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Manufacturer of Grinding and Polishing Machinery-Designer and Builder of Special Machinery for Specific Grinding Applications

- Pressure Grinders
- Polishing Lathes
- Stroke Sanders
- Swing Grinders
- Cylindrical Polishers
- Grinding Lathes
- Custom Designs

Light Pole Polisher
Polishes light poles up to 40 FT long with (3) 15 HP grinders Using 6” x 132” Belts.
**Wolfhead**
Brush backed sanding head is perfect for sanding and polishing flat, contour and irregular shapes.

**Variable and Single Speed Polishing Lathes**
Shown with optional belt attachments and tool rest. 5 to 20 H.P.

32 brush Wolfhead is mounted on a UA polishing lathe sanding moldings as they exit a molder.

**Belt Adaptor**
Converts spindle stands to abrasive belt grinders.

**Spindle Stands**

**EPN**
2 H.P. – 1200 or 1800 RPM. Shown with pneumatic drum and Wolfhead.

**PW**
2, 3 or 5 H.P. 1200 or 1800 RPM. Shown without guards.
Platen Grinders Vertical or Horizontal
Wet or dry, available in 2 to 15 H.P.

Pedestal Grinders
For off-hand grinding 2 to 7.5 H.P.

Lathe Mounted Polishers
Converts lathe into O.D. polisher. 2 to 7.5 H.P.

Cylindrical Polishers
Polishes straight or tapered shafts and cylinders from .5” to 3.5” diameters.
Swing Frame Grinders
A abrasive belt and hard wheel 2 to 25 H.P.

Stroke Sanders
Table sizes are 4, 6 and 8 feet long.
Options and accessories available.

Backstand Idlers
Spring and air tension.

Lathe Mounted Roll Grinders
A variety of contact wheels are available
making this grinder ideal for both
roughing and finishing. Precision
bearings and tapered spindle assure
holding close tolerances and uniform finish.
Power Grind
High pressure grinders. Reciprocating & rise and fall tables. 25 to 75 H.P. Single or dual motor. Single or multiple pass grinding.

Cylinder Grinder
Abrasive belt grinding of ice cream beater blades to ±.002" tolerance.

Brushing Turbine Blades with Nylon Brushes.

Rotary Indexing Machines
POWER GRINDERS
BULLETIN PG-3

Reduces abrasive costs & Reduces labor costs

- Grind flat or Curved Surfaces
- 25 to 75 Horsepower
- Programmable Controls
- Single End or Double End
- Single Motor or Double Motor
- Horizontal Reciprocating Table
- Rise and Fall
- Rotary Fixture

Dual Motor Grinder – Reciprocating Table on the left.
Rise and Fall Table on the right with cam for grinding contours.
Power Grinders

Bulletin PG-3

Model: PG 25S-SS
Motor: 25HP

Model: PG 25D-SS
Motor: 25HP (2)

Model: PG 30S-SS
Motor: 30HP

Model: PG 30D-SS
Motor: 30HP (2)

Model: PG 40S-SS
Motor: 40HP

Model: PG 40D-SS
Motor: 40HP

Model: PG 50S-SS
Motor: 50HP

Model: PG 50D-SS
Motor: 50HP

Model: PG 75S-SS
Motor: 75HP

Model: PG 75D-SS
Motor: 75HP (2)

- Single speed of 7500 SFPM – Standard
- Belt size: Length – 132” Standard Width – 10” Maximum
- Heavy Duty 3 7/18 “bore spindle bearings.
- Pneumatic tensioning for abrasive belts.
- Electronically controlled pneumatic brake.

Options:
- Variable Speed
- Belt Oscillation
- Belt Break Interlock

Accessories:
- Reciprocating Table
  Standard horizontal movement-28”
  Standard clearance- 3-3/4” min, 10” max
- Rise and Fall Table
  Vertical movement – 8” standard
  Horizontal movement – 5” standard

- Automatic Feed System.
- Automatic shut-off if belt breaks… A safety feature which provides an interlock to the idler system causing the fixture to react.

Single Motor • Single End Grinder with Reciprocating Table

Rotary fixture on Rise & Fall Table.
The casting is moved into position then rotated up to 108 degrees removing the risers. This picture shows a finished and unfinished part side by side.

Dual Motor Grinder – left side equipped with reciprocating table and rotary fixture for grinding large circular parts or multiple grinding of small parts.

Right side equipped with rise and fall table and horizontal rotary fixture for grinding small parts that have a radius.

G&P Machinery

Grinding & Polishing Machinery Corporation
2801 Tobey Drive / Indianapolis, IN 46219
Phone (317) 898-0750 • Fax (317) 899-1627

Pg 8
Model PG-50D-SS-2RF20
G & P Model PG-50D-SS-2RF20 Dual Motor, Dual Side Power Grinder, with Dual Rise and Fall tables complete with:

- Two (2) 50 horsepower, 1,800 rpm, TEFC, EISA compliant motors for 7,500 feet per minute abrasive belt speed (unless specified otherwise)

- Fully Guarded machine with Air tensioning on 8” wide x 132” abrasive belts and swarf clean out drawers

- Pneumatic spindle brake to rapidly stop spindle during emergency stop and belt break

- Two (2) Multiple pass Rise and Fall Tables, each with:
  - 18” wide x 29” deep tee-slotted table
  - Hydraulic cylinder for 20” (maximum) vertical travel (34 1/2” to 46 1/2” table height from top of base plate)
  - Servomotor and ball screw for table in-feed

- Allen Bradley CompactLogix PLC for single or multiple pass grinding with programmable stroke length and automatic part sensing infeed with 200 part parameter storage for Auto cycling

- Two (2) HMI touch screen panels each on a swing-arm mounted from the grinder base to operate each Machine side independently

- Rapid table advance with slow-down approach for controlled grinding speed and auto. Spark-out pass counter

- Programmable abrasive belt oscillation

- Hydraulic system with pump, reservoir, 110 volt valves, and plumbing for operation of two Rise and Fall tables up / down motions
Model PG-60S-SS-W

G & P Model PG-60S-SS-W Single Motor, Single Side
Power Grinder for wet grinding, complete with:

- One (1) 60 horsepower, 1,800 rpm, TEFC, EISA compliant motor
- Fully Guarded machine with Air tensioning on 16 1/2” wide (maximum) x 132” abrasive belt with automatic belt oscillation between two laser optic sensors to automatically control belt tracking
- Pneumatic spindle brake to rapidly stop spindle during emergency stop, belt break, or safety cage breach
- Reciprocating Bed Table, complete with 18” x 22” tee slotted table
- Hydraulic cylinder with high speed and low speed valves such that the table rapidly feeds in to grind position, grinds at slow speed and then rapidly returns to home position in Automatic mode
- Servo Motor controlled up / down incremental pass grinding in each direction
- Touchscreen for parameter set-up, manual control functions, and storage for parameters up to 200 parts
- Electromagnetic chuck with controller and necessary clamping hardware to mount onto reciprocating table
- Hydraulic system with reservoir, 110 volt valves, and plumbing for operation of reciprocating table.
- Steel base plate for grinder, table, hydraulic system, and deep bed filtration unit.
- NEMA 12 electrical controls with Allen Bradley CompactLogix PLC and 24 volts at HMI touch screen panel on swing-arm mounted from the grinder base extending outside of safety cage
- Grinder built for wet grinding with flood nozzles, coolant reservoir, solenoid valves, splash shields, deep bed filtration system with automatic indexing roll filter media, spray down hose, and all necessary plumbing
- Safety cage to enclose entire machine with safety door to prevent grinder from starting or shut off grinder should it be opened during cycle
**STROKE SANDER - GPSS AND PMC**

**BULLETIN ST-4000**

**Standard Accessories:**
Every Stroke Sander can be equipped with a manually operated traveling shoe.

**Optional Accessories:**
A Contact Wheel assembly with a matchless Contact Wheel (above) can be purchased where more aggressive sanding and/or a shorter scratch pattern is desirable.

**Table Height Adjustment**
The work table can be adjusted by the operator for accurate polishing of the desired material and thickness (illustration #10-A), simply by turning the aluminum knob (illustration #10-B).

