



WL 75

INSTRUCTIONS BOOKLET



Rim Press + Lathe

IMPORTANT NOTICE

The presents instructions booklet is an integral part of the product. Carefully study the warnings and instructions contained in it. This information is important for safe use and maintenance.

Conserve this booklet carefully for further consultation.

THIS MACHINE

is a rim pres to repair defective rims.

The machine has been designed to operate within the limits described in this booklet and in accordance with the manufacturers instructions.

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

The manufacturers cannot be held responsible for eventual damage casued by improper , erroneous or unacceptable use

Our firm is not responsible for printed mistakes.

IMPORTANT

This machine may be operated only by suitably trained personnel. Any work on the electrical , hydraulic , pneumatic systems must be conducted only by professionally qualified personnel.
10 years in the life of the machine.

CONTENTS

	<u>PAGE</u>
CLAUSE 1 General Notice.....	3
CLAUSE 2 Technical Characteristics.....	3
CLAUSE 3 Parts Of The Machine.....	4
CLAUSE 4 Introduction	5
CLAUSE 5 Packaging, transport, storage and safety	5
CLAUSE 6 Safety Warnings.....	6
CLAUSE 7 Rim repair equipment.....	7
CLAUSE 8 Problems , Causes , Remedies.....	7
CLAUSE 9 Installation.....	8
CLAUSE 10 Operations and use.....	9-10
CLAUSE 11 Routine Maintenance.....	11
CLAUSE 12 Technical service and warranty.....	11
CLAUSE 13 Electric Curcuit Plan.....	12
CLAUSE 14 Demontage Plan and Spare Parts List.....	13-17

CLAUSE 2

TECHNICAL CHARACTERISTICS

DIMENSIONS

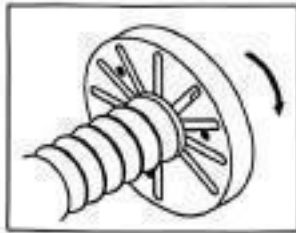
Height(1.853,5 min / 2.153,5 max) mm
Lenght (866,5 min / 1.032,5 max) mm
Widht (1.305 min / 1.555 max) mm

WEIGHT

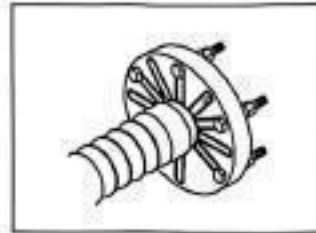
Net weight..... 455 Kg
Noise Level.75 db

CLAUSE 3

PARTS OF THE MACHINE

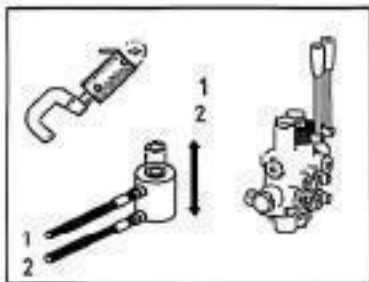


FLANSH must rotate in arrow direction

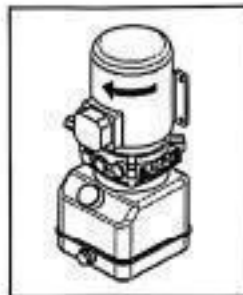


RIM CONNECT FLANSH

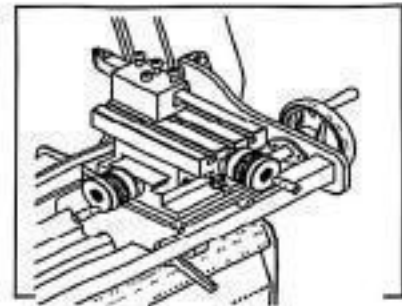
The flansh desinged to serve different size of rims



CONTROL UNIT controls the pistons movements

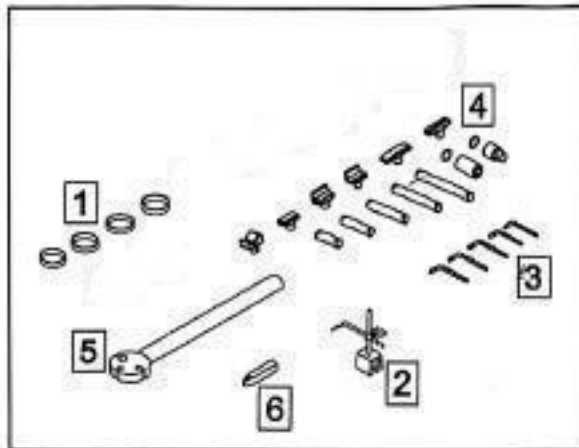


HYDRAULIC UNIT moves the piston up and down position



LATHE UNIT lathes the defective rims after repair

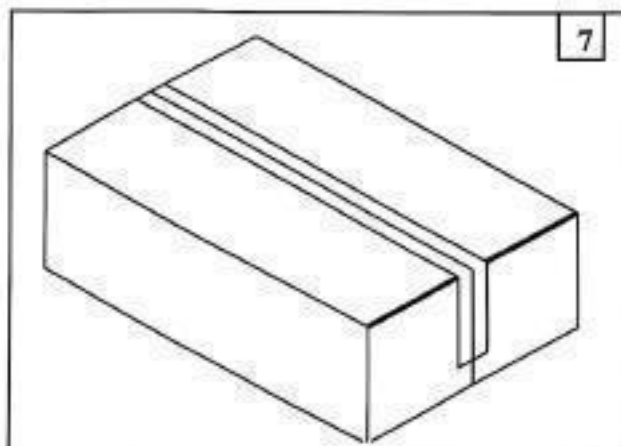
ACCESSORIES PROVIDED



- 12 pcs conneting flanches for different sizes of rims.
- 1 pcs gauge.
- 5 pcs allen head wrenches.
- 1 pcs angular supports
1 pcs square supports small
1 pcs gradual supports
1 pcs side chisel supports
1 pcs square supports big
1 pcs square supports reverse
5 pcs support miles
2 pcs connection horoscope
- 1 pcs lever.
- 1 pcs lathe cutter
- Cartoon box.

