User Manual

PLASMA

HOG

67290-SHP

Slag Removal Tool for use on plasma and oxy fuel cutting machines.

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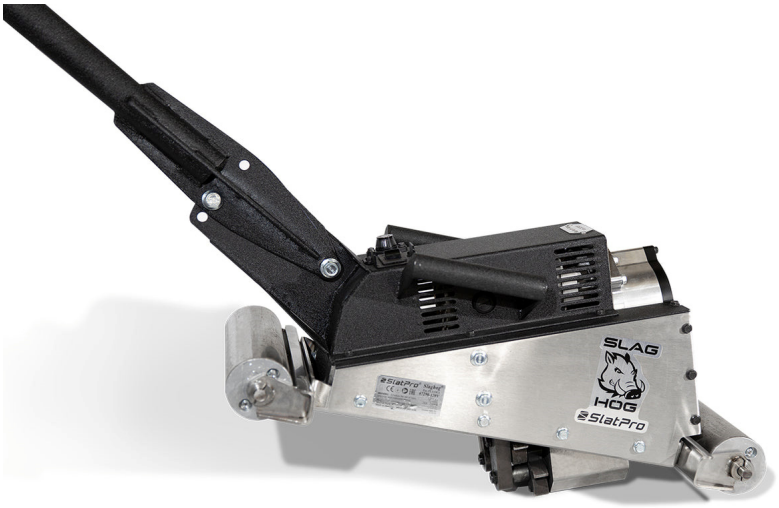


1. Safety

1.1 General Safety Instructions

ΔWARNING! Read all safety warnings and all instructions. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.
Save all warnings and instructions for future reference.

1.2 Plasma Hog Specific Safety Warnings and Instructions

A. Unplug tool from power before performing maintenance on Plasma Hog
B. Use protective equipment. Always wear safety glasses when working with the machine. Protective clothing is recommended such as dust mask, gloves, steel toed non-slip footwear and hearing protection.
C. Do not expose tool to wet conditions or operate in damp environment
D. Power cord to be kept clear from working range of machine. Always lead cord away from machine. Do not apply tension to power cord.
E. **Switch tool off immediately if it stalls.** Lift cutters out of slats before restarting.
F. Two people should lift unit onto slat surface due to weight. One person can operate.

2. Supporting Information

2.1 Conditions of Use

The tool is only to be used for removing the slag from slats on plasma or oxy fuel cutting machines, where the slats create a horizontal plane and the vertical slat sides are cleaned. The slats may be steel, stainless steel or copper. Not to be used in wet areas or outside.

WARNING

2.2 Mains Connection

Connect only to single-phase AC voltage as indicated on the rating sticker. Plug-in receptacle to have ground contact with current capacity exceeding the tools rating.

Only plug in when both tool switches are off.

2.3 Technical Information

Technical Data SlagHog Slag Removal Tool		
Production code	67290-120V	67290-230V
Voltage	120V a.c.	230V a.c.
Current	20 amps	10 amps
Frequency	50/60hz	
Weight	79 lb	36kg
Noise Information Measured values determined according to EN 60745. Typically, the A weighted noise levels of the tool are:		
Sound pressure level (Uncertainty K=3db(A))	90 db (A)	
Sound power level (Uncertainty K=3db(A))	101 db (A)	
Wear ear Protectors!		
Vibration information Vibration total values (triaxial vector sum) determined according to EN 60745 Connect only to a single-phase AC current supply and only to mains voltage specified on the rating plate		
Vibration emission value $a_{h,d}$	4.3 m/s^2	
Uncertainty K=	1,5 m/s^2	

Warning

The Vibration emission level given in this information sheet has been measured in accordance with a standardized 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 working period.

An estimation of 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 vibrations such as: maintain the tool and the accessories, keep the hands warm, organization of work patterns.

2.4 Symbols

	Caution! Warning! Danger!
	Always disconnect the plug from the socket before carrying out any instructions
	Please read the instructions carefully before starting the machine.
	Tool uses protective earth and must be plugged into grounded outlet

