WOLFHEAD™ OPERATING & MAINTENANCE

INSTRUCTIONS & PARTS LIST

16 BRUSH and 32 BRUSH MODELS -- MANUAL FEED

ABRASIVE LOADING:

The 32 brush and 16 brush heads use an abrasive loading having strips of abrasive 16" long. Four of these strips are held together with a cloth loop. These four strips and the loop are called an assembly. Some abrasive manufacturers include the loop in their measurements and show a length of 19- 3/8".

One complete filling of a 32 brush head is called loading. This consists of 8 assemblies. The 16 brush head uses only 1/2 loading--or 4 assemblies.

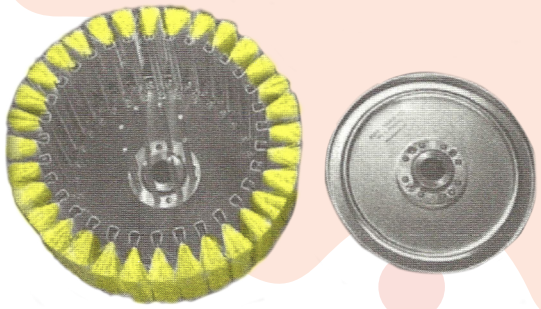

Photo 1

INSTALLATION:

The abrasive loading may be installed in the Head while the Head is mounted on a spindle, or with the Head laying on a bench or table. Because of interference from the guard that surrounds the head when it is on the spindle, it may be easier to load while off the spindle.

With the cap plate removed, (see photo 1) install each assembly with the cloth loop over on of the pins of the cylinder pin and them abrasive strips projecting between 4 adjacent brush holders and brushes (see photo 2).

Photo 2

The assemblies should be placed in the Head so that when the Head is rotating, the grain (abrasive side of the strips) will be making contact with the part that is to be sanded or polished. With all assemblies in place, you will have strips of abrasive extending beyond each brush tip approximately 12 inches (see photo 3).

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Replace the cap plate. *DOUBLE CHECK TO MAKE SURE THE PINS OF THE CYLINDER PIN ASSEMBLY ENGAGE THE HOLES IN THE CAP PLATE ASSEMBLY, AND MAKING SURE THE ENDS OF ALL BRUSH HOLDERS ARE ENCLOSED WITHIN THE LIP OF THE CAP PLATE* (see photo 4 -- arrow A s pointing to the ends of the brush holders that must be completely enclosed by the lip to which arrow B is pointing.)

The head should now be placed on the machine spindle, being careful when sliding it on that the cap plate does not become dislocated in relation to the pins and brush holders as described in photo 4. The spindle nut should now be replaced drawing it finger tight.

With the head in position on the machine spindle, use the wrenches provided to wind in the abrasive by using on wrench to hold the hub and back plate stationary while using the other wrench to turn the hub and cap plate in the direction the head will rotate when running (see photos 5 & 6). Wind until approximately 1/2" to 3/4" of abrasive is left protruding beyond the ends of the brushes. NOTE: If the cap plate is turned opposite the direction the head will be rotating, the spindle nut may come loose during use and the abrasive unload.

Tighten the spindle nut making sure it is locking the cap plate. It may be necessary to place a spacer between the head and the nut to accomplish this. With the head locked in place, jog it a couple times (turn on and immediately off) and check it for run out.

When doing this, centrifugal force may cause the abrasive strips to protrude slightly more than the amount extended prior to running the head.

