

# Operating instructions

**SuperCleanox IV+**

**EP-01-021**

**SuperCleanox VI**

**EP-01-017**

**SuperCleanox VI HD**

**EP-01-017-HD**

**Electrochemical cleaning, polishing, marking**



<p>2017-01-16 Rev.0</p>	<p>REUTER GmbH &amp; Co. KG Schimmelbuschstr. 9e 40699 Erkrath, Germany Tel.: +49(0)211-73060-430 Fax: +49(0)211-73060-477 mail@oreuter.de</p>
<p style="text-align: center;"><a href="http://www.oreuter.de">www.oreuter.de</a> <span style="float: right;">CE</span></p>	

## Table of contents

1	Introduction.....	5
1.1	Validity of these operating instructions.....	5
1.2	Target group for these operating instructions.....	5
1.3	Compliance with the operating instructions.....	5
1.4	EC and VDE (Verband Deutscher Elektrotechniker – German Electrotechnology Federation) directives.....	6
1.5	Accident prevention (UVV (Unfallverhütungsvorschriften - accident prevention regulations)).....	6
2	For your safety.....	7
2.1	Convention.....	7
2.1.1	Pictograms.....	7
2.1.2	Presentation.....	7
2.1.3	Warning signs.....	8
2.1.4	Prohibition signs.....	8
2.1.5	Mandatory signs.....	8
2.1.6	Information signs.....	8
2.2	Safety measures in the event of failure.....	9
2.2.1	Safety-relevant environmental conditions.....	9
2.3	Potential sources of danger and protective measures.....	10
2.3.1	Potential sources of danger.....	10
2.3.2	Before starting work, check.....	12
2.4	Potential misuses.....	12
2.5	Residual risks.....	12
3	Demands on personnel and operators.....	13
3.1	Users.....	13
3.2	Operator.....	13
4	Warranty and liability.....	13
4.1	Material defects.....	14
5	Technical terms.....	14
6	Delivery, in-house transport, unpacking.....	15
6.1	Delivery.....	15
6.2	Unloading.....	16
6.3	In-house transport.....	16
6.4	Unpacking.....	16
6.4.1	Opening the Euro plastic box.....	16
7	Scope of delivery of the "SuperCleanox" appliance set.....	17
7.1	Delivery list "SuperCleanox" appliance set.....	17
8	Storage requirements.....	20
9	Installation conditions.....	20
9.1	Safety.....	20
10	Decommissioning / storage.....	20
11	Storage.....	20
12	Appliance technology.....	21
12.1	SuperCleanox VI HD.....	21
12.2	SuperCleanox VI.....	21
12.3	SuperCleanox IV+.....	21
12.4	Applications.....	22
13	Controls and operating elements on the front panel.....	23
13.1	Performance level selector switch.....	23
13.1.1	SuperCleanox VI HD.....	24
13.1.2	SuperCleanox VI.....	24
13.1.3	SuperCleanox IV+.....	24
13.2	Automatic circuit breaker (overload FUSE).....	25
13.3	High-current combo jacks.....	25
13.4	Elements on the back panel.....	26

14	Accessories.....	26
14.1	Teflon handle with cable and plug.....	26
14.2	Earth clip with cable and plug.....	27
14.3	Carbon fibre brush XL.....	27
14.4	Assembly carbon fibre brush XL / Teflon handle.....	28
14.4.1	Adjusting the Teflon sliding sheath.....	28
14.5	Cables and plugs.....	29
14.5.1	1.5mm <sup>2</sup> cables with 4mm safety plugs.....	29
14.6	Marking stamp.....	29
14.7	Cleaningstamp.....	29
14.8	Carbon electrode.....	30
14.8.1	90° for marking/labelling.....	30
14.8.2	60° for cleaning and polishing.....	30
14.9	Surface cleaner (optional for SuperCleanox VI HD).....	30
14.10	Felts.....	31
14.10.1	White.....	31
14.10.2	Yellow.....	31
14.11	Electrolyte.....	32
14.11.1	Fill into wide-mouth containers.....	32
14.11.2	Information concerning non-toxicity.....	33
14.11.3	Information concerning the scope of delivery.....	33
14.12	Templates.....	33
15	Initial operation.....	34
15.1	Connection.....	34
15.1.1	Mains connection.....	34
15.1.2	Connecting the Teflon handle with carbon fibre brush.....	34
15.2	Connect and lock the high-current plugs.....	35
15.3	Release high-current plug and remove.....	35
15.4	Connecting the marking / cleaning stamp.....	35
15.4.1	Changing the marking felt.....	36
16	Working with the "SuperCleanox".....	37
16.1	Cleaning / polishing with the carbon fibre brush.....	37
16.1.1	Preparation.....	37
16.2	Workflow, cleaning with carbon fibre brush.....	38
16.2.1	Workflow, strong cleaning with carbon fibre brush.....	40
16.3	Workflow, polishing with carbon fibre brush.....	41
16.3.1	Workflow, strong polishing with carbon fibre brush.....	42
16.4	Cleaning / polishing with carbon electrode.....	44
16.4.1	Preparation.....	44
16.4.2	Workflow, cleaning with carbon electrode.....	44
16.5	Workflow, polishing with carbon electrode.....	46
16.6	Tips for cleaning with carbon fibre brush / carbon electrode.....	47
16.7	Tips for polishing with carbon fibre brush / carbon electrode.....	48
16.8	Marking/Labelling.....	49
16.8.1	Preparation.....	49
16.8.2	Workflow dark marking.....	50
16.8.3	Workflow, light marking.....	52
16.9	Tips for optimal marking / labelling.....	53
17	Possible faults and their remedies.....	54
18	Technical Data.....	55
19	Clean container, handles and workplace.....	55
20	Maintenance.....	56
20.1	Inspection and maintenance schedule.....	56
21	Disposal.....	57
21.1	Disposal of contaminated electrolytes.....	57
21.2	Disposal of electronic waste.....	57

22	Ordering spare and wear parts .....	57
23	Optional accessories .....	58
23.1	Teflon sliding sheath .....	58
23.2	Assembly .....	58
23.3	2 and 4-fold brush .....	58
23.4	Extension .....	59
23.5	Knee piece .....	59
23.6	Adapter brush .....	60
23.7	Surface cleaner .....	60
23.8	Printer .....	61
24	EC - Declaration of Conformity .....	62

## 1 Introduction

Thank you for choosing an electrochemical high-current brush weld cleaner from the "SuperCleanox series" made by REUTER GmbH & Co. KG.

The purpose of this manual is to provide you with information concerning the safe handling and operation of the "SuperCleanox" as well as general information for cleaning, polishing and marking.

The user is given information concerning basic concepts and applications, as well as practical advice and help in the selection of settings, so that operating errors can be avoided.

Your specialist dealer will be happy to support and advise you with regard to commissioning, applications or problems.

Our telephone hotline is always available with expert advice at +49 (0) 171-5450200.

Please read through these operating instructions carefully before commissioning.

We hope you enjoy working with our appliances and wish you every success.

### 1.1 Validity of these operating instructions

These operating instructions apply to the following appliances:

- SuperCleanox IV+            EP-01-021
- SuperCleanox VI            EP-01-017
- SuperCleanox VI HD        EP-01-017-HD

Type-specific differences are identified and described accordingly.

### 1.2 Target group for these operating instructions

These operating instructions are intended for those operating and using the "SuperCleanox".

Familiarise yourself thoroughly with these instructions before using the "SuperCleanox". You will achieve better results and work safely.

If you have any difficulties or questions please contact our Customer Service, who will be happy to assist you.

We reserve the right to make technical changes that help to improve our electrochemical processing appliances.

### 1.3 Compliance with the operating instructions

These operating instructions are a constituent of the "SuperCleanox" and can be downloaded from our website under the "Download" menu. Alternatively, you can scan the QR code on the Quick Start Guide with your smartphone and receive the operating instructions as a PDF document.

These operating instructions must be available to the operating personnel at all times. These operating instructions must be read by the operating personnel before commissioning the "SuperCleanox VI".

The operating personnel must have understood the content of the operating instructions before commissioning the "SuperCleanox".

If the "SuperCleanox" is passed on or resold, all operating instructions belonging to the appliance as well as any relevant documentation must be given to the new owner.

## 1.4 EC and VDE (*Verband Deutscher Elektrotechniker – German Electrotechnology Federation*) directives

Our electrochemical high current brush-weld cleaner, "SuperCleanox", has been EMC-tested and certified at the accredited laboratory of the International Approval Center of Mitsubishi Electric in Dusseldorf.

We would be happy to send you a copy of the EMC investigation reports.

This electrochemical processing appliance complies with the certificate of conformity "CE":



- EC directive 2004/108/EC (EMC directive)
- EC Directive 2006/95/EC (Low Voltage Directive)

This electro chemical processing appliance was made in accordance with:

- EN 61558-1 (VDE 0570)

## 1.5 Accident prevention (UVV (*Unfallverhütungsvorschriften* - accident prevention regulations))

- **Dangers may be caused by:**
  - Electrical currents,
  - Pollutants,
  - Gases,
  - Electrolytes,
- Read our safety data sheets concerning the electrolytes used by us.
- Observe the danger warnings.
- Note the following UVV regulations and information:
  - DGUV 1 (*Deutsche Gesetzliche Unfallversicherung* - German Social Accident Insurance) Principles of prevention
  - DGUV 3 Electrical systems and equipment
  - DGUV 4 Electrical systems and equipment
  - DGUV 6 Occupational health care
  - DGUV 9 Health and safety signs at work
  - DGUV 209-073 Workplace ventilation decision support for operational practice
  - DGUV 204-007 First aid handbook
  - DGUV 204-022 First aid at work
  - DGUV 251-003 Contemporary occupational safety
  - SDB's Safety data sheets

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### Note

As of 01/05/2014, all UVV rules and regulations have been renumbered and renamed.

Abbreviations such as BGV / GUV-V, BGR / GUV-R, BGI / GUV-I / BGG / GUV-G or GUV-SI are no longer used.

The publications are consistently divided into three categories:

- DGUV Regulations
- DGUV Rules
- DGUV Information

For detailed information see [www.dguv.de](http://www.dguv.de), for example.

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## 2 For your safety

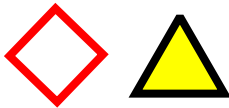
Read the operating instructions carefully. In the following chapter, the pictograms used in these operating instructions are explained.

### 2.1 Convention

#### 2.1.1 Pictograms

The pictograms used in these operating instructions have the following meanings:

##### Warning signs



- Indicate possible hazards in the handling of the appliance and accessories.
- Warning signs are identified by a yellow triangle with a black border, or white square with a red border and a symbol at the centre, which indicates a specific hazard situation.

##### Prohibition signs



- Indicate possible prohibitions in the handling of the appliance and accessories
- Warning signs are identified by a white circular area with a red border and a symbol at the centre, which indicates a specific prohibition.

##### Mandatory signs



- Indicate mandatory use of protective equipment.
- Mandatory signs are identified by a blue circular area with a thin black border and a symbol at the centre, which indicates a specific requirement e.g.: wearing protective clothing

##### Information signs



- Indicate sections of these operating instructions which demand special attention.

#### 2.1.2 Presentation

All normal descriptions in these operating instructions are written in the standard font size "Arial 10".

- Safety precautions which must be particularly observed are presented as shown in the following example:

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##### Safety information

The relevant text is written here.....

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- Tips that facilitate working with or handling the appliance or accessories are presented as shown in the following example:








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##### Tip


The relevant text is written here.....

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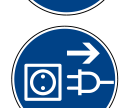

### 2.1.3 Warning signs

-  Warning of electromagnetic field
-  Warning of hot surface
-  Warning of explosive substances
-  Warning of harmful substances
-  Warning of dangerous electrical voltage
-  Warning of danger to life and limb
-  "Caution" warning of caustic chemicals



### 2.1.4 Prohibition signs

-  Prohibition for persons with cardiac pacemakers

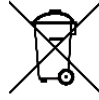
### 2.1.5 Mandatory signs

-  Use eye protection
-  Use protective gloves
-  Disconnect power supply before opening
-  Use protective clothing

### 2.1.6 Information signs

-  Information concerning general sources of danger. Read this section carefully!
-  Information concerning tips or important information about working with the "SuperCleanox" and accessories. Read this section carefully!





Disposal of old electrical and electronic equipment (applicable in the European Union and other European countries with separate collection systems).

This symbol on the product or packaging indicates that this product may not be treated as household waste.

This product must be disposed of properly.

## 2.2 Safety measures in the event of failure



Turn off the "SuperCleanox" immediately and pull out the mains plug.



Secure and mark the "SuperCleanox" to ensure that it is not switched on again.

- After any repairs, ensure that the "SuperCleanox" is fully functional.
- Inspect cables for damage.
- Check the functioning of all safety devices.



If you get electrolyte fluid in your eyes, rinse your eyes immediately with plenty of water.



- See an eye specialist immediately.




Secure hot workpieces against unauthorized access.

### 2.2.1 Safety-relevant environmental conditions



- **The use of the "SuperCleanox" is:**
  - restricted to closed industrial and commercial areas.
  -  expressly prohibited in fire endangered and potentially explosive environments.
  - expressly prohibited in humid environments.
- Cover stone and concrete floors well.
  - Acids react with alkaline floor coverings such as:
    - granite
    - marble
    - lime sandstone
    - stoneware
    - tiles
    - screed
- Wash electrolyte splashes or stains off immediately with plenty of water and / or Neutralyt.
- **The "SuperCleanox" may:**
  - only be operated in well ventilated area.
-  Chlorinated solvents must be removed from the work area.

-  When operating the "SuperCleanox", harmful vapours can be caused through chemical reactions.
  - For details, please refer to our MSDS's (Material Safety Data Sheets) for the respective electrolytes.




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**Safety information**


The operator is obliged to ensure adequate ventilation of the work area. The operator must ensure that the corresponding vapours are removed from the work area with a suitable extraction system .

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**2.3 Potential sources of danger and protective measures**

**2.3.1 Potential sources of danger**

 Improper use of "SuperCleanox" and its components.  
Placing the cleaning electrode or handle on the workpiece or work surface in such a way that the electrode or the felt / carbon fibre brush is in contact with the metal surface. In this case, current is still flowing.


 Incorrect connection of the components can lead to stray currents destroying the electrical protective conductor.


- Defective live cables.
- Damaged or defective switching elements.
- Defective connectors.
- Non-existent or damaged Teflon insulation.





Incorrect work environment.

 Not using protective clothing.

 The carbon fibre brush or the electrode as well as the workpiece can reach a temperature of approx. 200°C.

