G&P MACHINERY

Master Machine Booklet

G&P MACHINERY

GRINDING & POLISHING MACHINERY CORPORATION
2801 TOBEY DRIVE / INDIANAPOLIS, IND. 46219
PHONE (317) 898-0750 FAX (317) 899-1627
www.gandpmachinery.com

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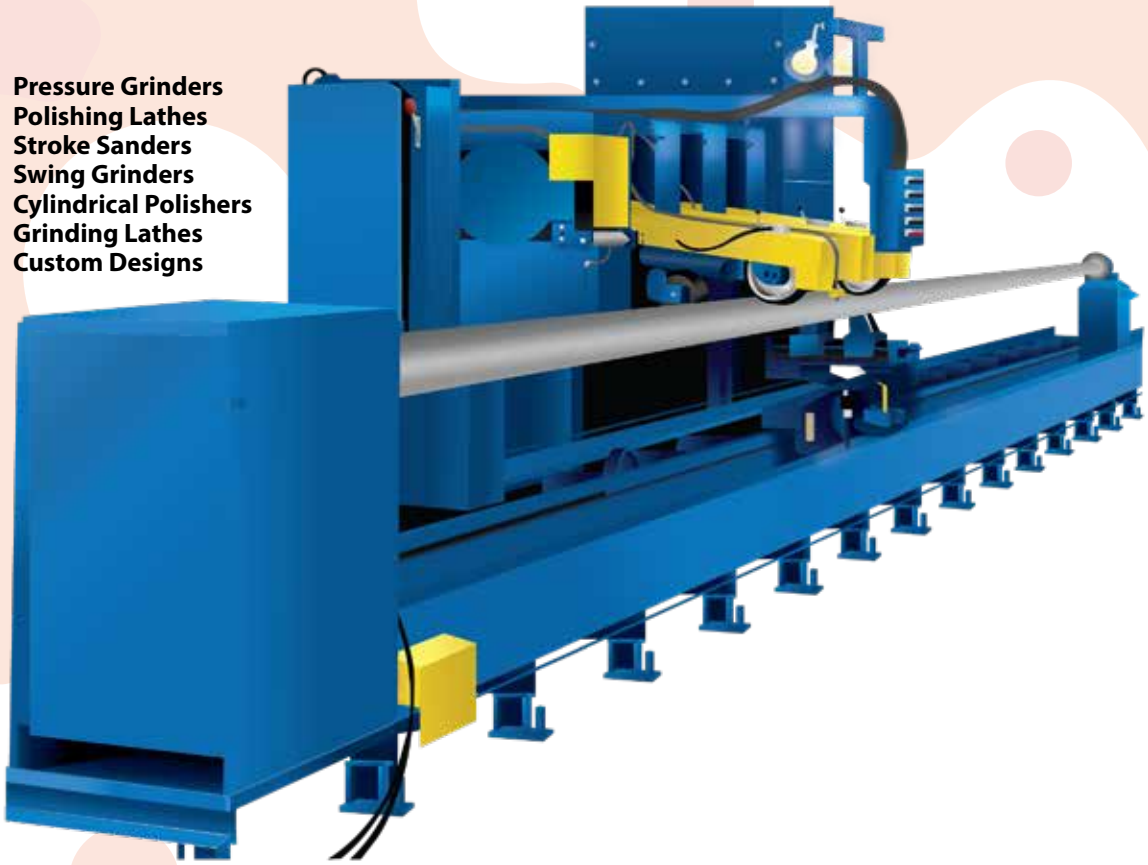
G&P MACHINERY BROCHURE

BROCHURE

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.

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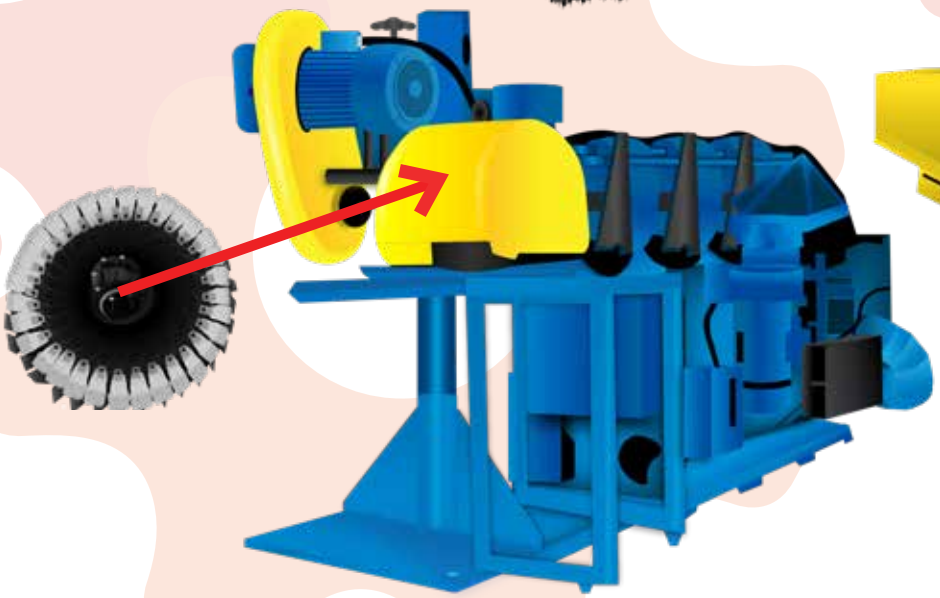
BROCHURE

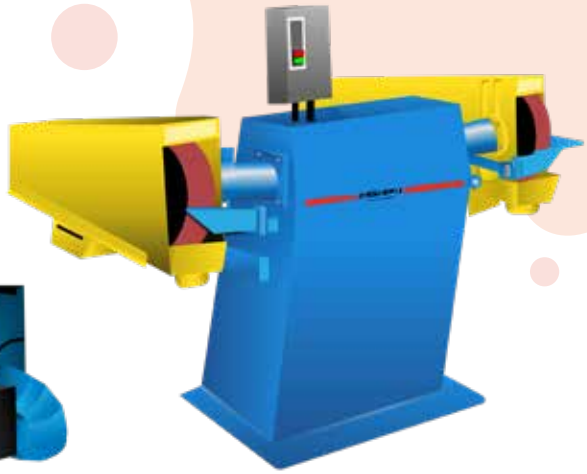
Wolfhead

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.

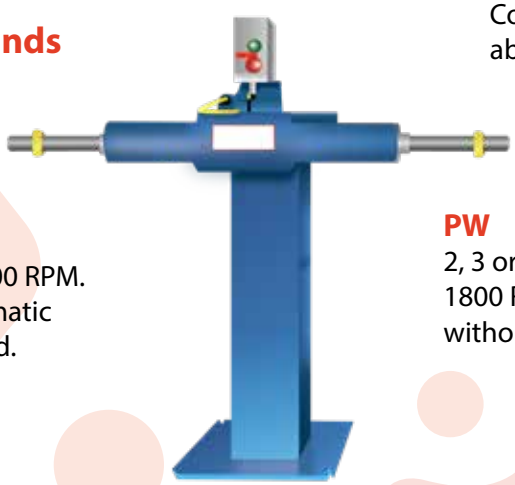
Belt Adaptor

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.

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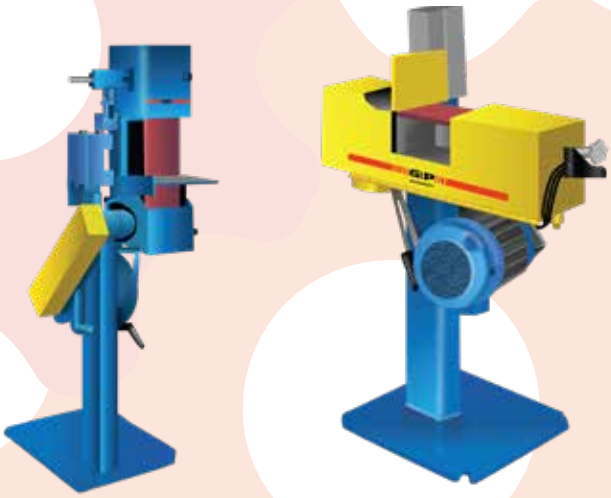
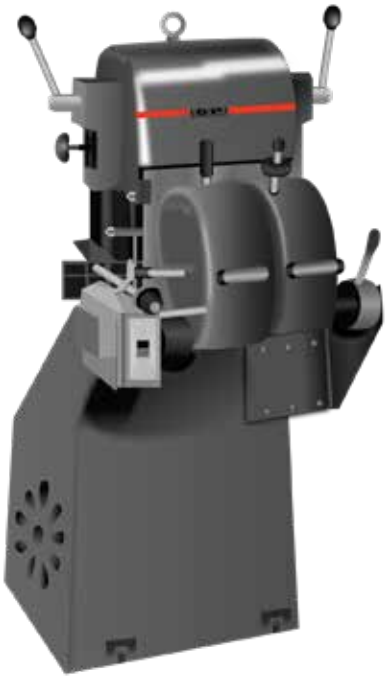
BROCHURE



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.

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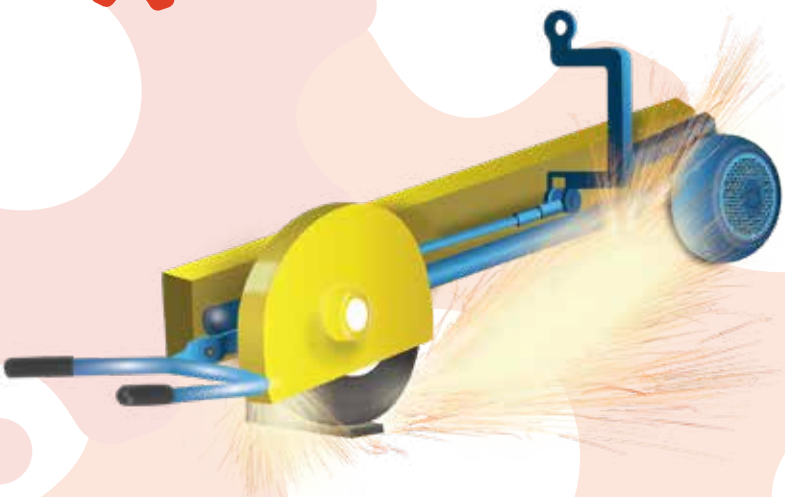
BROCHURE

STANDARD MACHINES

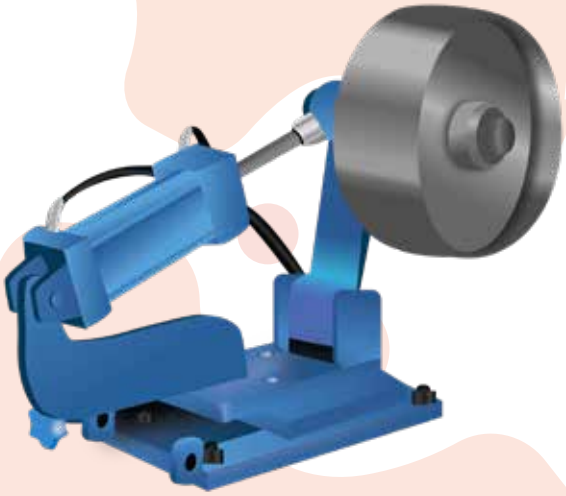


Swing Frame Grinders

Abrasive belt and hard wheel 2 to 25 H.P.

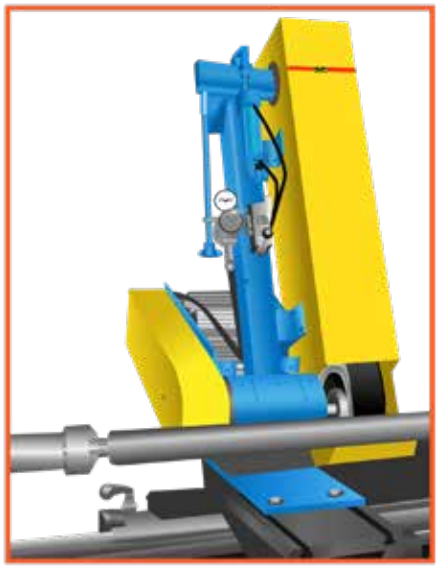
Stroke Sanders

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.