**Manual Lift Table**

---

**DOUCET MACHINERIES INC.**
An ISO-9001 Certified Manufacturer of High-Quality Machinery for the Woodworking Industry.

---

**GRINDING & POLISHING MACHINERY CORPORATION**
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
STROKE SANDER - GPSS AND PMC

BULLETIN ST-4000

G&P Machinery - GPSS Heavy Duty Stroke Sanders - MADE IN THE U.S.A.

<table>
<thead>
<tr>
<th>Model</th>
<th>HP</th>
<th>Belt Size</th>
<th>Table Length</th>
<th>Net Weight</th>
<th>Approx. Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>GPSS-6216-7</td>
<td>7.5</td>
<td>6&quot; x 216&quot;</td>
<td>6'</td>
<td>1900 lbs</td>
<td>2100 lbs</td>
</tr>
<tr>
<td>GPSS-6264-7</td>
<td>7.5</td>
<td>6&quot; x 264&quot;</td>
<td>8'</td>
<td>2000 lbs</td>
<td>2200 lbs</td>
</tr>
<tr>
<td>GPSS-6312-7</td>
<td>7.5</td>
<td>6&quot; x 312&quot;</td>
<td>10'</td>
<td>2200 lbs</td>
<td>2400 lbs</td>
</tr>
<tr>
<td>GPSS-6360-7</td>
<td>7.5</td>
<td>6&quot; x 360&quot;</td>
<td>12'</td>
<td>2300 lbs</td>
<td>2500 lbs</td>
</tr>
</tbody>
</table>

OPTIONS for GPSS Models
Heavy Duty Electric Scissors Lift Table - STANDARD
Air Tension - STANDARD
Contact Wheel Assembly (in place of traveling shoe)
Contact Wheel Assembly (in addition to traveling shoe)

DOUCET - Stroke Sanders

<table>
<thead>
<tr>
<th>Model</th>
<th>HP</th>
<th>Belt Size</th>
<th>Table Length</th>
<th>Net Weight</th>
<th>Approx. Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>PMC-168-6</td>
<td>5</td>
<td>6&quot; x 168&quot;</td>
<td>4'</td>
<td>800 lbs</td>
<td>1000 lbs</td>
</tr>
<tr>
<td>PMC-216-6</td>
<td>5</td>
<td>6&quot; x 216&quot;</td>
<td>6'</td>
<td>1100 lbs</td>
<td>1300 lbs</td>
</tr>
<tr>
<td>PMC-264-6</td>
<td>5</td>
<td>6&quot; x 264&quot;</td>
<td>8'</td>
<td>1400 lbs</td>
<td>1600 lbs</td>
</tr>
<tr>
<td>PMC-312-6</td>
<td>5</td>
<td>6&quot; x 312&quot;</td>
<td>10'</td>
<td>1700 lbs</td>
<td>2000 lbs</td>
</tr>
<tr>
<td>PMC-360-6</td>
<td>7.5</td>
<td>6&quot; x 360&quot;</td>
<td>12'</td>
<td>2000 lbs</td>
<td>2300 lbs</td>
</tr>
</tbody>
</table>

OPTIONS for PMC Models
Manual Hand Crank for Vertical Table Adjustment - STANDARD
Air Tension
7.5 HP (instead of 5 HP)
Contact Wheel Assembly (in place of traveling shoe)
Contact Wheel Assembly (in addition to traveling shoe)

ACCESSORIES - ALL MODELS
Graphite Coated Mitt
Graphite Stick
Graphite Coated Cloth (to recover Hand Block / Traveling Shoe)
Hand Block (6" x 9")
6 x 5-3/4 Grade B Matchless Contact Wheel
Variable Abrasive Belt Speed

STANDARD SPECIFICATIONS

- 7.5 HP 1800 RPM, TEFC motor
  230-460/3/60 (specify voltage) (GPSS Only)
- Magnetic push button starter with motor overload protection
- Air tension for abrasive belt (GPSS Only)
- Abrasive belt guard with 6" dia. Exhaust outlet at drive (motor) end
- 4, 300 SFPM Abrasive belt speed
- Traveling Shoe with Ball Bearing Rollers
- Steel Frame, Wood Slat Table with Ball Bearing Rollers for in/out motion

OPTIONAL EQUIPMENT

- Electronically powered vertical adjustment for table (PMC Only)
- 7 ½ HP motor (PMC Only)
- Electronic inverter for variable speed
- Contact Wheel assembly for use with matchless or other Contact Wheel.

*SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

*NEVER OPERATE ANY SANDING EQUIPMENT WITHOUT PROPER GUARDING

*ALWAYS WEAR EYE AND EAR PROTECTION WHEN OPERATING THIS OR ANY SANDING EQUIPMENT

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627

Pg 12
ABRASIVE BELT GRINDER

BULLETIN S10-B

SWING-FRAME ABRASIVE BELT GRINDERS

Standard Designs

- 10 or 15 Horsepower
- 2", 3", 4" or 6" x 132" Belt Sizes
- 5500 SFPM Abrasive Belt Speed Standard
- 7500 SFPM Abrasive Belt Speed Available

Custom Designs

- 20 HP or More

--Consult factory for details--

Model B-4132-10

120" SWIVEL MOTION CAN BE LOCKED IN ANY POSITION

Model SA-19 Foundry Swing-Frame Grinder

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
The 132 Series Grinders are equipped with a totally enclosed fan cooled ball bearing 208-230-460 volt, 3 phase, 60 hertz motor. The abrasive belt size is 2", 3", 4", or 6" wide x 132" long as indicated by the chart.

It is often necessary to do a certain amount of testing before determining which contact wheel is best suited to a particular job. As a rule, 90 durometer is used for rapid stock removal; 70 durometer for general purpose grinding; 50 durometer and softer for moderate stock removal and polishing.

* UNIT BELOW SHOWN WITHOUT BELT GUARD FOR ILLUSTRATION ONLY

5500 SFPM Abrasive Belt Speed Standard

<table>
<thead>
<tr>
<th>Model</th>
<th>Belt Size</th>
<th>Motor</th>
</tr>
</thead>
<tbody>
<tr>
<td>B-2132-10</td>
<td>2&quot; x 132&quot;</td>
<td>10 hp</td>
</tr>
<tr>
<td>B-3132-10</td>
<td>3&quot; x 132&quot;</td>
<td>10 hp</td>
</tr>
<tr>
<td>B-4132-10</td>
<td>4&quot; x 132&quot;</td>
<td>10 hp</td>
</tr>
<tr>
<td>B-6132-10</td>
<td>6&quot; x 132&quot;</td>
<td>10 hp</td>
</tr>
<tr>
<td>B-2132-15</td>
<td>2&quot; x 132&quot;</td>
<td>15 hp</td>
</tr>
<tr>
<td>B-3132-15</td>
<td>3&quot; x 132&quot;</td>
<td>15 hp</td>
</tr>
<tr>
<td>B-4132-15</td>
<td>4&quot; x 132&quot;</td>
<td>15 hp</td>
</tr>
<tr>
<td>B-6132-15</td>
<td>6&quot; x 132&quot;</td>
<td>15 hp</td>
</tr>
</tbody>
</table>

* Never operate this or any other machine without proper guarding. All G&P Swingframes come with standard guarding.
Compact and Medium Duty Swingframe Grinders

**BULLETIN S12**

**90 SERIES SWING FRAME**
90" Belt, 5 or 7.5 HP

Lathe Mounted  
Pedestal Mounted  
Carriage Mounted

Swing Frame Grinders work well on large parts where portable grinders are now being used. They are not as maneuverable as portable grinders, but they are more aggressive. If the work piece can be positioned so the area to be ground can be near the top, these grinders can do a quick and efficient job. They can also be swiveled up to 90 for angle or side grinding.

**72 SERIES SWING FRAME**  
72" Belt, 2 or 3 HP
The Compact Duty 72 Series
The 72 Series Grinders are equipped with a 2 or 3 horsepower motor 208-230-460 volt, 3 phase, 60 hertz motor. The abrasive belt size is 2", 2.5" or 3" wide x 72" long as indicated by the chart.