 Improper handling of chemicals

- Electrolyte splashes may cause eye burns.
- Spilled electrolyte fluid can cause stains on stone floors or other surfaces.

  Electromagnetic fields can affect cardiac pacemakers.

**Protection measures**



Repairs to electrical parts of the "SuperCleanox" or electric cables may only be carried out by qualified electricians.

- Let a qualified electrician check the "SuperCleanox" immediately after a short circuit or malfunction.
- Only use the "SuperCleanox" and accessories as intended.
- Only operate the "SuperCleanox" in the defined work area.



Avoid stray currents.

- Connect the earth wire directly to the workpiece or to the retainer intended for the workpiece.
- Lay the cleaning electrode or handle down on the workpiece or work surface in such a way that the electrode or the felt / carbon fibre brush has no contact with the metal surface. Otherwise current will continue to flow, which can cause damage or even danger.



In the event of an accident, immediately disconnect the "SuperCleanox" from the mains. Always pull out the plug when carrying out maintenance work.



Only operate the "SuperCleanox" wearing appropriate, personal, acid-proof protective equipment [protective gloves, apron and goggles].



Always switch the "SuperCleanox" off before changing the processing tools (brushes, felts...).



Secure hot objects against unintentional contact.



Never eat or drink at your workplace! It is prohibited!



After working with electrolytes, always wash your hands thoroughly with soap and water.

- Wash spilled electrolyte fluid off immediately with plenty of water.



Please observe the detailed instructions in our EC safety data sheet for these electrolytes.

- Store the "SuperCleanox", accessories or chemicals out of reach of children.



Persons with cardiac pacemakers may:

- not work with the "SuperCleanox"
- not stay in the immediate vicinity of the "SuperCleanox"!

### 2.3.2 Before starting work, check



- All current-carrying cables and wires for damage to the insulation.
- All electrified wires and cables for breaks and kinking of the strands inside the insulation.
- All plugs and connectors for damage such as loose solder joints.
- All switches for damage, e.g. chipped housing parts.
- The workpiece clamp for any external damage.
- Whether all Teflon insulations are present and undamaged.
- Please make sure that you do not pull or route any electrical cables across sharp edges.
- Your workplace must be freely accessible
- Make sure there are no tripping hazards.

### 2.4 Potential misuses



- The connection to an incorrect mains voltage can lead to the destruction of the "SuperCleanox".
- The connection of external components that are not approved by Reuter GmbH, can:
  - lead to the destruction of the "SuperCleanox",
  - put people at risk.
- The use of chemicals that are not approved by Reuter GmbH, can:
  - lead to health problems,
  - adversely affect the work results.
- Use of unsuitable electrolytes for a particular application.  
Example: The use of cleaning electrolytes for marking/ labelling
  - can result in staining or illegible marking / labelling.
- Carryover of marking electrolyte into the cleaning electrolyte
  - causes dull places or blacking on the workpiece surface.

### 2.5 Residual risks

Potential risk	Effect	Remedy
Electrolytes get into the hands of children or people who are inexperienced in dealing with chemicals	Depending on misuse - Skin burns - Burns on clothing - Burns on other objects - Severe internal injuries if the chemicals are swallowed	Store electrolytes and other chemicals so that they are only accessible to authorized persons.
Appliance is used by unauthorized persons (curiosity, play)	- Burning of skin if the electrode or the workpiece gets too hot - Inhalation of fumes with corresponding health damage	Ensure that the appliance can only be operated by authorized persons. Secure the appliance after use to prevent improper use.

Table 1 Residual risks

### 3 Demands on personnel and operators

#### 3.1 Users



- The following knowledge is required:
  - Instruction on operating the "SuperCleanox".
  - Instruction on handling the components.
  - Safety instruction concerning the dangers associated with handling electrical appliances.
  - Safety instruction concerning the dangers associated with handling chemicals.
- The following activities may be carried out:
  - Operating the "SuperCleanox".
  - Selecting and using electrolytes for relevant applications
  - Changing marking tools and wear parts
  - Switching the "SuperCleanox" on and off.
  - Easy troubleshooting after instruction has been given

This knowledge can be conveyed by either REUTER GmbH & Co. KG or other authorized persons or institutions.

#### 3.2 Operator



- The operator must instruct staff regularly in accordance with legal requirements.
- Untrained personnel or unauthorized persons may not use the "SuperCleanox".

### 4 Warranty and liability

Warranty and liability claims for injury and damage to property are excluded if they result from one or more of the following causes.



- **Improper use**
  - of the "SuperCleanox"
  - of components belonging to the "SuperCleanox".
  - of chemicals related to the electrochemical processing appliance.
  - Use of unsuitable chemicals.
- **Failure to comply with the**
  - work and safety instructions.
  - Operating instructions for the "SuperCleanox" and the components.
- **Improper**
  - commissioning of the "SuperCleanox"
  - commissioning of the "SuperCleanox" with improperly installed protective devices.
  - operation of the "SuperCleanox"
  - maintenance of the "SuperCleanox"
  - execution of repairs to the "SuperCleanox VI".
  - repairs carried out by unqualified personnel.
- **Use**
  - of the "SuperCleanox" in private homes and offices.
  - of the "SuperCleanox" in fire endangered and potentially explosive environments.
  - of the "SuperCleanox" in damp environments.
  - Unauthorised modifications to the "SuperCleanox"
- **Failure to comply with**
  - the specified maintenance intervals



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**Note**

No claims whatsoever can be made against REUTER GmbH & Co. KG for damage and malfunctioning that arises from operating the "SuperCleanox" with components and chemicals from other manufacturers.

Unless there is expert proof that the damage was clearly caused by negligent construction or manufacture by REUTER GmbH & Co. KG, and that this was foreseeable at the time of construction.

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## 4.1 Material defects



- The purchaser must inform the supplier of defects without undue delay, within 14 days, in writing.
- If no limitation period for claims has been agreed upon by the supplier and the consumer, the statutory provisions apply.
- When submitting a material defects claim, please include a certificate which shows clearly that the limitation period has not been exceeded.

## 5 Technical terms

### Distilled water

Distilled water contains no minerals and is therefore very "soft". It is obtained by distillation.

### Demineralised water

Demineralised water is obtained by filtration. It contains hardly any minerals and is therefore also very "soft".

### Electrolyte

Electrolytes are electrically conductive chemicals that are used in various compositions and concentrations for cleaning, polishing and marking.

- MARKING electrolyte is used for labelling.
- Cleaning electrolyte (Cleaner, Super Cleaner, Polisher) is used for cleaning and polishing.

### Felts

Felts are absorbent fabrics that are soaked with electrolyte and used for:

- Marking
- Cleaning
- Polishing

### Carbon electrode

Carbon electrodes have a rigid carbon body which serves to secure the marking and cleaning felts and transmit electricity.

### Carbon fibre brush

Carbon fibre brushes have up to 1.5 million individual carbon fibres. During the cleaning process the current is distributed over the individual fibres.

A small arc is formed on every fibre which comes into contact with the workpiece surface (~ 3 - 7 µm in size).

**Passivation**

Inactivation of oxidation processes on the workpiece surface through chemical treatment.

**Marking/Labeling**

Is a targeted oxidation process in the metal surface

- No superficial application of colour particles.
- Permanent and forgery-proof!

By means of a marking electrolyte and electrical current, information is transferred permanently from a template onto the surface of the workpiece.

- All electrically conductive metal surfaces can be labelled using the appropriate electrolyte.

**Marking templates**

Contain the information that is transferred by means of the marking tool, marking electrolyte and electrical current onto the surface of the workpiece.

**Marking stamp**

The combination of carbon electrode handle and the marking felt attached to it.

**Water hardness**

The mineral content of the water determines the degree of hardness.

The higher the concentration of certain minerals in the water, the higher the degree of hardness.

The hardness grade is measured in "degrees of German hardness" [° dH, deutscher Härte].

**6 Delivery, in-house transport, unpacking**



The complete appliance set is delivered in a sturdy Euro plastic box. This box is secured with a lead seal in our factory before shipment. The lid can only be opened by destroying and removing the lead seal. In addition, the lid latches are secured on both sides with cable ties to prevent accidental opening.



**Safety information**

All necessary activities concerning delivery, transportation and storage must be strictly carried out with the utmost care and comply with all safety rules and regulations.

Non-compliance with the safety rules and regulations can lead to serious cuts, bruising and fractures.

**6.1 Delivery**

- The appliance set is delivered by a carrier or parcel service in orange Euro plastic boxes on pallets.

## 6.2 Unloading



- Only use lifting equipment and a means of transport that is approved for the corresponding load to unload the equipment supplied.
- All lifting equipment and accessories must be suitable for the intended purpose and comply with current safety standards.

## 6.3 In-house transport



- For in-house transportation, you must use lifting equipment and a means of transport that is suitable for the intended purpose and complies with current safety standards.

## 6.4 Unpacking



- Remove the protective film, if present.
- Remove the strapping with which the load is secured to the pallet.
- Cut through the strapping with wire cutters.
- Lift the Euro plastic box(es) carefully from the pallet.
- To do this, only use suitable lifting equipment with safe sling attachment aids.
- Open the Euro plastic box carefully.

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### Safety information

The strapping is under high mechanical tension. Do not stand in the "trajectory" of the two strapping parts. Never hold the strapping whilst cutting.

- This could result in cuts.
  - Wear appropriate protective clothing.
- 

### 6.4.1 Opening the Euro plastic box



- First cut through the lead seal with metal shears.
- Remove the lead seal carefully.
- Remove the cable ties on the right and left of the lid latches.
- Unlock the lid latches
- To do this, slide the lid latches to the left or the right.
- Open the transport box.
- Check the delivery against the delivery note for completeness.
- Report missing, damaged or undelivered goods immediately.

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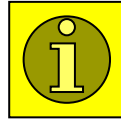
### Safety information

Cutting the lead seal with the metal shears can cause sharp edges. Wear gloves when removing the lead seal, to avoid cuts!

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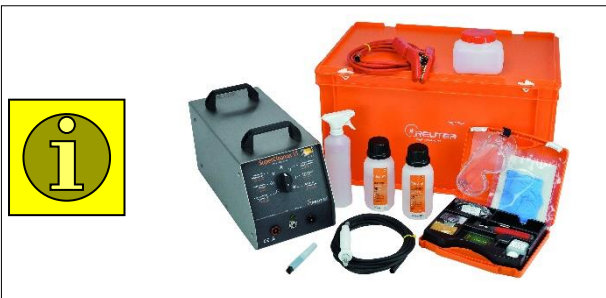
**Tip**

You can find the following information on and under the lid of the Euro plastic box:

- Safe handling of chemicals
- Information on the weight of the Euro plastic box including contents.
- Safety data sheets
- Brief instructions

**Please take note of this information!**





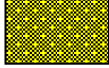
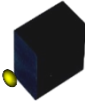
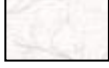



## 7 Scope of delivery of the "SuperCleanox" appliance set



- Check that the appliance set is complete when unpacking the delivery.
- Report missing or damaged parts immediately.

### 7.1 Delivery list "SuperCleanox" appliance set

Scope of delivery	VI HD EP-01-017 HD	VI EP-01-017	IV+ EP-01-21	Quantity	Order No.	Illustration
Power unit	✓	✓	✓	1		
Teflon handle with 4m cable 10mm <sup>2</sup>		✓	✓	1	<b>EP-07-600</b>	
Teflon handle with 10m cable 16mm <sup>2</sup>	✓			1	<b>EP-07-693</b>	
Earth cable 4m, 10mm <sup>2</sup> with 850A insulated cast clip		✓	✓	1	<b>EP-07-605</b>	

Earth cable 10m, 16mm <sup>2</sup> with 850A insulated cast clip	✓			1	EP-07-691	
Carbon fibre brush XL	✓	✓	✓	1	EP-02-912	
Marking handle' with 90° carbon electrode	✓		✓	1	EP-02-033	
Cleaning handle with 60° carbon electrode		✓		1	EP-02-018	
Cleaning and polishing felts made of Kevlar, yellow	✓	✓	✓	5		
90° carbon electrode for marking		✓		1	EP-03-001-1	
Marking felt, white	✓	✓	✓	5		
O-rings	✓	✓	✓	5		
Connection cable 1.5mm <sup>2</sup> marking handle	✓	✓	✓	1	EP-07-005	
Cleaner electrolyte	✓	✓	✓	0.5 kg		
POLISHER Electrolyte	✓	✓	✓	0.5 kg		
Marking electrolyte universal	✓	✓	✓	50ml		

Gloves	✓	✓	✓	1	EP-06-004-11	
Safety goggles	✓	✓	✓	1	EP-06-003	
Apron	✓	✓	✓	1	EP-06-005	
Euro plastic box 600x400x320mm	✓	✓	✓	1	EP-07-019	
Wide-mouth container	✓	✓	✓	1x 500 ml	EP-07-100	
spray bottle for water	✓	✓	✓	1	EP-07-002	

Table 2 Delivery list "SuperCleanox"

## 8 Storage requirements

For safe and careful storage of the "SuperCleanox" and accessories, observe the following measures:

- Remove the plugs and cables from the appliance before you put it back into the Euro plastic box.
- Keep the appliance set in the closed transport box.
  - Protection against moisture and dust.
- Ambient temperature 5°C to 40°C.
- Do not store outdoors.
- Protect against exposure to acids and alkalis.
- Store only in the normal standing position.
- Do not expose to ionizing or non-ionizing radiation.
- The appliance set must not be exposed to vibration, shock or continuous shock.




---

### Safety information

Keep chemicals under lock and key!  
Keep out of reach of children!

---

## 9 Installation conditions

### 9.1 Safety

- The "SuperCleanox" and accessories may only be installed and operated in a location which fulfils the installation requirements.
- All electrical connections must comply with current safety regulations and standards.



## 10 Decommissioning / storage



- Switch off the appliance.
- Wash the carbon fibre brushes, the carbon electrode and handle thoroughly with water.
- Wipe the cable with a damp cloth.
- Clean the appliance and accessories thoroughly. Maintenance should be carried out by a qualified technician.
- Dry all items.
- Close the electrolyte container carefully so that no electrolyte can leak out. Pack the appliance and accessories into the transport box.
- Close the Euro plastic box and secure it with a cable tie against unintentional opening.



## 11 Storage

- Store the closed transport box in a dry and frost free place.
- Make sure that the closed transport box cannot fall into the hands of children or other unauthorised persons.