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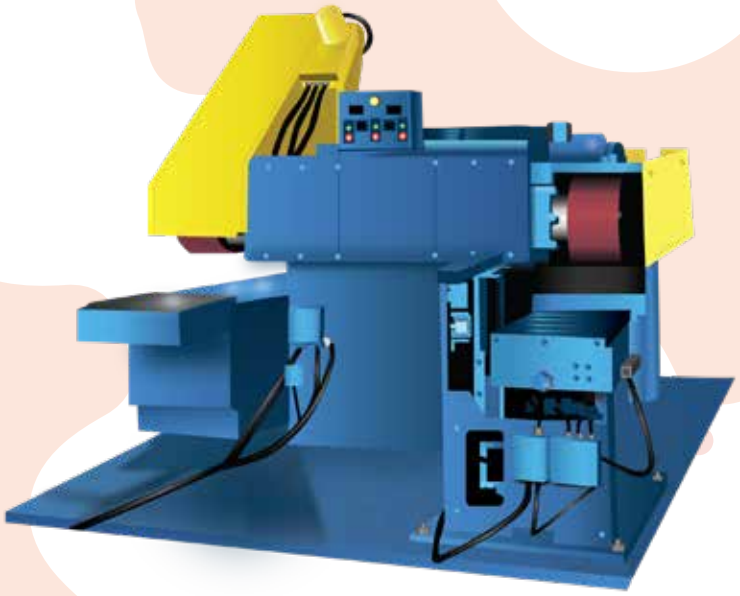
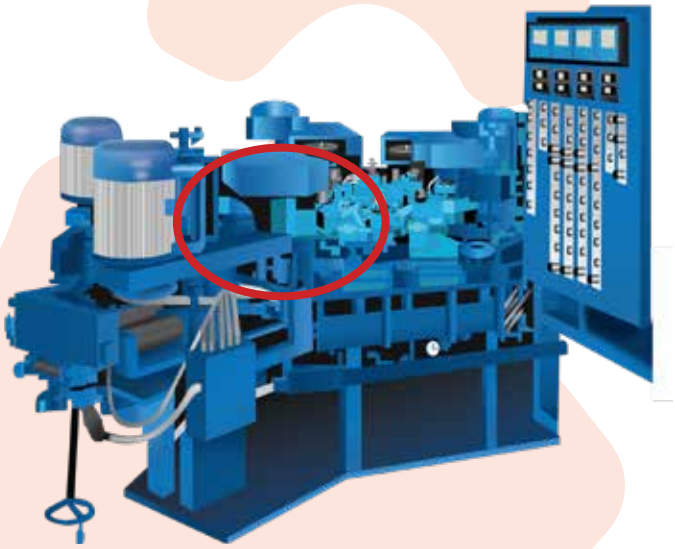
BROCHURE

CUSTOM BUILT MACHINES

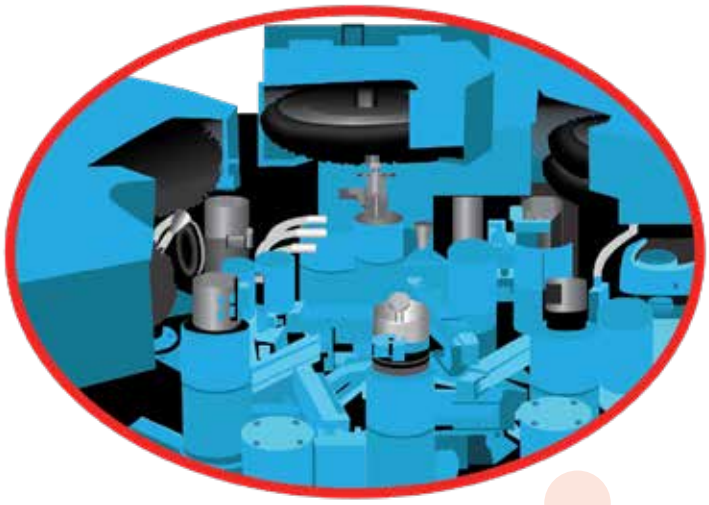
Power Grind
High pressure grinders. Reciprocating & rise and fall tables. 25 to 75 H.P. Single or dual motor. Single or multiple pass grinding.



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



Brushing Turbine Blades with Nylon Brushes.



Rotary Indexing Machines

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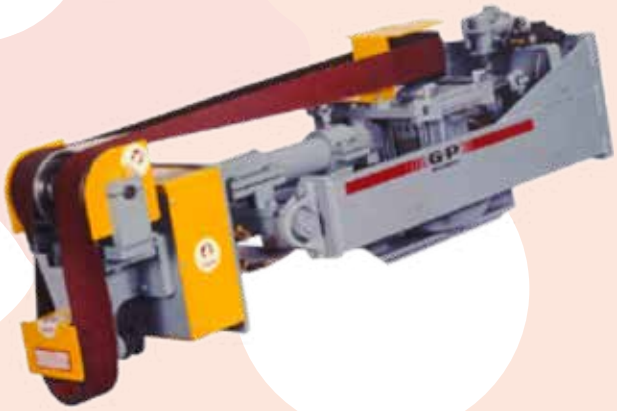
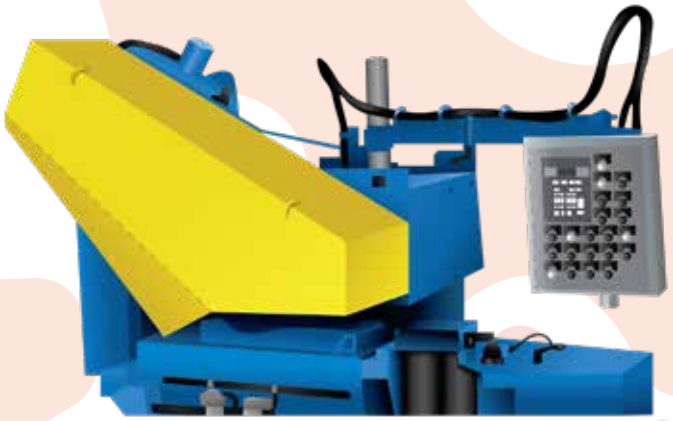
G&P MACHINERY BROCHURE

BROCHURE

MODIFIED STANDARDS

Right Angle I.D. Grinder





Reciprocating Grinder
Semi-Automatic and Programmable

Grind Assist Tables
Pneumatic and Hydraulic

Platen Grinder
Manual & Self-Propelled

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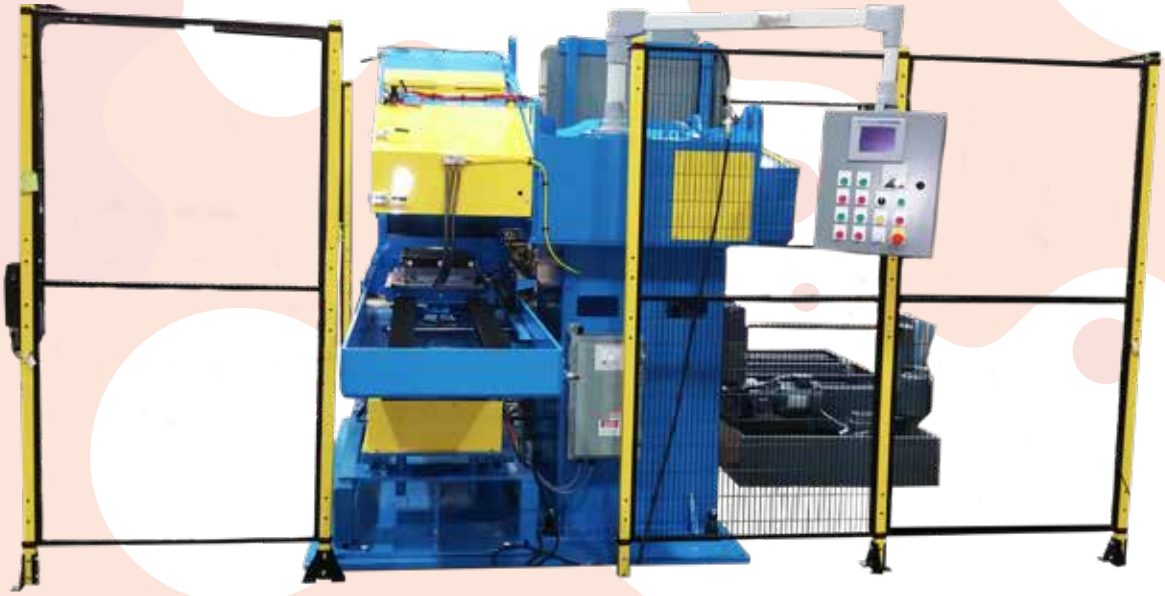
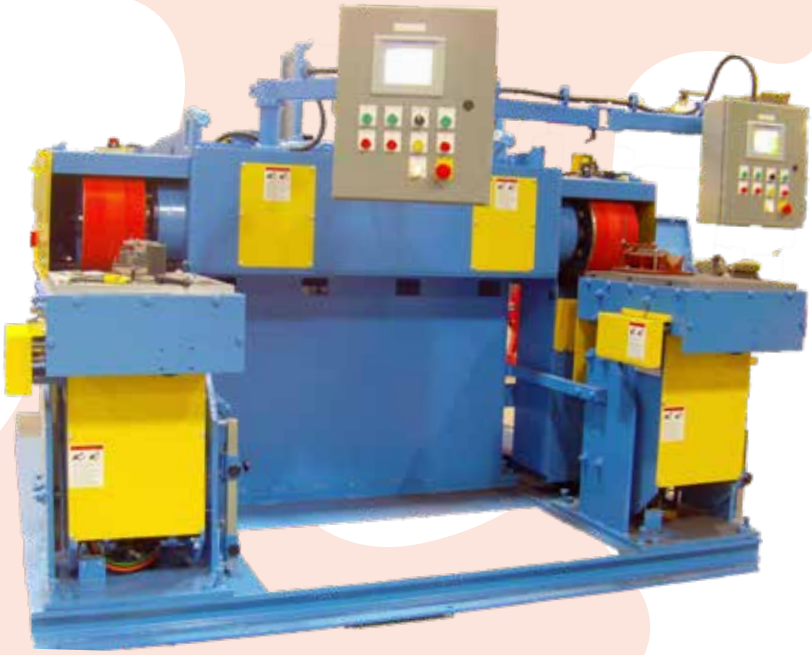
POWER GRINDERS

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.

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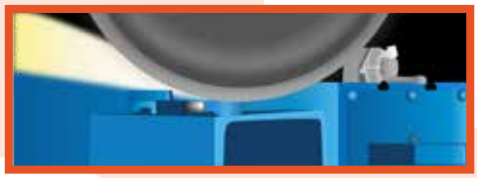
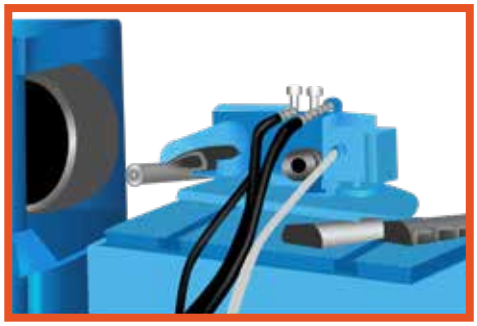
POWER GRINDERS

BULLETIN PG-3

MODEL	MOTOR
PG 25S-SS	25HP
PG 25D-SS	25HP (2)
PG 30S-SS	30HP
PG 30D-SS	30HP (2)
PG 40S-SS	40HP
PG 40D-SS	40HP
PG 50S-SS	50HP
PG 50D-SS	50HP
PG 75S-SS	75HP
PG 75D-SS	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

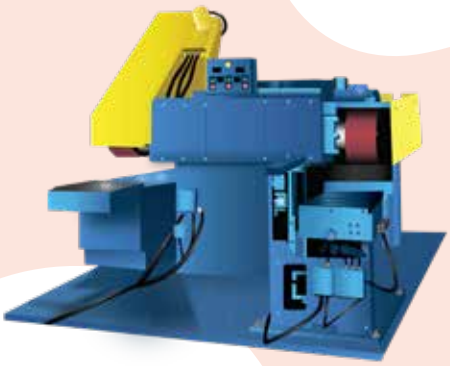
ACCESSORIES:
- **Reciprocating Table**

Standard horizontal movement-28'
Standard clearance- 3-3/4" min, 10" max
- **Rise and Fall table 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.

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POWER GRINDERS

BULLETIN PG-3

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:
  - o 18" wide x 29" deep tee-slotted table
  - o Hydraulic cylinder for 20" (maximum) vertical travel (34 1/2" to 46 1/2" table height from top of base plate)
  - o 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-50D-55-2RF20

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POWER GRINDERS

BULLETIN PG-3

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 outsideof 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

Model: PG-60S-SS-W

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STROKE SANDER - GPSS AND PMC

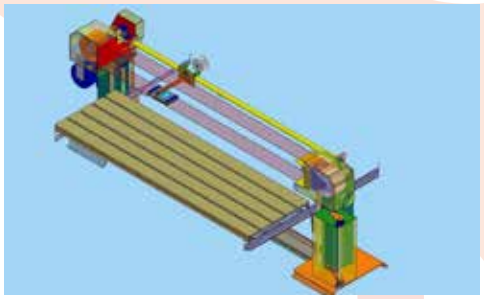
BULLETIN ST-4000

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.