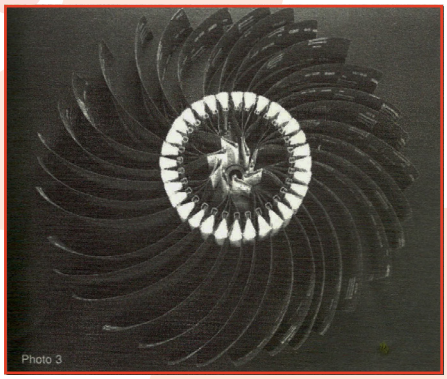
Photo 3

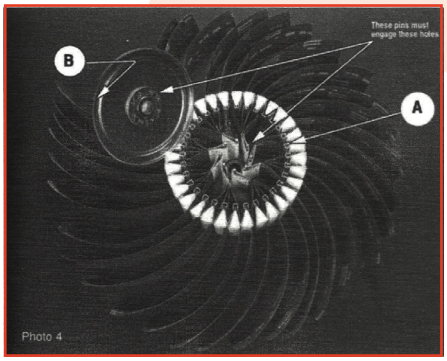

Photo 4

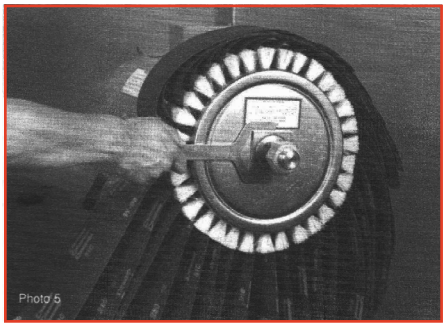
Photo 5

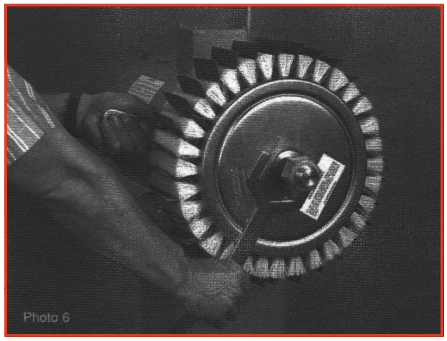
Photo 6

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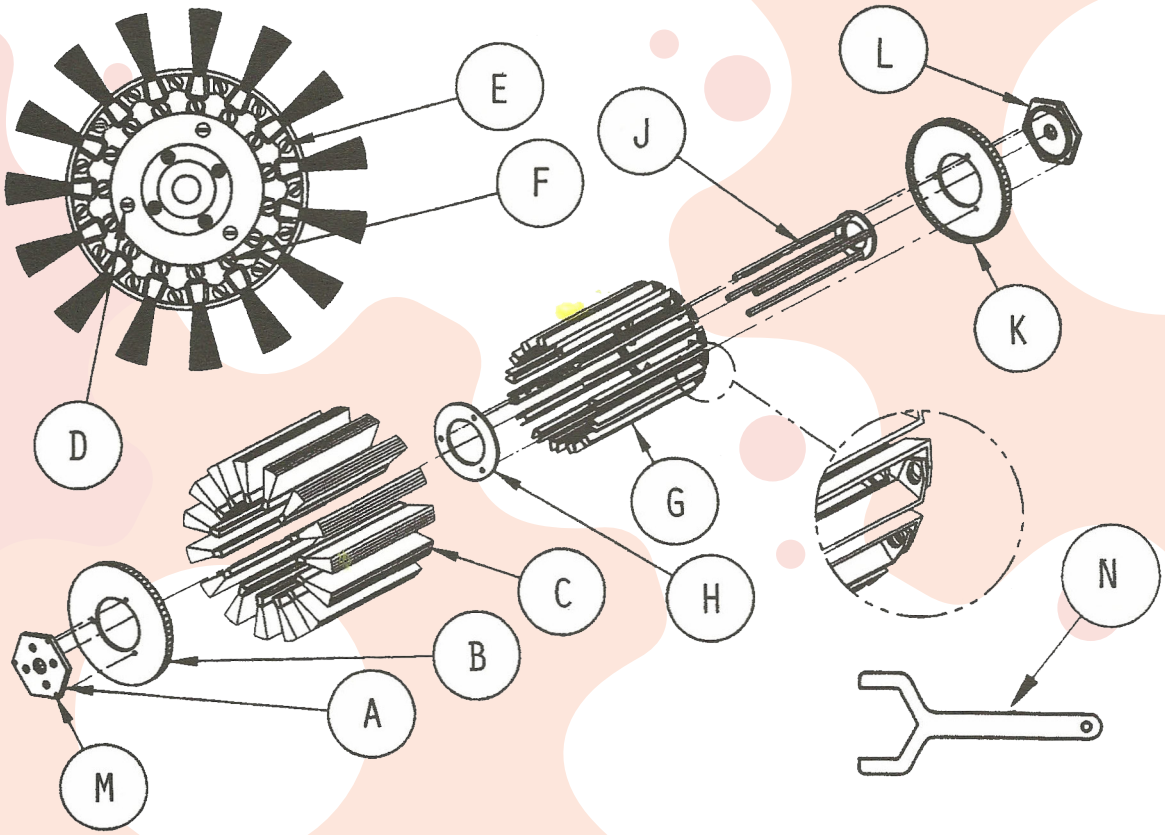