The Medium Duty 90 Series
The Medium Duty 90 Series Grinders are equipped with a 5 or 7.5 horsepower motor 208-230-460 volt, 3 phase, 60 hertz motor. The abrasive belt size is 2", 3" or 4" wide x 90" long as indicated by the chart.

Contact Wheels:
The proper contact wheel is an important factor in any grinding application.
* 90 durometer serrated face for rapid stock removal.
* 70 durometer serrated face for general purpose grinding.
* 50 durometer serrated face for moderate stock removal and polishing.

Accessories:
As shown on the front side, these grinders can be converted from swing frame grinders to lathe grinders, pedestal grinders, and plate/weld grinders with the proper accessories. The third wheel attachment can be used as a contact wheel or slack of belt polisher. Consult factory for additional information.
Mounted on wheels for...
- Plate Preparation
- Scale Removal
- Weld Grinding

15 to 25 HORSEPOWER
POWERED CARRIAGE

This grinder has a powered carriage eliminating the need for the operator to apply the force for moving it on the plate. The carriage is variable speed and travels 2.2 to 44 feet per minute.

Speed controls are mounted on the handlebars. The grinder uses a 4” or 6” x 90” abrasive belt that is air tensioned. An air operated lift wheel raises the contact wheel from the work area when not in use.

Electrical controls consist of a magnetic starter with 110 volt controls.

5 & 7.5 HORSEPOWER
NON-POWERED CARRIAGE

The force for movement of this grinder must be supplied by the operator. An adjustable gauge wheel control the depth of the grind. A safety switch guards against the possibility of the grinder running without an operator gripping the handlebar. The grinder uses a 2”, 3”, or 4” wide x 90” long abrasive belt that is air tensioned.

Options Include:
- Self Propelled Model
- Speed Control
- Forward and Reverse
- Manually Propelled Models
- Weld Seam Grinders - on a vee wheel carriage for running on an angle iron track

For light-duty applications, the G & P 2 and 3 horsepower belt grinders can also be supplied with wheels.

Grinders can be custom built to accommodate your specific grinding applications. Consult factory for more information.
Single Motor Polishers and Buffers

Dual Motors for Polishing and/or Buffing

Single and Variable Speeds
CONTACT WHEEL AND BELT ATTACHMENT

This accessory, as shown in the picture at the right offers advantages over the typical method of mounting the idlers on the floor.

Because the contact wheel, backstand idlers and guards are all mounted to a support frame that is secured to the base of the machine, it is possible to move or relocate the lathe without remounting or realigning the idlers.

The Contact Wheel and Belt Attachment can only be supplied if ordered at the same time as the polishing lathe.

Available with Spring Tensioned idlers or Air Tensioned idlers. The Air Tensioned idlers are recommended for belt speeds of 7500SFPM and faster due to larger diameter pulleys.

GUARDS

All polishing and sanding wheels must be guarded to protect the operator. Operating without guards may lead to serious injury. This is stated in a warning sign attached to every machine. G&P offers guards as listed below. Prices for guards will be supplied upson receipt of details of the application.

TYPE A - Cover swings clear of the wheel and spindle, providing easy access for wheel changing.
TYPE B - Door swings open for wheel access.
*Both have adjustable scoop, clean out door and exhaust outlet for connection to dust collector.

TYPE C - Open bottom to allow clearance when sanding or buffing long parts off-hand.
TYPE D - Closed bottom with adjustable scoop for improved dust collection.
*Both have hinged door and an exhaust outlet for connection to dust collector.

SPECIAL GUARDS AND ACCESSORIES ON REQUEST

G&P is happy to quote modified accessories to meet your specific requirements.

The photographs to the right show a machine with a special contact wheel and belt attachment providing a slack-of-belt polishing area in addition to the contact wheel.
HEAVY DUTY & SINGLE SPEED

15 & 20 HORSEPOWER

BULLETIN 11-B

SINGLE MOTOR OR DUAL MOTOR MODELS AVAILABLE

The VSH and SSH Series picks up in ruggedness where the others leave off with higher horsepower, 1 1/2" diameter spindles, a heavier base, and standard spindle brake.

MODEL 2MSSH SHOWN WITH BELT ATTACHMENTS & A GA-10 PRESSURE ASSIST TABLE

SINGLE FEATURES:

- Combination brake and stop switch that can be locked in position.
- Heavy duty fabricated steel base.
- LCD on VHS models.
- Full voltage push button starters in NEMA 12 enclosures.
- 1 1/2" x 6" long spindles.

MODEL SS-500 SHOWN WITH BELT ATTACHMENTS AND OPTIONAL TOOL RESTS

- Consult factory for modifications.
- See page 4 for optional belt attachment and guards.

All specifications are subject to change without notice.
SINGLE MOTOR OR DUAL MOTOR MODELS AVAILABLE

The VS models are variable speed, the SS models are single speed. Variable speed is accomplished with the use of a variable frequency drive.

STANDARD FEATURES:

• LCD on the VS models.
• Heavy duty fabricated steel base.
• Spindle lock on each side (spindle brake optional).
• Full voltage push button starters in NEMA 12 enclosures.
• 1 1/4” x 6” or 11” long spindles.

MODEL 2MVS SHOWN WITH GUARDS
GUARDS ARE PRICED SEPARATELY

These models are most often used for off hand grinding and buffing applications using abrasive belts or buffing wheels. Specify long or short spindles when ordering.

*See back page for optional belt attachment, guards, or special modifications.
PORTABLE ABRASIVE BELT GRINDER

BULLETIN AP-1
GRINDER MODEL B-136-2  MODEL B-236-2  MODEL B-336-2

CONTACT WHEEL GRINDING
FOR RAPID STOCK REMOVAL

SLACK OF BELT POLISHING
FOR FINE FINISH

MODEL B 136-2 CAN EASILY
GRIND IN LESS THAN 2” OPENING:

6000 RPM 2 H.P.* Air Motor
*1.9 H.P developed when
operating at 90 P.S.I.
volume of air 40 Cu. Ft. Per
Min 1/2” air line recommended.

EXTRA POWERFUL, EASY TO HANDLE & MANEUVERABLE

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>BELT SIZE</td>
<td>1” x 36”</td>
<td>2” x 36”</td>
<td>3” x 36”</td>
</tr>
<tr>
<td>BELT SPEED</td>
<td>4700 SFPM</td>
<td>4700 SFPM</td>
<td>4700 SFPM</td>
</tr>
<tr>
<td>CONTACT WHEEL</td>
<td>3” dia. x 1” face Rubber Cover</td>
<td>3” dia. x 2” face Rubber Cover</td>
<td>3” dia. x 3” face Rubber Cover</td>
</tr>
<tr>
<td>DRIVE POLICY</td>
<td>3” dia. x 1” face Rubber Cover</td>
<td>3” dia. x 2” face Rubber Cover</td>
<td>3” dia. x 3 face Rubber Cover</td>
</tr>
<tr>
<td>WEIGHT</td>
<td>13½#</td>
<td>17#</td>
<td>20#</td>
</tr>
</tbody>
</table>
BACKSTAND IDLERS

BULLETIN B200-B

SPRING TENSIONED & AIR TENSIONED

Model: ABS-HD Right Hand Shown

Model: ABS-HD Left Hand Shown

Model: SBS-4 Right Hand Shown

TORO REPLACEMENT BACKSTAND IDLERS

Models and specifications for:
SBS & ABS-HD Series Pg. 2
TR-4 Toro Replacement Pg. 3

Drop in replacement for Spring Tensioned
Toro Backstand Idlers

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE
Always wear eye protection when grinding  •  Be sure all guards are in place

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750  •  FAX (317) 899-1627
**SERIES SBS & ABS-HD**

**SERIES SBS (REPLACES RBS) - SPRING TENSIONED**

The SBS series of backstand idlers offer an economical method of tensioning and abrasive belt for manual grinding applications. Tension is provided by a torsion spring. The 6” dia. pulley is machined from an aluminum casting, and rotates on sealed ball bearings. The arm and base of the backstand are made of cast iron.

*Model SBS-4 - for belts of 4” width or less*
*Model SBS-6 - for belts of 6” width or less*

**Accessories:**

**Angle Mounting Brackets**
Shown on the front of this bulletin. When the backstand idler is to be at floor level, the angle mounting brackets position it at an angle that simplifies mounting a guard.