PMC-168,216,264,312 and 360

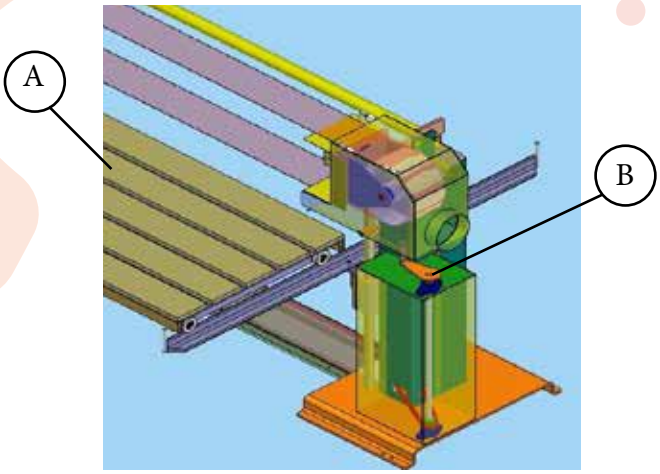
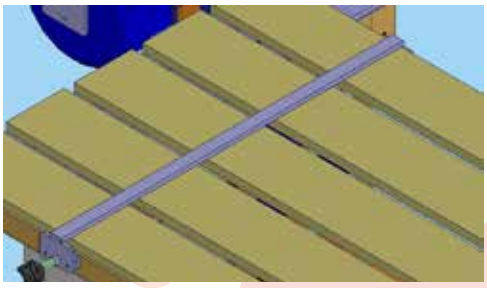


Table Height Adjustment

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

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STROKE SANDER - GPSS AND PMC

BULLETIN ST-4000

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

Model	HP	Belt Size	Table Length	Net Weight	Approx. Shipping Weight
GPSS-6216-7	7.5	6" x 216"	6'	1900 lbs	2100 lbs
GPSS-6264-7	7.5	6" x 264"	8'	2000 lbs	2200 lbs
GPSS-6312-7	7.5	6" x 312"	10'	2200 lbs	2400 lbs
GPSS-6360-7	7.5	6" x 360"	12'	2300 lbs	2500 lbs

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

Model	HP	Belt Size	Table Length	Net Weight	Approx. Shipping Weight
PMC-168-6	5	6'' x 168''	4'	800 lbs	1000 lbs
PMC-216-6	5	6" x 216"	6'	1100 lbs	1300 lbs
PMC-264-6	5	6" x 264"	8'	1400 lbs	1600 lbs
PMC-312-6	5	6" x 312"	10'	1700 lbs	2000 lbs
PMC-360-6	7.5	6" x 360"	12'	2000 lbs	2300 lbs

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 1/2 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

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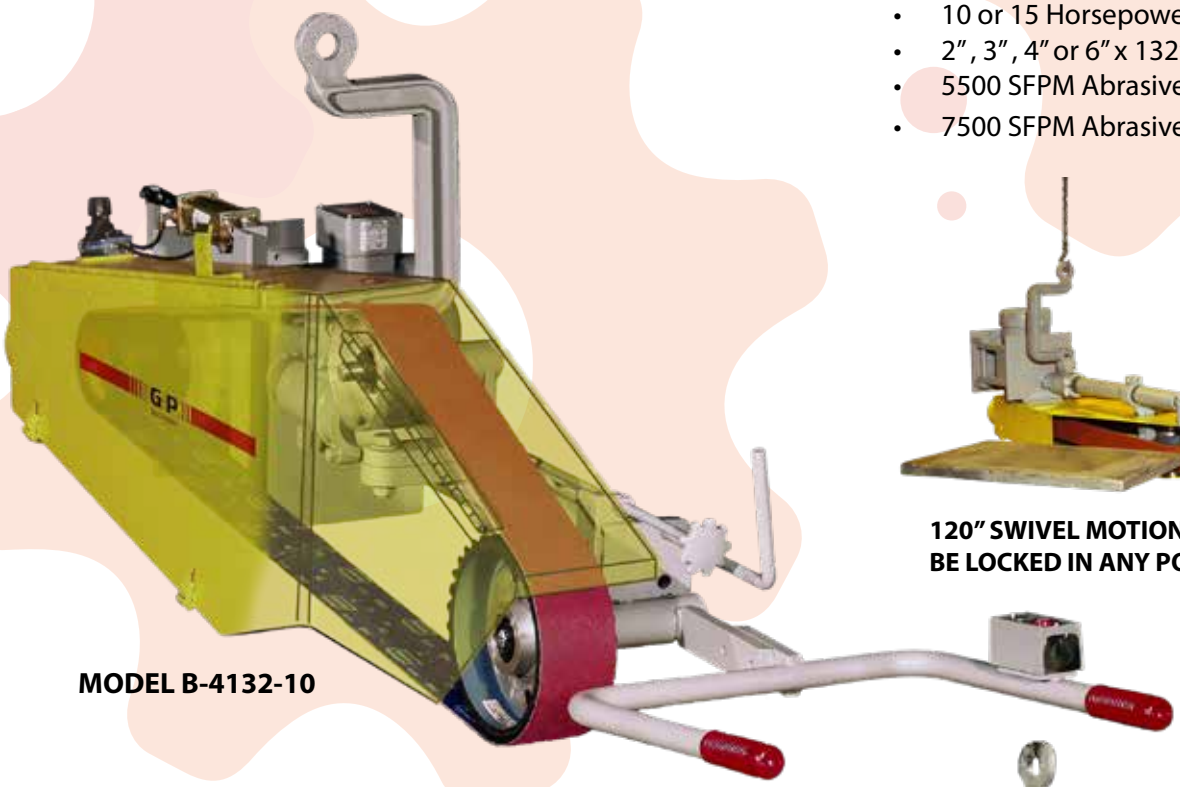
ABRASIVE BELT GRINDER

BULLETIN S10-B

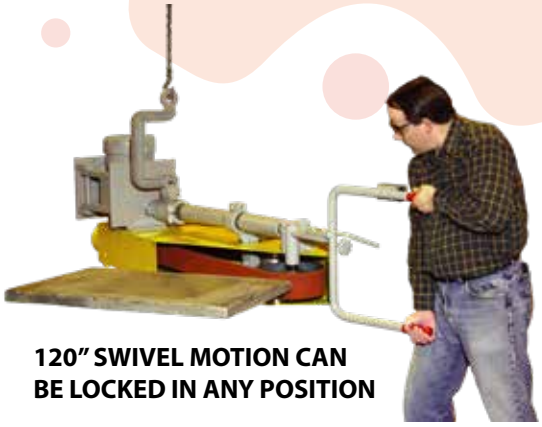
SWING-FRAME ABRASIVE BELT GRINDERS

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



MODEL B-4132-10

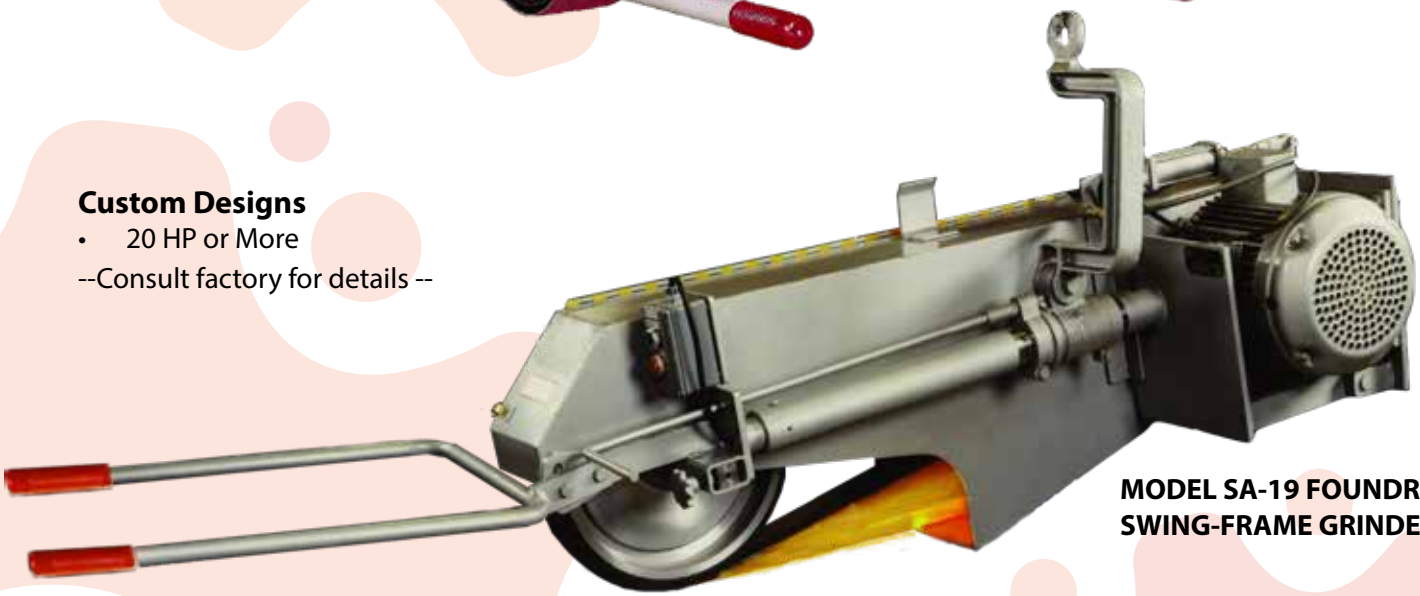


120" SWIVEL MOTION CAN BE LOCKED IN ANY POSITION

Custom Designs

- 20 HP or More

--Consult factory for details --



MODEL SA-19 FOUNDRY SWING-FRAME GRINDER

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PHONE (317) 898-0750 • FAX (317) 899-1627

ABRASIVE BELT GRINDER

BULLETIN S10-B

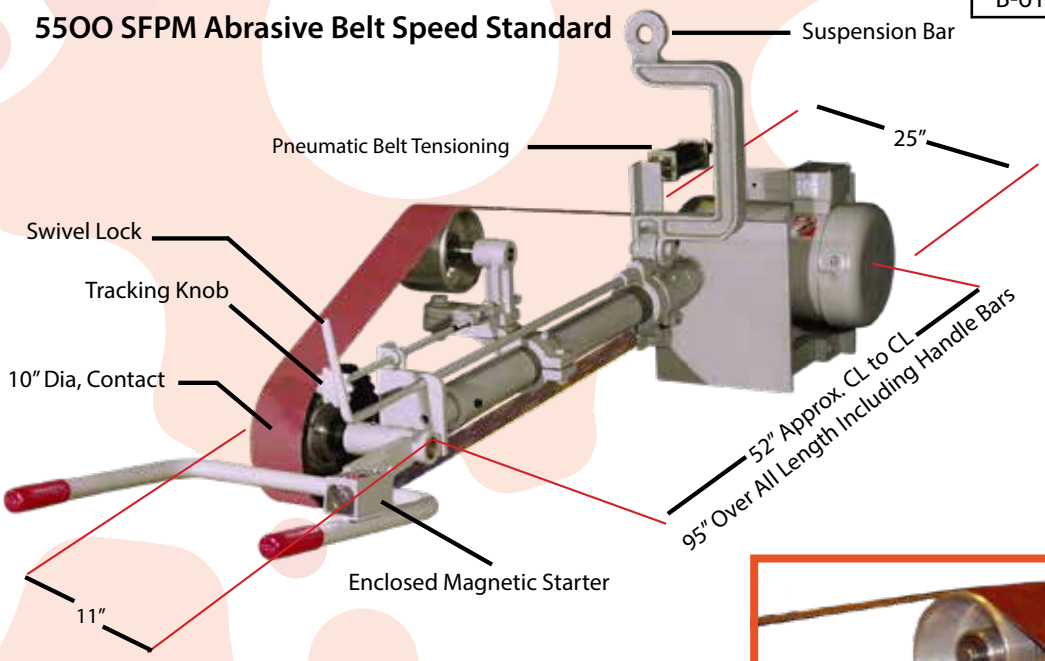
The **132 Series Grinders** are equipped with a totally enclosed fan cooled ball bearing 208-230-460 volt, 3 phase, 60 hertz motor.The abrasive belt size is 2" . 3" , 4", or 6" wide x 132" long as indicated by the chart.

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.

Model	Belt Size	Motor
B-2132-10	2" x 132"	10 hp
B-3132-10	3" x 132"	10 hp
B-4132-10	4" x 132"	10 hp
B-6132-10	6" x 132"	10 hp
B-2132-15	2" x 132"	15 hp
B-3132-15	3" x 132"	15 hp
B-4132-15	4" x 132'	15 hp
B-6132-15	6" x 132"	15 hp

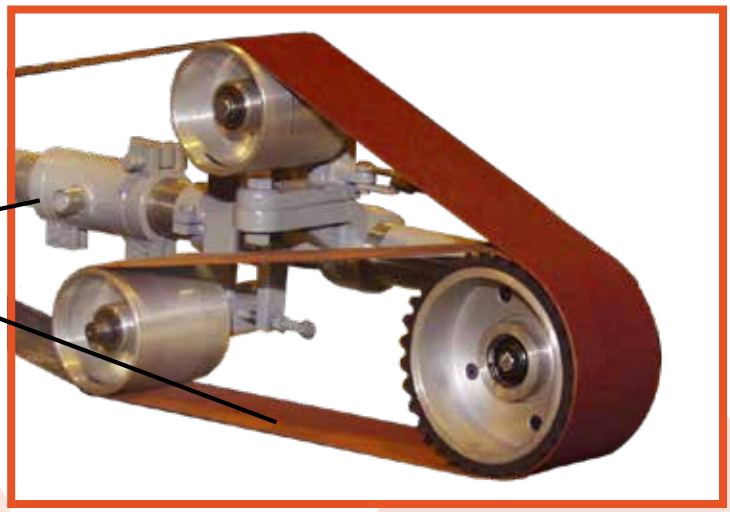
*** UNIT BELOW SHOWN WITHOUT BELT GUARD FOR ILLUSTRATION ONLY**

5500 SFPM Abrasive Belt Speed Standard



Optional Equipment:
- 7500 SFPM Belt Speed
- Trunnion Mounting
- Back-up Belt Attachment

For modifications and specials, please consult factory.