## 12 Appliance technology

### 12.1 SuperCleanox VI HD

- At 3,450VA, this is currently the most powerful weld cleaning appliance in the world!
- Three performance levels cover all your requirements:
  - from gentle cleaning of thin, TIG-welded metal sheets to polishing strongly tarnished or scaled MAG welds.
- The power electronics were matched to the high output.
  - Thermal fuses only switch off above 140A permanent current (100% duty cycle) or 400A pulse current.
- Brush and 16mm<sup>2</sup> earth cable
  - supply the power to the workpiece without electrical and thermal losses.
  - interruption-free under tough continuous use
  - up to 100 metre cable length can be used
  - 2-fold brush
  - 4-fold brush
  - Large surface cleaner
- Dark marking
- Light marking

### 12.2 SuperCleanox VI

The "SuperCleanox VI" is a compact electrochemical weld cleaning appliance. It was developed for commercial use in skilled trades and industry.

- Power output 2,500 VA
- up to 80A continuous current (100% duty cycle) or 200A pulse current.
- Three performance levels for both cleaning and polishing solve almost every cleaning problem:
  - from TIG-welded thin metal sheets
  - to MAG-welded beams, you can clean and polish all the different welds in heavy-duty industrial applications.
- Use of:
  - cleaning and polishing handles with rigid carbon electrode and felts.
  - 2-fold brush.
  - 4-fold brush.
  - Large surface cleaner (only under optimal conditions)
- Dark marking
- Light marking








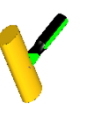




### 12.3 SuperCleanox IV+

The SuperCleanox IV+ has been designed for tough, permanent use in 3-shift industrial operations.

- Power output 1,500 VA
- 80A continuous current (100% duty cycle) or 140A pulse current
- two performance levels for cleaning and polishing.
  - This output power is completely sufficient for most cleaning tasks.
- Use of:
  - 2-fold brush.
  - Dark marking
  - Light marking
- Use of the following cleaning tools is limited:
  - 4-fold brush
  - Rigid carbon electrodes with felt

These electrochemical processing appliances work with low DC and AC voltages, which are not dangerous for humans.

## 12.4 Applications


Tools	Cleaning				Polishing				Cleaning	Polishing	Marking dark / light	
												
Super CleanoxVI HD Power output: 3,450VA	●	●	●	●	●	●	●	●	--	--	●	●
SuperCleanox VI Power output: 2,500VA	●	●	●	○	●	●	●	○	●	●	●	●
SuperCleanox IV+ Power output: 1.500VA	●	●	○	--	●	○	○	--	○	○	●	●

● fully operable    ○ conditionally operable    -- not operable

Table 3 Applications "SuperCleanox"

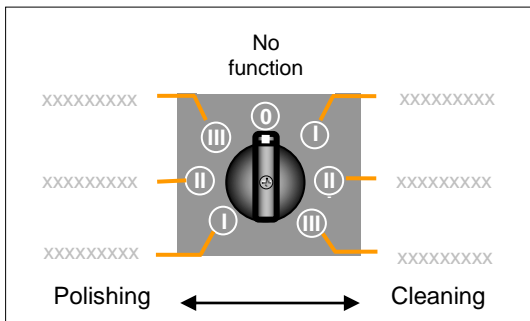
### 13 Controls and operating elements on the front panel

- The elements 1 - 5 are the same for all appliances in the SuperCleanox series.
- The selector for performance level selection "6" depends on the type.



- 1 Appliance main switch
  - ON / OFF
  - Lights up orange when switched on
- 2 Control lamp green
  - Ready for operation
  - Lights up when appliance main switch is in position I / II / III
- 3 Overload fuse
  - Overload protection
- 4 Black high-current combo jack
  - Appliance connection (e.g. Teflon handle / felt / surface cleaner)
- 5 Red high-current combo jack
  - Earth connection
- 6 Performance level selector
  - Polishing / cleaning

#### 13.1 Performance level selector switch



For cleaning, polishing and marking, there are several performance levels to choose from.

- The performance levels I... II... III for **cleaning** and **dark marking** are located to the right of the selector.
- The performance levels I... II... III for **polishing** and **light marking** are located to the left of the selector.



#### Safety information

Set the selector to level "0 -> No function" before turning on the appliance.



### 13.1.1 SuperCleanox VI HD



Please pay careful attention to the position of the selector.

- Selector position "I"
  - Soft cleaning - Soft polishing
- Selector position "II"
  - Cleaning with brush + Marking dark  
Polishing with brush + Marking light
- Selector position "III"
  - Strong cleaning / Strong polishing

### 13.1.2 SuperCleanox VI



Please pay careful attention to the position of the selector.

- Selector position "I"
  - Cleaning / polishing with brush + Marking light/dark
- Selector position "II"
  - Strong cleaning / Strong polishing with brush
- Selector position "III"



**Only with carbon electrode and felt!**



### 13.1.3 SuperCleanox IV+



Please pay careful attention to the position of the selector.

- Selector position "I"
  - Cleaning / polishing with brush + Marking light/dark
- Selector position "II"
  - Strong cleaning / Strong polishing



#### Safety information

**Never use performance level III if you are working with the carbon fibre brush!**

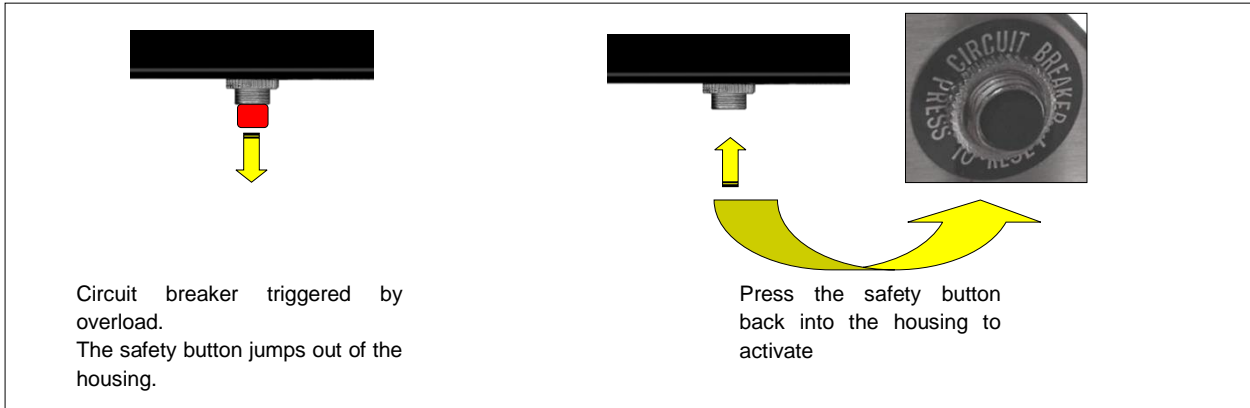


### 13.2 Automatic circuit breaker (overload FUSE)



The "SuperCleanox" is equipped with an automatic circuit breaker.

- In the event of overload or an electrical short circuit, the circuit breaker interrupts the circuit.



#### Safety information

Wait a moment until the circuit breaker has cooled down.

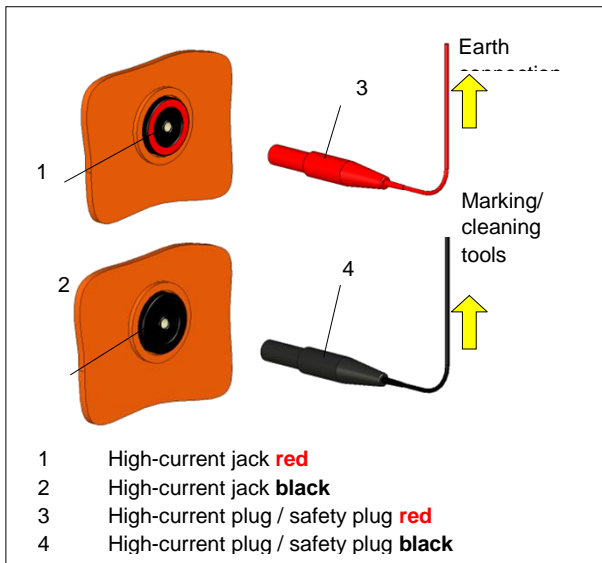
Before activating the circuit breaker button:

- The appliance **must** be switched off.
- The selector **must** be turned to position "0".
- There must be no contact between the brush and the workpiece or earth.

If the circuit breaker is triggered again:

- Check the way you are working!
- Dip the brush more often into the wide-mouth container
- --> Cool it!
- Do not press the brush too hard against the workpiece!

### 13.3 High-current combo jacks



The "SuperCleanox" is equipped with high-current combo jacks **red / black** for safely transmitting the cleaning current.

These accommodate:

- High-current plug **black** with 10/16mm<sup>2</sup> cable
  - only for cleaning and polishing with carbon fibre brush.
- 4mm safety plug **black** with 1.5mm<sup>2</sup> cable
  - only for marking, cleaning and polishing with felt.
- High-current plug **red** with 10/16mm<sup>2</sup> cable.
  - **only** to connect the earth clip.
- 4mm safety plug **red** with 1.5mm<sup>2</sup> cable.
  - **only** for connecting the earth clip for marking, cleaning and polishing with felt.



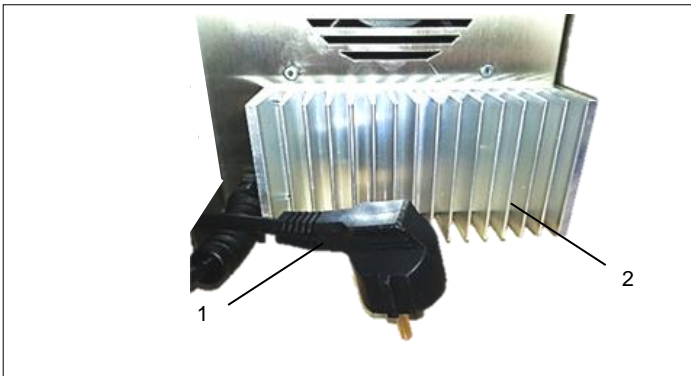
#### Note

The 10/16mm<sup>2</sup> high-current plugs lock and can only be released by gently pressing inwards.

The 1.5mm<sup>2</sup> safety plug does not lock.



### 13.4 Elements on the back panel

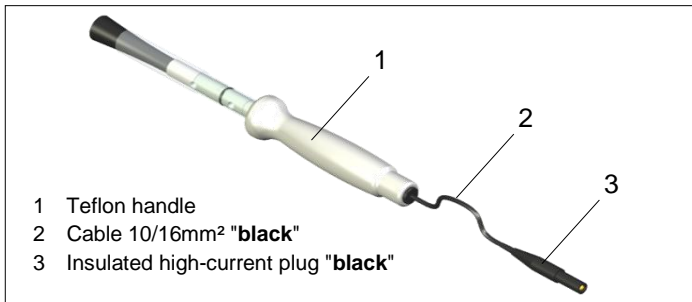


1) Power supply 230V / 16A

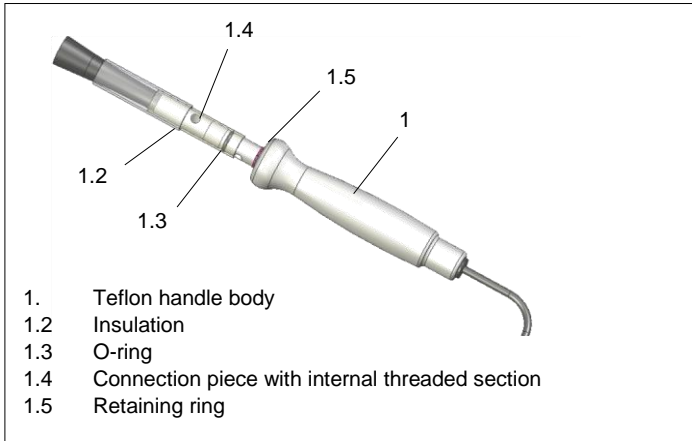
2) Cooling element

## 14 Accessories

### 14.1 Teflon handle with cable and plug



- The Teflon handle (1) is fixed to the **black** 10/16mm<sup>2</sup> cable (2) and the black high-current plug (3).
  - **Always** insert the **black** high-current plug (3) into the **black** high-current jack.
- Tool connections are always **black**.



The Teflon handle consists of the following components:

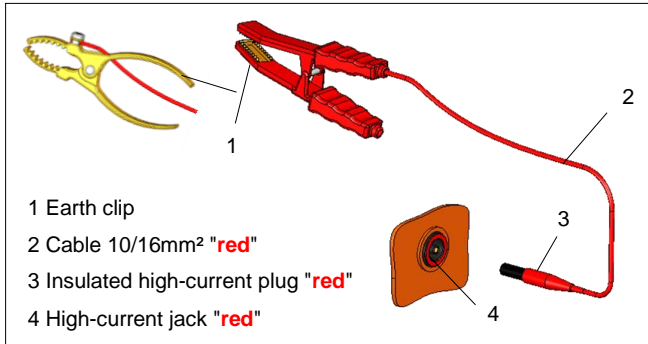
- Teflon handle body (1)
  - Electrical insulation
  - Thermal insulation
- Electrical insulation (1.2)
- O-ring( 1.3)
  - Prevents electrolyte passing into the interior of the brush.
- Connection piece with threaded section (1.4)
  - Brush fixture
  - Power transmission

## 14.2 Earth clip with cable and plug

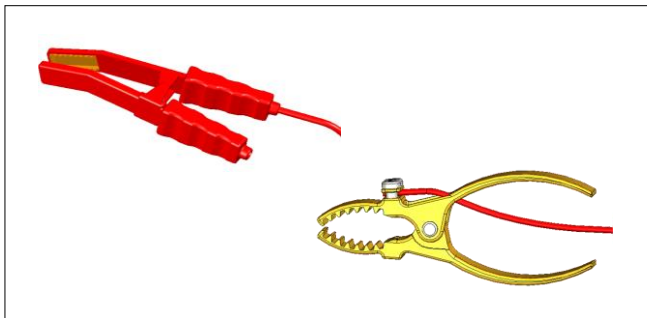


### Safety information

Earth connections are always "red".

