

VONNEGUT INSTRUCTIONS

BULLETIN V-INST OPERATING INSTRUCTIONS – FOR VONNEGUT HEADS 16 BRUSH and 32 BRUSH MODELS – Manual feed.

(For Semi-Automatic Feed Device see Bulletin 127)

ABRASIVE LOADING:

The 32 brush and 16 brush Vonnegut Heads use an abrasive loading having strips of abrasive 16" long. Four of these strips are held together with a cloth loop. These strips and the loop are called assembly. Some abrasive manufactures include the loop in their measurements and show a link of 19-3/8". One complete filling of a 32 brush head is called a loading. This consists of 8 assemblies. The 16 brush head uses only 1/2 loading--or 4 assemblies.

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. With the cap plate and safety ring* removed, (See photo 1) install each assembly with the cloth.

Loop over one of the pins in the cylinder pin assembly and the abrasive strips projecting between 4 adjacent brush holders and brushes. (See 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 13 inches. (See photo 3).

Replace the safety ring* and cap plate, MAKING SURE THE PINS OF THE CYLINDER PIN ASSEMBLY (See photo 4) ENGAGE THE HOLES IN THE CAP PLATE ASSEMBLY, (See photo 5) AND MAKING SURE THE ENDS OF ALL BRUSH HOLDERS ARE ENCLOSED WITHIN THE LIPS OF THE CAP PLATE. (See photo 6) the little finger is pointing to the ends of the brush holders that must be completely enclosed by the lips to which the index finger is pointing.

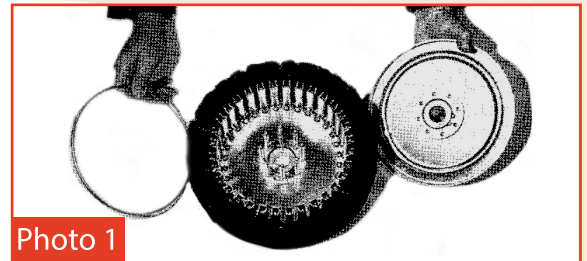


Photo 1

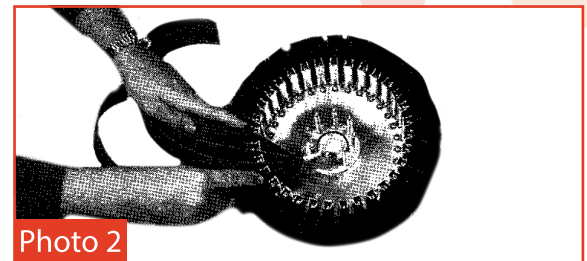


Photo 2

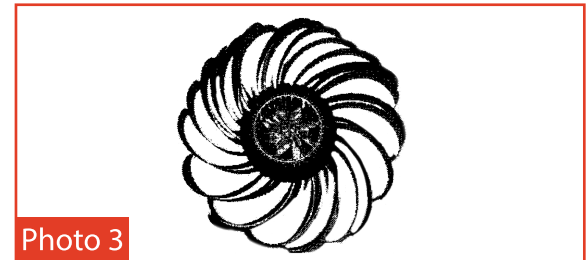


Photo 3

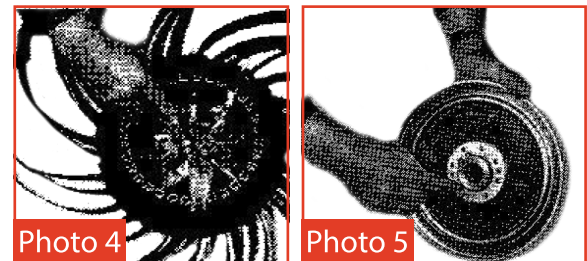


Photo 4

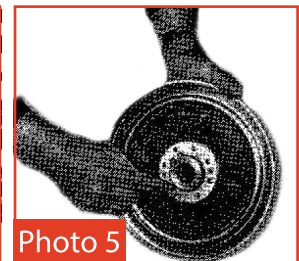


Photo 5

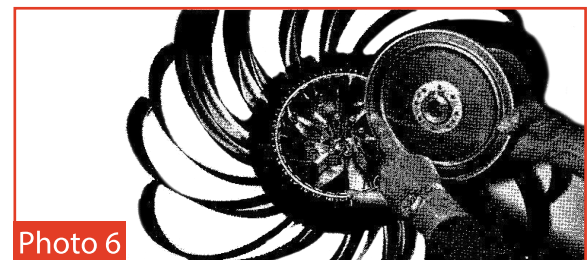


Photo 6



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Mount the head on the spindle, and with the wrenches provided, use one wrench to hold the hex hub and back plate stationary while using the other wrench to turn the hex hub and cap plate in the direction the head will rotate when operating (See photo 7) Wind until approximately 1/2" to 3/4" of abrasive is left protruding beyond the ends of the brushes. (See photo 8) Tighten the spindle nut with the wrench, (See photo 9) and the Head is ready for operation.

If the spindle extends beyond the hub to the extent that the threads do not allow the spindle nut to secure the head, it will be necessary to insert a spacer between the spindle nut and hub. It is important that the head be locked tightly against the shoulder on the spindle. Always be sure that the ends of any spacers that are used are square with the bore of the spacer. If they are not, it may cause the spindle to spring when the nut is drawn tight.

Do not attempt to wind in the abrasive by grasping the ends of the pins with your hand. This may bend the pins. Always wind the abrasive in with the cap plate in place.

ADJUSTMENTS:

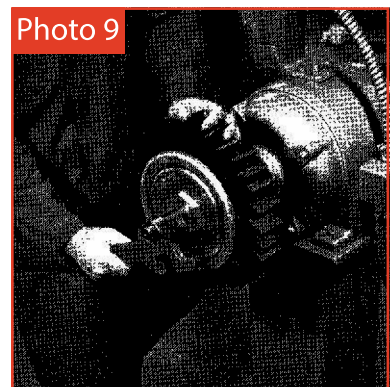
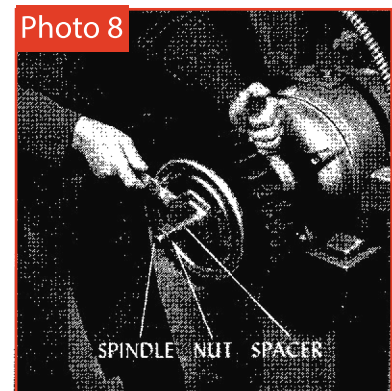
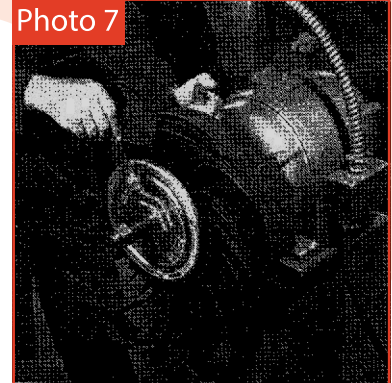
When fresh abrasive is required, stop the head and loosen the spindle nut sufficiently to allow turning the cap plate slightly in the direction opposite normal Head rotation.

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. When the machine is restarted, extension of abrasive will occur either from centrifugal force ... Or as soon as work pressure is applied.

REMEMBER:

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

**Safety ring is not used on 1" wide models.*



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