* Never operate this or any other machine without proper guarding. All G&P Swingframes come with standard guarding.

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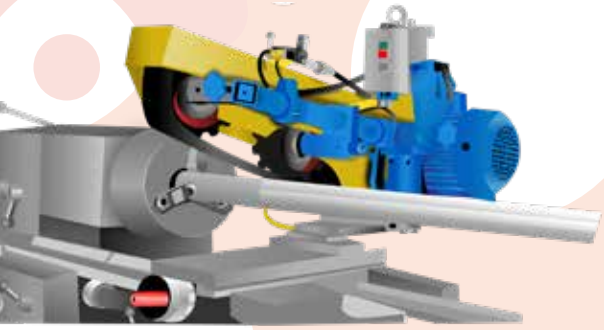
Compact and Medium Duty Swingframe Grinders

BULLETIN S12

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

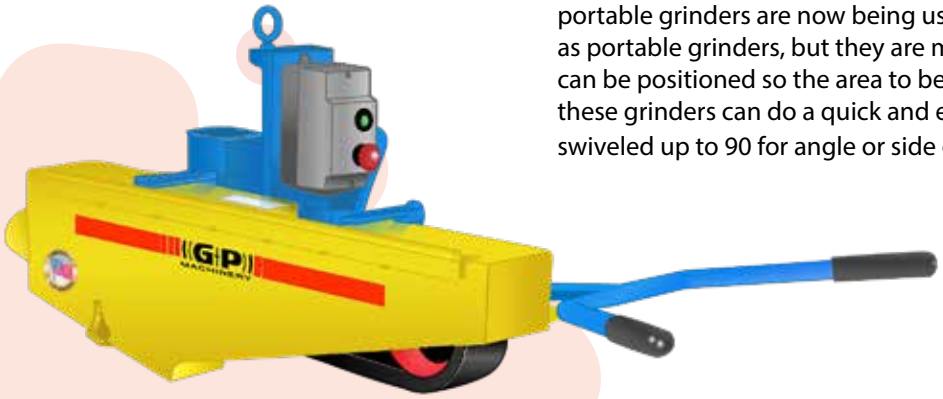


Lathe Mounted

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

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Compact and Medium Duty Swingframe Grinders

BULLETIN S12

The Compact Duty 72 Series

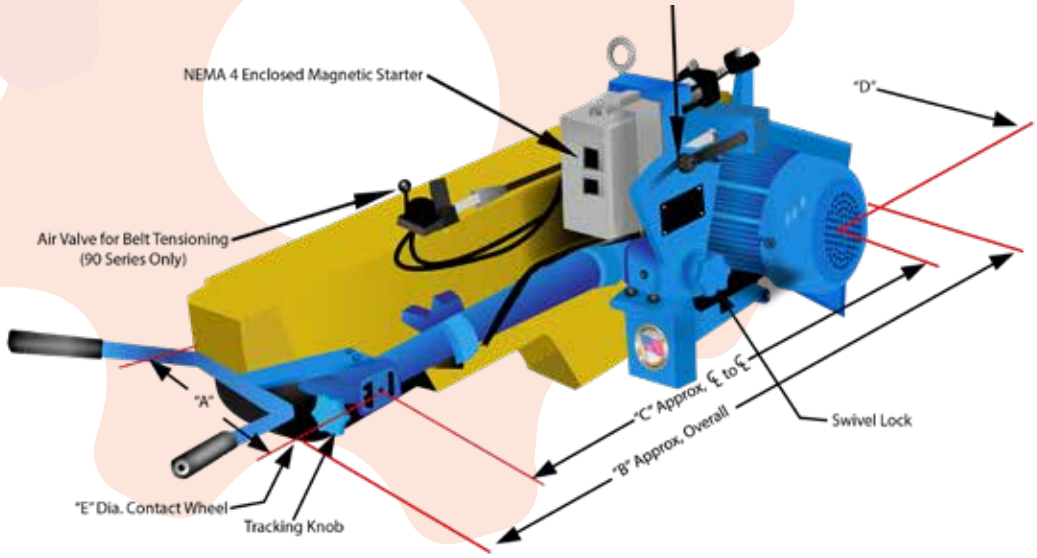
The 72 Series Grinders are equipped with a 2 or 3 horsepower motor 208-230-460 volt, 3 phase, 60 hertz motor. The abrasive belt size is 2", 2.5"or 3" wide x 72" long as indicated by the chart

Model	Belt Size	Motor
B-272-2	2" x 72"	2 hp
B-2572-2	2.5" x 72"	2 hp
B-372-2	3" x 72"	2 hp
B-272-3	2" x 72"	3 hp
B-2572-3	2.5" x 72"	3 hp
B-372-3	3" x 72"	3 hp

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.

Model	Belt Size	Motor
B-290-5	2" x 90"	5 hp
B-390-5	3" x 90"	5 hp
B-490-5	4" x 90"	5 hp
B-290-7	2" x 90"	7.5 hp
B-390-7	3" x 90"	7.5 hp
B-490-7	4" x 90"	7.5 hp



Dim	A	B	C	D	E	Belt Tensioning
72 Series	9"	35"	27"	15"	6"	Spring
90 Series	9"	44"	34"	18"	8"	Pneumatic

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.

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.

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ABRASIVE BELT GRINDERS

MOUNTED ON WHEELS

BULLETIN SA-23

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.

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

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

Grinders can be custom built to accommodate your specific grinding applications. Consult factory for more information.

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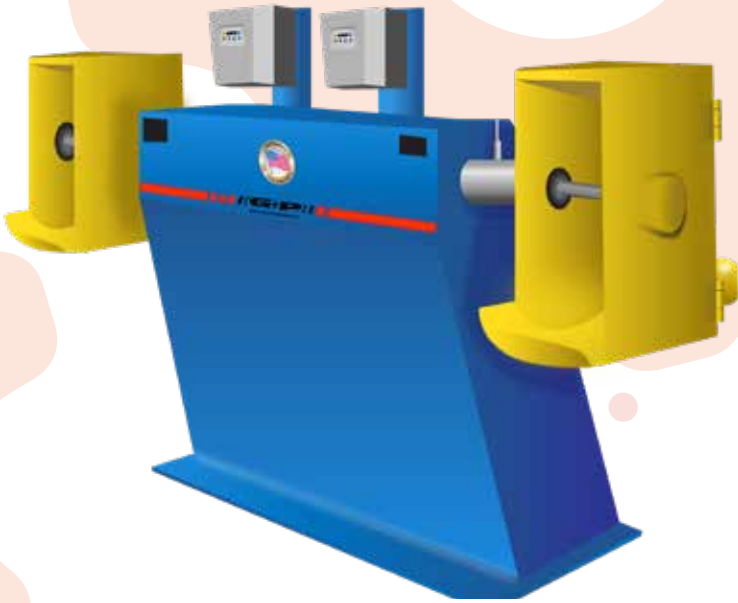
GRINDING - POLISHING - BUFFING LATHES

BULLETIN 11 - B

Single Motor Polishers and Buffers



Dual Motors for Polishing and/or Buffing

Single and Variable Speeds

GRINDING & POLISHING MACHINERY CORPORATION
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OPTIONAL CONTACT WHEEL & BELT ATTACHMENT

BULLETIN 11-B

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.

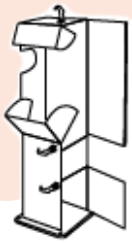
Available with Spring Tensioned idlers or Air Tensioned idlers. The Air Tensioned idlers are recommended for belt speeds of 7500SFPM and faster due to larger diameter pulleys.

GUARDS

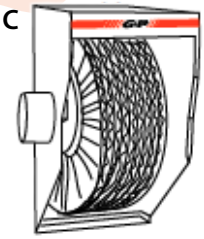
All polishing and sanding wheels must be guarded to protect the operator. Operating without guards may lead to serious injury. This is stated in a warning sign attached to every machine. G&P offers guards as listed below. Prices for guards will be supplied upson receipt of details of the application.

TYPE A

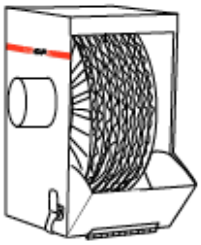
TYPE B



TYPE C



TYPE D



Free Standing

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.*

For Mounting on Machine

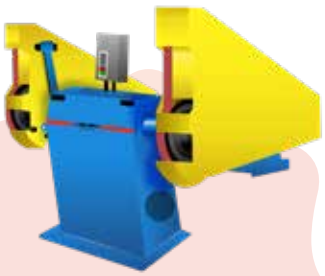
TYPE C - Open bottom to allow clearance when sanding or buffing long parts off-hand.
TYPE D - Closed bottom with adjustable scoop for improved dust collection.

**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.



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HEAVY DUTY & SINGLE SPEED

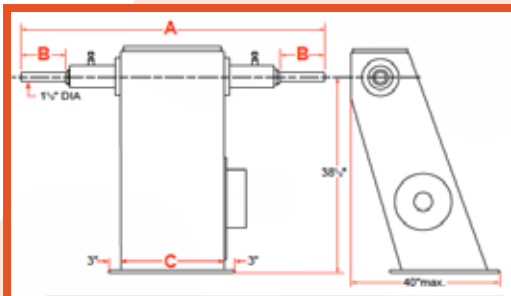
15 & 20 HORSEPOWER

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



MODEL	H.P.	RPM	A	B	C
VHS-1500	15	800-2400	63"	6"	29½"
VHS-2000	20	800-2400	63"	6"	29½"
SSH-1500	15	1800	63"	6"	29½"
SSH-2000	20	1800	63"	6"	29½"
2MVSH-1500	(2) 15	800-2400	91"	6"	57½"
2MVSH-2000	(2) 20	800-2400	91"	6"	57½"
2MSSH-1500	(2) 15	1800	91"	6"	57½"
2MSSH-2000	(2) 20	1800	91"	6"	57½"

STANDARD 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.

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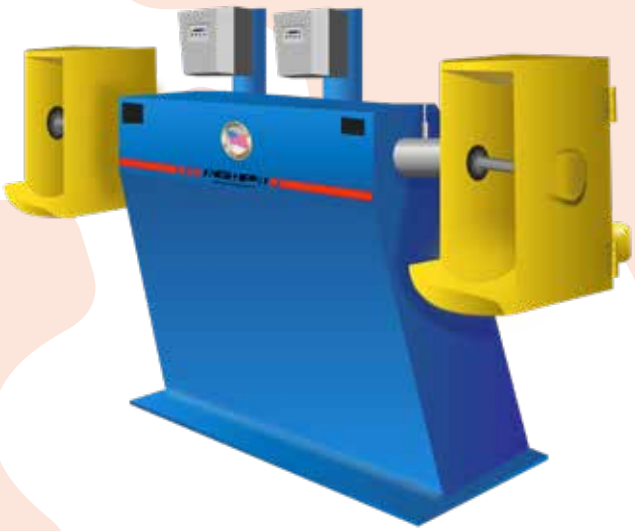
VARIABLE SPEED & SINGLE SPEED

5 - 7 1/2 - 10 HORSEPOWER

BULLETIN 11-B

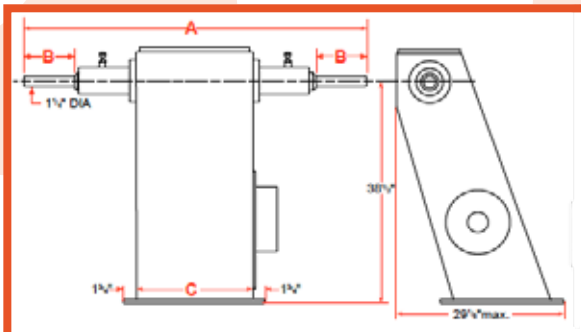
SINGLE MOTOR OR DUAL MOTOR MODELS AVAILABLE

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:

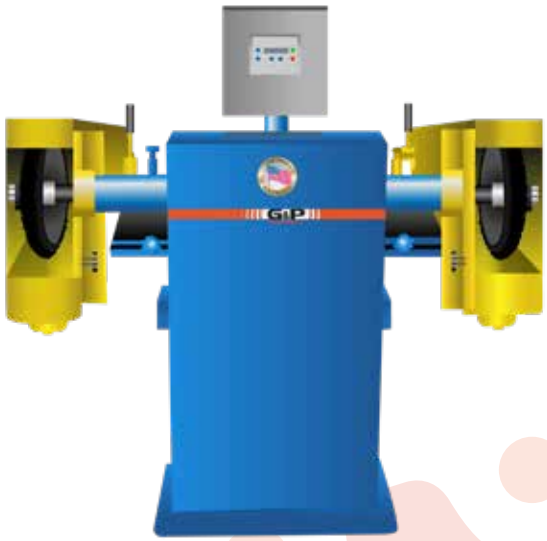
- LCD on the VS models.
- Heavy duty fabricated steel base.
- Spindle lock on each side (spindle brake optional).
- Full voltage push button starters in NEMA 12 enclosures.
- 1 1/4" x 6" or 11" long spindles.