**Pedestal**
Provides a mounting for backstand idler at approximately the same height as the contact wheel.

**Universal Joint**
Provides the advantage of removing the tracking knob from the base of the backstand and repositioning it at the front of the machine within easy reach of the operator.

**SERIES ABS-HD - AIR TENSIONED**

The ABS-HD series is adequate for grinding applications where pressure assist units are used to apply grinding pressure. Tension is provided by a heavy duty air cylinder. The 9” dia. pulley is machined from an aluminum casting, & rotates on sealed ball bearings. The base of the unit is a weldment.

*Model ABS-HD-4 - for belts of 4” width or less*
*Model ABS-HD-6 - for belts of 6” width or less*
**Toro Drop-In Replacement**

The TR-4 and TR-5 are dimensionally identical to the old Toro Backstand Idlers. The Idler pulleys are crowned aluminum. 9” diameter, and 4 1/4” (TR-4) or 6 1/4” (TR-6) wide. Tension is supplied via two torsion springs. Tracking is adjustable by rotating the idler pulley shaft, screwing it in or out. These Backstand Idlers are *dimensionally equivalent* to the old Toro Backstand Idlers, enabling them to be “dropped in” as replacements.
Adapt your lathe for rolls with a grinder from G&P – Standard models or special models custom built for your specific needs.

Features
- Precision Ball Bearings
- Tapered Spindle
- Tapered Bore Contact Wheel
- Air Tensioning
- Enclosed Belt Guard

WEAR EYE, EAR & RESPIRATORY PROTECTION WHEN GRINDING
Abrasive belt roll grinding and polishing principle and machine requirements do not differ widely from established grinding wheel procedures. Mainly, the difference lies in the ability of a belt to cut faster and consequently, to be used at higher traverse speeds. The accuracy factor is in the machine itself. Thus, a lathe that is capable of producing tolerances to .001" with a tool bit set-up, can be expected to preform equally well with an abrasive attachment—the G&P Belt Grinder designed for lathe mounting.

On large lathes, the G&P Belt Grinder can be mounted on the compound. On smaller lathes, the compound must be removed, and the grinder is mounted to the cross slide. Even on larger lathes, when the lathe is to be used permanently for roll grinding, the recommended procedure is to remove the lathe compound and fasten the grinder to the cross slide. This provides greater rigidity and maintains use of the cross-slide feed mechanism.

When supplied with the information requested under “mounting information” in bulletin BRG-3B, G&P can provide an adaptor to mount the grinder to your lathe.

**Metal and Rubber Roll Grinding**

To provide a satisfactory finish, all equipment must be in good condition. Loss of rigidity, or presence of wear anywhere in the system will produce a poor finish and cause a loss of accuracy.

A lubricant or coolant is recommended for grinding all types of metal rolls and is sometimes useful in obtaining a fine finish on rubber rolls in medium to hard range.

For 40 and softer durometer rubber, the application of powdered soap stone or powdered zinc stearate at the point of contact is an excellent grinding aid. For chilled or cast-iron rolls, a water-soluble type coolant is suggested.

**Lubricants and Coolants**

For steel and stainless steel, a mixture of water and a good water-soluble oil of the heavy-duty type containing extreme pressure additives will give substantially better belt life, rate of cut and finish.

Coolants which circulate through settling tanks should have an adequate filtering system to remove foreign particles. Good efficient filters are necessary in any stage of roll grinding, but they are vital for high finishes.
The drawing to the right shows two methods of bringing the abrasive belt into contact with the work roll. For most roughing and finishing, the method shown in figure A is recommended. If slack of belt polishing is required, a removable front guard is recommended. If slack of belt polishing is required, a removable front guard section is provided that will allow the grinder to be tilted forward as shown in Figure B.

**Modifications... To Meet Your Requirements**

If you need some changes from Standard models... such as something smaller... or larger...let us know. We will provide a quotation on a model to fit your needs. Figure 1 shows a 2-horsepower model using 1” x 54’ belt. Figure 2 shows a grinder equipped with a Tungsten carbide grinding wheel, for grinding rubber, plastic or synthetic materials.

The grinding wheel guard has been removed in this picture for clarity. Fig 2
When mounting this grinder on a lathe, the center line of the contact wheel must be the same height as the center line of the roll. On most lathes this requires the use of an adapter to bridge the space between the bottom surface of the grinder and the top surface of the compound or slide on which the grinder will be mounted.

This drawing may be helpful if you plan to make the adapter - or G&P can supply it if we have the mounting information from bulletin BRG-3B.
The proper contact wheel is an important factor in any grinding application. For assistance in determining which wheel is best suited for your application, we offer the following illustrations with description. If you are in doubt about your selection, we will be glad to make a recommendation if you supply information regarding the type of material being ground, amount of stock to be removed, finish requirements, etc.

**TYPE “SAR”**
Serrated Aluminum Wheel with Rubber fill. Roughing wheel only for aggressive grinding applications. This wheel is directional and can only be run in one direction.

**TYPE “PAR”**
Plain Aluminum Wheel with Rubber fill. This has been found to be best for producing very close tolerances. It should be noted that the lathe must be in excellent condition. Otherwise, use Type PDDR.

**TYPE “SDDR”**
Serrated Dual Density Rubber. This wheel will produce tolerances nearly equal to type “PAR” but a better finish is achieved. This wheel is directional and can only be run in one direction.

**TYPE “PDDR”**
Plain Dual Density Rubber. This wheel is used where a good finish is needed with moderate stock removal and close tolerance. This is the most commonly used wheel.

**TYPE “PR”**
Plain Rubber. A smooth face wheel, 70 to 90 durometer (specify) for applications requiring the use of diamond or structured abrasive belts. This wheel can also be serrated (TYPE “SR”) for general purpose grinding.

**TYPE “PA”**
Plain Aluminum Face. For grinding soft rubber rolls.

**DRESSING THE CONTACT WHEEL**

**IT IS IMPORTANT** that all wheels be “dressed” to the roll before grinding. This assures squareness of the contact wheel to the roll. Each time the grinder is removed, it is best to re-dress the wheel.

**TO DRESS**, place the grinder on the lathe and look for the best area of the roll. Be sure the grinder is as square as possible. Clean the roll so pressure sensitive abrasive can be placed on the roll. This should go at least 3/4 way around the roll and be 50 to 80 grit. Start the grinder and move the contact wheel in unit it makes contact with the abrasive. Move the grinder back-and-forth completely across the abrasive both ways. This must be repeated until the entire surface of the contact wheel has been dressed. Don't plunge cut.

Wear eye protection - Keep hands clear when using grinding equipment.

**RECOVERING USED WHEELS**
Type “SAR” AND “PAR” wheels have aluminum lands which, when worn down, can’t be replaced. They can be made into Type SDDR, PDDR, and PR wheels at some savings. The SDDR, PDDR and PR type wheels can be recovered at considerable savings. It is strongly recommended that a spare contact wheel be ordered with the grinder. Delivery on replacement wheels may require 6 to 8 weeks.
Mounting Information

A schematic on the lower portion of this page illustrates two common types of lathe compound tool holders and the cross slide of a lathe. The size of the lathe on which the grinder is to be used frequently determines whether it is best to mount on the compound slide of the cross slide.

On the large lathes, mounting on the compound slide may prove satisfactory, but on smaller lathes, it is better to remove the compound and mount directly on the cross slide.

The schematic shows which dimensions are needed. In order to provide an adaptor that will fit the lathe.

NOTE: Size of tailstock housing determines minimum diameter of roll grinding.

FOR THE BEST PLACEMENT OF THE GRINDER - PLEASE SPECIFY THE MINIMUM AND MAXIMUM SIZE OF ROLL
FOR BUFFING - POLISHING - SANDING

Note: These units should never be used without proper guarding. Guards have been removed in these pictures to provide a clear view of the polishing wheels and belt.

*Please refer to the price sheet for information regarding guards and exhaust enclosures.
NOTE: These units should never be used without proper guarding. Guards have been removed in these pictures to provide a clear view of the polishing wheels and belt.*Please refer to the price sheet for more information regarding guards and exhaust enclosures.

