



Tool Post Grinding Attachment

Instruction Manual



BE SURE TO READ THIS MANUAL BEFORE USING

1.Specifications

Grinding wheel size:	80mm diameter x 10 mm width
Available Grits:	60, 80, 120, 180, 240
Spindle Arbor:	20mm
Spindle speed:	6000±10% r/min
Motor power:	250W, 110VAC
Gross weight:	11lbs.

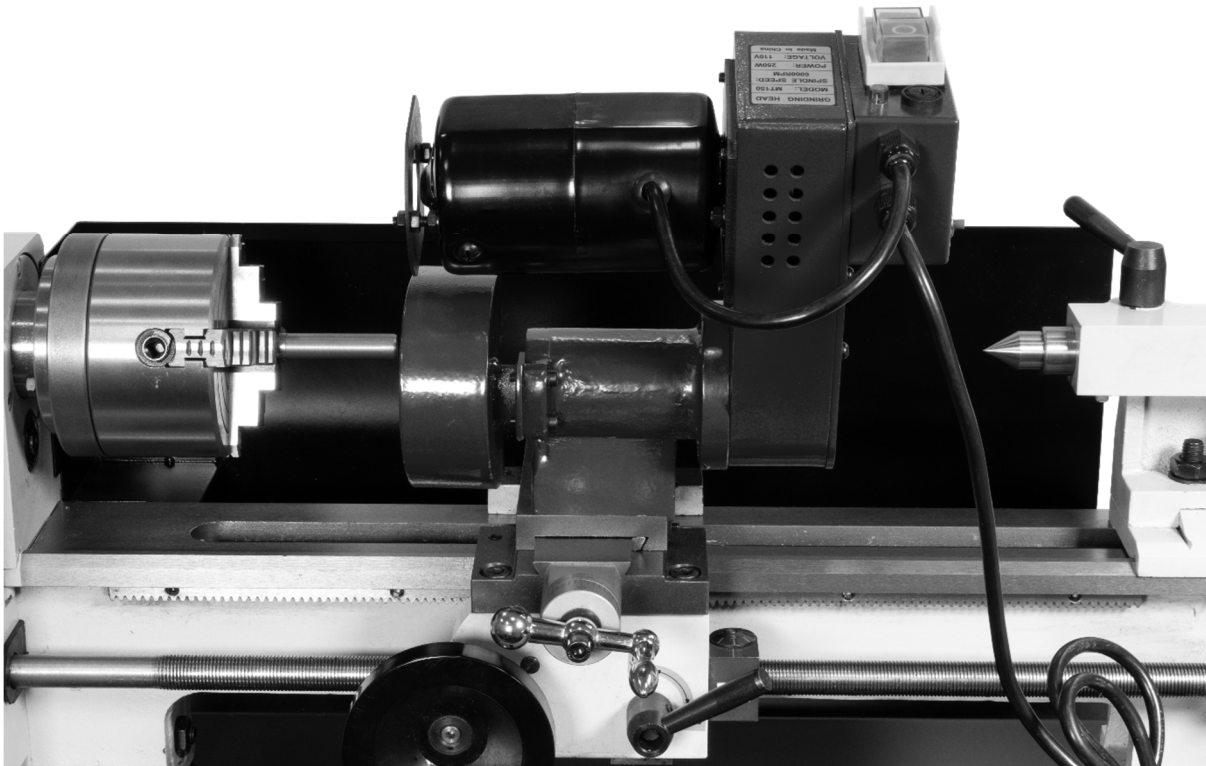
2.General Safety Precautions

Notice: All machines and power tools are dangerous! Ensure your safety, read manual carefully before using.

1. Tighten all fasteners before starting grinder.
2. Inspect grinding wheel for nicks and cracks.
3. Keep the work area clean and dry.
4. Use safety goggles or glasses.
5. Use a filter mask to prevent dust inhalation.
6. If the main cable or any part of the switch assembly becomes damaged, it must be replaced before use.
7. Always turn off the power and unplug before making any adjustments to the machine.