16 BRUSH MODEL

ITEM	PART NAME	WH-1041	WH-1042	WH-1044	WH-1046	QUANTITY
A	HUB - CAP PLATE SPECIFY BORE SIZE	SH-474	SH-474	SH-474	SH-474	1
B	CAP PLATE	SH-404	SH-404	SH-404	SH-404	1
C	BRUSH- 1-1/2" Std. Trim	SH-357	SH-215	SH-65	SH-91	16
	or 3-1/2" Long Trim	SH-358	SH-306	SH-304	SH-309	16
D	10-32 x 5/8 Round Head Mach. Screw and #10 Lockwasher					3
E	10-32 x 5/16 Pan Head Screw and #10 Lockwasher					16
F	10-32 x 1/4 Fillister Head Screw and #10 Lockwasher					16
G	BRUSH HOLDER	P-1001	P-1002	P-1004	P-1006	16
H	RETAINER FOR PIN ASSEMBLY	SH-475	SH-475	SH-475	SH-475	1
J	PIN ASSEMBLY	SH-472-1	SH-472-2	SH-472-4	SH-472-6	1
K	BACK PLATE	SH-478	SH-478	SH-478	SH-478	1
L	HUB - BACK PLATE SPECIFY BORE SIZE	SH-407	SH-407	SH-407	SH-407	1
M	10-32 x 3/8 Round Head Machine Screw and #10 Lockwasher					3
N	Adjusting Wrench	SH-355	SH-355	SH-355	SH-355	2

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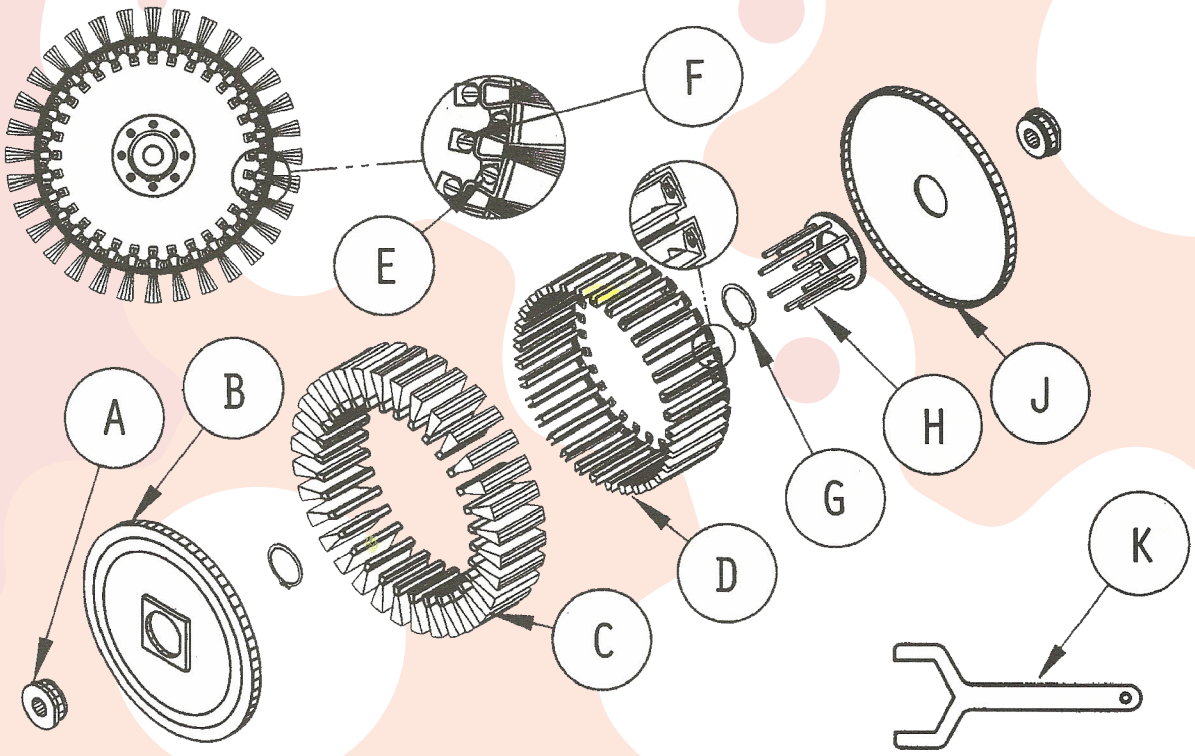