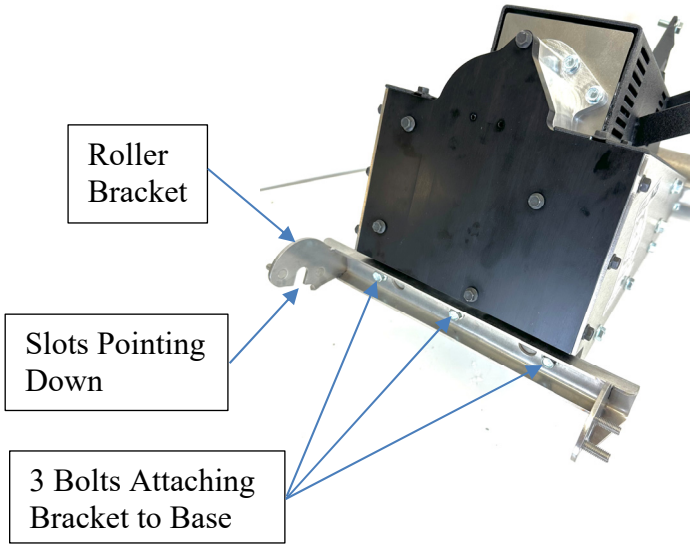
3. Description

The tool is moved along the slats on the bed of a plasma or oxy fuel cutting machine to remove slag that accumulates while cutting. Rotary cutting tools ride on each side of the slat to lift and remove the slag. It may be used on steel, copper or hybrid steel/copper slats. When not in use it may be rolled along the floor and can be stored in the upright position with the optional support stand. It may be operated while standing on the floor with handle near horizontal or by standing on the cutting table with handle angled up.

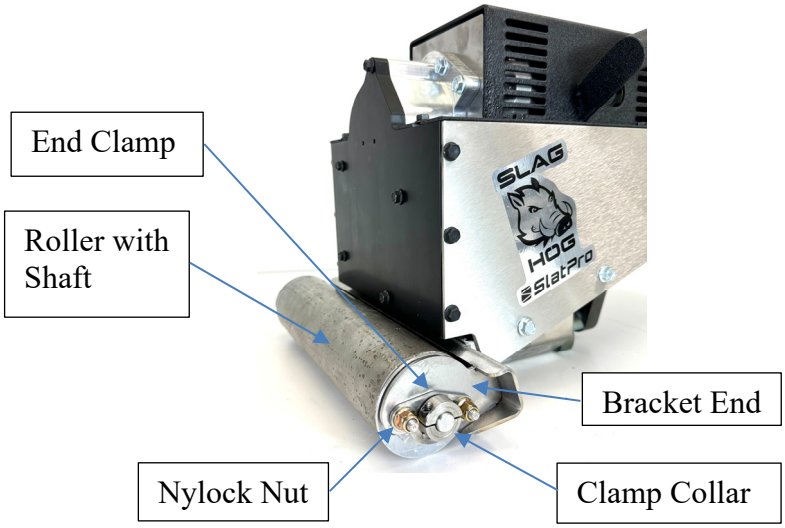
4. Initial Assembly

The Plasma Hog ships in three pieces; power unit, handle assembly and roller hardware. Most fasteners are metric.

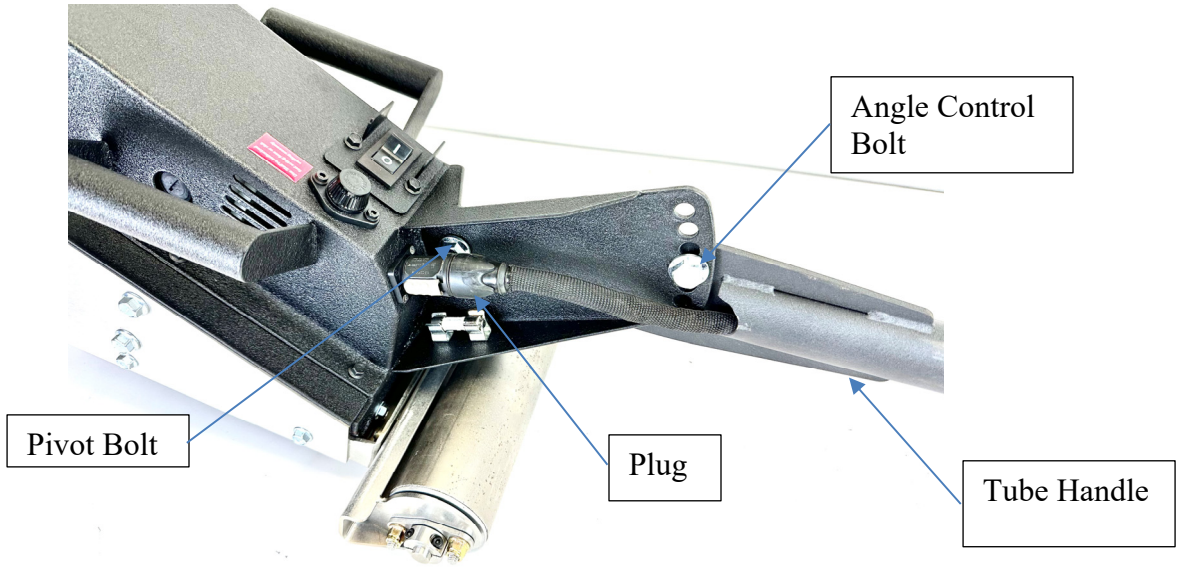
A. Attach Roller Brackets to each end of Base Weldment with three 6mm bolts each. Bracket End slots to point down as shown in below picture. Use Loctite 242 on threads.



