



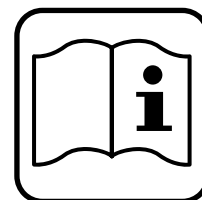
STAYER

- ES** Manual de instrucciones
- IT** Istruzioni d'uso
- GB** Operating instructions
- FR** Instructions d'emploi
- P** Manual de instruções
- PL** İşletim Talimatları
- TR** Inverter Kaynak Makinesi

SD27BE

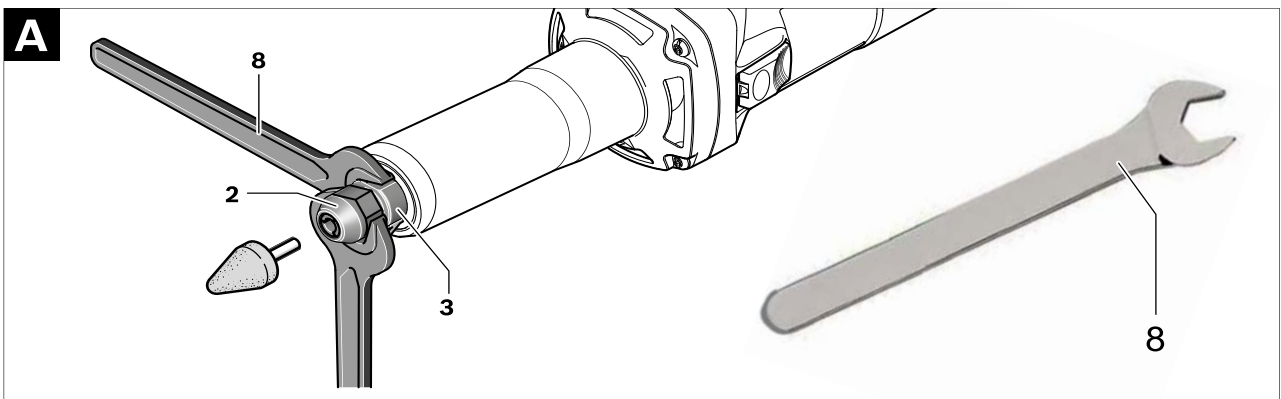
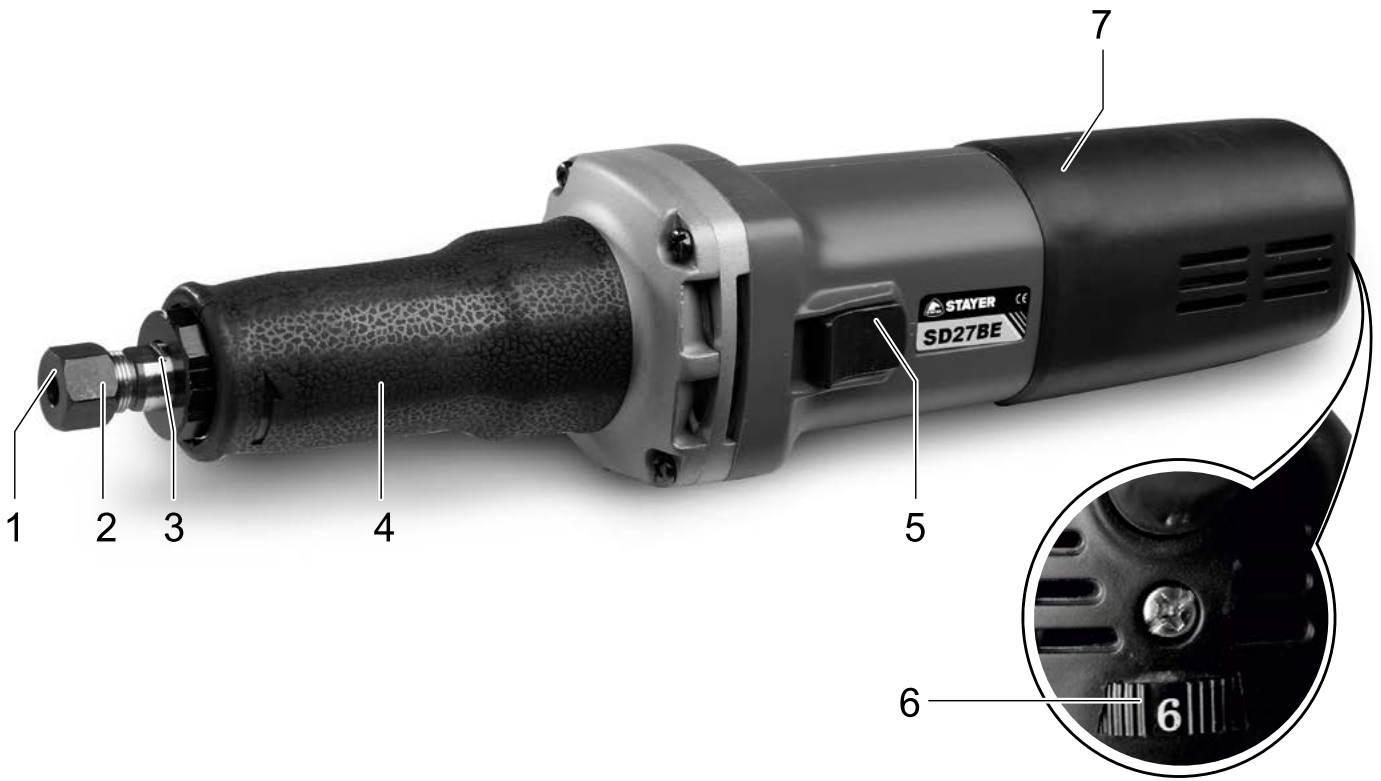
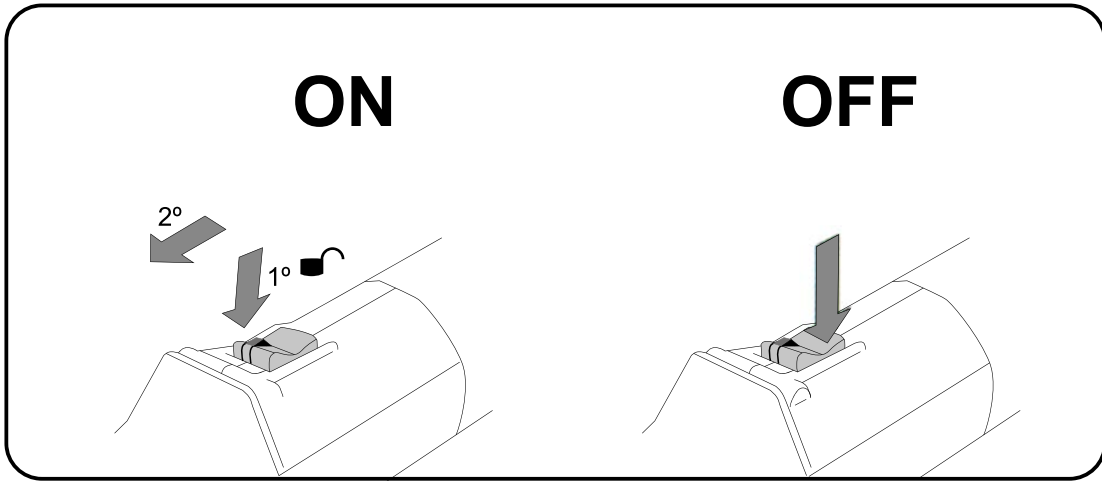
SD27CE