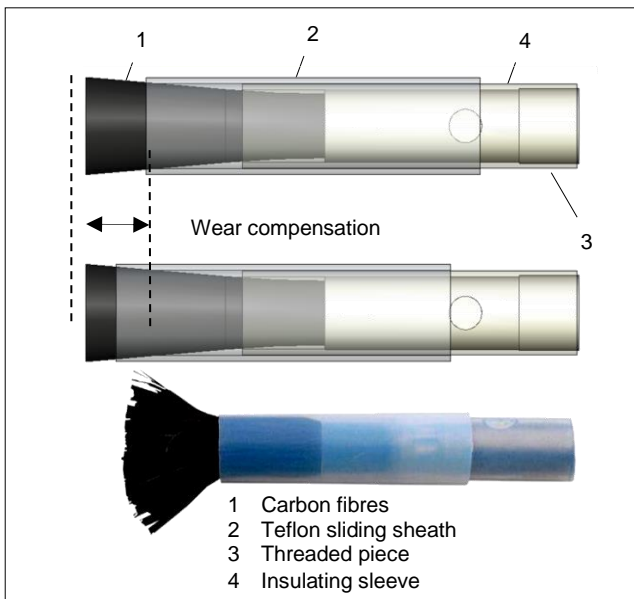


- The earth clip (1) is fixed to:
  - Red 10/16mm<sup>2</sup> cable (2)
  - Red high-current plug (3).
  - Always insert the red high-current plug (3) into the red combo jack (4).



- The earth clip (cast brass clip) establishes the electrical contact between the workpiece and the electrochemical cleaning appliance.
  - Very high currents flow during cleaning. Connect the earth clip directly to the workpiece to be cleaned, in order to avoid shunts.
  - Ensure bare metal contact points.

## 14.3 Carbon fibre brush XL



Use the carbon fibre brush supplied, type XL, for cleaning welds.

The carbon fibre brush comprises the following components:

- ≈ 1.5 million individual carbon fibres (1)
  - The light arcs, important for the cleaning process, form on the ends of these fibres
- Connection piece with internal thread (3)
  - Fixing the brush on Teflon handle and power transmission: Handle <--> carbon fibre
- Teflon sliding sheath
  - Wear compensation
  - The combustion of the carbon fibres is compensated for by sliding

See our accessories catalogue for a variety of special sheaths for different applications, available in addition to the carbon fibre brush supplied.

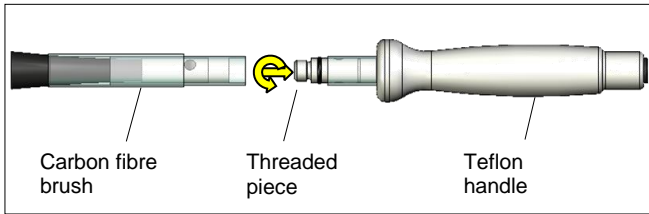


### Note

New brushes must first be worked in before they develop their full cleaning effect.

- You can speed up the burn-in process by working at level II on a piece of scrap sheet for a few seconds in advance.

## 14.4 Assembly carbon fibre brush XL / Teflon handle



Use the carbon fibre brush XL for cleaning welds.

- Screw the carbon fibre brush onto the white Teflon handle.
- Tighten the brush firmly.
- Note the tip for tightening and loosening the screw joint.



### Safety information:

Make sure that the carbon fibre brush is firmly attached.

A loose screw joint can burn and damage the thread.

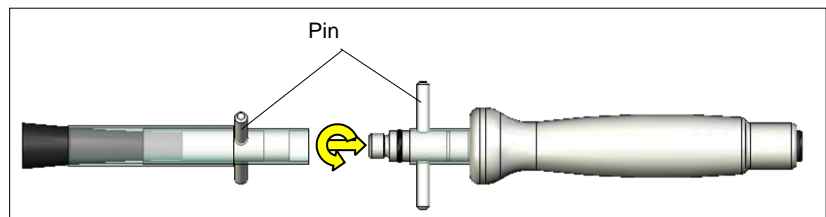
- The Teflon insulation must be present both on the handle and the brush, as the high currents could otherwise lead to shunts via the workpiece.

Green LED on the appliance lights up but no cleaning performance:

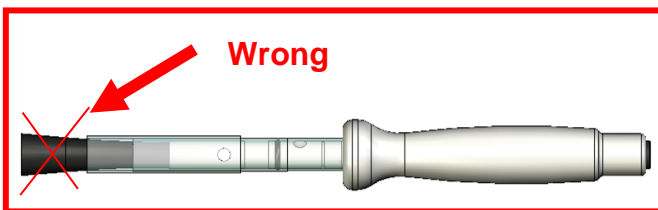
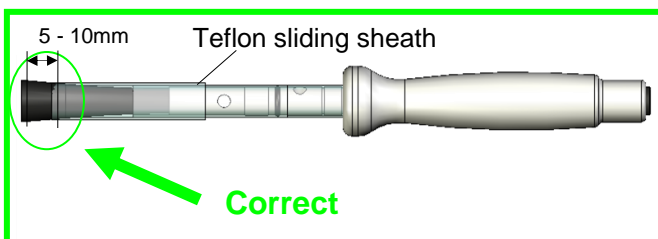
- No or only insufficient contact on the brush thread.
- Clean the thread
- Tighten the thread

### Tip for tightening and loosening tight screw joints:

- Insert the two pins supplied through the cross-holes in the lower part of the handle and the brush.
  - You can then apply greater force for tightening or loosening.



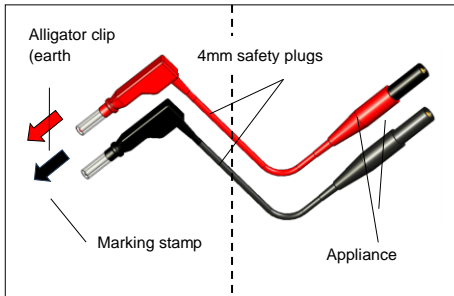
### 14.4.1 Adjusting the Teflon sliding sheath



- During the cleaning process, the carbon fibre tips of the carbon fibre brush wear out.
- By means of the Teflon sliding sheath, you compensate for the wear on the carbon fibres.
  - Adjust the Teflon sliding sheath on the carbon fibre brush so that the carbon fibre tips protrude by approx. 5-10mm.
  - The many small arcs between the carbon fibre ends and the workpiece can only form if this is correct!
  - This guarantees an optimum cleaning effect.

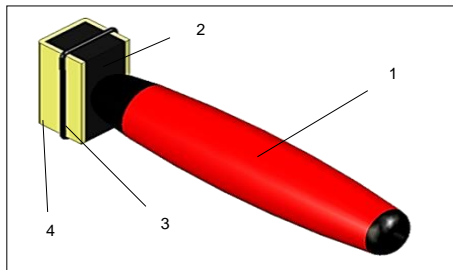
## 14.5 Cables and plugs

### 14.5.1 1.5mm<sup>2</sup> cables with 4mm safety plugs



- **Only** use the 1.5mm<sup>2</sup> cable for connecting marking stamps / cleaning stamps with felt!
  - The 4mm safety plugs are equipped with a transparent sliding sleeve.
  - The appliance plugs have a rigid insulating sleeve.
- Connections for marking stamp / cleaning stamps with felt are always **"black"**.
- Earth connections are always **"red"**.

## 14.6 Marking stamp



- For marking use:
  - red marking handle (1)
  - 90° carbon electrode (2)
  - white felt (4)

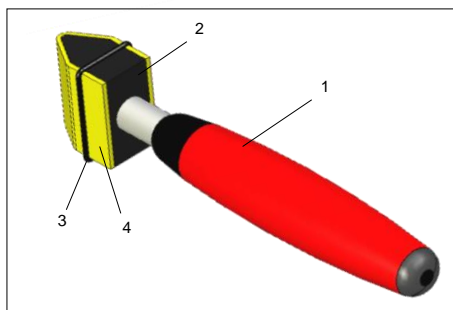
1	Marking handle
2	Carbon electrode
3	O-ring
4	Felt



### Note

From now on, the assembled combination of felt, carbon electrode, O-ring and handle will be referred to as **marking stamp**.

## 14.7 Cleaningstamp



- For cleaning use:
  - the red cleaning handle (1)
  - the 60° carbon electrode (1)
  - the yellow felt (4)

1	Marking handle
2	Carbon electrode
3	O-ring
4	Felt

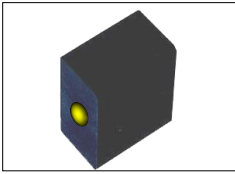


### Note

From now on, the assembled combination of felt, carbon electrode, O-ring and handle will be referred to as **cleaning stamp**.

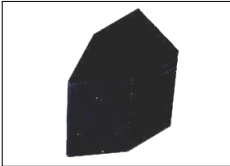
## 14.8 Carbon electrode

### 14.8.1 90° for marking/labelling



- Use the 90° carbon electrode supplied in conjunction with the white felt for marking/ labelling.

### 14.8.2 60° for cleaning and polishing



- Use the 60° carbon electrode supplied in conjunction with the yellow felt for cleaning and polishing:
  - surfaces
  - or long smooth fillet welds
- For thin fillet welds, we recommend our 30° carbon electrode.
  - See price list. (Item No.: EP-02-002)




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#### Tip

Do not use the carbon electrode for cleaning or polishing sharp-edged components or complex contours.  
For this work, use the brush only.

---

## 14.9 Surface cleaner (optional for SuperCleanox VI HD)



For cleaning, rust removal and passivation of large stainless steel surfaces such as tanks, silos, façades, etc.

For efficient cleaning, the surface cleaner requires the highest energy output, it can therefore only be used optimally in conjunction with the VI SuperCleanox HD.

Use with the SuperCleanox VI is limited.

Welds should first be cleaned with a carbon fibre brush.



**More information can be found in our general catalogue!**

## 14.10 Felts

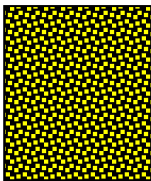
- Two different grades are available as standard.
  - White
  - Yellow

### 14.10.1 White



- Preferred use:
  - Marking
  - Easy cleaning of TIG welds which are not too tarnished.

### 14.10.2 Yellow



- These yellow felts are made of the most robust fibre in the world,
  - Made of Kevlar®.
- Preferred use:
  - Cleaning of heavily tarnished or oxidized TIG welds
  - Polishing

---

#### Tips for using felts

- Renew felts in good time, before the material thickness has decreased too much, due to wear and tear, or holes arise.
    - Excessive wear and tear causes short circuits.
    - This results in damage to the surface of the material.
  - Short circuits present no danger to the user or the appliance, due to an integrated thermal fuse which triggers in the event of overcurrents, as a precaution.
  - Felts may be used only in conjunction with:
    - Rigid carbon electrodes 30°...,60°... or 90°
    - Red marking or cleaning handles
    - Thin 1.5mm<sup>2</sup> connecting cables.
  - Felts must be secured with an O-ring to the carbon electrode. This prevents:
    - Current flowing between the carbon electrode and the work piece, in the event of a short circuit.
    - Indirect current flow through the felt soaked in electrolyte.
  - Keep the felts wet at all times.
  - Dip the felt attached to the carbon electrode frequently enough into the container with electrolyte.
    - The felt and the carbon electrode are cooled.
    - This significantly extends the service life.
- 



## 14.11 Electrolyte



### Note

We have a wide range of suitable electrolytes available for you, suitable for the different applications and materials.

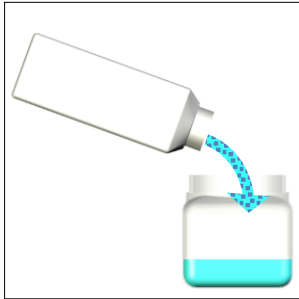
Please follow our operating instruction carefully when using electrolytes.

Observe all safety regulations.

For questions regarding the application of our electrolytes, please contact REUTER directly.

We are happy to advise you.

### 14.11.1 Fill into wide-mouth containers

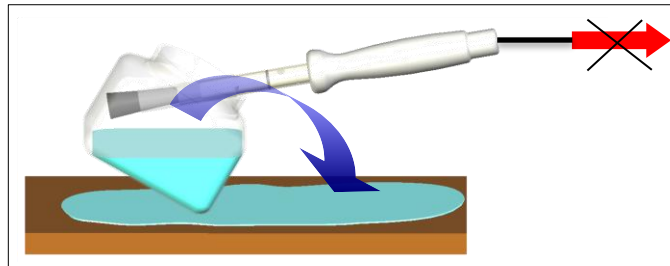


- Unscrew the cap of the electrolyte container and carefully make 2 holes in the aluminium seal (if present).
- Fill the wide-mouth container up to the first lower mark with electrolyte.
- This corresponds to a fill level of 2cm.
- Never fill the wide-mouth container too full.
- The electrode handle then remains dry and electrolyte cannot get onto your hands.

### Safety information

The wide-mouth container can tip over due to the weight of the handle or accidental tension on the cable.

Electrolyte may leak out.



### Tip

We recommend the use of our safety brush holder for wide-mouth containers. With a suitable clamp, it can be securely fastened to the work bench.



- Item No.: EP-07-102



### 14.11.2 Information concerning non-toxicity



- We only use non-toxic mineral acids in different concentrations as cleaning electrolytes.
- Our electrolytes are also used as acids and preservatives in food, in low concentrations - the acidifier E338 in Cola, for example.

**We hereby confirm that our cleaning electrolytes  
CLEANER / SUPERCLEANER / POLISHER  
are non-toxic!**

### 14.11.3 Information concerning the scope of delivery

- We provide cleaning and polishing electrolytes in the following sizes:
  - 1.5 litre container, 5 litre bottle with handle, 30 litre canister.
- For production reasons the containers are never completely filled.
  - The fill level depends on the specific gravity of the electrolyte.
- POLISHER is more concentrated and its density is almost twice as high as that of CLEANER electrolyte. This explains the different container fill levels for the same weight of electrolyte.
- Our containers are provided with safety caps and are therefore leak-proof until opened.
- Our 1.5 litre container, 5 litre bottle with handle, 30 litre canister are approved according to the German Federal Institute for Materials Research and Testing (BAM) and the UN as packaging for dangerous goods.

## 14.12 Templates



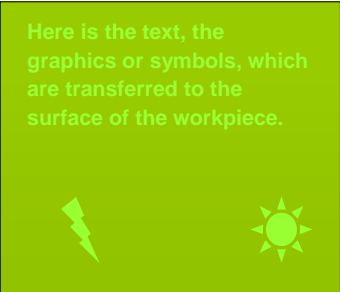
Type the text for the short-life template here

### Short-term templates

- Short-term templates are used to mark / label variable data (for example, serial or batch numbers).
  - Create a template with your printer.
  - Remove the template.
  - Remove the protective paper (green).
  - Marking is carried out using the white paper.

### Long-term templates

- Long-term templates are suitable for marking / labelling large quantities of non-variable data (e.g. logos).
  - These templates are produced using screen printing, based on template files.
  - The following common file formats can be used for the template files: PDF, JPG, TIF ...



Here is the text, the graphics or symbols, which are transferred to the surface of the workpiece.

### Two variants are available:

- Framed templates
  - Stable, suitable for large surfaces.
- Unframed templates
  - Flexible, imperative for curved surfaces.