B. Install Rollers with Shafts into slots in Bracket Ends. Slide End Clamps onto shaft and threaded rods on bracket. Thread on and tighten 6mm nylock nuts onto threaded rods. Center shaft and tighten screws in clamp collars with 7/64" hex wrench.



C. Attach Handle Tube



Remove the nuts and flanged bolts from the attachment face on the power unit.

- Place the handle tube mount face on the attachment face opposite side of plug receptacle. Insert Pivot Bolt with head on receptacle side. Insert the Angle Control Bolt in the location that sets Handle Tube to appropriate angle. Thread on nylock nuts and tighten.
- Plug the power cord from handle tube into the power unit receptacle.

⚠ WARNING

- Do not plug into power outlet before verifying the switches on the handle and power unit are off; both rocker switches to 0.

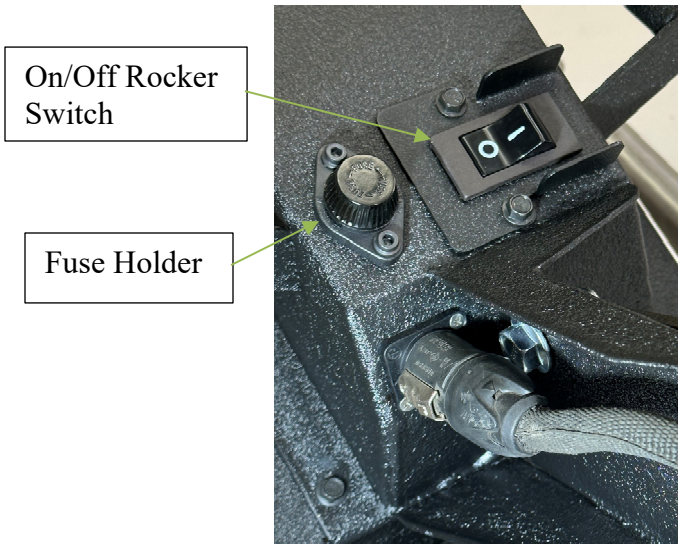
5. Operation

The tool must be plugged into a receptacle with a grounded outlet
Before plugging into power verify that the two switches on machine are turned off (0 position)
Wear work gloves and safety glasses when operating
Two people should lift unit onto the cutting machine bed with care

WARNING Use extreme care near the cutters. Do not touch them unless the tool is unplugged.

The tool has two on/off switches

Rocker switch on handle end, in off position.



Rocker Switch on motor enclosure in off position.

Both switches must be in ON or "I" position to run. Turning either switch OFF ("0" position) stops motor operation.

Should the unit have excessive loading, the motor may slow down and stall. This will cause the fuse to blow in the fuse holder (See Figure 2), and the unit will stop operating. Typical causes of stalling are excessive slag build-up, pushing the machine too hard, or slugs getting in the cutters.

The fuse is there to protect the machine from damage. The fast-acting fuse must be replaced with an identical one. **Bypassing the fuse or replacing with either a higher current or slow acting version will result in loss of warranty coverage.**

- To begin use, place the tool on the slat bed of the plasma or oxy fuel machine
- With switches off, plug tool into a power outlet with current capacity that meets or exceeds label on machine
- Center the cutters over a slat, lever the cutters up a little. Turn it on and lower the cutters onto the slat. Move the unit forward by pushing on the tee handle. **Do not push too hard.**
- Levering the unit up and down a little may help to keep moving forward without excessive force.
- When done cleaning a slat by moving forward, lever the cutters out, roll unit back to next slat and start cleaning.

Fuses are fast acting class cc:
120V machines use 20 amp KTK-R-20
230V machines use 10 amp KTK-R-10

Figure 3
Cutters shown centered on slat

Two versions are available:

- Standard machine has 10” Rollers for 3” to 4” slat spacing
- Wide version has 14” Rollers for slat spacing up to 6”

When storing in upright position the unit is unstable and care must be taken to ensure that it does not fall over, which may lead to damage of handle end components. Damage due to dropping, improper handling, or falling over is not covered by warranty. An optional stand is available to securely store unit.