32 BRUSH MODEL

	PART NAME	W-1001	W-1002	W-1004	W-1006	QUANTITY
A	HUB - SPECIFY BORE SIZE	P-1009-15	P-1009-15	P-1009-15	P-1009-15	2
B	CAP PLATE	P-1035	P-1035	P-1035	P-1035	1
C	BRUSH- 1-1/2" Std. Trim	SH-357	SH-215	SH-65	SH-91	32
	or 3-1/2" Long Trim	SH-358	SH-306	SH-304	SH-309	32
D	BRUSH HOLDER	P-1001	P-1002	P-1004	P-1006	32
E	10-32 x 5/16 Pan Head Screw and #10 Lockwasher					32
F	10-32 x 1/4 Fillister Head Screw and #10 Lockwasher					32
G	RETAINER RING	5100-200	5100-200	5100-200	5100-200	2
H	PIN ASSEMBLY	P-1018-1	P-1019-2	P-1020-4	P-1021-6	1
J	BACK PLATE	P-1036	P-1036	P-1036	P-1036	1
K	Adjusting Wrench	SH-355	SH-355	SH-355	SH-355	2

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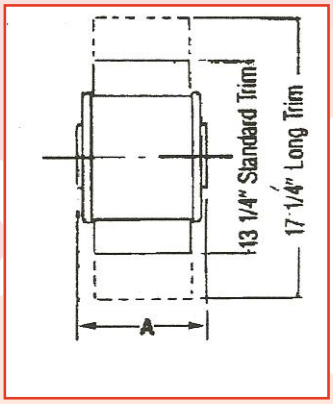
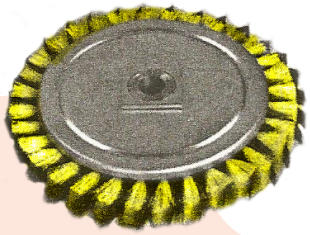
WOLFHEAD™ SPECIFICATIONS

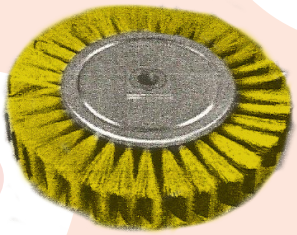
Wolfhead™

32 Brush





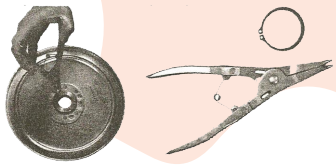
32 Brush
Standard Trim 2" Width



32 Brush Long Trim

Model Number and Abrasive Width	Length through Bore Dim "A"	Bore Size	Recommended Speed (RPM) Standard Brushes	Recommended Speed (RPM) Long Trim Brushes	Maximum Speed (RPM) Standard Brushes	Maximum Speed (RPM) Long Trim Brushes
WH-1041-1"	2 3/4"	5/8 - 1 1/4"	1800	1200-1800	3000	3000
WH-1042-2"	4 1/2"	3/4 - 1 1/4"	1800	1200-1800	3000	3000
WH-1044-4"	6 1/2"	3/4 - 1 1/4"	1800	1200-1800	3000	3000
WH-1046-6"	8 1/2"	3/4 - 1 1/4"	1800	1200-1800	3000	3000