Rim to center washer

- 1 - \varnothing 54
- 2 - \varnothing 56.5
- 3 - \varnothing 57
- 4 - \varnothing 58
- 5 - \varnothing 59.5
- 6 - \varnothing 60.1
- 7 - \varnothing 63.3
- 8 - \varnothing 64
- 9 - \varnothing 65
- 10 - \varnothing 66.6
- 11 - \varnothing 72
- 12 - \varnothing 72.5



CONTENT OF THE BOX

- 1 pcs up support.
1 pcs down support.
- 4 pcs support pins.
- 6 pcs screws.
- Provided accessories.

- When the machine arrives check that it has not been damaged during transport and that all the accessories are present.

CLAUSE 4

INTRODUCTION

This Manual Has Been Prepared For Workshop Personnel Expert In The Use Of The Machine (Operator) And Technicians Responsible For Routine Maintenance (Maintenance Fitter); Read The Manual Before Carrying Out Any Operation With The Rim Repair And/Or Packing . This Manual Contains Important Information Regarding :

Rim Repair Machines Safety
He Personnel Safety Of Operators And Maintenance Workers

CONSERVING THE MANUAL

The Manual Is An Integral Part Of The Rim Repair, Which It Should Always Accompany Even If The Unit Is Sold. The Manual Must Be Kept In Proximity Of The Rim Repair, In An Easily Accessible Place. The Operator And Maintenance Staff Must Be Able To Locate And Consult The Manual Quickly And At Any Time. Lifting, Transport , Unpacking , Assembly , Starting Up , Initial Adjustment And Testing , Extraordinary Maintenance , Repair , Overhauls, Transport And Dismantling Of The Rim Repair Machine Must Be Performed By Specialised Personnel From The Licensed Dealer Or A Service Centre Authorised By The Manufacturer . The Manufacturer Declines All Responsibility For Injury To Persons Or Damage To Vehicles Or Objects When Any Of The Above Mentioned Operations Has Been Performed By Unauthorised Personnel Or When The Rim Repair Has Been Subject To Improper Use. This Manual Indicates Only The Operative And Safety Aspects That May Prove Useful To The Operator And Maintenance Worker, In Better Understanding The Structure And Operation Of The Rim Repair And For Best Use Of The Same. In Order To Understand The Terminology Used In This Manual, The Operator Must Have Specific Experience In Workshop, Service, Maintenance And Repair Activities.

CLAUSE 5

PACKING , TRANSPORT , STORAGE

All packing, lifting , handling , transport and unpacking operations are to be performed exclusively by expert personnel with knowledge of the rim press and the contents of this manual.

PACKING

Rim Repair machine is crated and stretched on wooden pallet.

LIFTING AND HANDLING

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 , Barycentres , Jests And Fragile Parts Not To Be Damaged.

STORAGE

Packed Machinery Must Always Be Kept In A Covered , Protected Place At A Temperature Between -10 °C To +40 °C And Must Not Be Exposed To Direct Sunlight.

OPENING CRATES

When The Crates Arrive, Check That The Machine Has Not Been Damaged During Transport And That All The Listed Parts Are Present. The Crates Must Be Opened Using All Possible Precautionary Measures To Avoid Damaging The Machine Or Its Parts. Make Sure That Parts Do Not Fall From The Crate During Opening

DISPOSAL OF CRATES

The Wood Of The Pallets And The Stretch Film May Be Re-Used.

SAFETY

- THIS MACHINE IS DESIGNED ONLY FOR 10" - 26" RIMS.
- THIS MACHINE MUST BE USED ONLY FOR RIM REPAIR PROCEDURE.
- 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 press the emergency button and switch off the main switch and check the section "Malfunctions causes and possible remedies" in the instructions manual. If the problem is still call the service.

- Wear protection glasses and gloves during the operation.
- Stand straight during operation.
- 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.

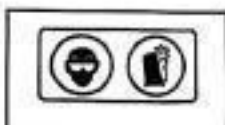
DO NOT STAND IN FRONT OF THE FLANSH WHEN IT IS ROTATING.



SAFETY WARNINGS



PLEASE READ THE INSTRUCTIONS MANUAL CAREFULLY BEFORE START USING THE MACHINE



DON'T USE YOUR MACHINE WITHOUT GLASSES AND GLOVES.

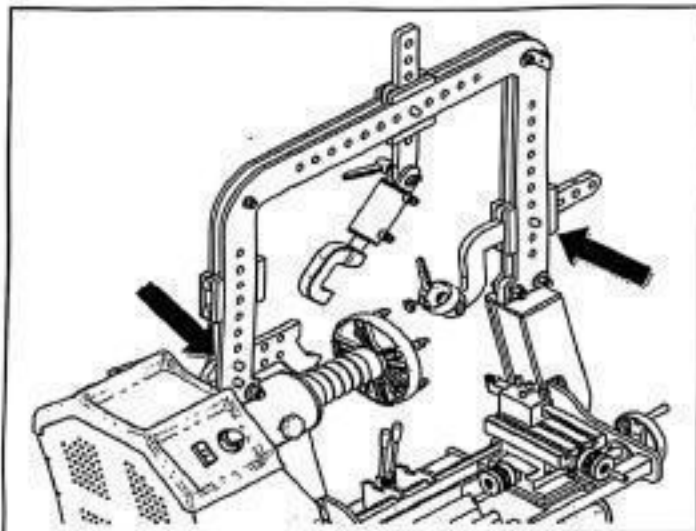


DO NOT PUT YOUR HANDS BETWEEN THE PISTON AND FLANSH DURING THE OPERATION.