6. Maintenance

Only use SlatPro replacement parts when performing repairs or maintenance with work performed by qualified personnel.

WARNING Disconnect power by unplugging from outlet before performing any work on the tool

6.1 If the **Supply Cord** is damaged it must be replaced.

6.2 Motor Ventilation Slots must be kept clear or over-heating may result

6.3 Motor Brush Replacement

If the tool has less torque while in use, it is likely that the brushes need replacement.

- Parts Required: **Qty 1 of 67265 SET Brush Kit**
- There are access holes to brushes on sides of Motor Enclosure
- Unthread and remove Brush Caps from motor
- Remove old brushes, install new, and thread caps back in place

6.4 Cutter Replacement

The cutters will wear over time and require replacement.

Tools required for replacement

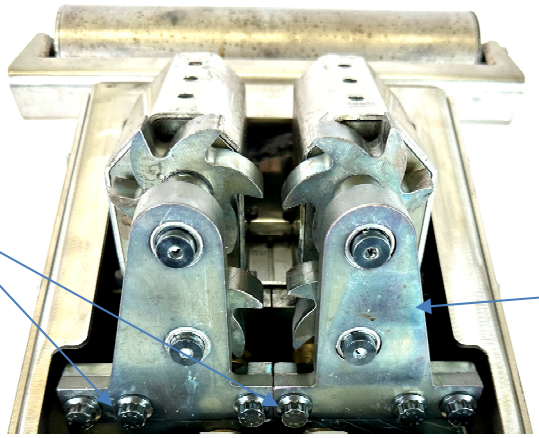
- 10mm 12 point ratcheting box wrench

Replacement Cutters

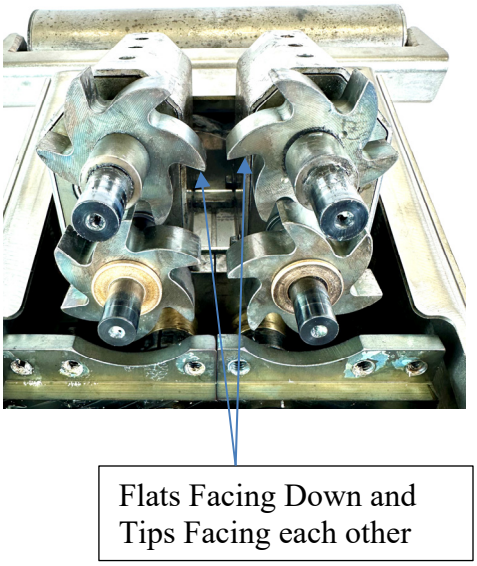
- 67152-0.19 – 3/16” Slats
- 67152-0.25 – 1/4” Slats
- 67152-0.38 – 3/8” Slats