Model UA-2 can be used when single speed of 1200 RPM or 1800 RPM is adequate. For example, the 32 brush Vonnegut Head operating at 1200 RPM is suitable for most wood and metal applications.

GENERAL SPECIFICATIONS –MODEL UA-2 SPINDLE – 1¼” diameter x 11’ length from shoulder to end. Motor – 2 horsepower, totally enclosed ball bearing motor 20B/22D/44D volt, 3 phase, 60 cycle 1200 or 1800 RPM available. Specify which speed is required. Electrical Controls – Manual Start-Stop Push Button. Specify which voltage will be used.

Ideally suited for conveyorized and rotary automatic application also frequently used with the optional plywood table and bracket for manual operations.

The photos on these pages illustrate the adjustable features of all UA models. In addition to horizontal and vertical adjustments the spindle may be positioned around a 360-degree area. See the back cover of this brochure for minimum and maximum dimensions.
VARIABLE SPEED

Models UA-VS and UA-3-VS
With variable spindle speed of 600 through 1800 RPM, are applicable where job requirements may vary, both as to work materials and abrasive media such as Vonnegut Heads, Bulls, Wire Wheels, Etc.

GENERAL SPECIFICATIONS
- MODEL UA-2-VS Spindle
1 ¼” diameter x 9 ½” length from shoulder to end. Spindle speed - 600 RPM through 1800 RPM (for higher speed consult the factory) Motor – 2 horsepower totally enclosed ball baring motor 230/460-volt, 3 phase, 60 cycle or 575-volt, 3 phase, 60 cycle. Electrical controls – manual start-stop push button, specify which voltage will be used. TYPE OF VARIABLE SPEED DRIVE – Wide Belt-Variable pitch sheave

GENERAL SPECIFICATIONS
- MODEL UA-3-VS
Spindle – 1 ¼” diameter x 9 ½” length from shoulder to end. Spindle speed – 600 RPM through 1800 RPM. (for higher speed consult the factory) Motor – 3 horsepower totally enclosed ball baring motor 230/460-volt, 3 phase, 60 cycle or 575-volt, 3 phase, 60 cycle. Electrical controls – manual start-stop push button, specify which voltage will be used. TYPE OF VARIABLE SPEED DRIVE – Wide belt-variable pitch sheave

MODELS: UA-2 - OS & UA-3-OS

OSCILLATING SPINDLE

Models UA-OS and UA-3-OS with oscillating spindle may be used with a variety of building and polishing wheels, the oscillation providing a more uniform finish, and eliminating streaks and patterns, the oscillating spindle arrangement in Vee Belt driver, with 3/16” oscillation.

GENERAL SPECIFICATIONS – MODEL UA-2-OS Spindle
1 ¼” diameter x 12” length from shoulder to end.
Spindle speed – 600 RPM -130 oscillations per minute, 1250 RPM -170 oscillations per minute 800 RPM -140 oscillations per minute
Oscillation stroke - 3/16”
Motor – 2 horsepower totally enclosed ball baring motor 230/460-volt, 3 phase, 60 cycle or 575 volt, 3 phase, 60 cycle.
Electrical controls – manual start-stop push button, specify which voltage will be used.

GENERAL SPECIFICATIONS – MODEL UA-3-OS
Spindle – 1 ½” diameter x 12” length from shoulder to end.
Spindle speed – 1400 RPM -130 oscillations per minute
1250 RPM -170 oscillations per minute
800 RPM -140 oscillations per minute
Oscillation stroke – 3/16”
Motor – 3 horsepower totally enclosed ball baring motor 230/460 volt, 3 phase, 60 cycle or 575 volt 3 phase, 60 cycle.
Electrical controls – manual start-stop push button, specify which voltage will be used.
OPERATIONAL DIMENSIONS

UA-2-OS & VS OR UA-3-OS & VS

BULLETIN 169

THE DIMENSIONS SHOWN ARE FOR ALL STANDARD UA MODELS — MODIFICATIONS CAN BE SUPPLIED BY CONSULTING THE FACTORY.

ALL DIMENSIONS SUBJECT TO CHANGE WITHOUT NOTICE.
GRIND ASSIST TABLE

BULLETIN GA-10

Standard Specifications

- 3 1/4" Bore x 9" stroke air cylinder for up and down movement.
- 2" Bore x 3" stroke air cylinder for in and out movement.
- Adjustable infeed stop with lock for grind depth control.
- Air control panel with manual valves, regulators and gages. Panel can be mounted on either side.
- Adjustable stop on table height for in and out plunge grinding.
- Tee-Slotted Table top (not shown).

Options

- Hydro-check
- Air Logic controls

Always wear eye protection when grinding. Be sure all guards are in place.

For pressure Grinding Adaptable to Existing Equipment
Or – Available With New G+P Grinders For Use with Abrasive Belts Only

Do Not Use with Grinding Wheels
Using With Grinding Wheels May Result In Serious Injury
G&P SPINDLE STANDS

BULLETIN P-5A
SINGLE SPEED/V-BELT DRIVEN
MODELS PN-2, PN-3, PN-5PW-2, PW-3, PW-5

• 2, 3, or 5 H.P. TEFC Ball Bearing motors
• Vee belt drive
• 1200 or 1800 RPM (Standard)
• Exceptional front clearance due to unique base design
• Magnetic push button starter
• Long spindle available for use with Wolf-Head sanding wheels, pneumatic drums or other sanding/polishing wheels
• Short spindle for BA belt attachment or other applications
• Spindle lock for easy wheel change

STANDARD FEATURES:

* Model PW with wheel guards ordered separately. Specify wheel size when ordering guards.

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Model PN (Narrow Type)  
Requires minimum amount of space. Shorter overall spindle length.

NEVER OPERATE SPINDLE STANDS WITHOUT PROPER GUARDING.
G&P BELT ADAPTOR

CONVERTS POLISHING LATHES TO ABRASIVE BELT GRINDERS

Fits G&P Series PW, Series VS, SS, 2MVS, 2MSS, or any polishing lathe with 4 1/2” O.D. Spindle Housing

*Please specify right-hand or left-hand.

Note: Includes spring tension arm, 6” dia x 4 1/4” wide aluminum Idler pulley, belt tracking adjustment, and 10” dia - 1 1/4” bore rubber covered contact wheel.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>WHEEL WIDTH</th>
<th>WHEEL DIA.</th>
<th>BELT SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>BA - 2</td>
<td>2”</td>
<td>10”</td>
<td>2” X 72”</td>
</tr>
<tr>
<td>BA - 3</td>
<td>3”</td>
<td>10”</td>
<td>3” X 72”</td>
</tr>
<tr>
<td>BA - 4</td>
<td>4”</td>
<td>10”</td>
<td>4” X 72”</td>
</tr>
</tbody>
</table>

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Occupying a minimum of floor space, this model offers an economical means of driving a variety of sanding and polishing wheels.

Powered with a 2 horsepower motor and equipped with 1-1/4” diameter spindles, the EPN can accommodate a pair of Brush-Backed Sanding Heads, a pair of pneumatic drums... or one of each. The spindle length is 11” from shoulder to tip, providing adequate length for 9” wide drums.

**Exhaust Hoods**

The exhaust hoods shown in the picture are for use with Brush-Backed Sanding Heads. Regardless of the wheel used, some type of guard *must* be installed, but because of the variety of wheel sizes, guards are frequently custom built.
MODEL EPN

BULLETIN P-13

SPECIFICATIONS

- Motor, 2 HP totally enclosed,
- 208/220/440 volt, 3 phase, 60 cycle
- Speed, 1200 or 1800 RPM
- Electrical Controls - Manual Start - Stop, Push Button with overload protection. (Specify which voltage will be used.)

Base Dimension ................................................................. 20” x 20”
Total Spindle Length .......................................................... 35”
Spindle Height from Floor ................................................... 39”
Spindle Diameter .............................................................. 1-1/4”
Spindle Length ................................................................. 11” from shoulder to tip

Specifications are subject to change without notice.
Sanding Wheels and Guards not included in basic price.

