

632 MANUAL CONTROL QUICK REFERENCE GUIDE

“SPIN” Grind Process

****WARNING****: This guide is for “QUICK REFERENCE” ONLY!
Read manual for detailed setup procedures and operational instructions. Follow all safety instructions in the operators manual!

ALWAYS CHECK FOR

- 1.) Bent or broken blades.
 - 2.) The reel spins freely in the frame.
*** 3 Main Switches OFF ***
 - 1.) Traverse Switch - Off
 - 2.) Spin Drive Toggle Switch
(Middle Position) - Off
 - 3.) Grinding Wheel Switch - Off
- SPIN / RELIEF Button in Spin Mode (up)**

STEP BY STEP

- 1.) Position the reel into machine : Use your settings for the **Horizontal and Vertical Brackets**.
- 2.) Clamp two front clamps, rear roller, and connect spin drive.
- 3.) Use the **digital alignment set up gage** - From the front first, then from the bottom.
- 4.) **SET PROX. SWITCHES** to where the grinding wheel FULLY comes off of the reel blade. The right hand prox. should be positioned where the blade clears the fixed finger, but remains on the spring loaded index finger
- 5.) Jog the grinding wheel up to make contact with the reel blade, and then slightly lower the stone.
- 6.) Close doors and turn on :
 - **GRINDING WHEEL**
 - **SPIN DRIVE** toggle switch up (clockwise direction)
- 7.) Travel to the center of the reel, with infeed speed switch in **TURTLE (slow)** mode, upfeed the grinding wheel until you make contact.
- 8.) Traverse and check for taper of the reel, jogging the grinding head down if necessary.
- 9.) Find the correct spin speed.
- 10.) Upfeed when appropriate.

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****Read manual for set up and operational instructions****

SWITCHING TO THE RELIEF GRIND PROCESS

ROTATE TRAVERSING SPEED DIAL DOWN AT RIGHT HAND PROX.

STEP BY STEP

- 1) **TURN OFF : Spin Drive Motor and Grinding Wheel .**
- 2.) Jog grinding head down slightly, and travel left to the center of the reel.
- 3.) Change spin grinding stone to relief stone.
- 4.) Pull “T” handle on left side of head, and rotate relief finger assembly into relief position.
- 5.) Jog grinding head up to trap the reel blade between the stone and the finger.
- 6.) Pull roll pin on the right side of head and release the spring loaded index finger.
- 7.) Adjust dowel to 1/32” to 1/16” play behind reel blade.
- 8.) Jog down slightly and travel left until the spring loaded index finger pops up and off of reel blade, and the blade comes off of the stone. Stop travel at this point.
- 9.) **RESET THE LEFT HAND PROX.**
- 10.) Travel back to the right hand prox. applying pressure to keep the reel on the fixed finger if needed.
- 11.) **CLOSE** the doors.
- 12.) Turn relief spin torque knob all the way down.
- 13.) Change to relief mode, (change “switch” from spin to relief).
- 14.) Turn on Spin Drive Toggle switch **DOWN** (COUNTER CLOCKWISE).
- 15.) Rotate the relief torque dial, slowly, until the reel blade indexes hard enough to push the dowel all the way back.
- 16.) Turn ON grinding wheel.
- 17.) Turn traverse dial up and travel left.
- 18.) Jog up and grind, infeeding as needed. Grind until there is 20% to 30% land area.