MODEL	H.P.	RPM	A	B	C
VS500	5	850-2200	66 5/8" long 56 5/8" short	11" long 6" short	24"
VS700	7 1/2	800-2400	56 5/8"	6"	24"
VS1000	10	800-2400	56 5/8"	6"	24"
SS500	5	1800	66 5/8" long 56 5/8" short	11" long 6" short	24"
SS700	7 1/2	1800	56 5/8"	6"	24"
SS1000	10	1800	56 5/8"	6"	24"
2MVS500	(2) 5	850-2200	90 5/8" long 80 5/8" short	11" long 6" short	48"
2MVS700	(2) 7 1/2	800-2400	80 5/8"	6"	48"
2MVS1000	(2) 10	800-2400	80 5/8"	6"	48"
2MSS500	(2) 5	1800	90 5/8" long 80 5/8" short	11" long 6" short	48"
2MSS700	(2) 7 1/2	1800	80 5/8"	6"	48"
2MSS1000	(2) 10	1800	80 5/8"	6"	48"

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.

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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

MODEL	B-136-2	B-236-2	B-336-2
BELT SIZE	1" x 36"	2" x 36"	3" x 36"
BELT SPEED	4700 SFPM	4700 SFPM	4700 SFPM
CONTACT WHEEL	3" dia. x 1" face Rubber Cover	3" dia. x 2" face Rubber Cover	3" dia. x 3" face Rubber Cover
DRIVE POLICY	3" dia. x 1" face Rubber Cover	3" dia. x 2" face Rubber Cover	3" dia. x 3 face Rubber Cover
WEIGHT	13½#	17#	20#

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BACKSTAND IDLERS

BULLETIN B200-B

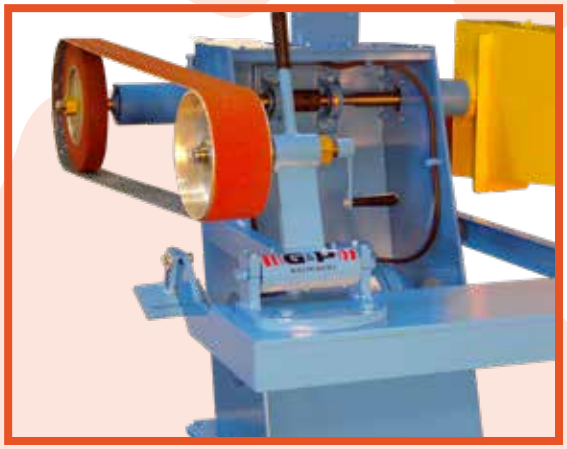
SPRING TENSIONED & AIR TENSIONED

Model: ABS-HD Right Hand Shown

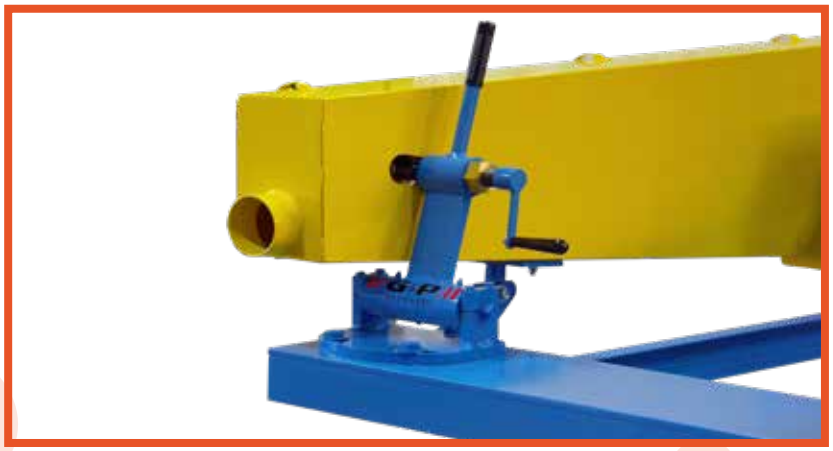
Model: ABS-HD Left Hand Shown

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

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BACKSTAND IDLERS

BULLETIN B200-B

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.

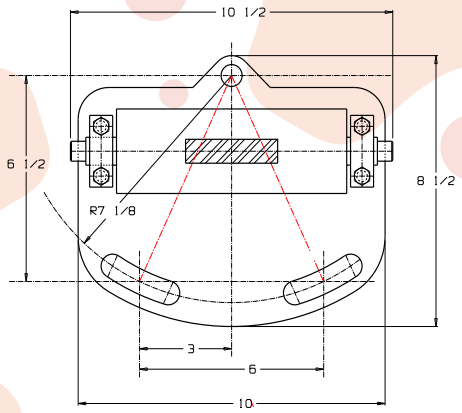
Model ABS-HD-4 - for belts of 4" width or less
Model ABS-HD-6 - for belts of 6" width or less

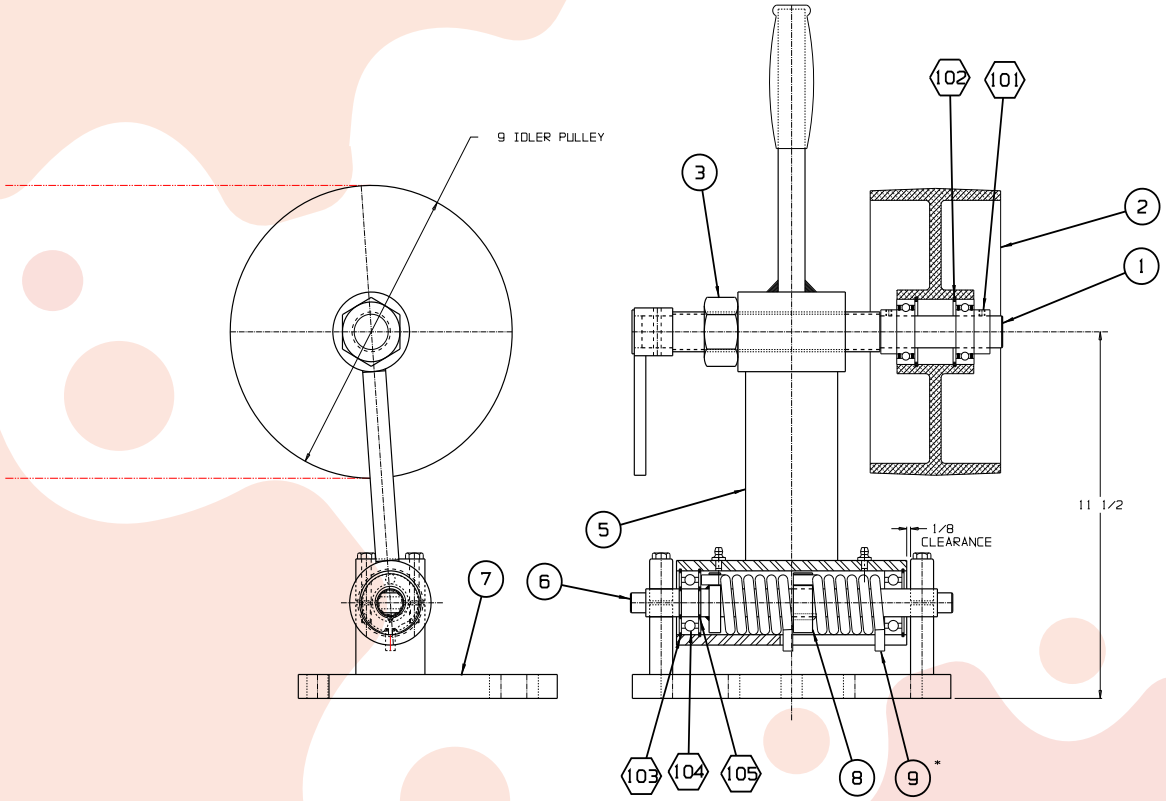
BACKSTAND IDLERS

BULLETIN B200-B

Toro Drop-In Replacement

The TR-4 and TR-5 are dimensionally identical to the old Toro Backstand Iders. 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.





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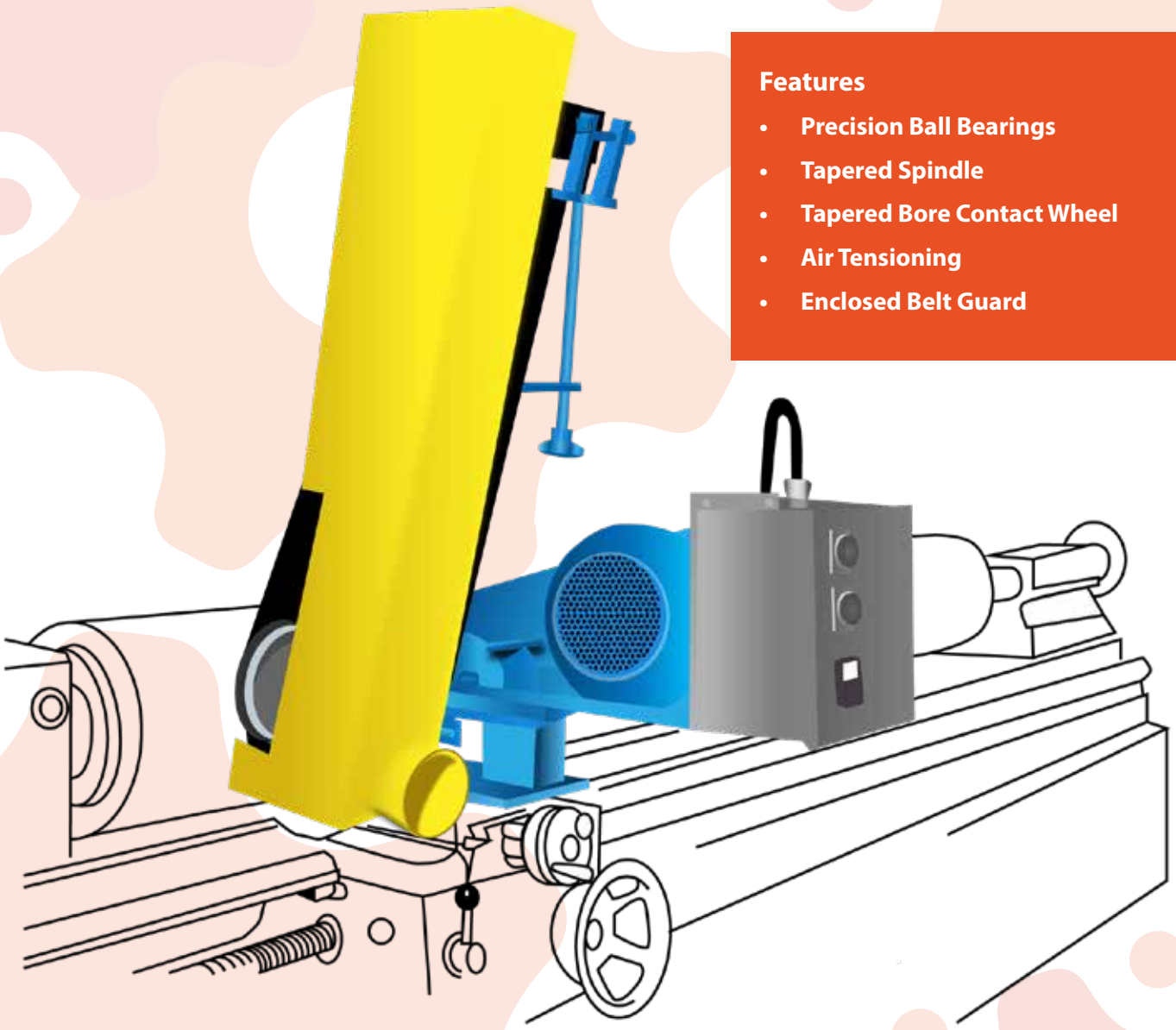
THE G&P APPROACH TO ROLL GRINDING

BULLETIN BRG-3

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

G&P MACHINERY

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CONVERT YOUR LATHE INTO A ROLL GRINDER

BULLETIN BRG-3

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.