***We would be happy to create long-term templates according to your specifications.***

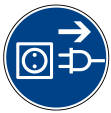
***Please contact our sales partners if we can be of help.***



**Tip**

You can also create short-term templates with a printer, yourself. In our price list you will find the optimal printer and the appropriate template material for every application.

**15 Initial operation**



**Safety information**

Make absolutely sure that the "SuperCleanox" is switched off when connecting the cables and when replacing the handles, brushes, carbon electrodes or felts

- Selector to **0**
- Mains switch **off**

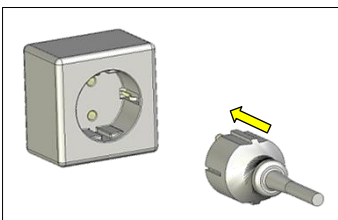
The "SuperCleanox" is equipped for single-phase connection to 230V / 50Hz earthed sockets and provided with a standard safety plug.

"SuperCleanox" appliances with special voltages are available as an option and are delivered without plugs or with country-specific plugs.

Observe the specifications on the type plate on the back of the appliance.

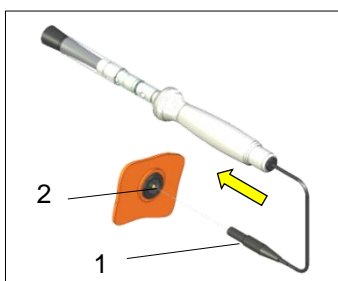
**15.1 Connection**

**15.1.1 Mains connection**



- Connect the mains plug of the "SuperCleanox" with an appropriate 230V mains socket.
- Observe the safety information

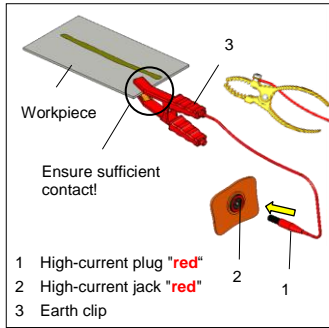
**15.1.2 Connecting the Teflon handle with carbon fibre brush**



- Connect the **black** high-current plug (1) with the **black** combo jack (2) on the appliance.

1 High-current plug "black"

2 High-current jack "black"



Earth clip connection

- The earth clip (3) establishes the electrical contact between the workpiece and the electrochemical cleaning appliance.
- Very high currents flow during cleaning.
- Connect the earth clip directly to the workpiece to be cleaned,
  - to prevent shunts.
- Ensure good electrical contact between the earth clip (3) and the workpiece.
  - Clean the contact point if necessary.
- Connect the **red** high-current plug (1) to the **red** combo jack (2) on the appliance.

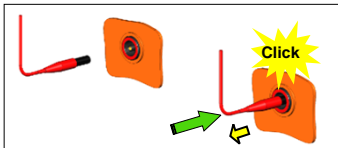
## 15.2 Connect and lock the high-current plugs



**Note**

The high-current plugs lock automatically when inserted into the high-current combo jacks and can only be unlocked by pressing inwards again! Ensure that the connections are correct.

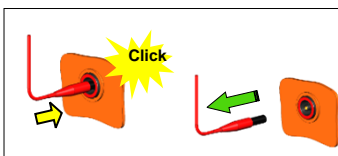
- Red high-current plug in red high-current jack.
- Black high-current plug in black high-current jack.
- The following procedure applies for **red** and **black** high-current plugs.



- Push the high-current plug into the high-current combo jack until you feel a distinct clicking.
- Check the correct fitting of the high-current plug by pulling it gently.
  - The plug should not pull out.



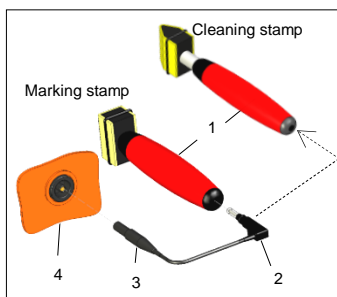
## 15.3 Release high-current plug and remove



- To release, press the high-current plug lightly into the high-current combo jack until you feel resistance (slight click).
  - The lock is released.
  - Now pull the high-current plug out of the high-current combo jack.



## 15.4 Connecting the marking / cleaning stamp



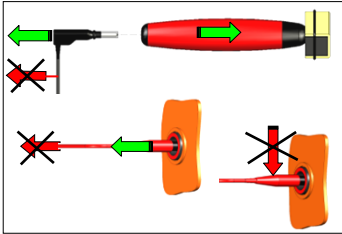
- Insert the **black** safety plug (2) with the transparent, sliding, insulating sleeve into the jack in the handle (1).
- Insert the **black** 10mm<sup>2</sup> high-current plug (6) into the **black** high-current combo jack (8) on the appliance

- |   |                                        |
|---|----------------------------------------|
| 1 | Handle                                 |
| 2 | Safety plug                            |
| 3 | High-current plug                      |
| 4 | High-current jack (front of appliance) |



**Note**

4mm safety plugs have no locking mechanism.  
To remove, simply pull the plug out of the appliance.



**Safety Information**

- Never pull the plug out of the jack by the cable!
  - This can damage the cables.
- Never put weight on the plug transversely.
- Jacks can easily break at the edges
- ***This applies to all electrical connections!***

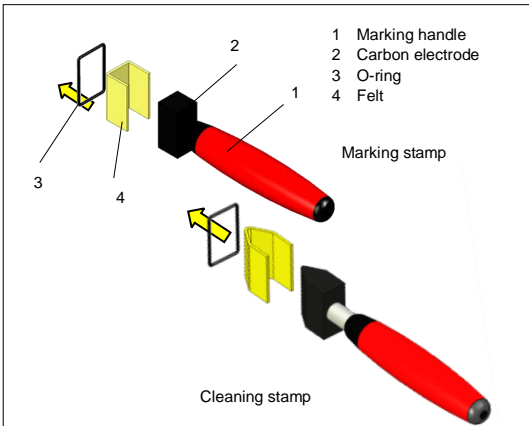


**Safety information**

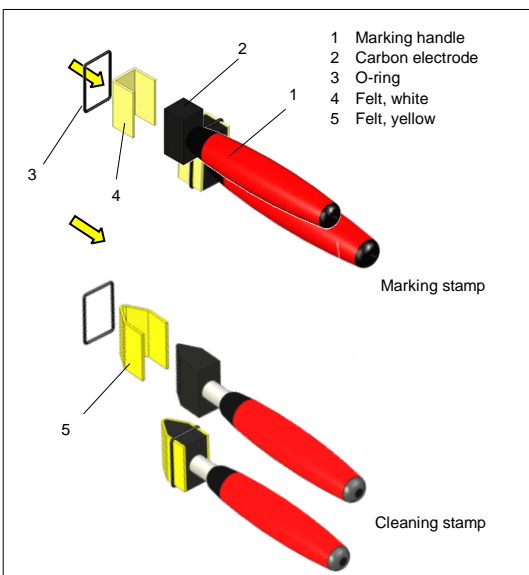
Make sure you use the correct cable cross-section and plug type for the different work steps.

- 1.5mm<sup>2</sup> for marking and polishing with a carbon electrode
- 10/16mm<sup>2</sup> for cleaning and polishing with a brush

**15.4.1 Changing the marking felt**



- First remove the O-ring (3)
- Now remove the felt (4)
  - Dispose of the felt properly



- Use a white marking felt (4) for marking.
- Use a yellow felt (5) for cleaning.
  - Fold the felt in half and lay it over the carbon electrode (2).
  - Secure the felt with the O-ring (3) supplied.

## 16 Working with the "SuperCleanox"

Our many years of experience in welding and handling pickling chemicals has enabled us to develop this highly effective and environmentally friendly electrochemical high-current cleaning process with carbon brushes.

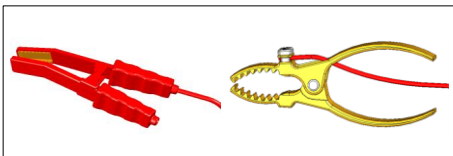
- Low doses of electrolytes are used that alone have no cleaning or marking effects.
- Electrolysis is only set in motion when current flows.
- An increase in temperature on the surface of the workpiece starts the chemical cleaning process.
- Important for good results:
  - precise matching of electrolytes
  - voltage types
  - amperage
  - correct selection of electrode material
- The unsurpassed cleaning effect is achieved through:
  - Strong high current source
  - Millions of small arcs at the ends of the carbon fibres.
- The electrolytes can therefore be produced from non-toxic mineral acids in very low concentrations, and nevertheless provide unmatched cleaning performance.

### 16.1 Cleaning / polishing with the carbon fibre brush

#### 16.1.1 Preparation



- Carbon fibre brush






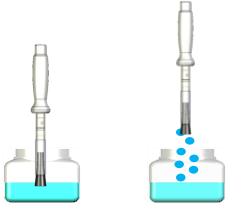


- Earth connection



- Cleaning electrolyte
- Polisher electrolyte

## 16.2 Workflow, cleaning with carbon fibre brush

	Workflow - cleaning -	Comment
1		<ul style="list-style-type: none"> <li>● Switch on the appliance. <ul style="list-style-type: none"> <li>➤ The mains switch lights up.</li> </ul> </li> </ul>
2		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>➤ Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>➤ These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>➤ Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>➤ Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>
3	<p>SuperCleanox VI HD</p> 	<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➤ Soft cleaning with brush</li> <li>➤ The green LED lights up</li> </ul> </li> </ul> <p>For heavily oxidized welds or MAG welds, stage II can be selected.</p>
	<p>SuperCleanox VI</p> 	<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➤ Cleaning with brush</li> <li>➤ The green LED lights up.</li> </ul> </li> </ul>
	<p>SuperCleanox IV+</p> 	<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➤ Cleaning with brush</li> <li>➤ The green LED lights up.</li> </ul> </li> </ul>
4		<ul style="list-style-type: none"> <li>● Dip the carbon fibre brush into the wide-mouth container.</li> <li>● Take the carbon brush out again and let excess electrolyte drip off.</li> </ul>

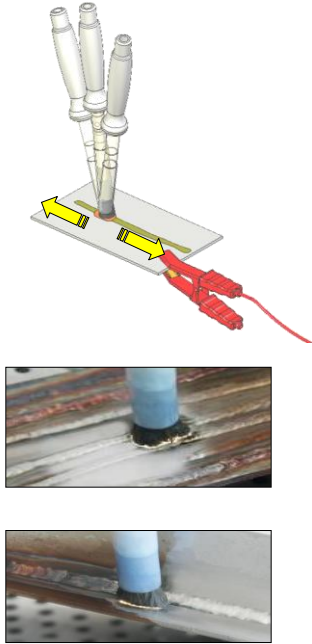

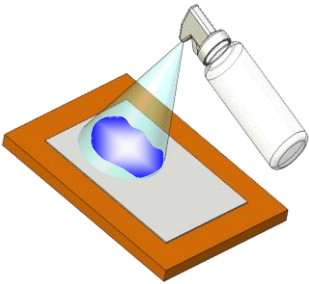

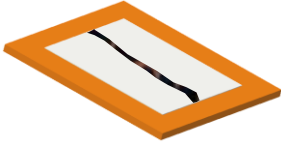





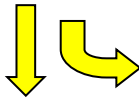
<p>5</p>		<ul style="list-style-type: none"> <li>● Position the brush vertically on the workpiece.</li> <li>● Now stroke lightly over the welding seam with the brush.</li> <li>● Never press too hard on the carbon fibre brush <ul style="list-style-type: none"> <li>➢ Just circle lightly, with a circle diameter of 1-2 cm, and very slowly over the surface of the workpiece.</li> </ul> </li> <li>● The maximum cleaning effect is achieved when the carbon fibres are perpendicular to the workpiece surface. <ul style="list-style-type: none"> <li>➢ Only in this way do the arcs, which are decisive for the cleaning process, form at the tips of the carbon fibres.</li> </ul> </li> <li>● Depending on the quality of the weld, you will need to brush over it several times in order to achieve the desired cleaning effect. <ul style="list-style-type: none"> <li>➢ The darker the tarnishing of the welds, the longer the cleaning phase.</li> <li>➢ You can increase the cleaning effect on heavily oxidized welds by using our SuperCleaners or Polishers.</li> </ul> </li> </ul>
<p>6</p>		<ul style="list-style-type: none"> <li>● Dip the carbon fibre brush into the wide-mouth container at regular intervals. <ul style="list-style-type: none"> <li>➢ Move the carbon fibre brush back and forth, 2-3 times, in the wide-mouth container.</li> <li>➢ dissolved oxides are removed</li> <li>➢ the carbon fibres can absorb fresh electrolyte.</li> <li>➢ You achieve maximum cooling of the electrode and increase its service life.</li> </ul> </li> </ul>
<p>7</p>		<ul style="list-style-type: none"> <li>● After cleaning, spray the surface off immediately with water. <ul style="list-style-type: none"> <li>➢ Use the spray bottle supplied.</li> <li>➢ Use demineralised or distilled water.</li> <li>➢ In this way, you avoid unsightly white edges of lime.</li> <li>➢ The water hardness must be less than 10° dH.</li> <li>➢ The suddenly evaporating water entrains the dissolved impurities and electrolyte residues.</li> </ul> </li> </ul>
<p>8</p>		<ul style="list-style-type: none"> <li>● Dry the surface. <ul style="list-style-type: none"> <li>➢ Use paper towels.</li> <li>➢ In this way, you obtain a stain-free, dry surface.</li> </ul> </li> </ul>
<p><b>For more information, see the tips for "cleaning" and "polishing".</b></p>		

Table 4 Cleaning / polishing with the carbon fibre brush



### 16.2.1 Workflow, strong cleaning with carbon fibre brush

Workflow - strong cleaning -		
1		<ul style="list-style-type: none"> <li>You can <b>briefly</b> pre-treat particularly strongly oxidized or darkened surfaces with <b>strong cleaning</b>.</li> </ul>
2		<ul style="list-style-type: none"> <li>Switch on the appliance.               <ul style="list-style-type: none"> <li>The mains switch lights up.</li> </ul> </li> </ul>
3		<p>Safety information</p> <ul style="list-style-type: none"> <li>Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>
4	<p>SuperCleanox VI HD</p> 	<ul style="list-style-type: none"> <li>Select operating position "III".               <ul style="list-style-type: none"> <li>Strong cleaning</li> <li>The green LED lights up.</li> </ul> </li> </ul>
	<p>SuperCleanox VI</p> 	<ul style="list-style-type: none"> <li>Select operating position "II".               <ul style="list-style-type: none"> <li>Strong cleaning</li> <li>The green LED lights up.</li> </ul> </li> </ul>
	<p>SuperCleanox IV+</p> 	<ul style="list-style-type: none"> <li>Select operating position "II".               <ul style="list-style-type: none"> <li>Strong cleaning</li> <li>The green LED lights up.</li> </ul> </li> </ul>
5		<ul style="list-style-type: none"> <li>The workflow for strong cleaning is the same as for normal cleaning.</li> </ul>