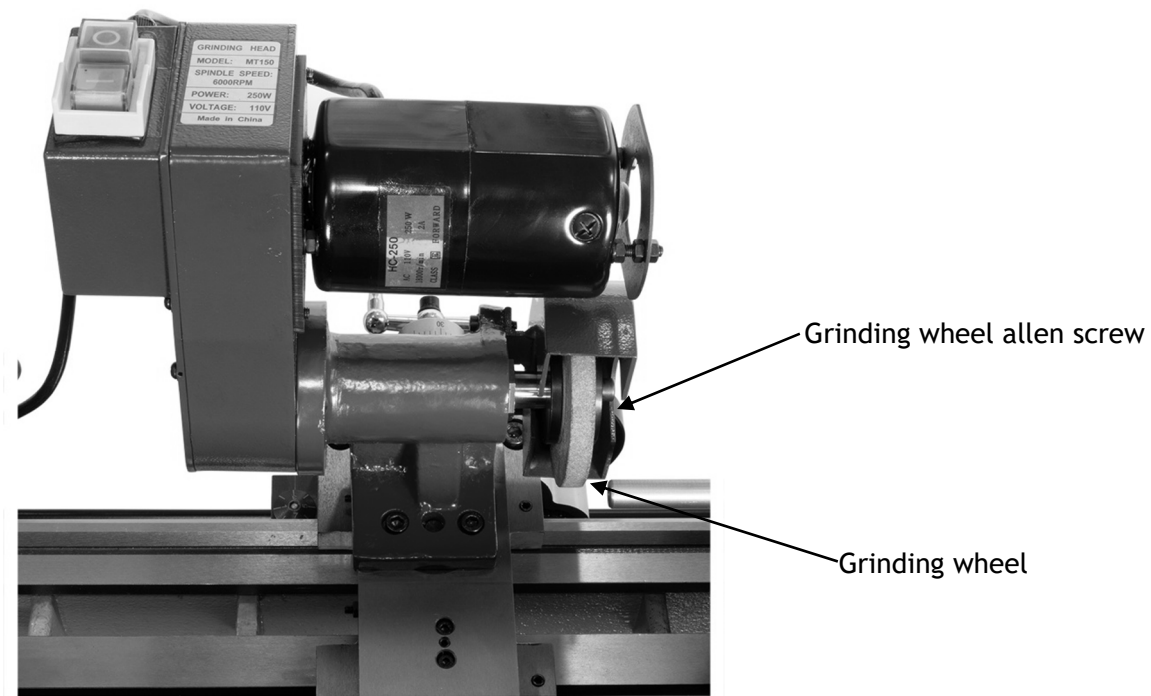
3. Installation and Setup

1. Remove the compound assembly by retracting the compound to expose the compound angle adjustment screws. Remove the screws and the compound assembly.
2. Rotate the compound disk so that the holes and pivot are parallel to the bed.
3. Mount the grinder in place of the compound of the lathe, with grinding wheel facing away from you and toward the headstock. The compound pivot should be in the center hole of the grinder mounting flange. The grinder mounting flange lip, should be toward the tailstock. (fig. 1)
4. Use the included short M6 allen screw to secure the grinder to the compound swivel disc. **Note:** do not use the compound screws as they are too long and will lock the cross slide.

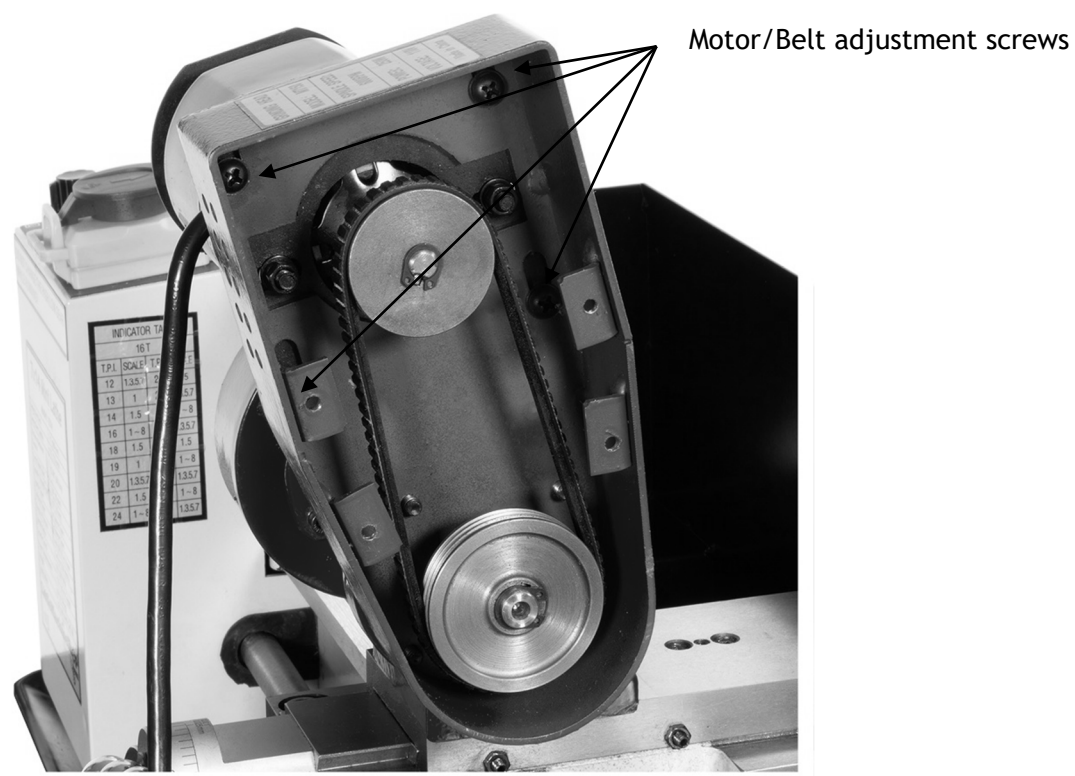


(fig. 1)