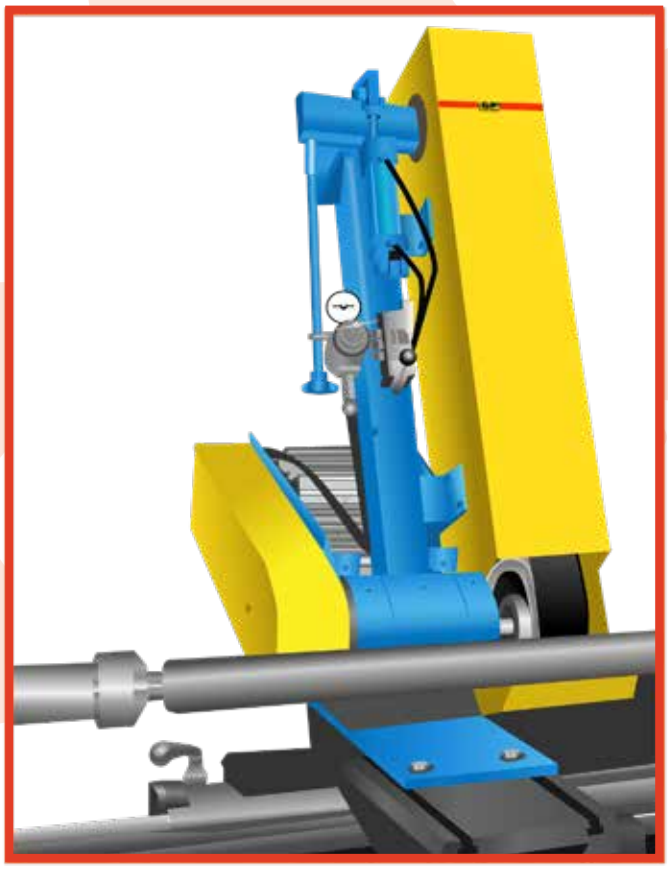
When supplied with the information requested under "mounting information" in bulletin BRG-3B, G&P can provide an adaptor to mount the grinder to your lathe.

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 powered 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

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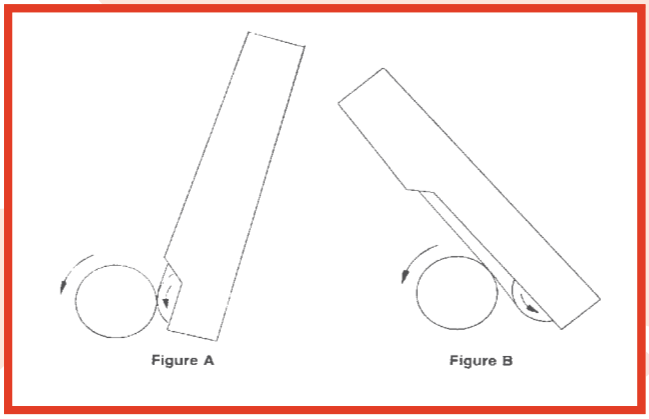
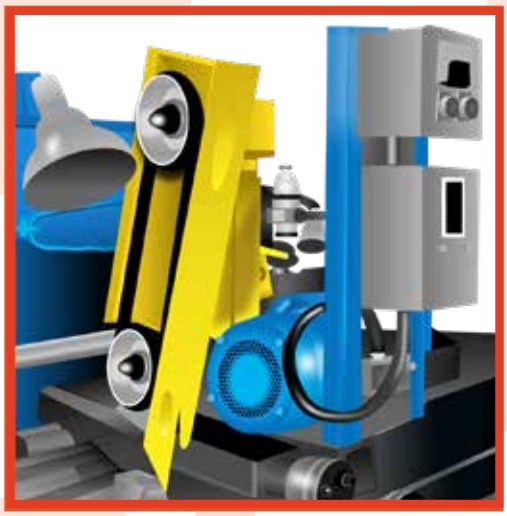
THE G&P APPROACH TO ROLL GRINDING

BULLETIN BRG-3

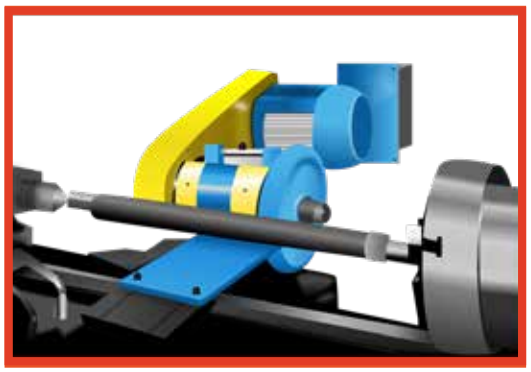
The drawing to the right shows two methods of bringing the abrasive belt into contact with the work roll. For most roughing and finishing, the method shown in figure A is recommended. If slack of belt polishing is required, a removable front guard is recommended. If slack of belt polishing is required, a removable front guard section is provided that will allow the grinder to be tilted forward as shown in Figure B.





Contact Wheel Selection. Fig 1

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-horse power 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

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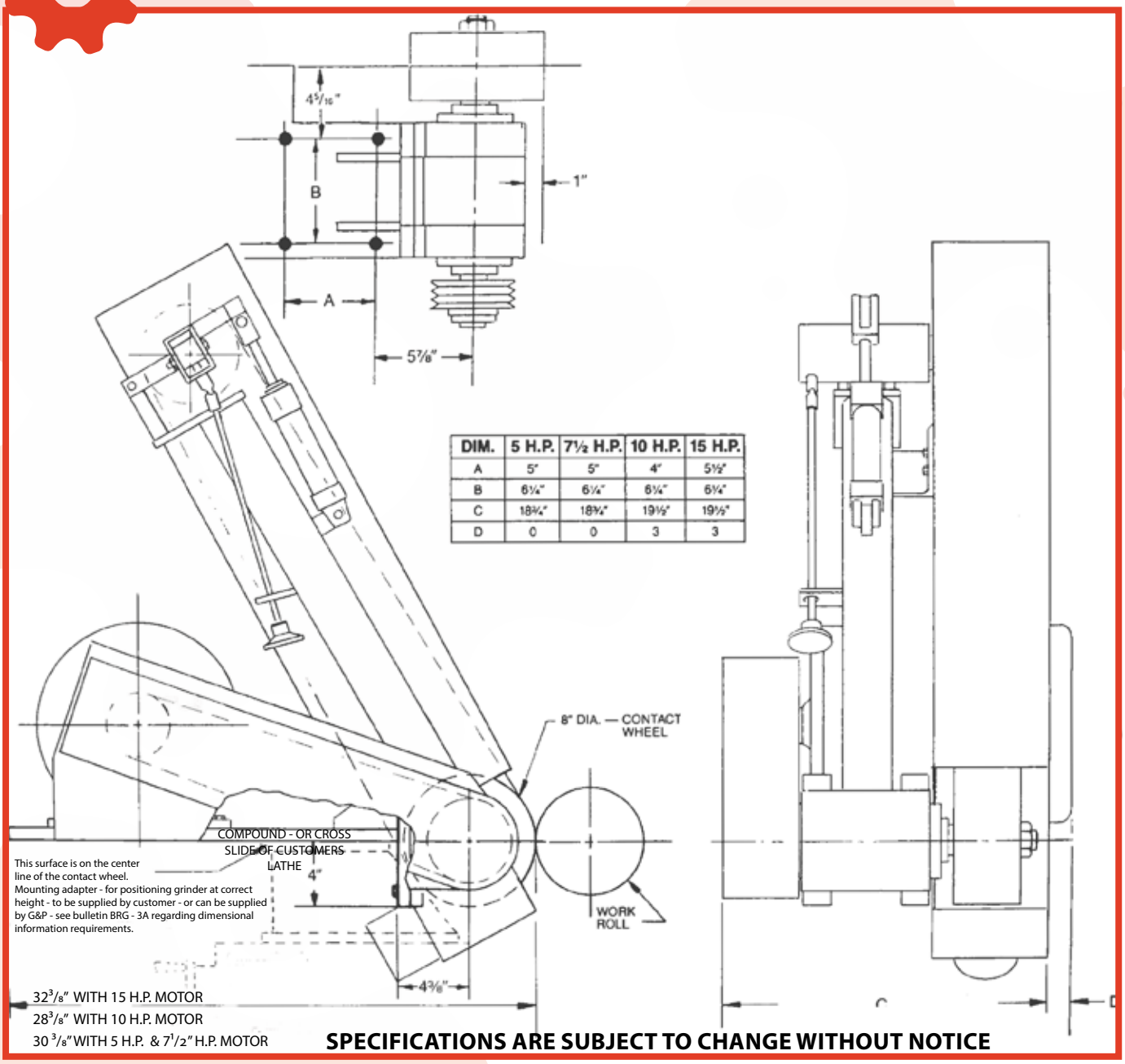
THE G&P APPROACH TO ROLL GRINDING

BULLETIN BRG-3



DIM.	5 H.P.	7½ H.P.	10 H.P.	15 H.P.
A	5"	5"	4"	5½"
B	6¼"	6¼"	6¼"	6¼"
C	18¾"	18¾"	19½"	19½"
D	0	0	3	3

SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE

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

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CONTACT WHEELS FOR ROLL GRINDING

BULLETIN BRG-3

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.

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THE G&P APPROACH TO ROLL GRINDING

BULLETIN BRG-3

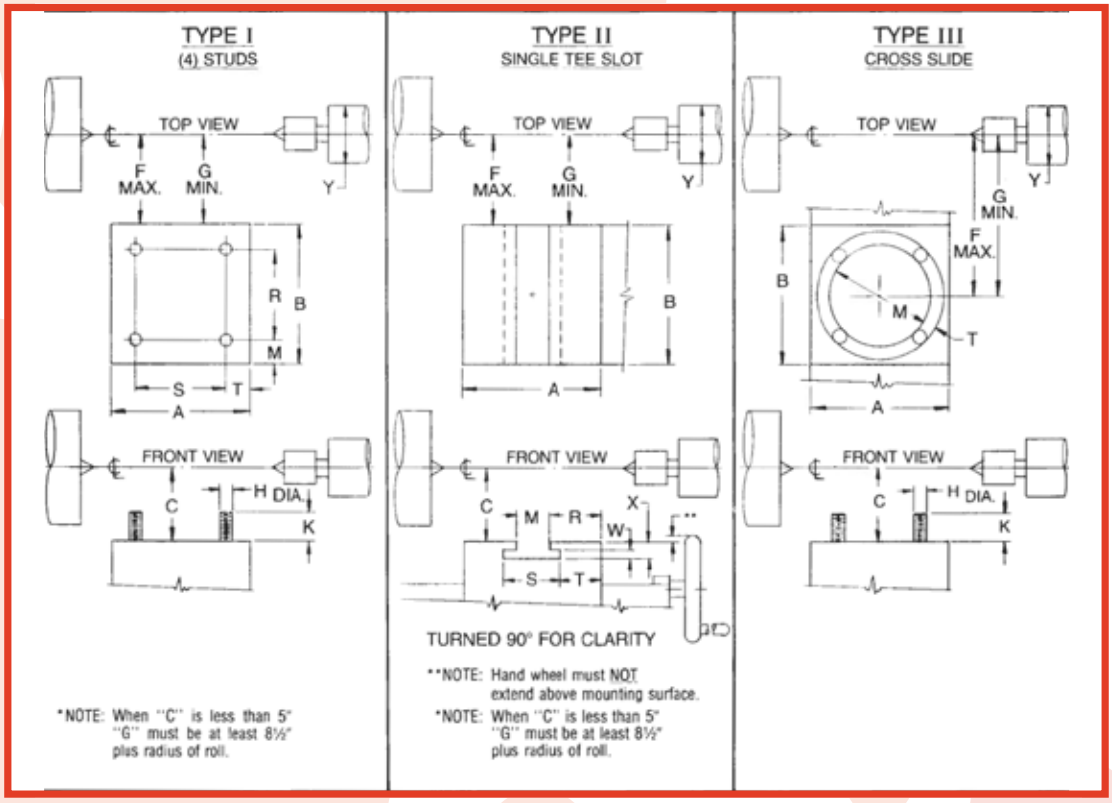
Mounting Information

A schematic on the lower portion of this page illustrates two common types of lath 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