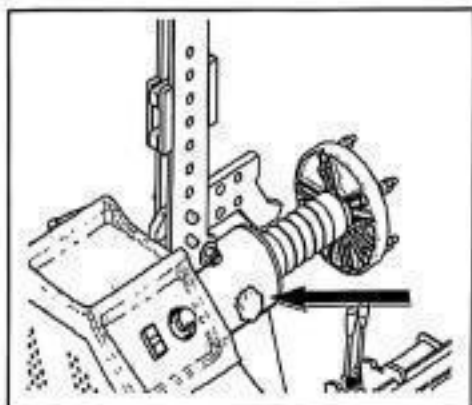


DO NOT USE THE PISTON ON LIVING THINGS.

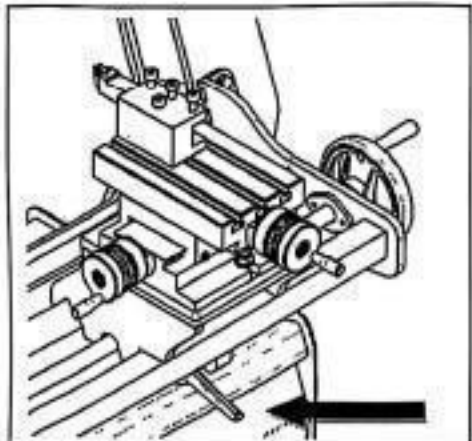
- BE SURE THAT THE RIM IS WELL FIXED TO THE FLANSH.



- BE SURE ABOUT ATTACHMENT OF THRUSTING PINS AND BE CAREFUL ABOUT PISTON MUST BE WELL PLACED TO PRESSURE FOOT.



TIGHT THE NUTS BEFORE THE REPAIRING PROCEDURE.
UNTIGHT THE NUTS DURING LATHE OPERATION.

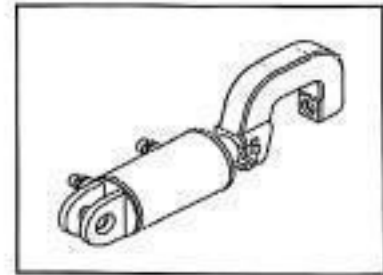
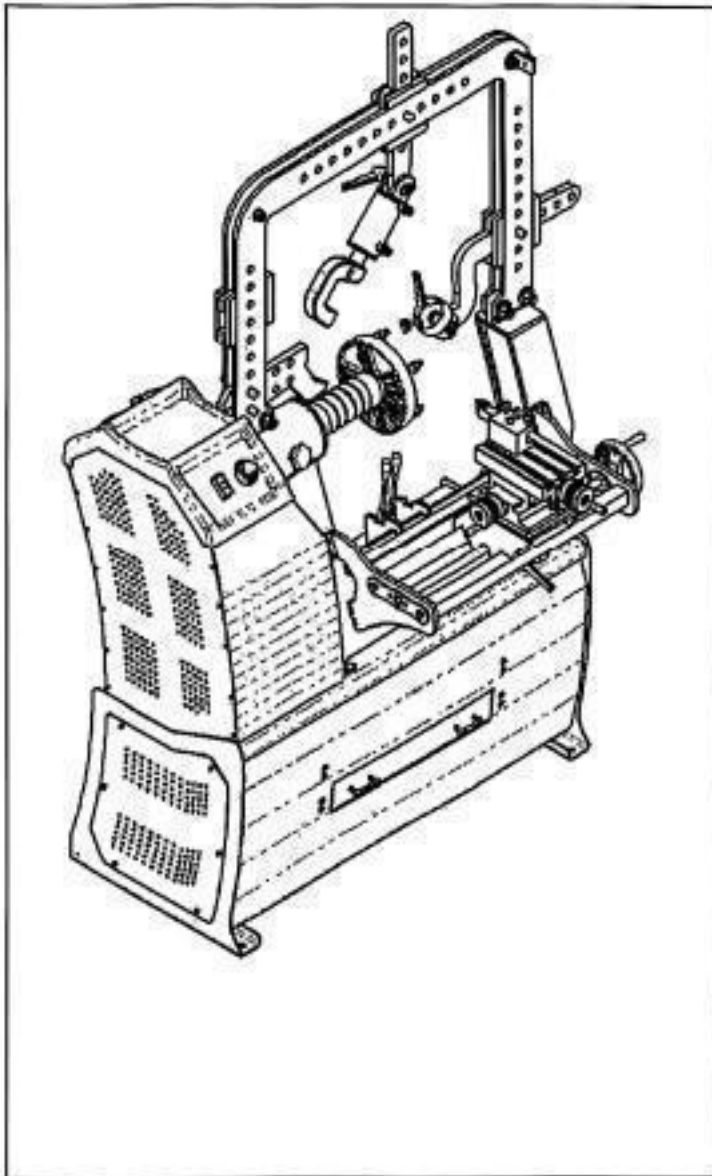


- TIGHT THE FIXING HANDLE DURING LATHE OPERATION

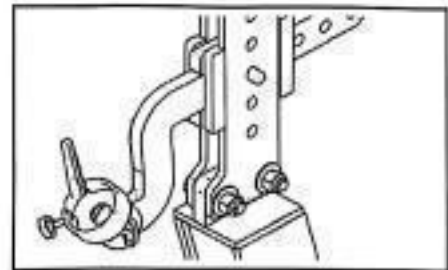
DO NOT USE JETS OF WATER , STEAM (HIGH PRESSURE WASH UNITS), SOLVENTS NEAR THE RIM REPAIR MACHINE.

UNPLUG OR SWITCH OFF THE MAIN SWITCH BEFORE YOU START CLEANING THE MACHINE.