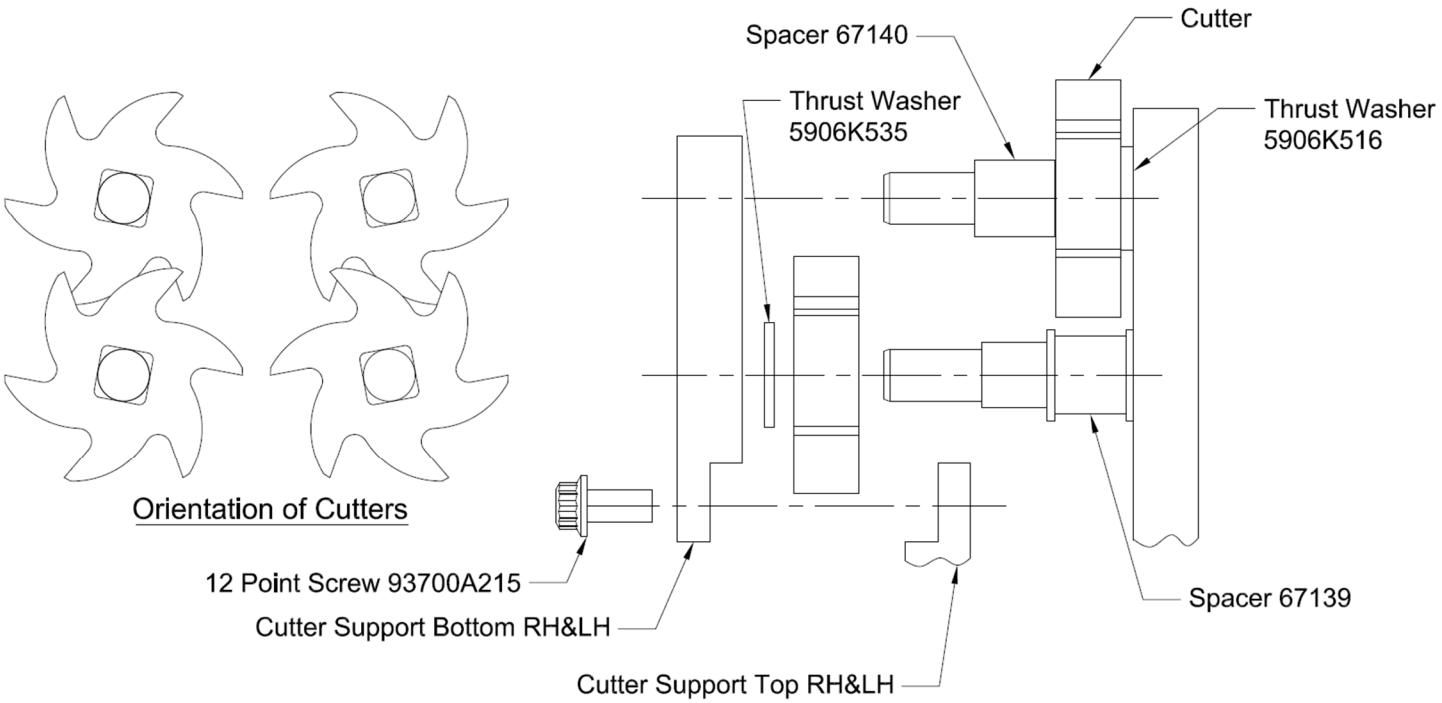
Cutters come in sets of four.

A. Turn switches off and unplug from power. Place unit on its back with cutters up.
B. Remove six M8 x 16 12 point screws with 10mm 12 point ratcheting box wrench
C. Slide two Cutter Support Plates from four cutter shafts



D. Remove four worn cutters and spacers as necessary. Replace with new cutters and existing spacers located properly.
E. Cutters positioned as shown below with flats facing down in center and tips opposite.
F. Apply Loctite 242 to six 12 point screw threads, insert and tighten.





Above drawing shown with unit upside down

6.5 Cutter Wear and When to Replace

Even though cutters are made from hardened tool steel they do wear and will need to be replaced. When slag removal gets worse it may be time to replace cutters. The best way to determine if they are worn is to measure the Cutter diameter.

Cutter Part Number	Slat Thickness	Cutter Dia New	Cutter Dia Worn
67152-0.19	3/16" or 7 ga	2.287	2.187
67152-0.25	1/4" or 6mm	2.216	2.125
67152-0.38	3/8"	2.091	2

Max Cutter Diameter for Replacement

6.6 Other maintenance

All other repairs require qualified personnel to perform. In this case, the factory or distributor should be contacted for further instructions.

9. Warranty

The Slaghog product warranty, issued by Slatpro LLC, guarantees that all products are free from material and workmanship defects for 12 months from the shipping date, provided they are used under normal conditions. This limited warranty is non-transferable and applies solely to the original purchaser of new products bought directly from Slatpro or authorized distributors. If a defect is identified, Slatpro may choose to repair, replace, or refund the purchase price of the product, with the buyer's sole remedy limited to these options. Notably, the warranty excludes coverage for issues arising from misuse, inadequate maintenance, unauthorized modifications, and normal wear and tear, including consumables such as cutters.

EC Declaration of Conformity

Object of the Declaration

Product	Slaghog Tool used for removing slag from plasma machine slats
Model/Type	67290- Slaghog for Plasma
Manufacturer	Slatpro
Address	4757 Mustang Circle, Mounds View, MN 55112, U.S.A.

This Declaration is issued under the sole responsibility of the manufacturer

The object of the declaration described above is in conformity of the relevant union harmonization legislation

2011/65/EU
2006/42/EC
2014/30/EU

Conformity is shown by compliance with the applicable requirements of the following documents:

Reference & Date:
EN 60745-1:2009 + A11:2010
EN 55014-1:2017/A11:2020
EN 55014-2:1997/A1:2001,A2:2008
EN 61000-3-2:2014
EN 61000-3-3:2013
EN 50581:2012

Signed for on Behalf of	Slatpro LLC
Place of issue:	Mounds View, MN, USA
Date of Issue	22nd Auguust 2024
Name:	Eric Chalmers
Position:	President of Slatpro LLC
Signature:	

CE