SD150







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			SD 27 BE	SD 27 CE	SD 150
P	W		650	750	1100
R	min ⁻¹		7000-2800	10000-30000	6000
Dmax	mm		Ø 25	Ø 25	Ø 125
Pz	mm		Ø 6	Ø 6 / 8	Ø 6
	Kg		1.7	1.7	4
			II	II	II
	K=3 dB	L _{pA} dB(A)	78	83	88
		L _{VVA} dB(A)	89	98	95
	K=1.5m/s ²	a _n m/s ²	3	3	3

This manual is consistent with the date of manufacture of your machine, you will find information on the technic data of the machine acquired manual check for updates of our machines on the website: www.grupostayer.com

The machine is designed for grinding and deburring metal using corundum grinding tools, as well as for working with sanding wheels. The machine is additionally intended for brushing and polishing metal.

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2. Specific safety instructions

Safety Warnings Common for Grinding, Wire Brushing, Polishing or Carving:

- **This power tool is intended to function as a grinder, carving tool, polisher or wire brush. 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.
- **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.
- **The rated speed of the accessory must be at least equal to the maximum speed marked on the power tool.** Accessories running faster than their rated speed can break and fly apart.
- **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.
- **The arbour size of wheels, sanding drum 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.
- **Mandrel mounted wheels, sanding drums, cutters or other accessories must be fully inserted into the collet or chuck. The “overhang” or the length of the mandrel from the wheel to the collet must be minimal.** If the mandrel is insufficiently held and/or the overhang of the wheel is too long, the mounted wheel may become loose and ejected at high velocity.
- **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.
- **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.
- **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.
- **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.
- **Always hold the tool firmly during the start-up.** The reaction torque of the motor, as it accelerates to full speed, can cause the tool to twist.
- **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 both hands 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.
- **Position the cord clear of the spinning accessory.** If you lose control of the power tool, the cord may be cut or snagged and your hand or arm may be pulled into the spinning accessory.
- **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.

