap lightly with a rubber hammer.

That's all there is to it!

Now you're ready to strip, polish or remove old finishes.



## Machine operation

### What if the tools don't work?

#### What do I do if the tool glazes\* over or grinds poorly?

1. Increase the weight (pressure)
2. Vary the speed
3. Moisten the surface
4. Switch to tools with a softer bond

#### What should I do if the tool wears out too fast?

1. Choose a tool with a harder bond
2. Reduce the pressure
3. Increase to a full set (Tools in all places.)

#### What is meant by "too fast"?

1. If the tool wears down more than 1mm in 30 minutes. Measure the tool for wear after about 10 minutes.

#### What should I do if the machine is sluggish or disengages?

1. The pressure is too high, remove any weights
2. Reduce the speed
3. Choose a different tool
4. Increase to a full set



**Check the tools after about 10 minutes to ensure they are not wearing down too quickly.**



\*Glazing over occurs when the tool's bond is too hard in relation to the floor and the diamonds do not drop. Glazing over can also occur if you grind at too fast a speed. On the left, a segment that has glazed over. On the right, a "dressed segment" with exposed diamonds.

## T-Rex®

Use T-Rex® for removing old finishes, not for conventional grinding! The tools are extremely efficient at removing finishes and can also strip thick finishes. The HTC X model is equipped with four grinding heads that rotate in different directions. A and B versions are available for different rotation directions.



T-Rex® Ring



T-Rex® EZchange model



The X models have four grinding discs and require both A and B versions of T-Rex®

# Machine operation

## Control knobs - Description of functions

The control panel has the following knobs:



### Emergency stop

Red button. Located on the control panel; cuts the power immediately.



### On/Off (main switch)

Starts and stops the machine's electronics and prepares for start-up. A green light is lit when the switch is turned.



### Speed (applies only to machines with variable speed)

Regulates the speed of the machine's grinding discs.



### Rew/Fwd (used to start and stop the machine)

Starts and stops the machine's grinding discs.

## Starting the machine

1. Begin by placing the machine in start-up mode by turning the on/off knob. A light comes on to indicate the machine is in standby mode.
2. Set the speed at which you want to begin grinding.  
The more uneven the floor is, the lower the speed should be.  
(Applies if you have a machine with variable speed.)
3. Start the machine by selecting the rotation direction.



**NB! Do not use On/Off for starting and stopping the rotation of the discs! This could very likely damage the electronics. Use Rew/Fwd instead.**

## General advice

### What if the machine doesn't start?

1. Make sure the emergency stop button is not pushed down.
2. Make sure the machine's power cord is okay, has sufficient area, and is not too long (30 meters [98 feet] maximum for single-phase, 50 meters [164 feet] for three-phase).
3. Is the grinding head pressure too high? Remove any weights or lift the machine slightly to ease the pressure on the grinding heads.
4. Check to see if a fuse blew.
5. Check for an error code on the converter's display in the electric cabinet.

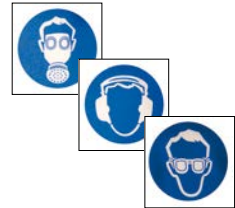
### How do I use the machine?

#### Before you get started, do the following:

- ✓ Inspect the floor carefully and remove any objects sticking up, such as reinforcement rods or bolts, and any debris that might get fastened in or damage the machine and tools.
- ✓ Mount the appropriate tool on the machine (see diamond tools on page 2).
- ✓ Mount the splash guard
- ✓ Use appropriate protective gear

If doing dry grinding, attach and start the vacuum before starting the machine.

**NB! Use only original HTC tools.**



## General advice



### Choose the right machine

Your choice of machine should be determined by the surface and time. Large surface area=large machine, and vice versa. It is essential to know how many times the surface needs grinding (grinding steps).



### Inspect the surface

Inspect the floor carefully and remove any objects sticking up that might get fastened in or damage the machine and tools.



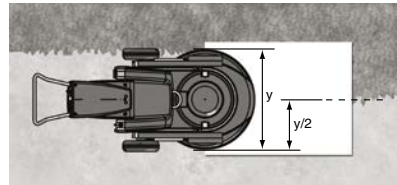
### Use the correct power cord

Use a power cord that is no longer than 30 meters (98 feet) for single-phase or 50 meters (164 feet) for three-phase and that covers an area big enough to accommodate the machine being used. Make sure your workplace has an adequate power supply. You may want to specify this in your bid request.



### Adhesive removal

When removing residual adhesive, we recommend grinding with a 50% overlap to obtain best results. See illustration.



### Keep an eye on the vacuum cleaner bag

Checking the amount of dust collecting in the vacuum cleaner bag is a good way of ensuring that the tools are working properly.

# Machinery for all floors from HTC - the industry leader



HTC 270 EG



HTC 420 VS



HTC 500



HTC 650 Classic



HTC 800 Classic



HTC 650 RX



HTC 800 RX



HTC 950 RX



HTC 1500 IXT



HTC 80 iD II

HTC Greylite™



HTC GL 270



HTC GL 400



HTC GL 450



HTC GL 550



HTC GL PS



HTC GL 25/35



HTC GL 40