Never operate sanding equipment without proper guarding. Always wear eye protection.
Never operate grinding equipment without proper guarding. Always wear eye protection.
SPECIFICATIONS FOR 8107-10

<table>
<thead>
<tr>
<th>Specification</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasive belt size</td>
<td>8&quot; x 107&quot;</td>
</tr>
<tr>
<td>Abrasive belt speed</td>
<td>5500 SFPM</td>
</tr>
<tr>
<td>Type of belt tension</td>
<td>Air</td>
</tr>
<tr>
<td>Motor</td>
<td>10 H.P. TEFC 230/460/3/60</td>
</tr>
<tr>
<td>Starter</td>
<td>NEMA 12-230 or 460/3/60 with 115 volt at P.B.</td>
</tr>
<tr>
<td>Drive Pulley</td>
<td>10&quot; dia. x 8&quot; face Rubber Covered</td>
</tr>
<tr>
<td>Idler Pulley</td>
<td>10&quot; dia. x 8&quot; face Rubber Covered</td>
</tr>
<tr>
<td>Platen</td>
<td>Steel – 8&quot; x 16&quot; Hardened Tool Steel Optional Water Cooled Optional on Model 8107 – 10 DV only</td>
</tr>
<tr>
<td>Table</td>
<td>12&quot; deep, 20&quot; wide with angle adjustment</td>
</tr>
<tr>
<td>Table Height</td>
<td>40 ½&quot;</td>
</tr>
<tr>
<td>Dimensions – Approx.</td>
<td>75&quot; high, 48&quot; wide 47&quot; deep on Model 8107-10 WV</td>
</tr>
<tr>
<td></td>
<td>75&quot; high, 29 1/2&quot; wide 40&quot; deep on Model 8107-10 DV</td>
</tr>
<tr>
<td>Exhaust Outlet</td>
<td>6&quot; dia Model 8107-10 DV only</td>
</tr>
<tr>
<td>Coolant System</td>
<td>21 gal. Capacity Model 8107-10 WV only</td>
</tr>
</tbody>
</table>

Specifications subject to change without notice
<table>
<thead>
<tr>
<th>Specification</th>
<th>HV660-D</th>
<th>HV860-D</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasive belt size</td>
<td>6&quot; x 60&quot;</td>
<td>8&quot; x 60&quot;</td>
</tr>
<tr>
<td>Abrasive belt speed</td>
<td>5500 SFPM</td>
<td>5500 SFPM</td>
</tr>
<tr>
<td>Type of belt tension</td>
<td>Air</td>
<td>Air</td>
</tr>
<tr>
<td>Motor</td>
<td>2 H.P., 3 H.P. or 5 H.P. TEFC</td>
<td>5 H.P. TEFC 230/460/3/60</td>
</tr>
<tr>
<td>Voltage</td>
<td>230/460/3/60</td>
<td>NEMA 1 Magnetic Full Voltage 230 or 460/3/60</td>
</tr>
<tr>
<td>Drive Pulley</td>
<td>6&quot; dia. x 6&quot; Face Rubber Covered</td>
<td>8&quot; dia. x 8&quot; Face Rubber Covered</td>
</tr>
<tr>
<td>Idler Pulley</td>
<td>6&quot; dia. x 6&quot; Face Aluminum</td>
<td>8&quot; dia. x 8&quot; Face Rubber Covered</td>
</tr>
<tr>
<td>Platen</td>
<td>Steel – 6&quot; wide, 10&quot; long</td>
<td>Steel – 8&quot; wide, 10&quot; long</td>
</tr>
<tr>
<td></td>
<td>Hardened Tool Steel Optional</td>
<td>Hardened Tool Steel Optional</td>
</tr>
<tr>
<td>Table</td>
<td>6&quot; deep, 8&quot; wide Angle adjustment when grinder in vertical position. In horizontal position table serves as Cross Fence</td>
<td>6&quot; deep 10&quot; wide Angle adjustment when grinder in vertical position. In horizontal position table serves as Cross Fence</td>
</tr>
<tr>
<td>Overall Height</td>
<td>62&quot;</td>
<td>62&quot;</td>
</tr>
<tr>
<td>Table Height</td>
<td>40 ¼&quot; when grinder is in vertical position</td>
<td>40 ¼&quot; when grinder is in vertical position</td>
</tr>
<tr>
<td>Platen Height</td>
<td>37&quot; when grinder is in horizontal position</td>
<td>37&quot; when grinder is in horizontal position</td>
</tr>
<tr>
<td>Base Plate</td>
<td>20” square</td>
<td>20” square</td>
</tr>
</tbody>
</table>

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SPECIFICATIONS FOR HV660-D & HV860-D
MODIFICATIONS & SPECIAL ACCESSORIES AVAILABLE

BULLETIN PL-200

MODEL HV 660-W
These pictures show a model HV 660-W for wet operation including a coolant pump reservoir and flood nozzle.

MODEL 8107 WV
These photos show an 8107-10 WV modified to a 8107-30 WV with a 30 horsepower motor and with a horizontal fixture mounting table with hydraulic movement on two axis.

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Pg 45
All Standard XH Models are equipped with either a 10 or 15 h.p. totally enclosed fan cooled ball bearing motor, 230-460 or 575 volt 3 phase 60 cycle. Each unit is supplied with a 10” dia rubber covered contact wheel with a serrated face. Abrasive belts are air tensioned.

The proper contact wheel is an important factor in any grinding operation. It is often necessary to do a certain amount of testing before determining which contact wheel is best suited to a particular job. As a rule, 80 or 90 durometer is used for rapid stock removal . . . 60-70 durometer for general purpose grinding, and 40-50 durometer and softer for moderate stock removal and polishing.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>BELT SIZE</th>
<th>HORSEPOWER</th>
<th>MODEL</th>
<th>BELT SIZE</th>
<th>HORSEPOWER</th>
</tr>
</thead>
<tbody>
<tr>
<td>XH-3132-10</td>
<td>3 x 132</td>
<td>10</td>
<td>XH-3132-15</td>
<td>3 x 132</td>
<td>15</td>
</tr>
<tr>
<td>XH-4132-10</td>
<td>4 x 132</td>
<td>10</td>
<td>XH-4132-15</td>
<td>4 x 132</td>
<td>15</td>
</tr>
<tr>
<td>XH-6132-10</td>
<td>6 x 132</td>
<td>10</td>
<td>XH-6132-15</td>
<td>6 x 132</td>
<td>15</td>
</tr>
</tbody>
</table>

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Pg 46
LUBRICATION
All ball bearings are sealed for life type. One Alemite fitting on the swivel housing requires periodic lubrication with a good grade of grease as use dictates.

ADJUSTMENTS
Tracking of the abrasive belt is accomplished by turning the tracking knob, item #46, to the right or left. The swivel lock controls the swivel adjustment to tip the contact wheel radially to left or right. This can be locked at any point.

BELT TENSIONING
Tensioning of the abrasive belt is accomplished through the use of an air cylinder, regulator and hand valve. The amount of tensioning can be adjusted by increasing the amount of air pressure shown on the regulator gauge. The normal setting is around 60 psi.

CHANGING CONTACT WHEEL TIRE
To change the tire, remove the screws holding the outer flange, remove the flange, then remove the old tire and install the new tire. Be sure the rim of the new tire is on the pilot or shoulder of inside hub before replacing outer flange.