- **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.
- **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.
- **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.
- **Do not operate the power tool near flammable materials.** Sparks could ignite these materials.
- **Do not use accessories that require liquid coolants.** Using water or other liquid coolants may result in electrocution or shock.

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.

- **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.
- **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.
- **Do not attach a thin toothed saw blade.** Such blades create frequent kickback and loss of control.
- **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.
- **When using 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 the steel saw, high-speed cutters or tungsten carbide cutter grab, it may jump from the groove and you could lose control of the tool.

Additional safety instructions for grinding.

- **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.
- **For threaded abrasive cones and plugs use only unthreaded wheel mandrels with an unrelieved shoulder flange that are of correct size and length.** Proper mandrels will reduce the possibility of breakage.
- **Do not "jam" the 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 binding of the wheel in the cut and the possibility of kickback or wheel breakage.
- **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.
- **When wheel is binding 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 binding.
- **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.
- **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.
- **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.

Safety warnings specific for polishing operations

- **Do not allow any loose portion of the polishing bonnet or its attachment strings to spin freely. Tuck away or trim any loose attachment strings.** Loose and spinning attachment strings can entangle your fingers or snag on the workpiece.

Safety warnings specific for wire brushing operations

- **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.
- **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.
- **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.

Additional safety warnings



Wear safety goggles.

- **Use suitable detectors to determine if utility lines are hidden in the work area or call the local utility company for assistance.** Contact with electric lines can lead to fire and electric shock. Damaging a gas line can lead to explosion. Penetrating a water line causes property damage or may cause an electric shock.
- **Release the On/Off switch and set it to the off position when the power supply is interrupted, e. g., in case of a power failure or when the mains plug is pulled.** This prevents uncontrolled restarting.
- **Secure the workpiece.** A workpiece clamped with clamping devices or in a vice is held more secure than by hand.

3. Instructions for use

3.1 Placement Tool

Read all safety warnings and all instructions.



Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury. While reading the operating instructions, unfold the graphics page for the machine and leave it open.

3.2 Assembly

Before any work on the machine itself, pull the mains plug.

Mounting the Grinding Tools (see figure A)



Only use properly fitting and undamaged opened spanners.

- Clean the grinder spindle 3 and all parts to be mounted.
- Hold the grinder spindle 3 with spanner 8 by the spanner flats.

Loosen the clamping nut 2 with spanner 8 by applying it to the spanner flats and turning in anticlockwise direction.

- Insert the clamping shaft of the grinding tool to the stop into the collet chuck 1.
- Hold the grinder spindle 3 firmly with spanner 8 and clamp the tool bit with spanner 8 by the spanner flats, turning in clockwise direction.

The grinding tools must run completely concentric. Do not continue to use out-of-round grinding accessories, instead, replace before continuing to work.

Do not tighten the collet chuck of the clamping nut as long as no grinding accessory is mounted. Otherwise, the collet chuck can become damaged.



Dust/Chip Extraction

Dusts from materials such as lead-containing coatings, some wood types, minerals and metal can be harmful to one's health. Touching or breathing in the dusts can cause allergic reactions and/or lead to respiratory infections of the user or bystanders.

Certain dusts, such as oak or beech dust, are considered as carcinogenic, especially in connection with wood-treatment additives (chromate, wood preservative). Materials containing asbestos may only be worked by specialists.

- Provide for good ventilation of the working place.
- It is recommended to wear a P2 filter-class respirator. Observe the relevant regulations in your country for the materials to be worked.

Prevent dust accumulation at the workplace. Dusts can easily ignite.

3.3 Electrical connection



Observe correct mains voltage! The voltage of the power source must agree with the voltage specified on the nameplate of the machine.

Power tools marked with 230 V can also be operated with 220 V.

3.4 Illustrated description

- 1 Collet chuck
- 2 Clamping nut
- 3 Grinder spindle
- 4 Spindle collar
- 5 On/Off switch
- 6 Thumbwheel for speed preselection
- 7 Handle (insulated gripping surface)
- 8 Spanner service

4. Operating instructions

4.1 Placement and testing

4.1.1 Model SD27BE

Switching On and Off

To **start** the power tool, push the On/Off switch 5 forwards.

To lock the On/Off switch 5, press the On/Off switch 5 down at the front until it latches.

