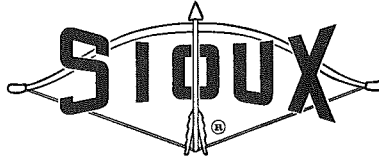




NOTE: Parts are no longer available for this tool.

The manual will continue on the next page.



CORRECTION OF UNEVEN GRINDING PRESSURE ON 680 VALVE GRINDING MACHINE

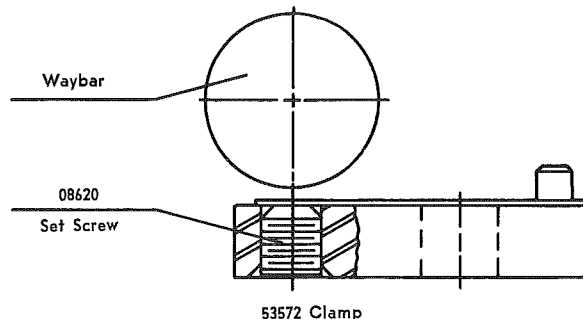
When pressure is heavier in one direction than the other while dressing the grinding wheel or grinding a valve, it is most generally caused by wear on the carriage plate waybars (24201), improper adjustment of the clamps (53572) or lack of lubrication. See pages 1, 14, and 16 in the Parts List.

The proper adjustment of the clamps (53572) is very important. If one or both of the front clamps are too tight, the pressure on the grinding wheel will be heavier when moving the carriage plate to the left. If the rear clamp is too tight, the pressure will be heavier when moving the carriage plate to the right.

Loosen the three (08620) set screws. There are two (53572) clamps on the front waybar and one on the rear.

1. Screw the rear set screw in until contact is made with the waybar, then unscrew it at least $\frac{1}{4}$ turn.
2. Tighten one front set screw at a time while moving the carriage plate. Contact with the waybar should be very light so that the traverse action will remain smooth. Repeat this adjustment with the remaining front clamp.

Check grinding pressure by dressing the wheel with a light, slow cut of the diamond. The first cut should show a bright steady spark. Without advancing the wheel or diamond, bring the diamond back across the wheel. A faint but steady spark should be noticeable and subsequent passes over the wheel should not remove any material until the diamond is again advanced.



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This pdf incorporates the following model numbers:

680, 53572