5. Ensure the grinding wheel spindle allen screw is tight before starting grinder. (fig. 2)
6. Inspect grinding wheel for nicks and cracks. (fig. 2)
7. Adjust the belt tension, if necessary, by removing cover and loosening Phillips screws to adjust motor tension on belt. (fig. 3)



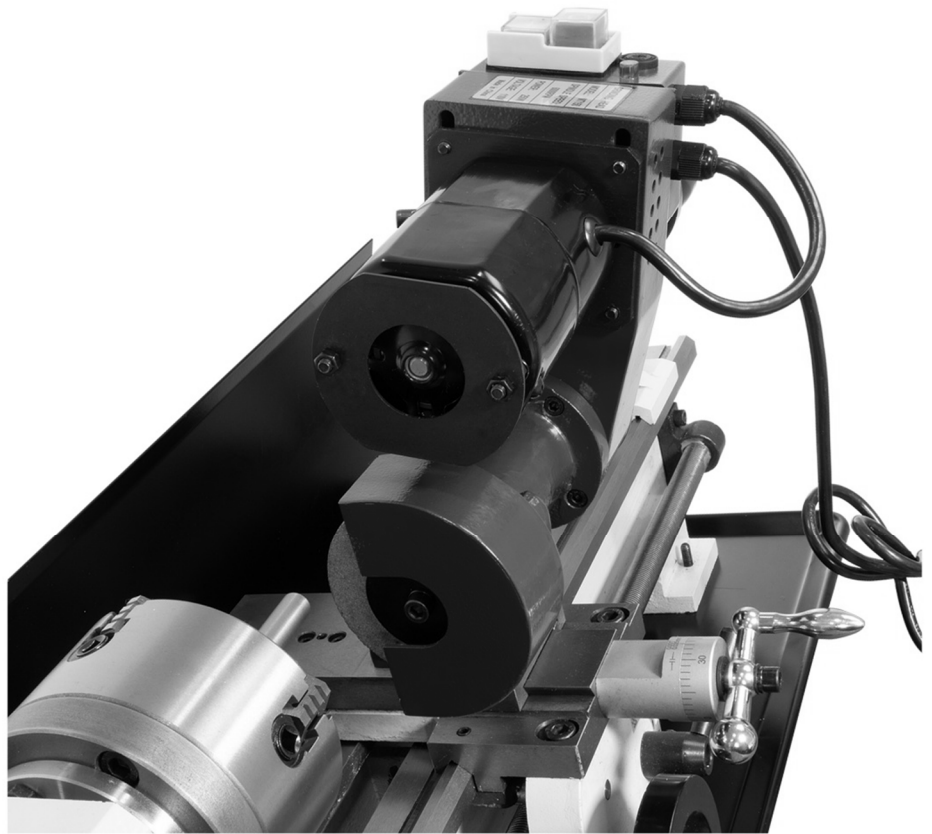
(fig. 2)



