CORRECTED COPY

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D E P A R T M E N T O F T H E A R M Y T E C H N I C A L M A N U A L

OPERATOR'S MANUAL

GRINDING MACHINE, VALVE FACE

(CEDAR RAPIDS ENG, CO.

KWIK-WAY MODEL VL)

FSN 4910-765-6358

This copy is a reprint which includes current pages from Change 1.

H E A D Q U A R T E R S , D E P A R T M E N T O F T H E A R M Y

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INSTRUCTIONS

FOR SETTING UP AND OPERATING
KWIK-WAY MODEL VL VALVE FACING MACHINE

CLEAN MACHINE

Clean machine thoroughly, removing all rust preventatives.

INSTALLATION OF BELTS

All belts have been removed for shipping and are tagged According to location. Install belts according to information given on tag attached to the bait.

OPERATING HANDLE

The hub of the operating handle on this machine is splined so the operating handle can be reset to the satisfaction of the operator. Normal position of the operating lever is to be vertical when the grinder spindle slide is in the middle of travel, but if the operator does decide to reset the handle, it is only necessary to remove the capscrew and washer, slide the hub off the spline and reset to the desired position.

VALVE CHUCKS

The machine as shipped from the factory is equipped with the standard lever-operated chuck that will be used in the capacity range from 9/32" to 5/8". Refer to special instructions for cleaning and installing chucks.

ASSEMBLING LIGHT BULB AND REFLECTOR

Use a standard bulb, 75 watts or less. Moisten the bulb neck before slipping it through the silicone grommet at the base of the reflector. After screwing the bulb in the socket, make sure the air space between the shade and receptacle is equal on all sides. To clean reflector, use mild soap solution and pat dry with a soft cloth.

ELECTRIC MOTOR CONTROLS

The motors are clearly marked as to voltage, cycle, and phase. Check source of supply to be sure that power supply is satisfactory for motor specifications.

Facing the machine the operator will find the push button control for grinder spindle and pump motor on his right. The left hand control switch controls the chuck drive motor, which is not activated until the grinder spindle slide is moved to the left. A micro switch is wired in series with the chuck motor so chuck rotation can be stopped for loading and unloading.

LUBRICATION

The machine is thoroughly lubricated in the test department during run-in and testing, but we recommend the operator lubricate the machine again before