MATERIAL LIST FOR EXTRA HEAVY DUTY SWING FRAME GRINDER

<table>
<thead>
<tr>
<th>ITEM</th>
<th>PART NO.</th>
<th>REQ’D</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-A</td>
<td>M-11205-E-4</td>
<td>1</td>
<td>Enclosed Belt Guard - 3&quot; &amp; 4&quot; Wide Belt, if ordered</td>
</tr>
<tr>
<td>1-B</td>
<td>M-11205-E-6</td>
<td>1</td>
<td>Enclosed Belt Guard - 6&quot; Wide Belt, if ordered</td>
</tr>
<tr>
<td>2-A</td>
<td>M-11024-E-1</td>
<td>1</td>
<td>Band Belt Guard - 3&quot; &amp; 4&quot; Wide Belt, Standard</td>
</tr>
<tr>
<td>2-B</td>
<td>M-11024-E-2</td>
<td>1</td>
<td>Band Belt Guard - 6&quot; Wide Belt, Standard</td>
</tr>
<tr>
<td>3-A</td>
<td>R-54 - 6&quot; x 4&quot;</td>
<td>1</td>
<td>Tire – Drive Pulley</td>
</tr>
<tr>
<td>3-B</td>
<td>R-54 - 6&quot; x 6&quot;</td>
<td>1</td>
<td>Tire – Drive Pulley</td>
</tr>
<tr>
<td>4-A</td>
<td>M-11088-B</td>
<td>1</td>
<td>Hub – Drive Pulley, 4&quot; Wide Belt</td>
</tr>
<tr>
<td>4-B</td>
<td>M-11079-B</td>
<td>1</td>
<td>Hub – Drive Pulley, 6&quot; Wide Belt</td>
</tr>
<tr>
<td>5</td>
<td>M-11260-D-3</td>
<td>1</td>
<td>Counterbalance</td>
</tr>
<tr>
<td>6</td>
<td>M-11025-E-1</td>
<td>1</td>
<td>Beam</td>
</tr>
<tr>
<td>7</td>
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<td>Hub – 10 x 1-1/2 Bore</td>
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ITEM | PART NO. | REQ’D | DESCRIPTION |
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<td>709 Type</td>
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<td>Pin – Pivot</td>
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<td>Arm – Tensioning</td>
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PC | PART NO. | REQ’D | DESCRIPTION |
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<td>A</td>
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<td>G</td>
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<td>Snap Ring</td>
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Stock belts to meet maximum width requirements, and slit narrow belts with this belt slitter.

This model shown is capable of accommodating belts to a maximum width of 7” and length of 90”. And occasional longer belt can be slit by using the guide roll to the front of the unit, however, if large quantities of long belts are to be slit, a model is available with an idler pulley extending to the rear.

Belt width as narrow as 1/2” can easily be cut. Cutting is done with a rotary knife mounted on a precision dovetail slide making contact with the belt as it is passed over a powered roll of hardened steel.

To operate, the abrasive belt is positioned over the hardened roll and air tensioned idler, with the edge of the belt against the flange. When the two push buttons are pressed, the belt is tensioned, rotation of the belt begins, and the slitter knife is brought into contact with the belt under air pressure. Slitting is accomplished in one revolution of the belt.

Technical Information:

Motor: 3/4 H.P. - Totally Enclosed Fan Cooled. 115 volt, 1 phase, 60 Hz.

Controls: Double push button. Both buttons must be pressed to operate the belt slitter.

Speed Reducer: 25 to 1 Ratio Producing 70 RPM at mandrel.

Belt Tensioning: Air Tension

Slitting Knife: Rotary knife mounted on 6” dovetail slide.
WELD GRINDERS

15 horsepower grinder using 4” x 148” abrasive belt. Features 20” of side adjustment for aligning grinder with weld.

15 horsepower grinder using 4” x 132” abrasive belt. Does not have side adjustment, but has a seat for the operator and has a counterbalance spring. Allowing the grinder to swivel freely, automatically adjusting for mismatch conditions.

40 horsepower grinder using 4” x 132” abrasive belt. The advantage of greater horsepower is related to the speed at which the work can be rotated. Due to the restriction of speed available on some turning rolls, it may be impossible to fully utilize 40 horsepower.

The equipment shown in this picture is being used to reduce grinding time approximately 80% on pressure vessels and similar products. A 15 horsepower unit can be expected to grind the circumferential weld of a 16 foot diameter vessel in approximately six hours.

The grinding is done by placing the grinding unit in position next to the vessel, which is setting on turning rolls. The grinding pressure is applied by an air cylinder which causes the grinder to pivot forward. The pressure is controlled by an air pressure regulator that is convenient to the operator.

Since these are custom built to meet the specific requirements of each individual customer, there is some variation from one to another. Some have a platform for the operator others have a seat. All have depth of grind gauge wheels located on each side of the contact wheel. The setting of these wheels is adjusted by turning a knob at the operator’s station.

The contact wheel assembly, including the gauge wheels, is easily removed from the grinder. By removing two pins, one complete assembly can be removed and the other installed making it easy to change from hard contact wheel for roughing to a softer contact wheel for blending.

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
This grinder can be used for grinding weld inside of tanks 48” diameter, and larger. Supported by a wheel carriage, and powered with an air motor developing approximately 4 horsepower, it brings more power to do the job then normal portable grinders. Abrasive belt size is 1” x 84”.

Weighing less than 60 pounds, it can be placed in a tank through a hole diameter of 18”. If desired, controls for the turning rolls that rotate the tank can be mounted on the handlebar of the grinder.
FEATURES INCLUDE:
7 1/2 horsepower T.E. F. C. Motor. NEMA 12 electrical controls with fused disconnect.
Air tensioning for 3”, 4”, or 6” x 148” abrasive belts.
1 1/2” diameter contact wheel spindle supported in housing with sealed ball bearings and spindle lock, with adjustable position for contact wheel sizes from 8” to 16” diameter.
Heavy base with clean out drawer and exhaust outlet.

Outstanding for production runs of such pieces as bicycle hubs, crank handles, etc., this grinder can deliver the exact contour required in a single pass. The abrasive belt flexes to the contour of the contact wheel behind the belt, which can be shaped to desired form.
Supplying the information requested here will enable us to determine in what manner we may be of assistance.

MAXIMUM DIAMETER__________________________________________________________

MINIMUM DIAMETER__________________________________________________________

MINIMUM LENGTH____________________________________________________________

SOLID BAR OR TUBING_________________________________________________________

MATERIAL___________________________________________________________________

RAW STOCK- OR - POLISH CHROME______________________________________________

PRODUCTION REQUIREMENTS___________________________________________________

FINISH REQUIRED____________________________________________________________
HARDWHEEL SWINGFRAME GRINDER
& CUTOFF MACHINES
BULLETIN SG-1
MANEUVERABLE & BALANCED

CUSTOM-MADE EQUIPMENT
G&P Machinery can design and build special equipment to meet your requirements

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
SPECIFICATIONS

BULLETIN SG-1

MODEL S20 C20
WHEEL SIZE: 20" x 3/16" x 1"
POWER: 20 HP
WEIGHT: Approximately 700 lbs.
LENGTH: 56- 5/8” from center of motor to center of spindle
DRIVE: Single speed – 2700 RPM
WHEEL SPEED: 14,200 SFPM

MODEL S20 G20
WHEEL SIZE 20” x 2” TO 3” x 8” (flanges available for other wheel hole sizes)
POWER: 20 HP
WEIGHT: Approximately 1000 lbs.
LENGTH: 56-5/8” from center of motor to center of spindle
DRIVE: single speed – 1800 RPM
WHEEL SPEED: 9500 SFPM

MODEL S24 C25
WHEEL SIZE: 24" X 3/16” X 1-3/4
POWER: 25 HP
WEIGHT: Approximately 900 lbs.
LENGTH: 57-5/8” from center of motor to center of spindle
DRIVE: Single Speed – 2260 RPM
WHEEL SPEED: 14,200 SFPM

MODEL S24 G25
WHEEL SIZE: 24” X 2” to 3” x 12”
POWER: 25 HP
WEIGHT: Approximately 1200 lbs.
LENGTH: 57-5/8” from center of motor to center of spindle
DRIVE: Single Speed – 1500 RPM
WHEEL SPEED: 9500 SFPM

MODEL S10 G5
WHEEL SIZE: 10” X 1” X1”
POWER: 5 HP
WEIGHT: Approximately 220 lbs.
LENGTH: 24- 3/4” from center of motor to center of spindle
DRIVE: Single speed – 3600 RPM
WHEEL SPEED: 9500 SFPM

MODEL S12 G7
WHEEL SIZE: 12” X 1 ½” TO 2”X 1 ½”
POWER: 7- ½ HP
WEIGHT: Approximately 250 lbs
LENGTH: 24- ¾” from center of motor to center of spindle
DRIVE: Single Speed – 3000 RPM
WHEEL SPEED: 9500 SFPM

MODEL S30 C30
WHEEL SIZE: 30” X 1/4”X 1-3/4”
POWER: 30 HP
WEIGHT: Approximately 1100 lbs.
LENGTH: 56- 5/8” from center of motor to center of spindle
DRIVE: Single Speed – 1800 RPM

MODEL S30 G30
WHEEL SIZE: 30” X 1/4” X 1-3/4”
POWER: 30 HP
WEIGHT: Approximately 1000 lbs.
LENGTH: 56- 5/8” from center of motor to center of spindle
DRIVE: Single speed – 1800 RPM
WHEEL SPEED: 9500 SFPM

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
Machined, cast aluminum pulleys equipped with heavy duty sealed-for-life ball bearings. Available size shown in chart below.