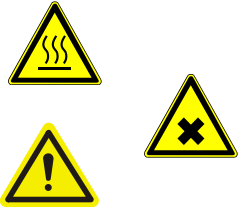
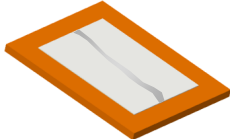



6		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>● Only apply "strong cleaning" for a <b>short time</b>. <ul style="list-style-type: none"> <li>➢ Then switch immediately back to operating position "I" and continue to work normally!</li> </ul> </li> <li>● Never use operating position "III" when working with carbon fibre brushes!</li> <li>● Carbon fibre brushes get very hot. <ul style="list-style-type: none"> <li>➢ Only grasp the carbon fibre brush and the Teflon sliding sheath wearing gloves.</li> <li>➢ It is better let it cool or rinse it with plenty of water.</li> </ul> </li> <li>● Smoke development is stronger when cleaning at performance level "II".</li> <li>● For chrome/nickel cleaning, please use the required air extraction systems.</li> </ul>
<p><b>For more information, see the tips for "cleaning" and "polishing".</b></p>		

Table5 Workflow polishing

### 16.3 Workflow, polishing with carbon fibre brush

Workflow - polishing -		
1		<ul style="list-style-type: none"> <li>● Polish the surface after cleaning.</li> </ul>
2		<ul style="list-style-type: none"> <li>● Switch on the appliance. <ul style="list-style-type: none"> <li>➢ The mains switch lights up.</li> </ul> </li> </ul>
3		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>➢ Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>➢ These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>➢ Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>➢ Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>
4		<ul style="list-style-type: none"> <li>● Select operating position "I" or "II". <ul style="list-style-type: none"> <li>➢ Polishing with brush</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>



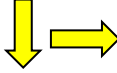
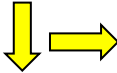
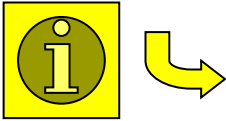



	<p><b>SuperCleanox VI</b></p> 	<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➢ Polishing with brush</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
	<p><b>SuperCleanox IV+</b></p> 	<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➢ Polishing with brush</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
5		<ul style="list-style-type: none"> <li>● For polishing use our Polisher electrolyte.</li> </ul>
6		<ul style="list-style-type: none"> <li>● <b>The workflow for polishing is the same as for cleaning</b></li> </ul>
7		<p><b>Note</b> If required, you can seal the surface with our Neutralyt-Soft (see catalogue).</p> <ul style="list-style-type: none"> <li>➢ The surface is less sensitive to new soiling, e.g. fingerprints.</li> <li>➢ Prevents subsequent rusting on corrosion-sensitive surfaces.</li> </ul>
<p><b>For more information, see the tips for "cleaning" and "polishing".</b></p>		

Table 6 Workflow polishing

### 16.3.1 Workflow, strong polishing with carbon fibre brush

Workflow - strong cleaning -		
1		<ul style="list-style-type: none"> <li>● Polish the surface intensively after cleaning.</li> </ul>
2		<ul style="list-style-type: none"> <li>● Switch on the appliance. <ul style="list-style-type: none"> <li>➢ The mains switch lights up.</li> </ul> </li> </ul>
3		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>➢ Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>➢ These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>➢ Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>➢ Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>




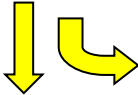
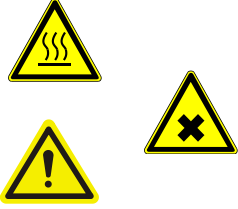
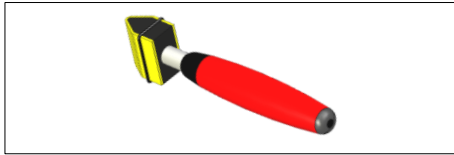
	<p>SuperCleanox VI HD</p> 	<ul style="list-style-type: none"> <li>● Select operating position "III". <ul style="list-style-type: none"> <li>➢ Strong polishing</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
4	<p>SuperCleanox VI</p> 	<ul style="list-style-type: none"> <li>● Select operating position "II". <ul style="list-style-type: none"> <li>➢ Strong polishing</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
	<p>SuperCleanox IV+</p> 	<ul style="list-style-type: none"> <li>● Select operating position "II". <ul style="list-style-type: none"> <li>➢ Strong polishing</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
5		<ul style="list-style-type: none"> <li>● The workflow for strong polishing is the same as for normal polishing.</li> </ul>
6		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>● Only apply "strong polishing" for a <b>short time</b>. <ul style="list-style-type: none"> <li>➢ Then switch immediately back to operating position "I" and continue to work normally!</li> </ul> </li> <li>● Never use operating position "III" when working with carbon fibre brushes!</li> <li>● Carbon fibre brushes get very hot. <ul style="list-style-type: none"> <li>➢ Only grasp the carbon fibre brush and the Teflon sliding sheath wearing gloves.</li> <li>➢ It is better let it cool or rinse it with plenty of water.</li> </ul> </li> <li>● Smoke development is stronger when cleaning at performance level "II".</li> <li>● For chrome/nickel cleaning, please use the required air extraction systems.</li> </ul>
<p><b>For more information, see the tips for "cleaning" and "polishing".</b></p>		

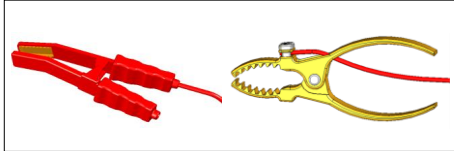
Table 6 Workflow, strong polishing

## 16.4 Cleaning / polishing with carbon electrode

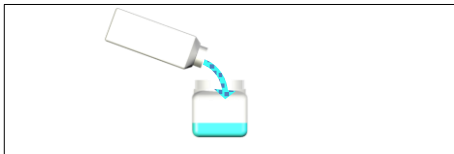
### 16.4.1 Preparation



- Carbon electrode






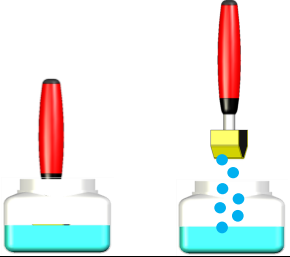
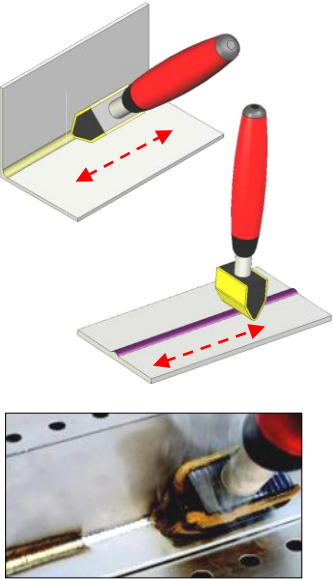

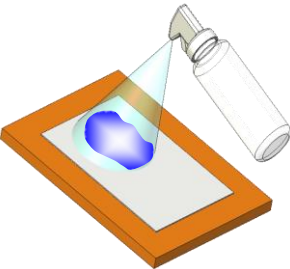

- Earth connection



- Cleaning electrolyte
- Polisher electrolyte

### 16.4.2 Workflow, cleaning with carbon electrode

	Workflow - cleaning -	Comment
1		<ul style="list-style-type: none"> <li>● Switch on the appliance. <ul style="list-style-type: none"> <li>➢ The mains switch lights up.</li> </ul> </li> </ul>
2		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>➢ Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>➢ These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>➢ Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>➢ Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>
3	SuperCleanox VI HD	<ul style="list-style-type: none"> <li>● Cleaning with carbon electrode not possible</li> </ul>
	SuperCleanox VI 	<ul style="list-style-type: none"> <li>● Select operating position "III". <ul style="list-style-type: none"> <li>➢ Cleaning with carbon electrode</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
	SuperCleanox IV+	<ul style="list-style-type: none"> <li>● Cleaning with carbon electrode not possible</li> </ul>

4		<ul style="list-style-type: none"> <li>● Dip the carbon electrode with the felt into the wide-mouth container <ul style="list-style-type: none"> <li>➤ Wait until the felt is completely saturated with electrolyte.</li> <li>➤ Let it drip a bit before removing.</li> </ul> </li> </ul>
5		<ul style="list-style-type: none"> <li>● Position the carbon electrode with the felt <b>vertically</b> on the workpiece.</li> <li>● Now brush lightly over the welding seam with the carbon electrode. <ul style="list-style-type: none"> <li>➤ Move the carbon electrode back and forth slightly as you brush.</li> </ul> </li> <li>● <b>Never</b> press too hard on the carbon fibre brush <ul style="list-style-type: none"> <li>➤ Just let it glide easily over the surface of the workpiece.</li> </ul> </li> <li>● Depending on the quality of the weld, you will need to brush over it several times in order to achieve the desired cleaning effect. <ul style="list-style-type: none"> <li>➤ The darker the tarnishing of the welds, the longer the cleaning phase.</li> <li>➤ You can increase the cleaning effect on heavily oxidized welds by using our <b>SUPERCLEANERS</b> or <b>POLISHERS</b>.</li> </ul> </li> </ul>
6		<ul style="list-style-type: none"> <li>● Dip the carbon electrode into the wide-mouth container at regular intervals. <ul style="list-style-type: none"> <li>➤ Move the carbon electrode back and forth, 2-3 times, in the wide-mouth container.</li> <li>➤ dissolved oxides are removed</li> <li>➤ The felt can absorb fresh electrolyte.</li> <li>➤ You achieve maximum cooling of the electrode and increase its service life.</li> </ul> </li> </ul>
7		<ul style="list-style-type: none"> <li>● After cleaning, spray the surface off immediately with water. <ul style="list-style-type: none"> <li>➤ Use the spray bottle supplied</li> <li>➤ Use demineralised or distilled water.</li> <li>➤ In this way, you avoid unsightly white edges of lime.</li> <li>➤ The water hardness must be less than 10° dH.</li> <li>➤ The suddenly evaporating water entrains the dissolved impurities and electrolyte residues.</li> </ul> </li> </ul>
8		<ul style="list-style-type: none"> <li>● Dry the surface. <ul style="list-style-type: none"> <li>➤ Use paper towels.</li> <li>➤ In this way, you obtain a stain-free, dry surface.</li> </ul> </li> </ul>

**For more information, see the tips for "cleaning" and "polishing".**

Table 7 Cleaning and polishing with carbon electrode

### 16.5 Workflow, polishing with carbon electrode

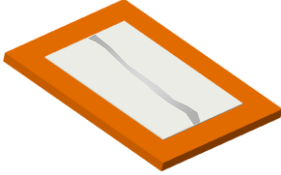



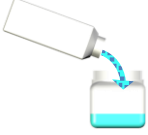
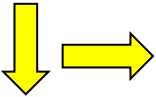
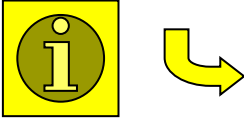
Workflow - polishing -		
1		<ul style="list-style-type: none"> <li>Polish the surface after cleaning.</li> </ul>
2		<ul style="list-style-type: none"> <li>Switch on the appliance.               <ul style="list-style-type: none"> <li>The mains switch lights up.</li> </ul> </li> </ul>
3		<p><b>Safety information</b></p> <ul style="list-style-type: none"> <li>Never switch the appliance ON/OFF with the mains switch repeatedly, in quick succession.</li> <li>These appliances are equipped with an inrush current limiting device, which prevents the circuit-breaker triggering too quickly.</li> <li>Switching on/off in quick succession may damage the electronics in the appliance.</li> <li>Wait at least 30 seconds after switching off before switching the appliance on again.</li> </ul>
4	SuperCleanox VI HD	<ul style="list-style-type: none"> <li>Polishing with carbon electrode not possible</li> </ul>
	SuperCleanox VI 	<ul style="list-style-type: none"> <li>Select operating position "III".               <ul style="list-style-type: none"> <li>Polishing with carbon electrode</li> </ul> </li> <li>The green LED lights up.</li> </ul>
	SuperCleanox IV+	<ul style="list-style-type: none"> <li>Polishing with carbon electrode not possible</li> </ul>
5		<ul style="list-style-type: none"> <li>For polishing use our Polisher electrolyte.</li> </ul>
6		<ul style="list-style-type: none"> <li>The workflow for polishing is the same as for cleaning</li> </ul>
7		<p><b>Note</b></p> <p>If required, you can seal the surface with our Neutralyt-Soft (see catalogue).</p> <ul style="list-style-type: none"> <li>The surface is less sensitive to new soiling, e.g. fingerprints.</li> <li>Prevents subsequent rusting on corrosion-sensitive surfaces</li> </ul>
<b>For more information, see the tips for "cleaning" and "polishing".</b>		

Table 8 Workflow, polishing

## 16.6 Tips for cleaning with carbon fibre brush / carbon electrode



### Tip

Use our Polisher for cleaning as well.

- Polisher is thicker,
- has a higher boiling point,
- the vapour development is lower.

***Never use Polisher for matte stainless steel surfaces!***



- Never clean too long in one place.
- Wet the electrode / the brush with electrolyte at regular intervals.
- Long cleaning sessions without re-wetting leads to:
  - Strong heating of the electrode / the brush and the workpiece.
  - Increased wear of the electrode / the brush.
  - Reduces the service life!
  - Reduces the cleaning effect!
- After cleaning, dull spots sometimes remain on either side of the weld in the HAZ (heat affected zone).
  - Dull spots are caused by the welding process and are process-related.
  - They cannot be eliminated through more intensive cleaning!
- You can match the gloss level by targeted polishing of the dull spots.
- After cleaning, spray the surface off immediately with distilled water.
  - The suddenly evaporating water entrains the dissolved impurities and electrolyte residues.
- Dry the surface with paper towels.
  - In this way, you obtain a stain-free, dry surface.
- Finish your workpiece, if necessary, with a commercially available stainless steel care product.
  - This makes the surface less sensitive to new soiling, e.g. with fingerprints.