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G&P UNIVERSALLY ADJUSTABLE

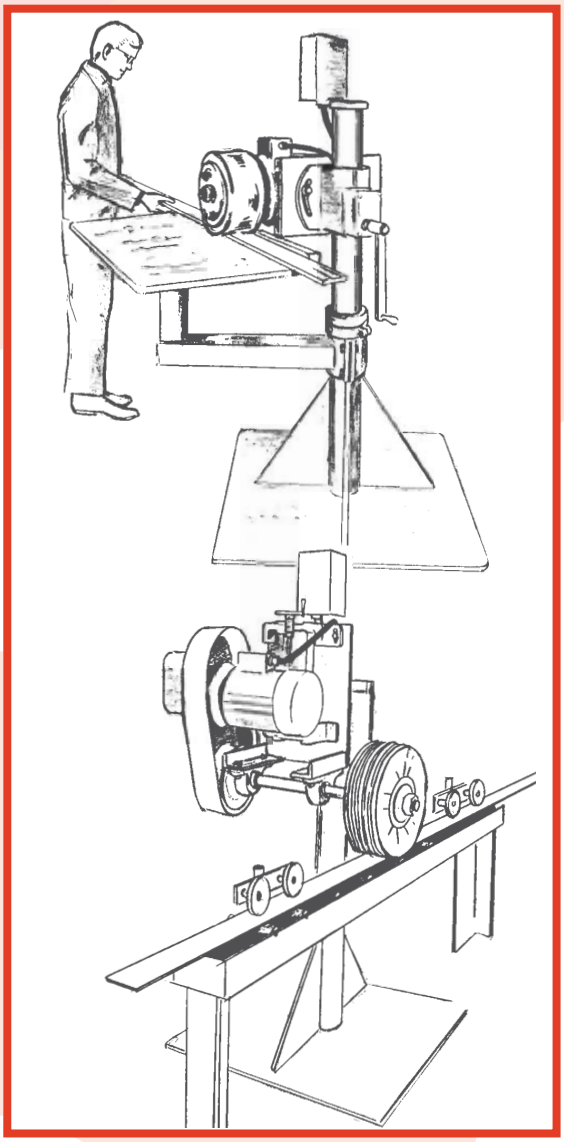
SPINDLE STANDS

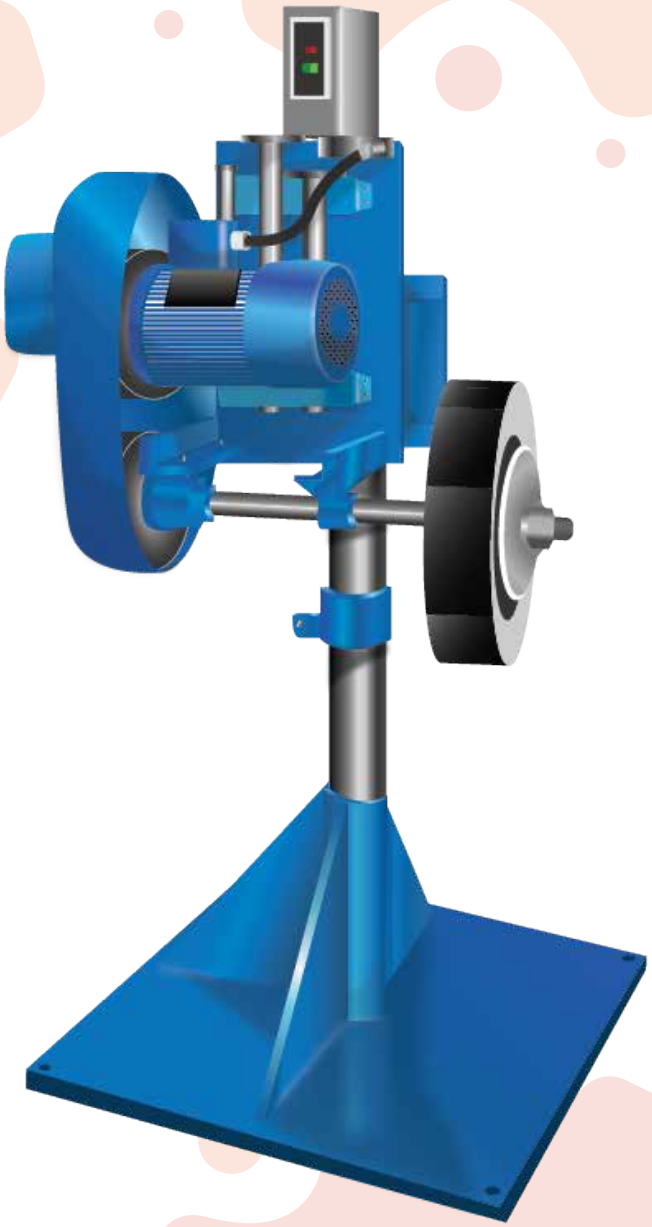
BULLETIN 169

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.





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MODEL UA-2

BULLETIN 169

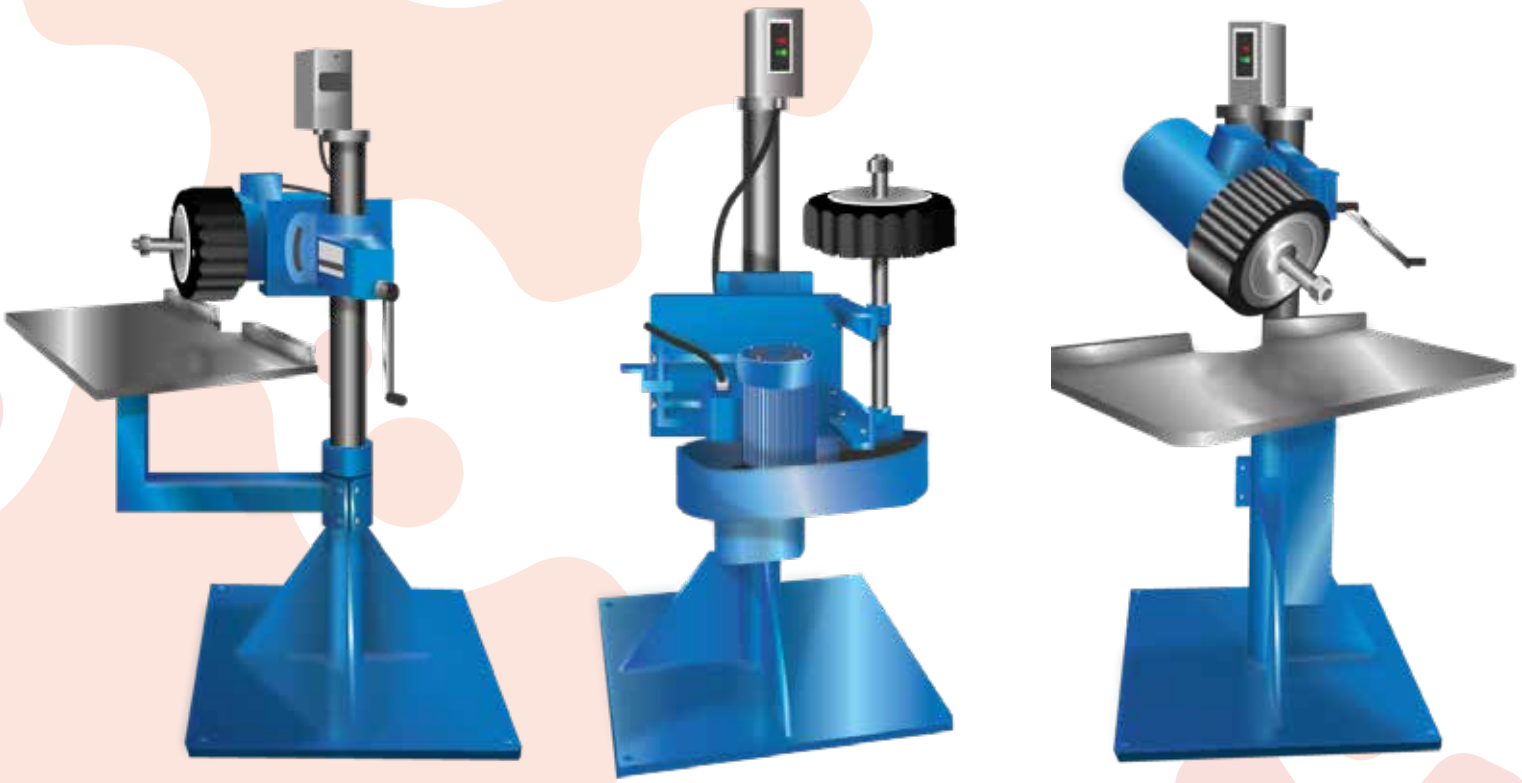
SINGLE SPEED

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 baring 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.

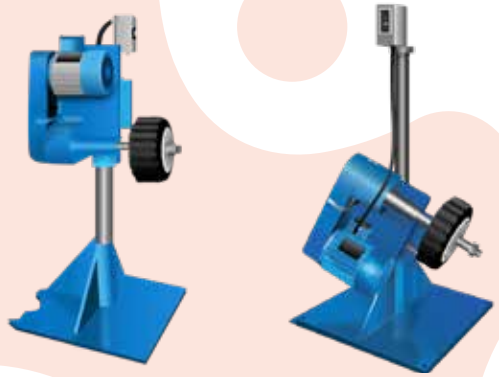
VARIABLE SPEED

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.

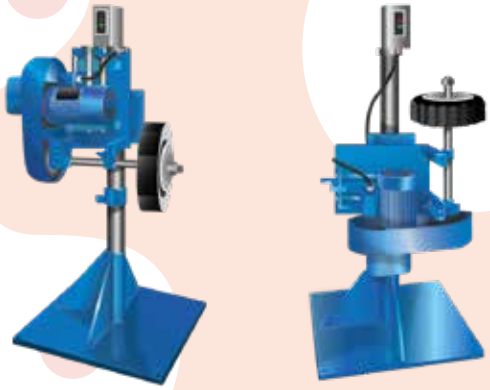
GENERAL SPECIFICATIONS –MODEL UA-2-VS Spindle
1¼" diameter x 91/2" length from shoulder to end. Spindle Speed-600 RPM through 1800 RPM (for higher speed consult the factory)Motor–2 horsepower totally enclosed bell baring motor 230/460-volt, 3 phase, 60 cycle or 575-volt, 3 phase, 60 cycle. Electrical 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–1¼" diameter x 9½" 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



MODELS: UA - 2 - VS & UA - 3 - VS



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 1½" 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-2 horsepower totally enclosed bell 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 – 1½" 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.

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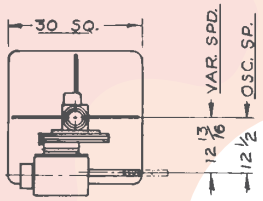
OPERATIONAL DIMENTIONS

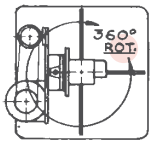
UA-2-OS & VS OR UA-3-OS & VS

BULLETIN 169

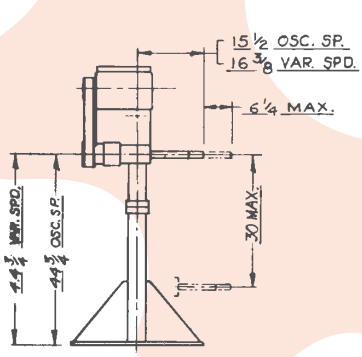


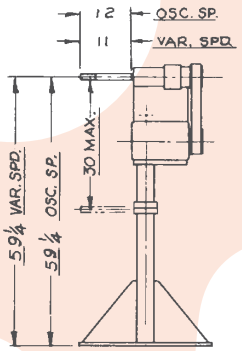
OPERATIONAL DIMENSIONS FOR UA–2–OS & VS OR UA–3–OS & VS

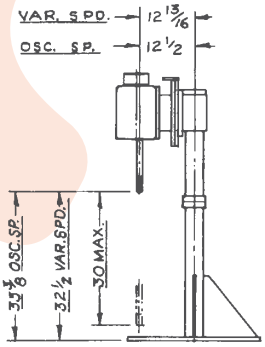
OS = OSC. SP.
VS = VAR. SPEED

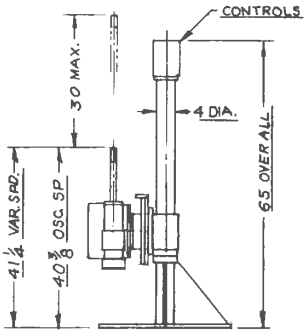


TOP & ELEVATION VIEWS
OF
OSCILLATING SPINDLE MACHINE
UA-3-OS

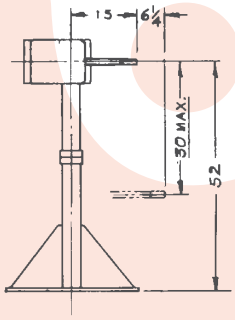


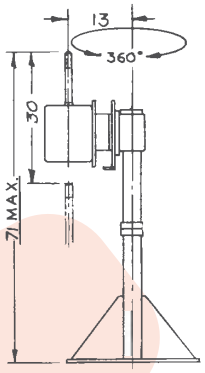


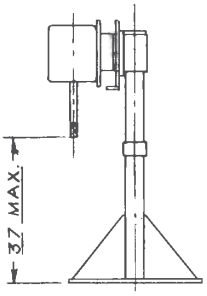




OPERATIONAL DIMENSIONS FOR UA–2







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

ALL DIMENSIONS SUBJECT TO CHANGE WITHOUT NOTICE.