- Aluminum pulleys with keyway also available in 6” dia. X 3 ¼” or 4 1/4 “width.
- Pulleys can be supplied with rubber covering.
- All pulleys are crowned. Belt won’t track well if the crown is worn down.
- Pulleys can be recrowned for extended life.

### PART NUMBERS & DIMENSIONS

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<th>DIMB</th>
<th>DIMC</th>
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<td>8 ¼</td>
<td>5 ¾</td>
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THROUGH FEED O.D. CYLINDRICAL FINISHERS

BULLETIN T-12

Because the part makes contact with the abrasive belt in an unsupported area, it is possible to polish tapered parts and straight parts.

Straight or Tapered parts of Metal, Plastics, Wood, Glass, Fiberglass, Molded Rubber, Fiber

Double Belt --- Single Belt Rough and Finish in One Pass On Double Belt Machine

Double Belt Machine

TYPE CF – 80B2
Range of work diameter ......1/2"-3"
Head drive motor ................. 5 H.P. – 3 Phase
Abrasive belt ....................... (5” x 73”)
Belt speed ......................... 3500 SFPM
Feed speed .......................... 20-65 FPM
Machine Size (LxWxH)......... 28x28x53
Net weight .......................... 1080 lbs
Gross weight ...................... 1200 lbs

All specifications subject to change without notice.

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627

Pg 57
TS-90D MULTI-PURPOSE ABRASIVE BELT GRINDER

BULLETIN TS-90D

SHARPENS CUTTING DIES

FOR GRINDING-DEBURRING-SANDING
1 H.P. Totally Enclosed Motor - 2750 SFPM Belt Speed

MULTI-PURPOSE

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
TYPE 1. (M-10058-B) Standard Top Bearing Assembly for general purpose use. Features platen one side and slack of belt on opposite side. Can be used on internal applications of 1” x 1-1/4” opening. Accommodates abrasive belts 1” x 90”.

TYPE 2. (M-10503-C) Top Bearing Assembly with Spreader Bar. Equipped with replaceable carbide tips at points of greatest wear. Features slack of belt for developing convex radii on internal surfaces – either straight or curved shapes. Will fit minimum opening 1-1/8” x 1-1/4”. Accommodates abrasive belts 1” x 90”. Spreader bar can also be used with type 1 by installing below the assembly.

TYPE 4. (M10504-C-1) Top Bearing Assembly. General purpose work where heavier grinding is needed. Features heavier construction, increased width and rubber covered contact wheel. Permits working on wheel, platen or slack of belt. Will fit internal opening 2-3/4” square. Accommodates abrasive belts 2” x 90”.

G&P Model TS 90D

The basic unit has a 1 horsepower 3450 RPM totally enclosed motor and switch for use with 115 volt 1 phase 60 hz electrical power. There are three top bearing assemblies available as described in the drawing on this page. A 90” long belt is used with all three. Types 1 and 2 require 1” width and type 4 requires 2” width. The belt is spring tensioned.

An adjustable tilting table is an accessory that is frequently ordered with this grinder.

Always wear eye protection when operating this or any other grinding equipment.
WOLFHEAD™ SANDING AND POLISHING WHEELS

BULLETIN W4

ELIMINATE COSTLY HAND SANDING
WITH THE SANDING WHEEL THAT FOLLOWS CONTOURS

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219
PHONE (317) 898-0750 • FAX (317) 899-1627
The Wolfhead™ is ideal for:

- satin finishing of aluminum extrusions and stainless steel trim
- deburring sprockets, gears and other parts
- blending operations and surface preparation prior to painting

Compared to other polishing wheels, the Wolfhead is more aggressive than nylon wheels and less aggressive than flap wheels.

**Other Materials**

The Wolfhead™ is used on fiberglass for sanding:
- Helmets
- Automotive parts
- Marine parts

**Operating Techniques**

Very little experience is required; however, to ensure good operating habits, certain precautions should be taken when using the Wolfhead for the first time.

When the work piece is applied to the head, the brushes “yield” to permit abrasive to flow into the depression and “envelop” irregular surfaces. The Wolfhead gives a softer feel than is common with grinding wheels, sanding drums, buffing wheels, and other devices. Therefore, while there may be an initial tendency to use excessive pressure against the work piece, this action destroys the abrasive and prematurely wears the brushes with no increase in production.

If the wheel is not cutting fast enough, rather than pushing harder, a courser grit of abrasive should be used or the speed should be increased.

For most applications, the abrasive is extended from 1/2” to 1” beyond the tips of the brushes. It is important to maintain that distance by releasing new abrasive as the old wears away. If the abrasive is allowed to wear down to a length even with the ends of the brushes, rapid brush wear will be experienced.

**Easy to Load**

The abrasive is stored in the wheel. As it wears, fresh abrasive is released. Installing new abrasive is done easily and quickly with packaged coated abrasive available in a variety of grits, bonds, and shreds from regular sources.
Better, Easier, and Faster

The Wolfhead™ sands all classes of shaped surfaces:
- mouldings
- intricate carvings
- furniture parts
- assemblies

The Wolfhead™ is used for:
- sanding out rough areas and raised grain
- sanding machined surfaces of wood and other fibrous materials
- sealer sanding

Follow the Contour

The Wolfhead Sanding Wheel lowers cost and reduces rejection rates associated with sanding mouldings and shaped wooden parts. The Wolfhead provides consistent finishes to both flat and intricate surfaces. Cushioning bristles work the abrasive strips into and around:
- corners
- hollow surfaces
- fluted surfaces
- small openings

Wolfhead™ — Choice of Models

The basic principle of the Wolfhead is the same as its predecessor, the Vonnegut Brush Backed Sanding Head. Strips of abrasive are held together with a cloth loop and are wound around a pin assembly in the center of the wheel. These strips extend between and beyond the brushes and as the abrasive wears away, new material is released. The abrasive strips are usually slashed in 1/8” or 1/4” segments across the width. Because the new abrasive is released to replace the worn, the wheel diameter remains constant. This eliminates the need for adjustment in speed or position for wheel wear. The end result is the most consistent finish available!

The choice between a 32 brush wheel and a 16 brush wheel is often determined by the speed of the equipment available for driving the wheel. For most applications, recommended speeds are 1200 rpm for the 32 brush wheel, and 1800 rpm for the 16 brush wheel.

Occasionally, the radius of a part will place restrictions on the wheel diameter. Without the limitation of machine speed or part size, the 32 brush wheel is most likely the best choice. The 12 brush wheel is almost always used for portable applications where it is mounted on a hand held tool.
The 12 brush head does not have a through bore; therefore, it cannot be mounted in the spindle of a buffing lathe or on a motor as in common practice with the larger wheels. Instead, a choice of mounting adapters is available for mounting on the threaded shaft of a portable lathe or in a chuck.

A 1/2” diameter male adapter is available for chuck mounting. Female adapters with the following threaded hole sizes are available for mounting on tools that have a threaded shaft: 5/8” - 11, 1/2” - 13, 1/2” - 20, and 3/8” -24. A 1/4” blank adapter is available for requirements other than those listed. Metric adapters are also available.

**Standard Trim and Long Trim Brushes**
Standard trim brushes have a bristle length of 1 1/2”, and are suitable for most applications. Long trim brushes have a bristle length of 3 1/2”, and are available for sanding parts that require a longer brush to reach deep recessed areas - and for applications requiring softer touch. The long trim brushes increase the diameter of the wheel by 4”; therefore, the speed of the wheel should be reduced to take advantage of the softer brushes.