***We recommend using our  
“FPR” Finger-Print-Remover!***

***Remove white spots, which sometimes  
arise after cleaning the surface, with our  
SFC (stainless finishing cleaner)!***



## 16.7 Tips for polishing with carbon fibre brush / carbon electrode



- Always clean first before polishing.
  - The AC voltage used for cleaning, causes oxidation layers to dissolve much faster than polishing!
- Only use the Polisher electrolytic for polishing stainless steel surfaces and welds.
- Previously cleaned welds can be:
  - Mirror polished.
  - The brightness can be matched to the surrounding surface.
- Oxides, silicates and scaling, which could not be completely removed through cleaning, can be removed almost entirely through polishing.
  - However, this results in a slightly shiny surface.
- Brush slowly over the workpiece surface with gentle pressure and circular movement.
- Dip the electrode / the brush in the wide-mouth container frequently enough, to absorb fresh electrolyte.
- When polishing, the carbon electrode and the workpiece can reach temperatures of up to 200°C.
- Allow the electrode to cool for several seconds in the electrolyte.
  - Stir several times.

---

### Safety information

- Avoid high workpiece temperatures and thus thermal distortion.
- Never polish for too long in one place.
- Flush the workpiece surface occasionally with water.
- Use the spray bottle supplied with the appliance set.
- Avoid direct contact with the electrode.
- Avoid direct contact with the surfaces just cleaned.
- Do not hold your face over or too close to the processing position.
  - You will avoid directly inhaling rising vapours.
- Provide good ventilation and extraction of vapours.
- Use demineralised or distilled water.
  - The water hardness must be less than 10° dH.
  - This prevents unsightly lime stains on freshly polished surfaces.
- Dry the surface with paper towels.
- Finish your workpiece, if necessary, with a commercially available stainless steel care product.
  - This makes the surface less sensitive to new soiling, e.g. with fingerprints.



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***We recommend using our  
“FPR” Finger-Print-Remover!***



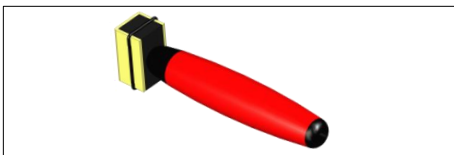
## 16.8 Marking/Labelling

All electrically conductive metal surfaces can be labelled using the appropriate electrolyte.

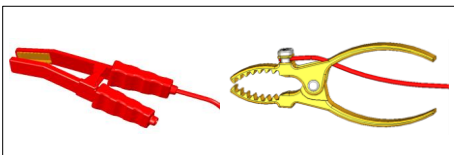
A distinction is made between dark and light marking.

- **Dark** marking is a targeted oxidation process, which takes place within the metal surface.
  - No superficial application of colour particles.
  - Therefore, permanent and forgery-proof!
  - Not ideal for non-ferrous metals.
- **Light** marking or negative marking is also known as "etching".
  - In contrast to dark marking, material is removed from the surface during this process, in places where there are micro-perforations in the templates.
  - Light marking is preferably used on aluminium materials and high-gloss surfaces.
  - Aluminium materials cannot be dark marked
  - Use our Marking electrolytes for light marking, which have been specially designed for the process.
- Prepare the workpiece and the marking stamp in the same way as for dark marking.
- For light marking, proceed in the same way as for dark marking.
- The marking time is longer, however,
  - ~ 3 - 5 sec.
- **Pay attention to the position of the selector**

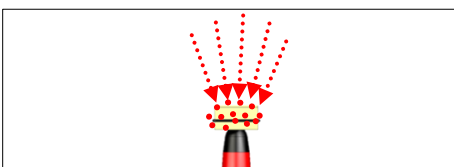
### 16.8.1 Preparation



- Carbon electrode 90 °
- Marking felt

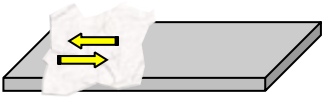
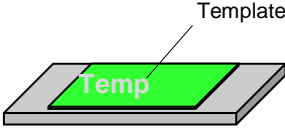







- Earth connection



- Marking Electrolyte

### 16.8.2 Workflow dark marking

	Workflow dark marking	Comment
1		<ul style="list-style-type: none"> <li>● Clean the area of the workpiece to be marked before starting to mark/label it.</li> </ul>
2		<ul style="list-style-type: none"> <li>● Position the template or labelling strip on the workpiece.</li> </ul>
3		<p><b>Tip</b> Before starting work, wet the templates with water or marking electrolyte</p> <ul style="list-style-type: none"> <li>➢ The templates then adhere to the workpiece better and do not slip so easily!</li> </ul>
4		<ul style="list-style-type: none"> <li>● Switch on the appliance. <ul style="list-style-type: none"> <li>➢ The mains switch lights up.</li> </ul> </li> </ul>
5		<ul style="list-style-type: none"> <li>● Select operating position "II". <ul style="list-style-type: none"> <li>➢ Marking dark</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
		<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➢ Marking dark</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
		<ul style="list-style-type: none"> <li>● Select operating position "I". <ul style="list-style-type: none"> <li>➢ Marking dark</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>


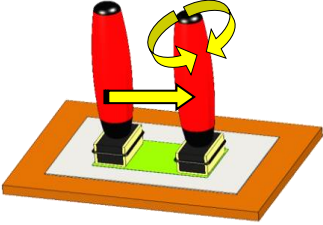
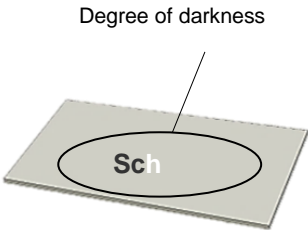
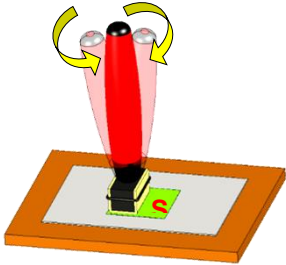
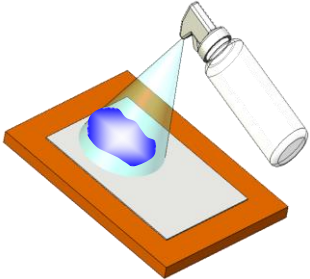

6		<ul style="list-style-type: none"> <li>● Drip some drops of marking electrolyte onto the felt until it is fully wetted.</li> </ul>
7		<ul style="list-style-type: none"> <li>● Press the whole surface of the marking stamp vertically and evenly onto the template.</li> <li>● Brush slowly over the template with gentle pressure.</li> <li>● Marking time 1 - 3 seconds <ul style="list-style-type: none"> <li>➢ Otherwise, the surface of the workpiece next to the template will be darkened.</li> </ul> </li> </ul>
8		<ul style="list-style-type: none"> <li>● The degree of darkness depends on: <ul style="list-style-type: none"> <li>➢ the marking period,</li> <li>➢ the electrolyte used,</li> <li>➢ the material.</li> </ul> </li> <li>● Make sure you do not brush over the edge of the template, otherwise the workpiece surface next to the template will be darkened.</li> </ul>
9		<ul style="list-style-type: none"> <li>● When marking/labelling smaller surfaces, work as follows: <ul style="list-style-type: none"> <li>➢ Press the whole surface of the marking stamp vertically and evenly onto the template.</li> <li>➢ Move the marking stamp lightly.</li> <li>➢ The electrolyte then flows through the template more easily.</li> </ul> </li> </ul>
10		<ul style="list-style-type: none"> <li>● Take the template off the workpiece.</li> <li>● Flush the workpiece surface thoroughly with water.</li> <li>● Use demineralised or distilled water. <ul style="list-style-type: none"> <li>➢ The water hardness must be less than 10° dH.</li> <li>➢ This prevents unsightly lime stains on freshly marked template</li> </ul> </li> </ul>
11		<ul style="list-style-type: none"> <li>● Dry the surface. <ul style="list-style-type: none"> <li>➢ Use paper towels.</li> <li>➢ In this way, you obtain a stain-free, dry surface.</li> </ul> </li> </ul>
<p style="text-align: center;"><b>For more information, see the tips for "marking" and "labelling".</b></p>		

Table 9 Workflow dark marking

### 16.8.3 Workflow, light marking

Workflow, light marking-		
1		<ul style="list-style-type: none"> <li>● Prepare the work as for "dark marking"</li> </ul>
2		<ul style="list-style-type: none"> <li>● Switch on the appliance.               <ul style="list-style-type: none"> <li>➢ The mains switch lights up.</li> </ul> </li> </ul>
3		<ul style="list-style-type: none"> <li>● Select operating position "II".               <ul style="list-style-type: none"> <li>➢ Marking light</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
		<ul style="list-style-type: none"> <li>● Select operating position "I".               <ul style="list-style-type: none"> <li>➢ Marking light</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
		<ul style="list-style-type: none"> <li>● Select operating position "I".               <ul style="list-style-type: none"> <li>➢ Marking light</li> <li>➢ The green LED lights up.</li> </ul> </li> </ul>
4		<ul style="list-style-type: none"> <li>● The workflow for light marking, is the same as for dark marking.</li> </ul>
5		<p><b><i>The marking time is longer, however ~ 3 - 5 sec.</i></b></p>
<p><b>For more information, see the tips for "marking" and "labelling".</b></p>		

Table 10 Workflow, light marking



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### Safety information

- Too little electrolyte or an excessively long contact time causes burning or damage to the film.
  - Begin therefore with short passes.
    - Check the success of the marking until the appropriate result is achieved.
- 

## 16.9 Tips for optimal marking / labelling



- Every electrolyte contains salts.
  - These can have a strongly oxidising effect, depending on the material.
  - Handle chemicals therefore with great care.
  - Avoid "electrolyte carryover".
  - Wash your hands frequently.
  - Clean the handles and carbon electrodes very thoroughly.
- Never use the same felts for marking/labelling and cleaning. This can otherwise lead to unwanted discolouration of surfaces due to electrolytic carryover.
- Ensure good electrical contact and wet felt. A poorly wetted felt inhibits the current flow.
- Templates get dirty with time due to salts and metal residues. Clean or rinse the templates between labelling processes as well.
- Reduce the marking / labelling duration if the label appears rusty.
- Make sure that the template does not heat up excessively.
  - Otherwise there is a danger of premature wear.
- If too much electrolyte evaporates, the fabric of the template will be glued. In this case, replace the template, otherwise the image will be poor.
- Felts wear out with time, they become dark.
  - Replace dark felts regularly.
- Large typefaces give rise to increased contamination of the felts.
  - Clean the felts regularly.
- The result of the marking / labelling depends on various factors.
- Material variations within a batch of material can influence the result.
  - Test the quality of the font before marking/labelling the workpiece, on a piece of scrap.
- It may be possible to optimise the results by using different electrolytes.
- Use our Neutralyt (see catalogue) to remove electrolyte residues.
  - This prevents subsequent rusting on corrosion-sensitive surfaces.
- Finish your workpiece, if necessary, with a commercially available stainless steel care product.
  - This makes the surface less sensitive to new soiling, e.g. with fingerprints.

## 17 Possible faults and their remedies

Fault / error message	Possible cause (s)	Remedy
No cleaning effect	<ul style="list-style-type: none"> <li>- appliance not switched on</li> <li>- alligator clip not connected</li> <li>- workpiece / electrolyte temperature too low</li> <li>- M10 thread on the cleaning handle oxidized or dirty</li> </ul>	<ul style="list-style-type: none"> <li>- switch on appliance</li> <li>- connect the alligator clip</li> <li>- process longer, increase power: performance level I--&gt;II--&gt;III</li> <li>- clean with a wire brush</li> </ul>
Weld or surface is matte	<ul style="list-style-type: none"> <li>- remaining too long in one place when cleaning</li> <li>- surface too hot</li> <li>- insufficient electrolyte</li> <li>- electrolyte quality too poor or used up</li> </ul>	<ul style="list-style-type: none"> <li>- <b>never</b> remain too long in one place when cleaning</li> <li>- cool surface (spray water on the surface)</li> <li>- increase the amount of electrolyte</li> <li>- use new electrolyte</li> </ul>
Felts/carbon fibre brush burn and the electrode gets too hot	<ul style="list-style-type: none"> <li>- insufficient electrolyte used</li> <li>- wrong operating position (II or III) selected</li> </ul>	<ul style="list-style-type: none"> <li>- dip and cool the electrode in the wide-mouth container more often</li> <li>- select level I</li> </ul>
Polished workpiece surface is matte again	<ul style="list-style-type: none"> <li>- surface temperature too high</li> </ul>	<ul style="list-style-type: none"> <li>- do not polish too long in one place</li> <li>- use more electrolyte more often</li> <li>- cool occasionally with water</li> </ul>
Felts/carbon fibre brushes wear out too fast	<ul style="list-style-type: none"> <li>- welds are too rough</li> <li>- too little cooling in the wide-mouth container</li> <li>- no Kevlar felts used when polishing</li> <li>- too much pressure when working</li> <li>- insufficient electrolyte used</li> </ul>	<ul style="list-style-type: none"> <li>- water hard (use distilled water)</li> <li>- cool longer in the wide-mouth container</li> <li>- use Kevlar felt for polishing</li> <li>- work with less pressure</li> <li>- use more electrolyte</li> </ul>
Marking does not work	<ul style="list-style-type: none"> <li>- no electrolyte between template and workpiece</li> <li>- in the case of aluminium, possibly anodized surface</li> <li>- wrong electrolyte</li> </ul>	<ul style="list-style-type: none"> <li>- wet felt with electrolyte</li> <li>- remove anodized surface or use non-anodized material</li> <li>- use suitable electrolyte</li> </ul>
Stains after cleaning, polishing, flushing	<ul style="list-style-type: none"> <li>- not flushed with water thoroughly enough</li> <li>- limescale, water too hard</li> <li>- surface too hot due to excessive polishing</li> <li>- electrolyte residues</li> <li>- electrolytic carryover through marking residues or electrolytes</li> </ul>	<ul style="list-style-type: none"> <li>- flush thoroughly with water</li> <li>- use water with lower hardness</li> <li>- shorter polishing time</li> <li>- clean</li> <li>- clean</li> </ul>

Table 11 Possible faults and their remedies

## 18 Technical Data

Item No.:	EP-01-017 HD	EP-01-017	EP-01-021
Power output [VA]	3450	2500	1500
Weight [kg]	32	28	25
Set weight incl. accessories [kg]	38	36	32
Dimensions [mm]	190 x 200 x 450		
Mains voltage	230V / 50Hz / 16A	230V / 50Hz / 10A	230V / 50Hz / 8A
Secondary voltage	6-21 V AC/DC	9-32 V AC/DC	9-18 V AC/DC
Protection class	IP 23		

Table 12 Technical data

## 19 Clean container, handles and workplace

- Always clean all accessories thoroughly after every use, with plenty of soap and water.
- Rinse the electrode handles, carbon fibre brush and carbons thoroughly, under running water.
- If necessary, wipe the appliance with a slightly damp cloth.
- Neutralise the diluted electrolyte residues.
- Clean your workplace thoroughly, with plenty of water.
- Electrolyte residues can cause chemical burns to the skin or clothing.
- Electrolyte residues can cause damage to the surfaces.
- Remove the felts and dispose of them.
- Wipe the cable and the alligator clip with water and a damp cloth.
- Fill the wide-mouth containers containing the dirty electrolyte with water.
- Dispose of the neutralised electrolyte residues.
- Afterwards rinse the wide-mouth container thoroughly with water, inside and outside.
- Remove any electrolyte residues around your workplace, the work table and the floor, with plenty of water.
- Add commercially available household cleaner or soap to the water.




