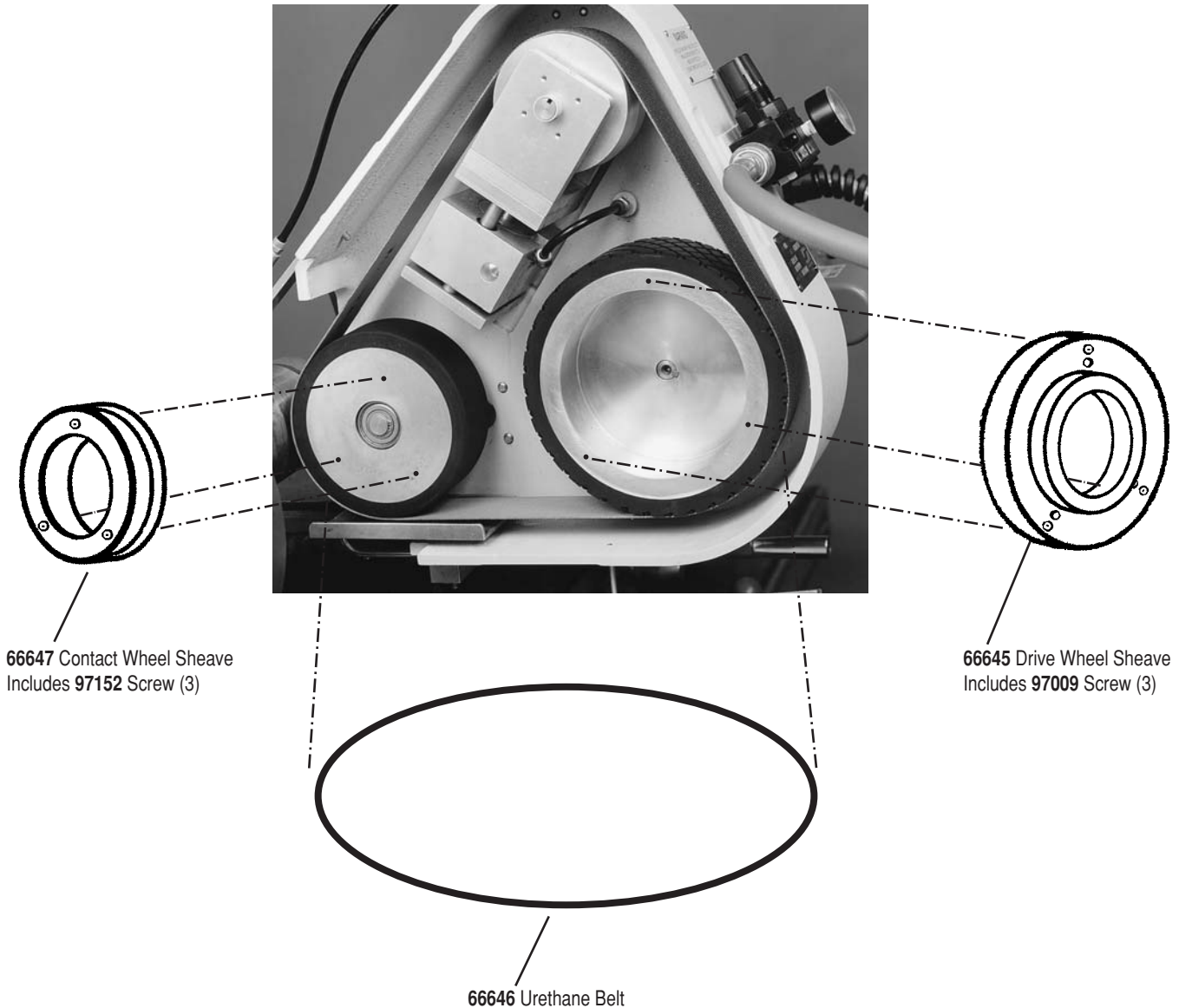


Instructions for Dressing Contact Wheels

For Use on All 2" x 48" Tool Post Grinders



Kit Includes:

95050 Hex Key
95052 Hex Key
97009 Button Head Screw (3)
97152 Cap Screw (3)
66645 Drive Wheel Sheave
66646 Urethane Belt
66647 Contact Wheel Sheave
93053 PSA Disc 100x

While the contact wheels for these machines are designed and manufactured to strict tolerances; on occasion it may be desirable to "dress" this wheel after the tool has been mounted. This will ensure removal of any out of round condition, correct any imperfections which may be created by centrifugal force acting on the elastic faces of the wheel and also provide perfect alignment of the contact wheel to the workpiece.

For these cases, we have provided a pulley system which can be attached to the grinder to drive the contact wheel at operating speed, without an abrasive belt installed on the tool. (Normally the contact wheel is idle)

1. Mount tool to the lathe as normal so that the contact wheel is at or slightly above the operating centerline of the lathe and so the face of the contact wheel is parallel to the "Z" axis of the lathe. Use a dial indicator to confirm this.
2. Tighten tool firmly once these above criteria have been met. Re-check parallelism to ensure the tool has not moved.
3. Install Drive Wheel Sheave 66645 to the drive wheel using (3) screws 97152. If this sheave is to stay attached to the tool, it is imperative to use a thread locking agent such as "LOCTITE" on the screws to prevent loosening during normal operation.
4. Repeat this process with Contact Wheel Sheave 66647 using screws 97009. This sheave may need to be removed after use if working into workpiece shoulders.
5. Connect air supply to tool and turn air belt tensioning on. This will move and hold the tension/tracking wheel in its fully extended position and provide clearance for installation of urethane Belt 66646.
6. Stretch Belt 66646 around the sheaves and install machine belt guard.
7. At this time, it is necessary to have a workpiece installed on the lathe which is: Perfectly round. Running perfectly "true". Perfectly aligned on the "Z" axis of the lathe. These items must be verified in order to produce the desired end result.
8. Evenly attach PSA disc 93053 to a cleaned section of the workpiece. If less than 2 inches in diameter, it may be necessary to trim the PSA disc so it does not overlap itself.
9. Slowly rotate the workpiece (20 -30 RPM) in reverse direction so the part advances towards the grinder from the bottom - up.
10. Turn grinder on. Once to operating speed, slowly move the contact wheel into the abrasive disc until just touching. Slowly (.001 - .002" at a time) advance until it is apparent that the entire contact wheel surface has been "dressed".
11. Shut down the grinder and the lathe. Remove urethane belt and the appropriate sheaves. Install an abrasive belt onto the grinder and adjust tracking. Machine is now ready for operation.



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