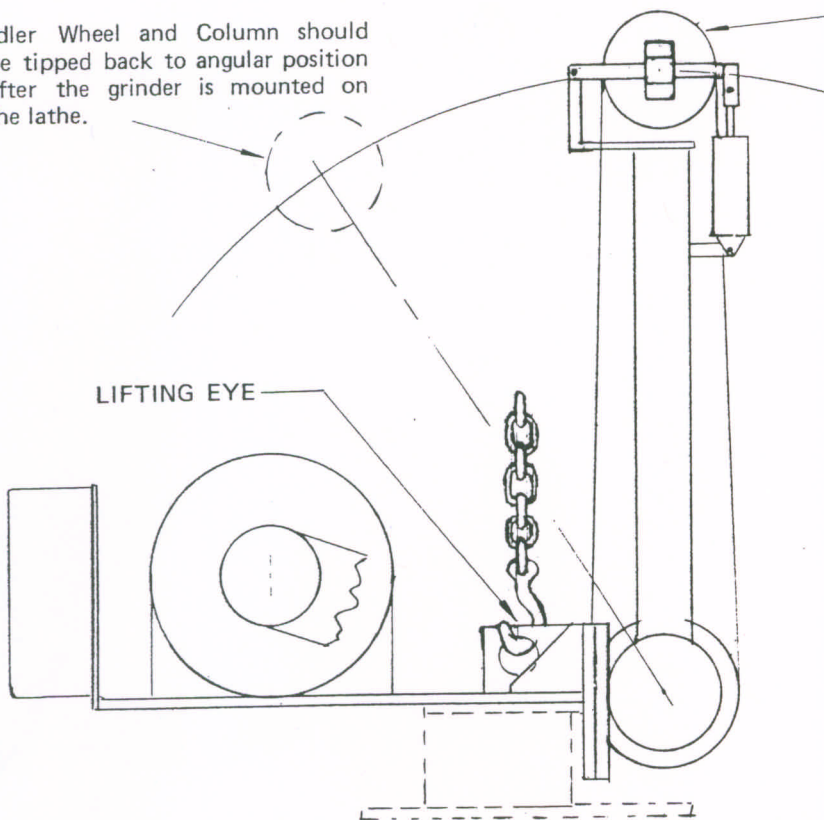


INSTALLATION and MAINTENANCE INSTRUCTIONS FOR G&P ABRASIVE BELT GRINDER

MODELS - RG-290-5, RG-390-5, RG-390-7, RG-490-7, RG-390-10, RG-490-10, RG-390-15, RG-490-15

Idler Wheel and Column should be tipped back to angular position after the grinder is mounted on the lathe.

Idler Wheel and Column should be in vertical position when grinder is removed from skid and placed on lathe.



MAINTENANCE INSTRUCTIONS

LUBRICATION

The ball bearings in the contact wheel bearing housing should be greased every 100 hours of use with Shell Darina AX-70330 or equivalent. There is a grease fitting at the V-belt pulley end of the contact wheel shaft. The idler pulley has sealed-for-life type ball bearings that do not need to be lubricated. Do not lubricate excessively as this will cause bearings and bearing housing to overheat.

ADJUSTMENTS

The main beam may be tilted if necessary by loosening the set screws at the beam collar that fits around the contact wheel bearing housing.

ABRASIVE BELT TENSIONING

Tensioning of the abrasive belt is accomplished by the use of an air cylinder and hand valve. The amount of tensioning can be adjusted by increasing the amount of air pressure shown on the regulator gage. The normal setting is around 40 psi.

VEE BELT TENSIONING

Proper tension should be maintained on the vee belts. A squealing noise at startup indicates the belts are loose.

INSTALLATION INSTRUCTIONS

1. Remove the crate and remove the lagging bolts holding the grinder to the skid.
2. Loosen the set screws at the bearing housing and position the idler pulley in the straight up position. Retighten at least one set screw.
3. The grinder can now be lifted from the skid, using the eye provided as shown in the drawing above. Use caution in lifting as the grinder is not completely balanced at this point.
4. Place the grinder and the mounting adaptor on the cross slide or compound of your lathe.
5. Using a feeler gage or a piece of paper, position the grinder so the contact wheel is square (as close as possible) with a work piece. The work piece should be chucked in the lathe and secure.
6. When the grinder is secured, connect the electrical power and air line. If a dust collector is used, be sure it is attached to the exhaust outlet of the belt guard.
7. Reposition the idler pulley back to the angular position. Tighten the set screw.
8. Dress the contact wheel as described below.
9. To remove the grinder from the lathe, move the idler pulley back to the vertical position. Place the hook of a chain hoist through the lifting eye and lift cautiously.

TO DRESS THE CONTACT WHEEL, place the grinder on the lathe and look for the best area of the roll. Be sure the grinder is as square as possible. Clean the roll so pressure sensitive abrasive can be placed on the roll. This should go at least 3/4 way around the roll and be 50 to 80 grit. Start the grinder and move the contact wheel in until it makes contact with the abrasive. Move the grinder back-and-forth completely across the abrasive both ways. This must be repeated until the entire surface of the contact wheel has been dressed. Don't plunge cut.

GRINDING & POLISHING MACHINERY CORP.
2801 TOBEY DRIVE, INDIANAPOLIS, IN 46219-1419
PHONE - 317 - 898-0750

PRINTED IN U.S.A.

(G+P)
MACHINERY