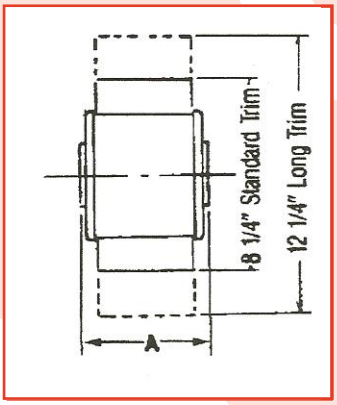
HUB CHANGE



The hubs of the 16 brush heads are secured to the cap plate and back plate with three screws. The only tool needed to change these is a screw driver.

The hubs for the 32 brush heads are easily changed, but it is almost essential that snap ring pliers be used to remove and install the snap ring. Many shops have these. If however, you do not have any, they are available from G&P.

16 Brush



16 Brush
Standard Trim 2" Width

16 Brush Long Trim

Model Number and Abrasive Width	Length through Bore Dim "A"	Bore Size	Recommended Speed (RPM) Standard Brushes	Recommended Speed (RPM) Long Trim Brushes	Maximum Speed (RPM) Standard Brushes	Maximum Speed (RPM) Long Trim Brushes
W-1001-1"	2 3/4"	3/4 - 1 1/2"	1200	1200	1800	1800
W-1002-2"	4 1/2"	3/4 - 1 1/2"	1200	1200	1800	1800
W-1004-4"	6 1/2"	1" - 1 1/2"	1200	1200	1800	1800
W-1006-6"	8 1/2"	1 1/4" - 1 1/2"	1200	1200	1800	1800

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When installing a new abrasive loading in a 16 brush head, it may be necessary to trim the ends of each strip so the same amount of abrasive is extending beyond each brush. Most commercially available loadings are assembled so the ends extend the same distance from each brush when installed in a 32 brush head. Since a 16 brush head is of smaller diameter, the amount of abrasive extending beyond each brush will not be equal. A scissors or metal snips can be used for this.

ADJUSTMENTS:

When fresh abrasive is required, stop the Head and loosen the spindle nut only slightly, enough to allow turning the cap plate in the direction opposite normal head rotation. The proper distance to turn this can best be determined by experience, but as a starting suggestion, either place a pencil mark on the edge of the cap plate or imagine you have a mark there. This mark should be moved approximately 1/4 inch. This will create slack in the loading. Tighten the spindle nut. Double check making sure it is locking the cap plate. When the machine is restarted, extension of abrasive will occur either from centrifugal force, or as soon as work pressure is applied.

BRUSH AND BRUSH HOLDER REPLACEMENT

Brushes can be changed by sliding the worn brush out of the channel shaped holder and inserting the new replacement brush into the open end of the holder.

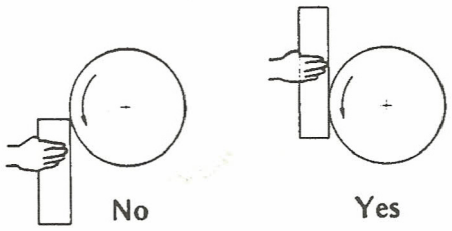
To replace the brush holders, it is first necessary to remove the screws holding the feet of the brush holder to the back plate of the head. After the screws and worn holders have been removed and the new holder is set in position, replace the screws, making sure each screw has a lockwasher. There are two different lengths of screws, the feet on the side of the holder requiring 10-32 x 5/16" pan head screw and #10 lockwasher, and the feet on the back of the holder requiring 10-32 x 1/4" fillister head screw and #10 lockwasher.

WARNING:

When replacing the cap plate, always be sure the ends of each of the brush holders are within the lip of the cap plate.

It is very important to check the condition of the brush holders when replacing the abrasive loading. if they show excessive wear they should be replaced. If a crack appears in the metal, the brush will eventually fly out.

This may cause serious injury.



Proper Holding of Workpiece

These heads must never be used on equipment not having adequate guards. To do so may lead to serious injury.

ALWAYS WEAR EYE, EAR & RESPIRATORY PROTECTION

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