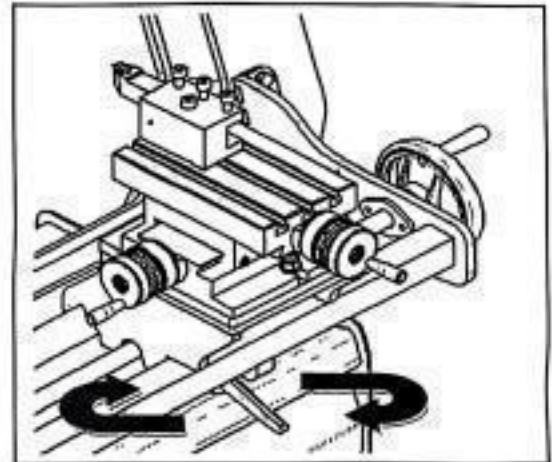
RIM REPAIR EQUIPMENT



Double impact correcting piston



Correcting Piston Bedding



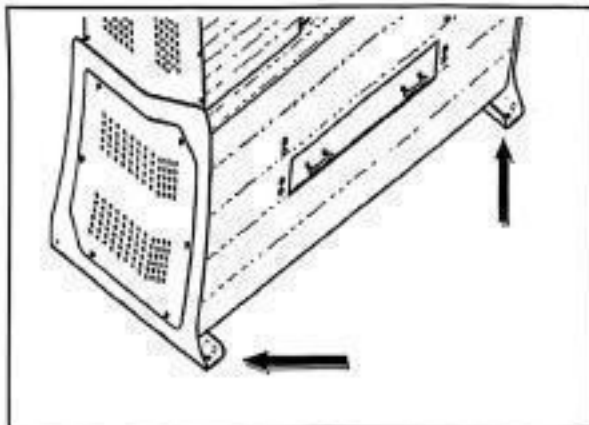
Slidable and Turnable Type Lathe

CLAUSE 8

PROBLEMS – CAUSES - REMEDIES

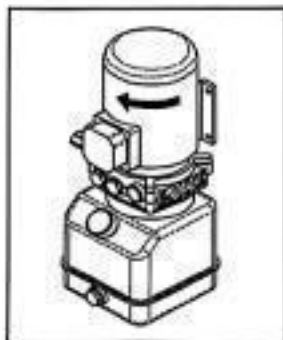
PROBLEMS	CAUSES	REMEDIES
The fanish does not rotate in any direction.	1.The mains connection is not plugged in. 2.The plug is not correctly wired. 3.The mains tension is not suitable for the machine 4.The mains switch is not on. 5.Faulty fuse.	1,2,3.Check the correct insertion of the plug and its connections. 4.Switch on the mains. 5.Replace the fuse.
The pressure of the hydraulic unit is not enough.	1.The rotation of the hydraulic engine is reverse. 2.There is leak of oil in the connections. 3.There is lack of oil in the hydraulic engine.	1.Reverse the two wires in the connection plug. 2.Check the couplings change them if necessary. 3.Put some oil till the level to the hydraulic engine.

MACHINE FIXING ONTO FLOOR

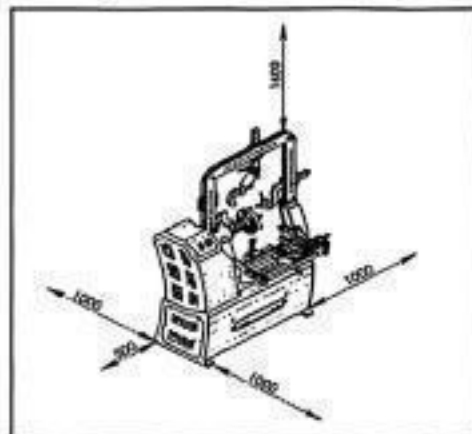


For a good functioning the machine must be fixed onto floor with expansion dowels.

- 1) Drill the floor with a helical concrete bit with a diameter of 15 mm. , using the holes in the base as a drilling template.
- 2) Move the rim repair and insert anchor bolts into the drills, then set the machine in the place to be fixed.
- 3) Insert into the anchor bolts and use a torque wrench (setting of 25 N / m) to tighten..

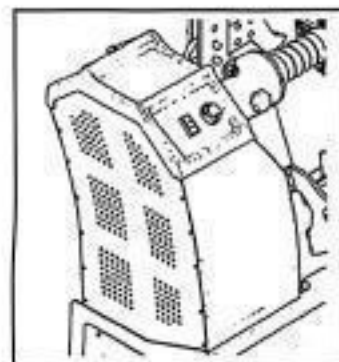


LOCATION



SAFE DISTANCE:

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



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

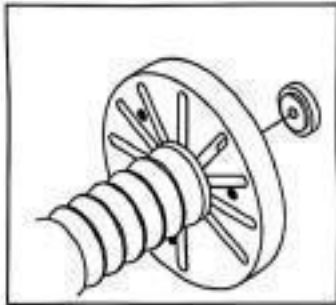
- Check that the mains supply is the same as that shown on the registration plate.
- Connect the cable to a plug that conforms with European norms or to the norms of the country in which the machine used.
- The plug must have an earth terminal.
- Check that the earth connection is effective.
- The machine must be connected to the mains through a multipole isolating switch which conforms with European norms and with contact openings of at least 3 mm.
- Check that the multipole connector on the electrical board is correctly connected.
- When the machine is connected switch it on and check the correct direction of rotation; this should be as shown by the arrow on the motor unit.
- If the rotation is reversed, reverse the two wires in the connection plug.
- If the machine behaves abnormally, immediately press the emergency button and switch off the main switch and check the section "Malfunctions: causes and possible remedies" in the instructions Manual.