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### Safety information

Always unplug from the mains prior to servicing, maintenance and repair work!

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## 20 Maintenance



### Note

The following maintenance work may be performed by the user of this appliance:

- All cleaning work on the appliance housing.
- All cleaning work on the accessories.
- Replacement of wear parts
  - Felts, Teflon handles, carbon electrodes, earth clamps, earth cables, marking accessories



### Safety information

The following maintenance work must be carried out by a qualified electrician:

- Replacing defective mains plug.
- Replacing defective mains cable.
- Replacing the earth and marking jacks on the appliance.
- Replacing or repairing any components located inside the appliance housing.

### 20.1 Inspection and maintenance schedule

- Maintenance of the appliance consists of thorough cleaning and inspection by a qualified electrician. The frequency depends on the degree of contamination.
- Observe the proposed maintenance intervals.
- Before starting, the appliance must be disconnected from the mains (unplug).
- Dust deposits must be removed with a vacuum cleaner. Wipe the components with a dry cloth.
- Use only degreasing agents that are suitable for electrical equipment.
- Observe the instructions on cleaning the appliance and accessories.

Table 11 Inspection and maintenance schedule

before start = before every start, d = daily, weekly. = w, monthly = month, quarterly = every 3 months, half-yearly = every 6 months, annually = every 12 months

Work to be done	before start	d	w	m	quarterly	half-yearly	annually
Safety check as described in section 2.3 and below	X		X				
Check marking felt for wear and replace if necessary	X	X					
Check marking felt for contamination and replace if necessary	X	X					
Check template for contamination and replace if necessary	X	X					
Clean marking handle	X	X					
Check carbon electrodes for contamination and wear, clean or replace if necessary	X						
Clean earth clamps		X					
Check earth clamps for oxidation, clean if necessary			X				
Check electrolyte, if used up--> replace	X	X					
Clean power unit			X				
Maintenance of the appliance						X	
Repeat tests in accordance with DGUV 3							X



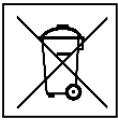
## 21 Disposal

### 21.1 Disposal of contaminated electrolytes



- Never dispose of undiluted contaminated electrolytes into drains or the environment.
- Heavy metal residues from oxidized welds and metal surfaces can be carried in the contaminated electrolytes.
- These must be filtered out and disposed of properly.
- Dilute electrolytes prior to disposal with plenty of water, lime or Neutralyt to a pH value greater than 5.

### 21.2 Disposal of electronic waste



- Old appliances and batteries must not be treated as normal household waste.
- At the end of its service life, this appliance, as well as all components, must be brought to a proper disposal site.
- Take the old appliance and components to a collection point for electronic waste.
- For further information, contact your local waste disposal company or your local authority.

## 22 Ordering spare and wear parts



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### Tip for ordering spare and wear parts

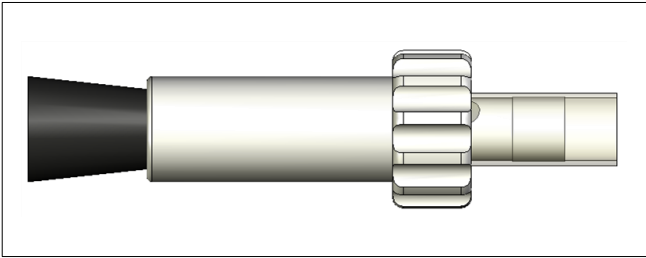
For our complete range of products, including all spare and wear parts, see our general catalogue:

[http://www.oreuter.de/upload/PDFs/REUTER\\_General\\_Catalogue\\_2016\\_en.pdf](http://www.oreuter.de/upload/PDFs/REUTER_General_Catalogue_2016_en.pdf)

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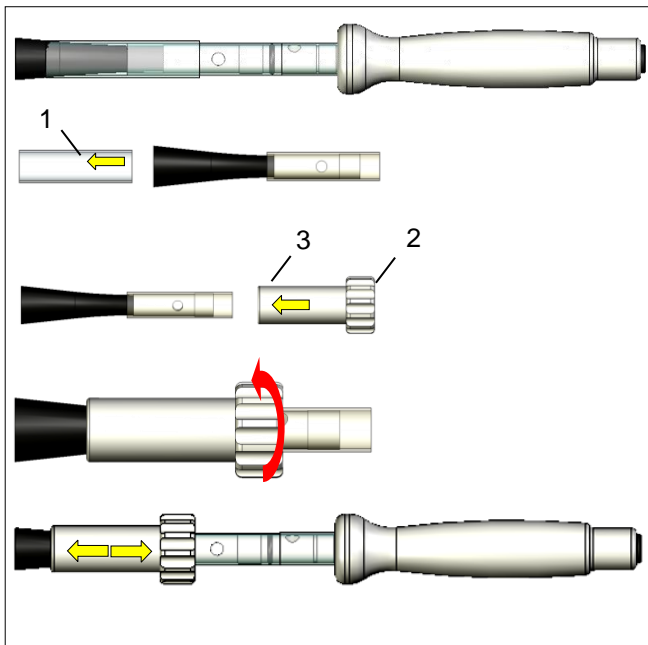
## 23 Optional accessories

### 23.1 Teflon sliding sheath



- This Teflon sliding sheath can be used as an alternative to the standard thin Teflon sliding sheath for XL brushes.
- It is manufactured from solid Teflon and withstands even the toughest stress in continuous industrial application.

### 23.2 Assembly



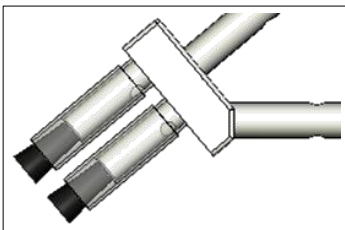
- Remove the original Teflon sleeve (1) from the XL brush.
- Loosen the M22 union nut (2) on the massive Teflon sheath (3) slightly.
- Slide the massive Teflon sheath (3) over the brush.
- Then tighten the union nut (2) slightly.
- In this way, you can move the massive Teflon sleeve (3) with your thumb while you work, without having to stop the cleaning process.
- This ensures that you are always cleaning or polishing with the fibre length best suited to your application.



#### Note

The sheath is subject to almost no wear and can be used again for new replacement brushes.

### 23.3 2 and 4-fold brush

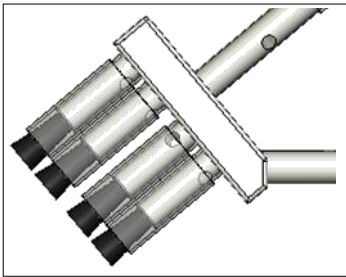


With a 2 and 4-fold brush, you can further increase cleaning and polishing efficiency.

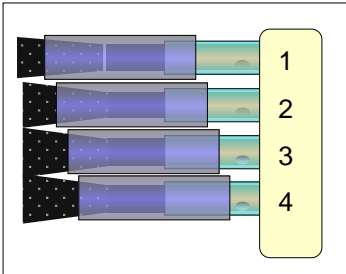


#### Note

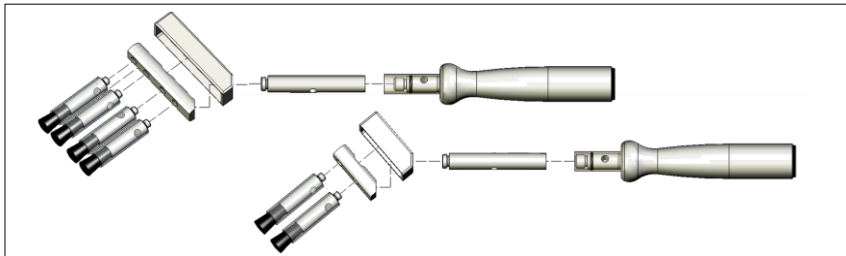
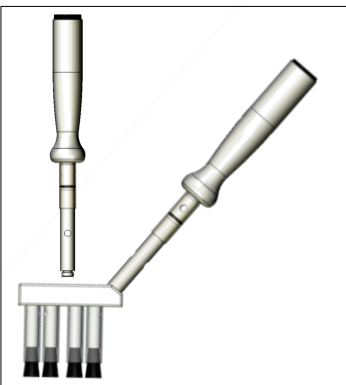
We also always recommend combination with an additional brush extension Item No. EP-02-903.



- The 4-fold brushes can be used as surface cleaners.
  - This allows cleaning with a width of 100mm in a single work step, or cleaning intensively.
  - You can work in a more relaxed way if you screw the handle, with the extension, on at the side, at an angle of 35°.



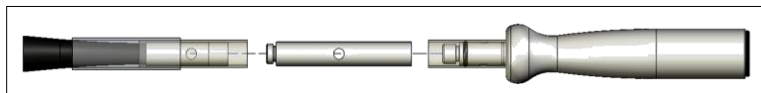
- Brush adjustment:
  - Up to four brushes are placed in succession in the direction of cleaning.
  - Through adjusting the Teflon sheaths on the M brushes to different lengths, you can adjust the performance of the brush.
  - Adjust the carbon fibres of the first brush (in the direction of cleaning) so that approximately 5mm are protruding.
  - As a result, the carbon fibres are more focused and more concentrated light arcs are formed.
- Adjust the subsequent brushes so that the fibres protrude 2-3mm further out each time.
- The fibres of the last brush should protrude approx. 15-20mm.
  - The fibre ends fan out further and bring about a smooth transition at the edge of the weld.



### 23.4 Extension



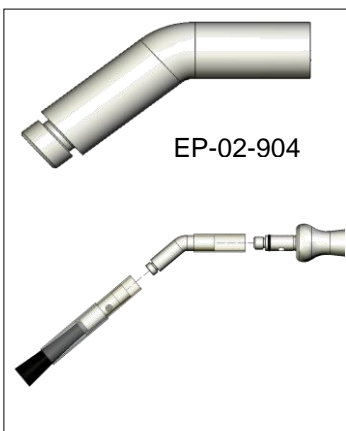
- With the optional extension, you can extend the handle as desired by connecting several pieces together, or combine it with knee pieces or multiple brushes, if required.



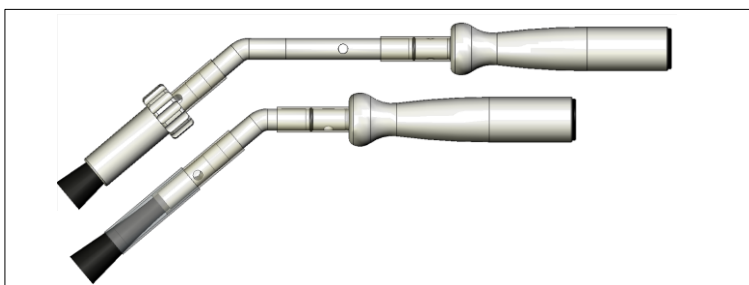
#### Tip

Using an extension not only increases the operating range, but also keeps your fingers further away from the workpiece so that fewer hot splashes reach your hands.

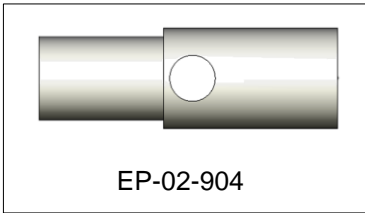
### 23.5 Knee piece



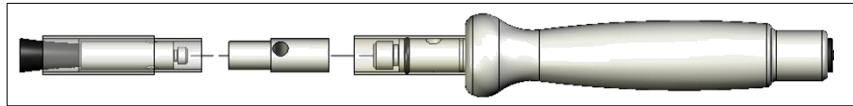
- With the optional knee piece, you can adjust the handle to suit your specific cleaning tasks and workpiece geometries.
- If required, you can combine it with extension pieces or multiple brushes as desired.



### 23.6 Adapter brush



- The optional adapter also allows you to use the small M or S brushes.
  - This enables you to reach the corners more easily.



**Note**

The adapter is absolutely necessary in order to use the M or S brush.

### 23.7 Surface cleaner



- The surface cleaner enables you to clean and passivate large-area workpieces such as tanks, silos, containers.
- The surface cleaner set consists of
  - Rectangular bucket
  - Cleaning pad
  - Handle, length adjustable
- Attach the cleaning pad to the handle.
- Then connect the black cable to the jack on the appliance.
- Select the appropriate performance level "II" on the appliance (SuperCleanox VI).



**Tip**

Rust removal and passivation is best achieved with SuperCleaner electrolyte and performance level III polishing. Afterwards, flush the cleaned area thoroughly with plenty of water.

## 23.8 Printer

Printer type	Description	Item No.:
	<p><b>PT-9800PCN</b> Professional labelling machine for the PC, network connection, print resolution 360 dpi, band width 18-36 mm, incl. mains cable / USB cable</p>	<p>EP-05-222</p>
	<p><b>PT-9700PC</b> Professional labelling machine for the PC, print resolution 360 dpi, band width 18-36 mm, incl. mains cable / USB cable</p>	<p>EP-05-202</p>
	<p><b>PT-E550WVP</b> Professional labelling machine for industrial application, print resolution 180 dpi, band width 18-24 mm, WLAN, incl. Li Ion battery, mains cable / USB cable, carrying case</p>	<p>EP-05-220</p>
	<p><b>PT-H500</b> Professional labelling appliance with PC connection, print resolution 180 dpi, band width 18-24mm, supplied without batteries / mains cable incl. USB cable</p>	<p>EP-05-221</p>
	<p><b>PT-D600VP</b> Professional labelling machine including colour display, print resolution 180 dpi, band width 18-24mm, incl. mains cable / USB cable, carrying case</p>	<p>EP-05-204</p>

Table 12 Printer

## 24 EC - Declaration of Conformity

Appliance designation: "SuperCleanox VI".

Appliance for the electrochemical cleaning, marking and polishing of metals.

The version of the appliance marketed by us conforms in design and type to the

requirements of the following directives:

- EC Low Voltage Directive 2006/95/EC



Applied standards:

- EN 61558-1 (VDE 0570)

In the case of unauthorized changes, unauthorized repairs, or modifications that are not expressly authorized by the manufacturer, this declaration becomes invalid.

A handwritten signature in blue ink, appearing to read 'O. Reut'.

Erkrath, 06/01/2012

Company stamp / signature