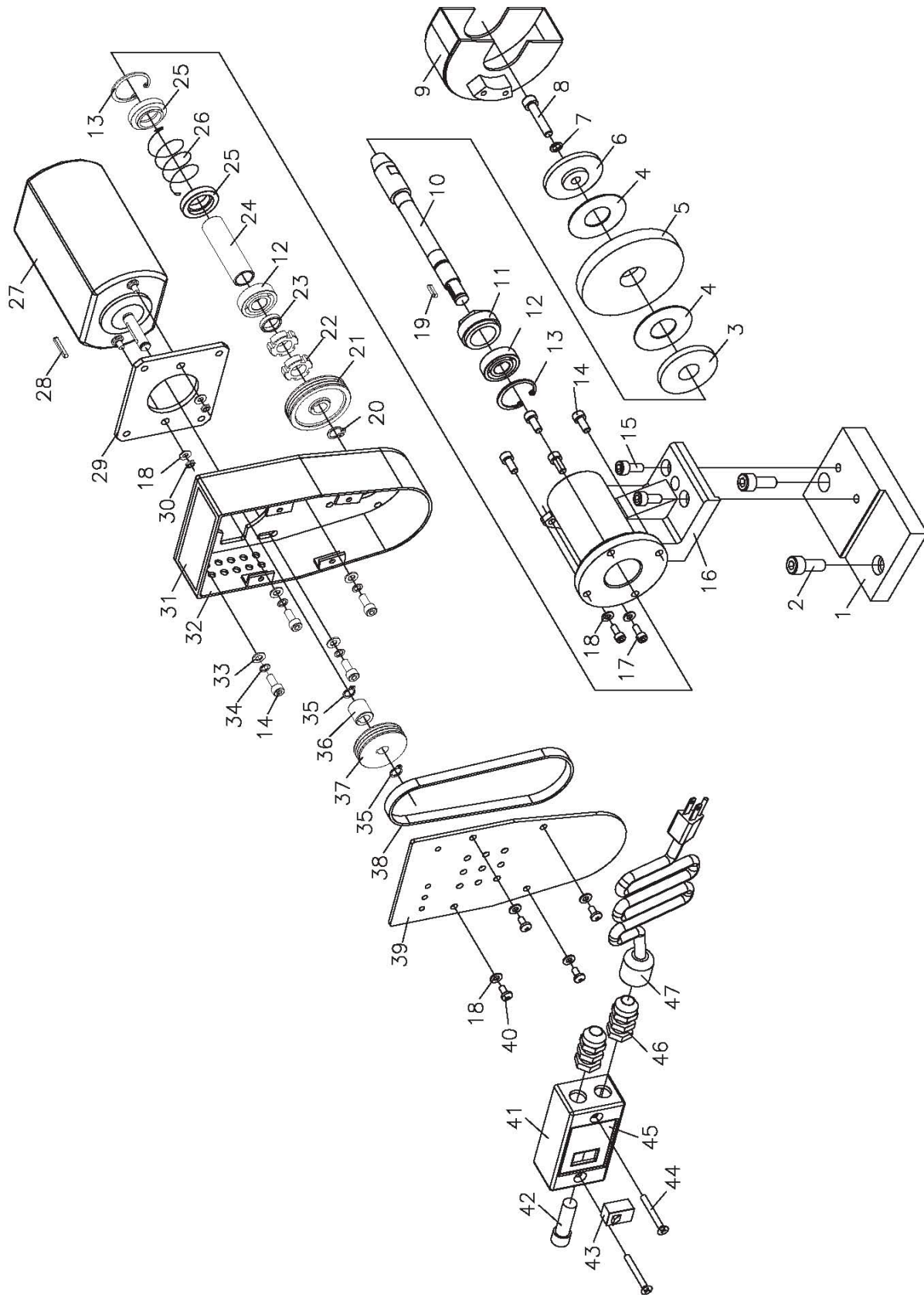
(fig. 3)

4. Operation

1. Mount the workpiece tightly in the chuck, ensuring workpiece is centered.
2. Position grinder to start of operation. It is a good idea to cover ways and precision ground surfaces so that grinding wheel grit does not become entrapped in grooves and on sliding surfaces.
3. Start lathe and choose a slow spindle speed.
4. Start grinder and perform grinding operation.
5. When finished, clean up all grinding wheel grit and debris and wipe down all precision surfaces.



5. Parts Diagram



6.Parts List

No.	Description	Q'ty	No.	Description	Q'ty
1	Block up (optional parts)	1	25	Spring seat	2
2	Screw M8*20 (optional parts)	2	26	Compression spring	1
3	Grinding wheel pressing(2)	1	27	Motor	1
4	Rubber pad	2	28	key 3*20	1
5	Grinding wheel	1	29	Motor adjust plate	1
6	Grinding wheel pressing(1)	1	30	Nut M4	2
7	Spring washer	1	31	Label	1
8	Screw M6*25	1	32	Boby case	1
9	Protect Cover	1	33	Washer 5	4
10	Spindle	1	34	Spring washer 5	4
11	Locking bolt	1	35	Check ring 8	2
12	Bearing	2	36	Motor shaft space	1
13	Check ring 28	2	37	Capstan	1
14	Screw M5*10	8	38	Belt	1
15	Screw M6*14	2	39	Cover	1
16	Support	1	40	Screw M4*8	4
17	Screw M4*10	2	41	Electric box	1
18	Washer 4	8	42	Fuse	1
19	Key 3*12	1	43	Power switch	1
20	Check ring 10	1	44	Screw M4*35	2
21	Driven pulley	1	45	Switch label	1
22	Round nut M12*1.25	2	46	Lock nut M12	2
23	Septa posterior	1	47	Power line	1
24	Spacer	1			

7. Packing List

Part Name	Q'ty
Grinding head 150	1
Green grinding wheel	1
Red grinding wheel	1
Inside six born wrench 5mm	1
Inside six born wrench 6mm	1
Double end Wrench 14*17	1
Carton for Grinding head 150	1