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

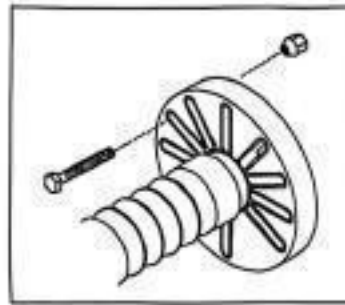
OPERATIONS AND USE

• CONNECTING THE DEFECTIVE RIM TO THE FLANSH

1. Clean the muds and the balance weights from the rim.

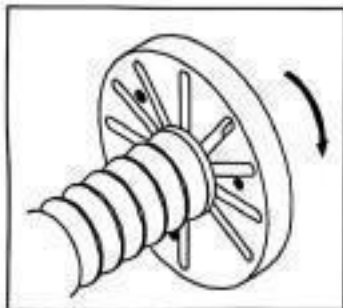


2. Choose a suitable sized connecting flansh for the rim.

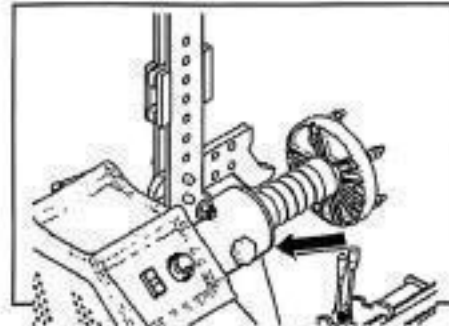


3. Tight the connecting flansh and fasten to the suitable canals on the flansh.

• ANALYSING THE DEFECTIVE AREA

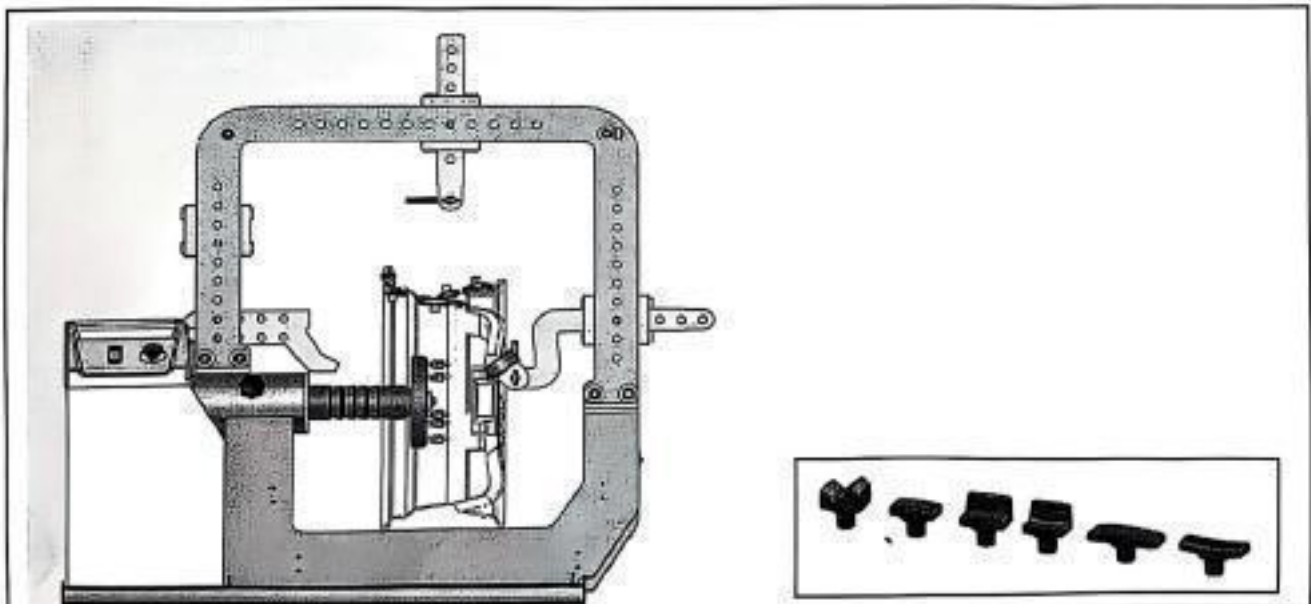


1. Rotate the flansh.
2. Locate the defective area by using gauge and sign it.



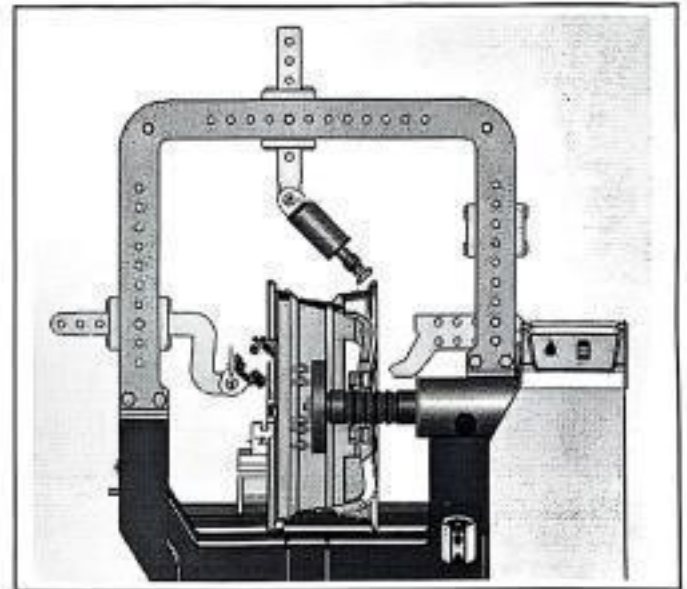
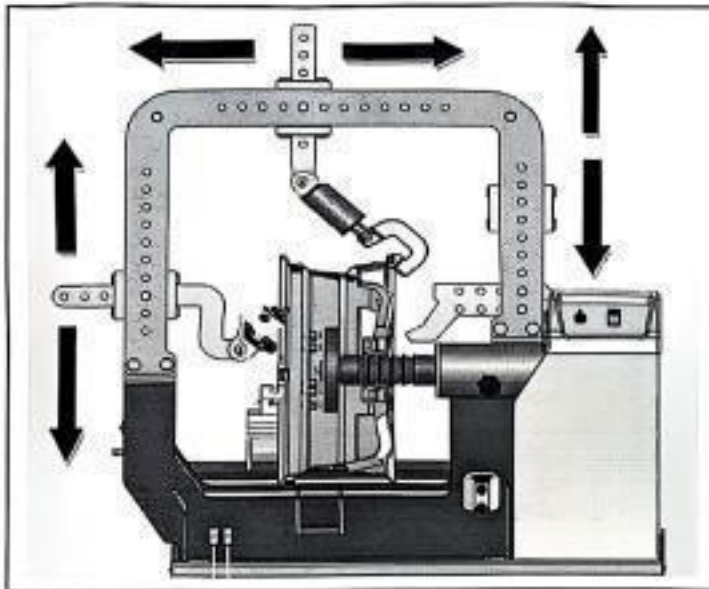
3. Tight The Nuts To Start The Repairing Procedure
4. Choose a suitable support and repair it by using the pres.

