

# **AIXIN MEDICAL**

# **USER MANUAL**

*AX-D2 Electrolytic  
Polisher*

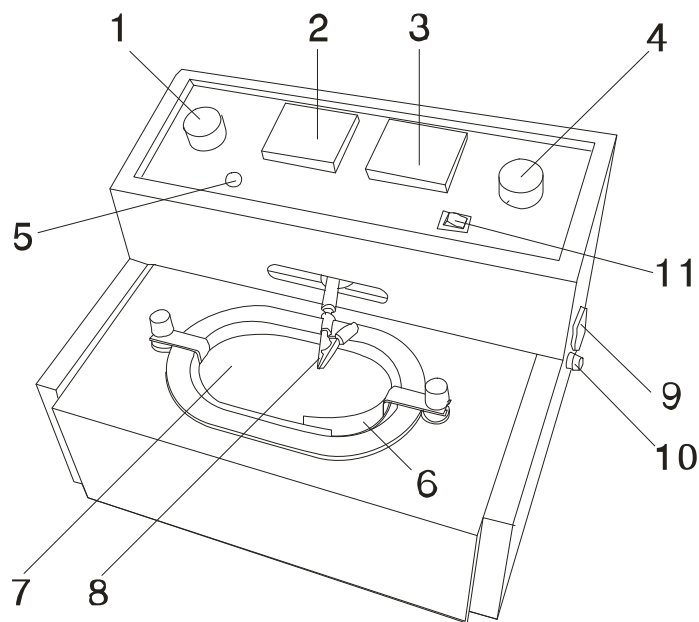
## Description:

The AX-D2 Electrolytic Polisher is equipped with an oval-shaped electrolytic bath which enables the workpiece to soak and move in the electrolyte easily. The vibration system is driven by a motor which moves a pole through an eccentric wheel and the workpiece on the clip moves back and forth along the track. The workpiece can make steady and smooth moves in the electrolyte, which makes it thoroughly polished. Comparing to the motionless method, you can get better results with this new method, and the vibration can be switched off if not needed.

## Specifications:

Power supply voltage	AC 220V / 110V 50HZ / 60HZ $\pm 10\%$
Power	150W
Timer	0-15mins
Current	10A
Dimensions	$37 \times 31 \times 26\text{cm}^3$

## Diagram:



1. Rotary voltage switch
2. DC voltmeter
3. DC ammeter
4. Rotary timer
5. Power indicator
6. Protective case
7. Electrolytic bath
8. Clip
9. Electric outlet with fuse tube (1A)
10. DC fuse (5A)
11. Vibration switch

## Instructions:

1. Unpack the package, check if all the accessories are inside. Read this manual carefully before using.
2. Pour electrolyte into the electrolytic bath, heat the electrolyte to the desired working temperature (about 40 degrees Celsius) with the heat source.
3. Put the heated electrolytic bath into the electrolytic polishing machine.
4. Hang the work-piece firmly with a stainless steel wire, hold the other end of the wire with the anode clip.
5. Rotate the timer switch clockwise to the desired working time, the working indicator light should be on, bubbles will come out of the electrolyte, and the polishing process begins.
6. Press the Vibration switch, the work-piece will move back and forth in the electrolytic bath. To stop vibration press the switch again.
7. When the timer returns to 0 the polishing process stops. To stop the machine temporarily, turn off the power switch.
8. 10-15V of voltage and 2.5-3.5A of current is the optimum setting. The current should not be over 5A. Small current should be used to polish small work-pieces. Observe the polishing process carefully to avoid over-polish which might damage the work-piece.

## Cautions:

1. Make sure the power voltage is compatible with the machine.
2. Check the electrolytic bath regularly, replace it when there is leaks.
3. While the machine is working, make sure there is good contact among the work-piece, stainless steel wire and the clip.
4. Check if there is short circuit among the work-piece, stainless steel wire and the cathode before switching on the power, if such cases happen please solve the problem immediately.
5. The surface of the work-piece must be treated before being polished (deoxidizing, degrease, etc.), otherwise best result may not be achieved.
6. Make sure the temperature of the electrolyte does not exceeds the temperature rating (80°C).
7. Please change electrolyte regularly. In the following cases electrolyte should be replaced immediately: while increasing the voltage within the normal range, the current is small, does not change or decreases; the polishing time is long but the result is not good; the electrolyte is dirty.
8. The machine must stop working for 30 minutes after working continuously for 90 minutes.
9. Cut off the power before repairing the machine.
10. There must be a good contact between the cathode pole of the electrolytic bath and the cathode hole.
11. There should be a reliable ground connection to the case of the machine.

## Accessories:

Manual	1
Power cord	1
Fuse tube	2
Clip	1