To **switch off** the power tool, release the On/Off switch 5 or, if it is locked, briefly push down the back of the On/Off switch 5 and then release it.

Kickback stop

In case of a sudden drop in speed, e.g., caused by a jammed disc while cutting, the power supply to the motor is electronically interrupted.

To **restart the operation**, switch the On/Off switch 5 to the Off position and start the machine again.

Constant Electronic Control

Constant electronic control holds the speed constant at no-load and under load, and ensures uniform working performance.

Speed preselection

The required speed can be preselected with the thumbwheel 6 (also while running).

The required speed depends on the material being worked and the diameter of the application tool. Observe the maximal allowable speed of the application tool.

Thumbwheel Position	No load speed	
1	10000	2500
2	12700	3600
3	16700	5700
4	19700	5700
5	23500	6800
6	28000	7000

4.1.2 Model SD150

Connection / disconnection

Press the switch to start the equipment.

The trunk has slow start and protection against sudden restart with machine blocked.

To **lock** the machine press the round button next to the switch.

To stop the machine with the main karabiner.

4.2 General instructions for use



Never push forward the spindle collet. Only use it for guide.

Optimum grinding results are achieved when the grinding tool is moved uniformly back and forth with light pressure. Pressure that is too strong reduces the performance capability of the machine and causes the grinding tool to wear more quickly.

5. Maintenance and service instructions

Before any work on the machine itself, pull the mains plug.

For safe and proper working, always keep the machine and ventilation slots clean.

5.1 Cleaning

In extreme conditions, always use dust extraction as far as possible. Blow out ventilation slots frequently and install a residual current device. When working metals, conductive dust can settle in the interior of the power tool. The total insulation of the power tool can be impaired.

If the machine should fail despite the care taken in manufacturing and testing procedures, repair should be carried out by an after-sales service centre for **STAYER** power tools.

5.2 Repair service

Our after-sales service responds to your questions concerning maintenance and repair of your product as well as spare parts.

Exploded views and information on spare parts can also be found under: **info@grupostayer.com**

Our customer consultants answer your questions concerning best buy, application and adjustment of products and accessories.

5.3 Warranty

Warranty card Included in the documentation that accompanies this equipment, you should find the warranty card. You should fill out the card completely and return to vendor with a copy of purchasing receipt or invoice and you should receive a receipt.

Note: If you cannot find the warranty card within the documentation, you must ask for it through your supplier.

The warranty is limited only to manufacturing defects and expire if pieces have been removed or manipulated or repaired other than the manufacturer.

5.4 Disposal and recycling

The machine, accessories and packaging should be sorted for environmental-friendly recycling.

Only for EC countries:

Do not dispose of power tools into household waste! According the European Guideline 2002/96/EC for Waste Electrical and Electronic Equipment and its implementation into national right, power tools that are no longer usable must be collected separately and disposed of in an environmentally correct manner.

Subject to change without notice.

6. Regulations


6.1 Technical Data


P = Rated power input 1

R = Load speed 1

Dmax = Wheel diameter, max.


Pz = Pin

 = weight

 = Protection class

L = Sound power level WA

L A = Sound pressure level P

 = Vibration

Wear hearing protection!

The vibration emission level given in this information sheet has been measured in accordance with a standardised test given in EN 60745 and may be used to compare one tool with another. It may be used for a preliminary assessment of exposure.

The declared vibration emission level represents the main applications of the tool. However if the tool is used for different applications, with different accessories or poorly maintained, the vibration emission may differ.

This may significantly increase the exposure level over the total working period.

An estimation of the level of exposure to vibration should also take into account the times when the tool is switched off or when it is running but not actually doing the job. This may significantly reduce the exposure level over the total working period.

Identify additional safety measures to protect the operator from the effects of vibration such as: maintain the tool and the accessories, keep the hands warm, organisation of work patterns.

6.2 EU declaration of conformity

The undersigned: **STAYER IBERICA, S.A.**

With address at:

Calle Sierra de Cazorla, 7
Área Empresarial Andalucía - Sector 1
28320 PINTO (MADRID)
Tel.: +34 902 91 86 81

CERTIFIES

That the machine:

Type: STRAIGHT GRINDER
Models: SD 27 B E- SD27CE - SD 150

We declare under our sole responsibility that this product is in conformity with the following standards or standardized documents:

EN 60745-1, EN 60745-2-3, EN 55014-1, EN 55014-2, EN61000-3-2, EN61000-3-3 according to EU Regulations 2014/30/UE, 2006/95/CE, 2006/42/CE.

January, 2018


CE  **RÖHS**

Ramiro de la Fuente
Managing Director



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