RIM REPAIRING POSITIONS



OPERATIONS AND USE

RIM REPAIRING POSITIONS



- 1) With the help of double impact cylinder, it can press both as pulling and as pushing.
- 2) Moving thrusting part to left, right, up and down, can do the best repairing process.
- 3) Damages on rim from in to out, out to in, front and back can be pressed as shown in the figure.

OPERATIONS AND USE

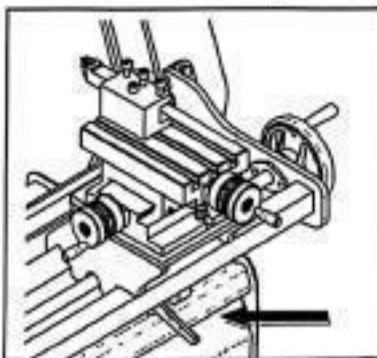
***When repairing iron rims use also the manual handle plus to the pres.

***Before the pressing operation some rims need to be heated (especially aluminum rims). This procedure is for:

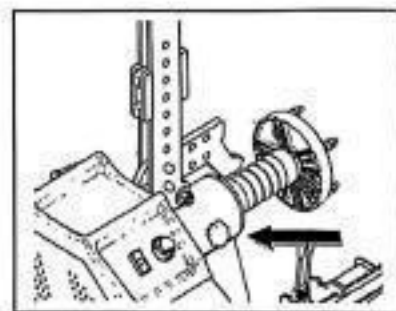
1. Avoiding cracks and faults on the rim
2. Piston's safety
3. Your personal safety

***If the rim is too defected first mend it with the lever and then repair it with the pres..

LATHE OPERATION



*** TIGHT THE FIXING HANDLE DURING LATHE OPERATION.



***UNTIGHT THE NUTS DURING LATHE OPERATION

Lathe operation: this procedure is for cleaning the burrs and the overplus parts of the welding operation.

CLAUSE 11

ROUTINE MAINTENANCE

To guarantee the efficiency of the machine and for its correct functioning is essential to carry out routine cleaning and maintenance.

Routine maintenance must be carried out by the user according to the maker's instruction.

** Before starting any cleaning or maintenance switch off the main switch and remove the mains plug from socket.

EVERY DAY...

Clean and grease the fan and the lathe.

EVERY MONTH...

Check the oil level of the hydraulic system.

Tight the screws of the lathe unit.

EVERY 6 MONTHS...

Grease the bearings. Make a general check.

EVERY YEAR...

General Check: Visual inspection of all structural parts and mechanisms to guarantee that there are no problems or anomalies.

Electric Plant: Skilled electricians should test the electric plant.

STORAGE

PERIODS OF INACTIVITY	PERMANENT STORAGE
During the times the machine is temporarily stored or whenever the machine is not in use, remove the plug from the mains.	If it is decided to store the machine long term it is advisable to make it inoperative by removing the mains cable after having unplugged it from the mains.

CLAUSE 12

TECHNICAL ASSISTANCE AND SPARE

- THE MACHINE IS GUARANTEED (1 YEARS)
- FOR ANY MACHINE MALFUNCTIONS CONSULT THE SECTION "MALFUNCTIONS: CAUSES AND POSSIBLE REMEDIES". ANY OTHER MALFUNCTIONS MUST BE CHECKED BY PROFESSIONALLY QUALIFIED PERSONNEL.
- IN ALL CASES CONTACT THE ASSISTANCE SERVICE OF HATCO. FOR PROMPT ASSISTANCE IT IS IMPORTANT AT THE TIME OF THE CALL TO SPECIFY THE MACHINE MODEL, THE PRODUCTION NO. (FOUND ON THE REGISTRATION PLATE) AND TYPE OF MALFUNCTION

WARNING

ANY WORK ON THE ELECTRICAL, HYDRAULIC AND PNEUMATIC SYSTEMS MUST BE CARRIED OUT ONLY BY PROFESSIONALLY QUALIFIED PERSONNEL.

- ***THE MOTORS ARE NOT UNDER WARRANTY.



THERE IS NO OIL IN THE HYDRAULIC

- The machine is provided without oil in the hydraulic unit. Put some oil till the level to the hydraulic unit from the oil can that you can find in your accessories box provided with your machine.
- Use only SHELL TELLUS 37 in the hydraulic unit
- Run the machine idle for 10 minutes during the winter months. Start work later please.

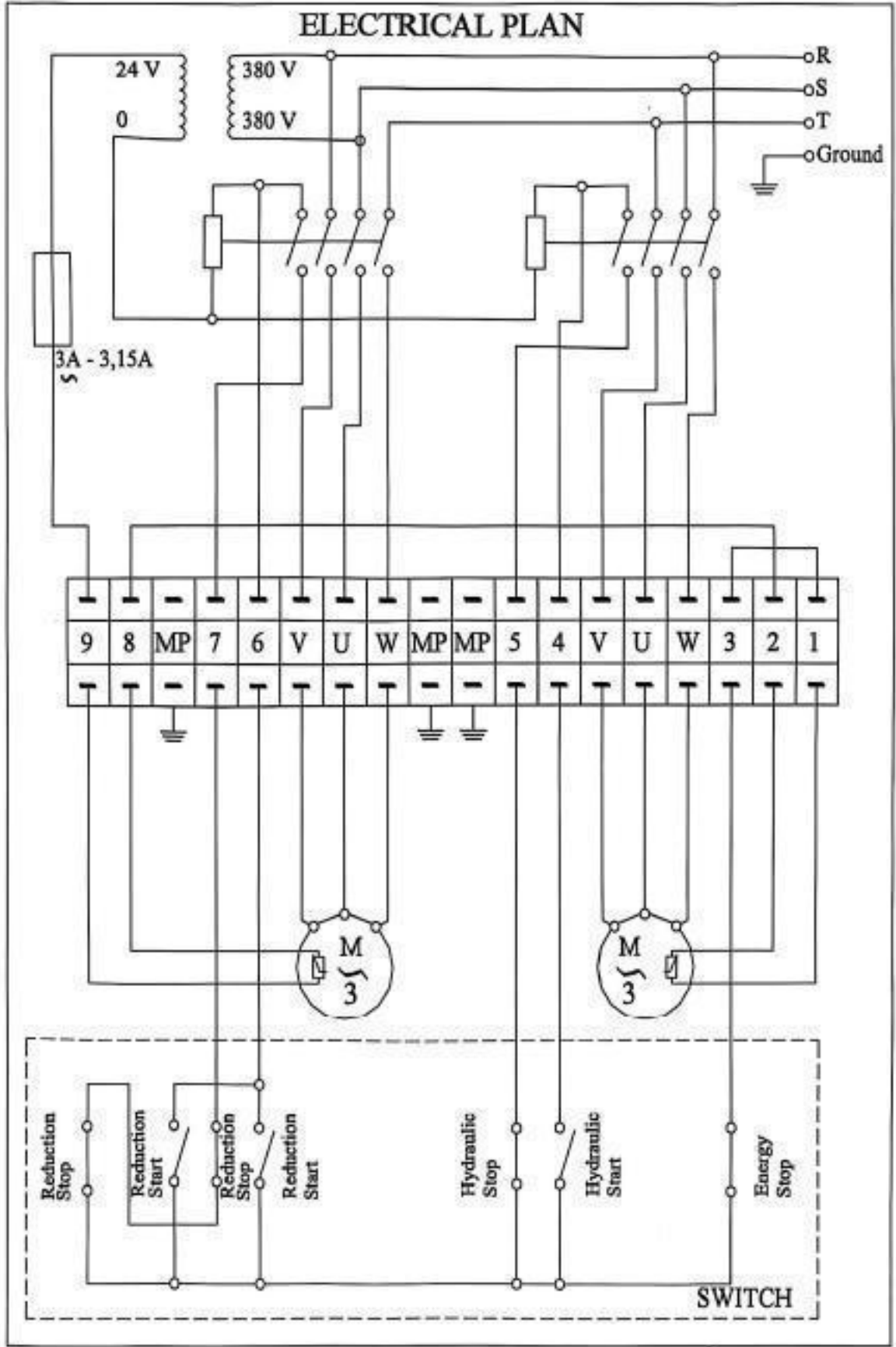
WARNINGS

USE ONLY ORIGINAL PARTS OF THIS MACHINE
THE MANUFACTURER TAKES NO RESPONSIBILITY OF THE NONORIGINAL PARTS

TO ORDER SPARE PARTS:

- INDICATE THE SERIAL NUMBER OF THE MACHINE AND THE YEAR BUILT.
- INDICATE THE CODE OF THE PIECE REQUESTED.
- INDICATE THE QUANTITY REQUIRED.

ELECTRICAL PLAN



JUMBO DOUBLE PARTS LIST

NO	PART NO.	DESCRIPTION
1	84 01 000	Lower Body Group
2	84 01 001	Body Group
3	84 01 003	Fixing Plate Of Drawer Slider
4	84 00 004	Lower Body Cover
5	01 0073 016	Imbus Bolt Screw
6	01 0200 02	Switch
7	01 0112 05	Washer
8	01 0071 010	Imbus Bolt Screw
9	01 0112 08	Washer
10	84 01 002A	Drawer Body Group
11	84 01 002B	Drawer Body Plate
12	84 01 002C	Connection Plate Of Drawer Slider
13	01 0062 33	Handhold
14	01 0062 110	Telescopic Rail
15	01 0113 010	Screw
16	01 0112 004	Washer
17	01 0117 004	Fiber Nut
18	01 0117 005	Fiber Nut
19	01 0112 05	Washer
20	01 0071 016	Imbus Bolt Screw
21	01 0070 010	Imbus Bolt Screw
22	84 02 000	Upper Body Group
23	84 02 001	Body Group
24	15 05 001	Main Shaft
25	15 10 001	Occurentie Ring Back Cover
26	15 08 001	Rim Connect Flash
27	15 12 000	Baserotor Hoop
28	15 15 000	Piston Pendent
29	26 10 000	Rim Centering Group
30	01 0014 176	Record Body
31	55 04 000	Bottom Piston Clothes Tree
32	01 0024 020-3	O-Ring
33	15 14 004	Nut
34	01 0021 35-46.3-10 BP NBR70	Nutring
35	01 0024 080-3	O-Ring
36	01 0024 035-3	O-Ring
37	01 0022 060-044	Compact Set
38	15 14 003	Hydraulic Cylinder Piston
39	15 14 001	Hydraulic Cylinder
40	84 02 002	Hose Clamp
41	01 0072 020	Imbus Bolt Screw
42	01 0053 06016-YW	Bearing
43	01 0139 080	shaft ring
44	01 0081 016	Counter Screw Rivet
45	01 0074 035	Imbus Bolt Screw
46	01 0124 020	Setscrew
47	01 0072 010	Imbus Bolt Screw
48	01 0114 42	Fixing Screw
49	01 0064 080-1.5	Bolt
50	01 0115 001	Rim Connect Nuts.
51	01 0075 030	Imbus Bolt Screw
52	01 0112 10	Washer
53	01 0063 025	Bolt
54	01 0131 1-4	Copper Flake 1/4
55	01 0115 010	Bolt
56	84 06 001	Engine Connection Sheet Metal
57	01 0112 08	Washer
58	01 0062 030	Bolt
59	01 0275 07	Engine
60	15 34 000	Engine Hoop 3^
61	01 0013 1325	V - Belt (13^1325)
62	84 03 000	Lathe Unit group
63	84 03 001	Right Connection Group Of Lathe Unit
64	84 03 002	Left Connection Group Of Lathe Unit

65	84 03 003	Sport Skidding Metal Sheet
66	84 03 004	Sport Handling Axle
67	84 03 005	Bearing Stopping Plate
68	84 03 006	Supporting Plate For Arm Connection
69	01 0112 08	Washer
70	01 0073 025	Imbus Bolt Screw
71	01 0084 025	Bolt
72	01 0112 10	Washer
73	01 0063 025	Bolt
74	01 0139 017	Shaft Ring
75	01 0053 06203-FAG	Bearing
76	01 0315 005	Swivel Arm
77	01 0315 004	Wheel
78	84 03 007A	Body Group
79	84 03 007B	Sport Turning Plate
80	84 03 007C	Slider Locking Plate
81	84 03 007D	Fixing Screw
82	84 03 007E	Square Nut
83	15 37 001	Grooving Holder Connecting Equipment
84	01 0074 070	Imbus Bolt Screw
85	01 0074 035	Imbus Bolt Screw
86	01 0050 01	Fixed Sport
87	01 0047 02	Tool Bit (Lathe Cutter)
88	01 0083 90	Bolt
89	01 0112 12	Washer
90	01 0117 012	Fiber Nut
91	01 0114 05	Lathe Unit To Stop Switchcrank
92	15 32 000	Hydraulic Unit Group
93	01 0159 27	Power Unit
94	01 0014 176	Record Body
95	01 0131 1-4	Copper Flake 1/4
96	01 0014 79	Record Thimble
97	01 0014 23C	Pipe Squeezing Nut
98	01 0014 211	Record
99	01 0131 3-8	Copper Flake
100	01 0014 20	Record Body
101	01 0157 08	Hydraulic Valve
102	84 07 001	Hydraulic Unit Connection Sheet Metal
103	01 0112 06	Washer
104	01 0061 020	Bolt
105	01 0117 006	Fiber Nut
106	01 0112 08	Washer
107	01 0115 008	Bolt
108	84 05 000	Cabin Group
109	84 05 001	Cabin Right Body Group
110	84 05 002	Cabin Left Body Group
111	84 05 003	Cabin Top Body Group
112	84 05 004	Cabin Inner Cover Plate
113	84 00 005	Cabin External Cover Plate
114	01 0039 121	Top Cover.
115	01 0200 25	Switch
116	84 00 003	Pipe
117	15 30 001	Valve Handle Shaft
118	01 0157 02	Hydraulic Valve 3/8-1/4
119	01 0018 1800	Horse Set
120	01 0107 040	Screw
121	84 04 000	Bridge Group
122	84 04 001	Bridge Body Plate
123	84 04 002	Bridge Interconnection Bush
124	84 04 003	Thrust Moving Tap Group
125	84 04 004	Linear Thrust Plate
126	84 04 005	Bottom Thrust Plate
127	84 04 006	Top Thrust Plate
128	84 04 007	Switchblade Pin Group
129	84 04 009	Repairing Piston Bedding Group
130	15 13 001	Hydraulic Cylinder Supports Pin Set.

131	84 04 010	Hose Fixing Plate
132	84 02 002	Hose Clamp
133	01 0072 020	Imbus Bolt Screw
134	01 0114 04	Bakelite Bolt
135	01 0117 014	Fiber Nut
136	01 0065 070	Bolt
137	01 0069 3-4	Bolt
138	01 0112 3-4	Washer
139	01 0117 3-4	Fiber Nut
140	01 0112 14	Washer
141	84 04 008A	Piston Body Group
142	84 04 008B	Body Group Platon Shaft
143	84 04 008C	Hydraulic Cylinder Nut.
144	84 04 008D	Presser Foot Puller Plate
145	84 04 008E	Presser Foot Fixing Pin
146	01 0140 012	Segment
147	01 0031 112	Arc
148	01 0131 3-8	Copper Flake
149	01 0014 176	Record Body
150	01 0024 035-3	O-Ring
151	01 0024 070-3	O-Ring
152	01 0022 070-50-22.4	Compact Set
153	01 0021 35-46.3-10	Wipper
154	84 01 005	Electric Panel Group
155	84 01 005A	Connection Plate
156	01 0202 03	Transformer
157	01 0196 27	Contactora
158	01 0028 42	Cable Canal
159	01 0028 64	Klemenes Rail
160	01 0028 42-K	Cable Canal Cover
161	01 0028 26	Klemenes
162	01 0028 169	Insured Klemenes
163	01 0028 29	Klemenes
164	01 0028 28	Klemenes (Ground)
165	15 32 004	Coupling Group
166	01 0014 23	Nipple
167	01 0111 006	M6 Washer
168	01 0278 51	Hydraulic UnitGroup
169	26 06 003	Pump Outlet Pipe
170	01 0149 02 (3-8)	Suction Filter 1/8
171	01 0014 65	Hydraulic Record 3/8" - 1/4"
172	01 0072 016	M6x16 Imbus Bolt
173	01 0145 12	Caproni Pump
174	01 0135 1-2P	Blind Stopper Plastic
175	01 0137 1-2 AL	1/2" Level Gauge Plastic
176	15 25 000	Up Cover Of Oil Tank
177	15 19 000	Oil Tank Welding Group
178	84 00 002	Pipe