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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

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

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

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G&P SPINDLE STANDS

BULLETIN P-5A

SINGLE SPEED/V-BELT DRIVEN

MODELS PN-2, PN-3, PN-5PW-2, PW-3, PW-5

STANDARD FEATURES:

- 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

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

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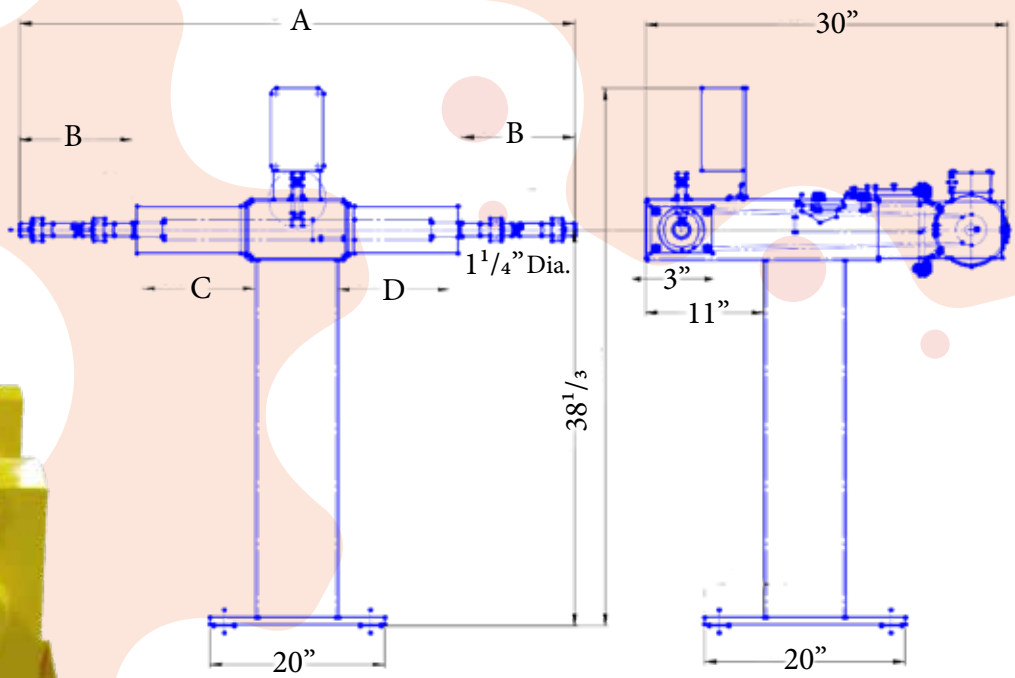
G&P SPINDLE STANDS

BULLETIN P-5A



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

MODEL	H.P.	RPM	DIM A	DIM B	DIM C	DIM D
PW-2 PW-3 PW-5	2 3 5	1200 or 1800	54" w Long Spindle-both ends 42" w Short Spindle-both ends	11" long 5" short	12"	12"
PN-2 PN-3 PN-5	2 3 5	1200 or 1800	37 1/4" w Long Spindle-both ends 25 1/4" w Short Spindle-both ends	11" long 5" short	3 9/16"	3 9/16"

NEVER OPERATE SPINDLE STANDS WITHOUT PROPER GUARDING.

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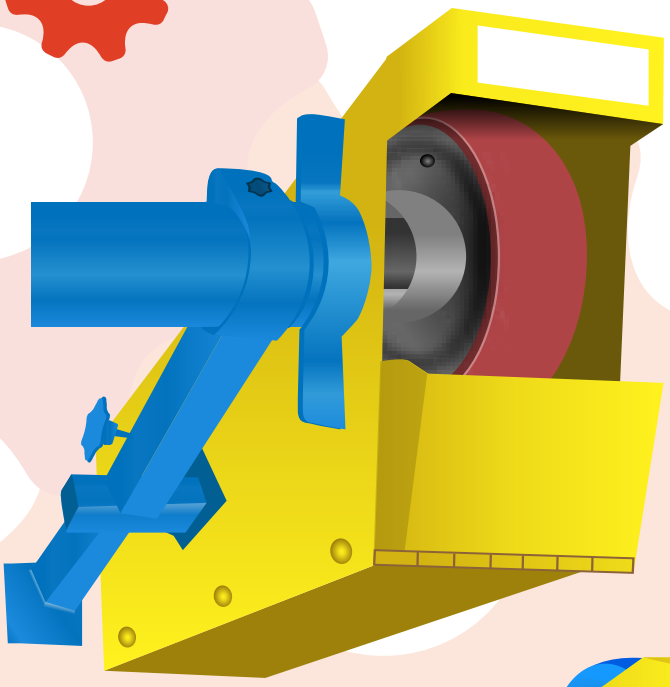
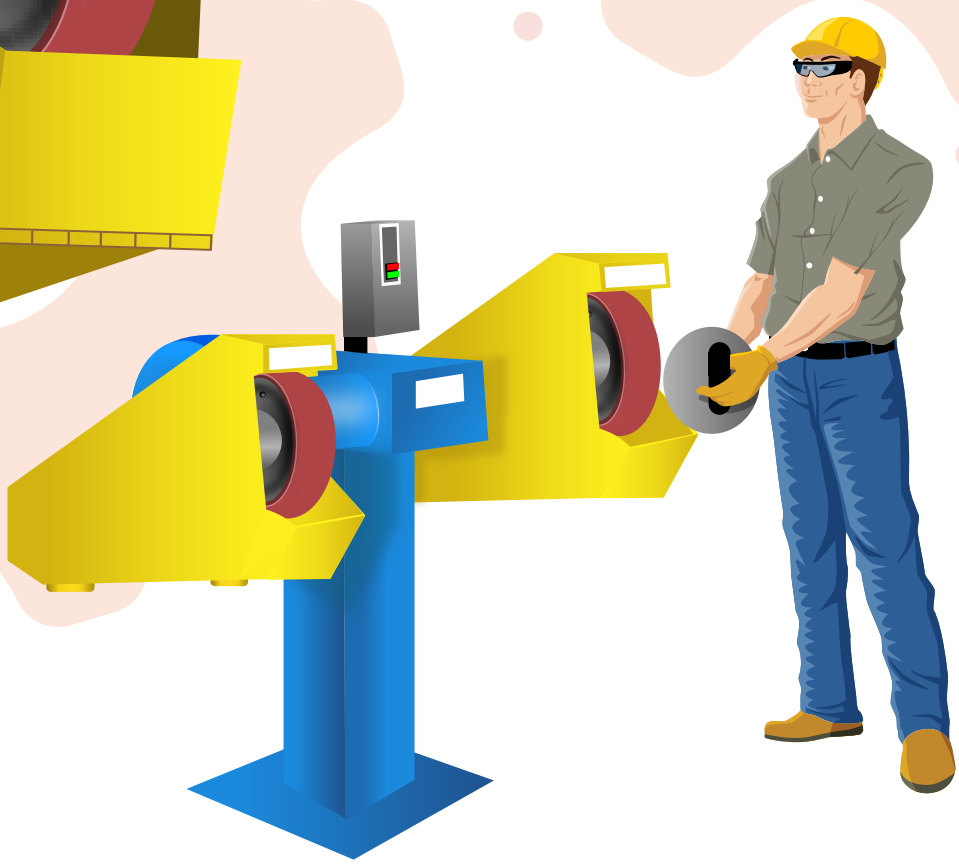
G&P BELT ADAPTOR

BULLETIN P-12



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.



MODEL	WHEEL WIDTH	WHEEL DIA.	BELT SIZE
BA - 2	2"	10"	2" X 72"
BA - 3	3"	10"	3" X 72"
BA - 4	4"	10"	4" X 72"

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.

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G&P MODEL EPN - SANDER/POLISHER

BULLETIN P-13

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.

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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.

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ABRASIVE BELT PLATEN GRINDERS

BULLETIN PL-200

Never operate grinding equipment without proper guarding. Always wear eye protection.

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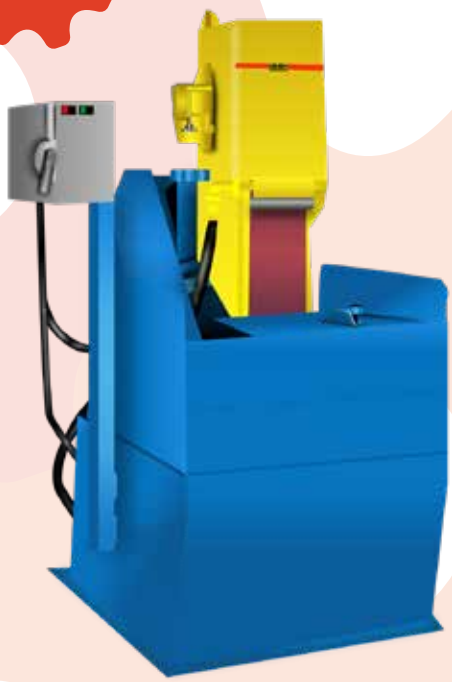
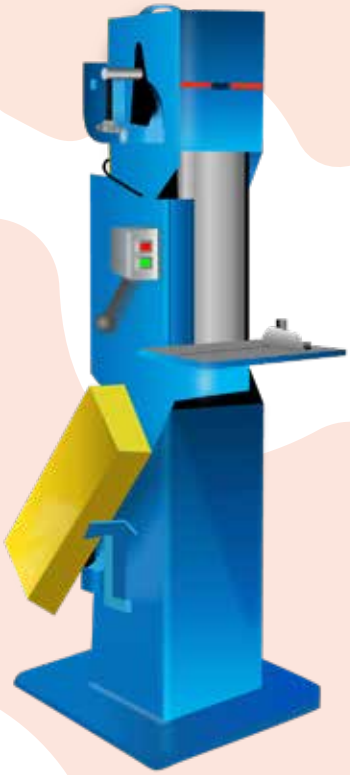
WET/DRY PLATEN GRINDER

BULLETIN PL-200

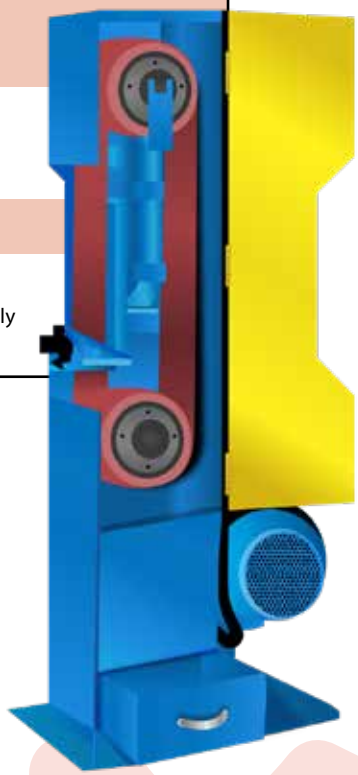


MODEL 8107-10
WV FOR WET GRINDING



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

Specifications subject to change without notice



MODEL 8107-10
DV FOR DRY GRINDING

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HORIZONTAL OR VERTICAL PLATEN GRINDER

BULLETIN PL-200

SPECIFICATIONS FOR HV660-D & HV860-D		
Abrasive belt size	6" x 60"	8" x 60"
Abrasive belt speed	5500 SFPM	5500 SFPM
Type of belt tension	Air	Air
Motor	2 H.P., 3 H.P. or 5 H.P. TEFC 230/460/3/60	5 H.P. TEFC 230/460/3/60
Starter	NEMA 1 Magnetic Full Voltage 230 or 460/3/60	NEMA 1 Magnetic Full Voltage 230 or 460/3/60
Drive Pulley	6" dia. x 6" Face Rubber Covered	8" dia. x 8" Face Rubber Covered
Idler Pulley	6" dia. x 6" Face Aluminum	8" dia. x 8" Face Rubber Covered
Platen	Steel – 6" wide, 10" long Hardened Tool Steel Optional	Steel – 8" wide, 10" long Hardened Tool Steel Optional
Table	6" deep, 8" wide Angle adjustment when grinder in vertical position. In horizontal position table serves as Cross Fence	6" deep 10" wide Angle adjustment when grinder in vertical position. In horizontal position table serves as Cross Fence
Overall Height	62"	62"
Table Height	40 ¾" when grinder is in vertical position	40 ¾" when grinder is in vertical position
Platen Height	37" when grinder is in horizontal position	37" when grinder is in horizontal position
Base Plate	20" square	20" square

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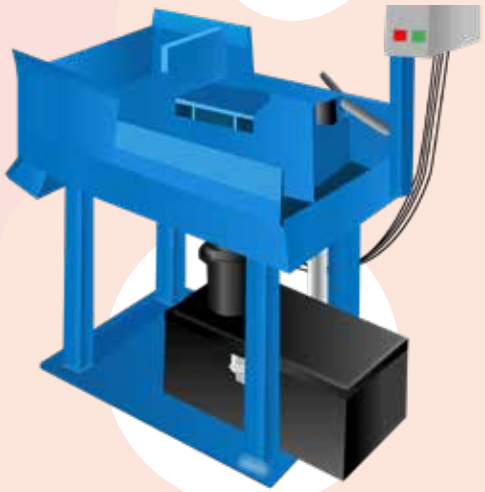
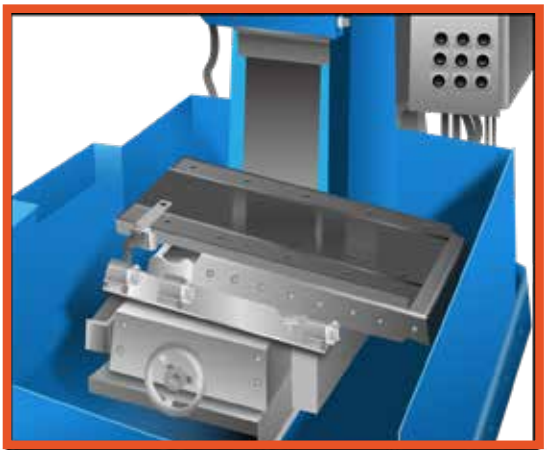
MODIFICATIONS & SPECIAL ACCESSORIES AVAILABLE

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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XTRA HEAVY DUTY

ABRASIVE BELT SWINGFRAME GRINDER

BULLETIN S-3

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.

MODEL	BELT SIZE	HORSEPOWER	MODEL	BELT SIZE	HORSEPOWER
XH-3132-10	3 x 132	10	XH-3132-15	3 x 132	15
XH-4132-10	4 x 132	10	XH-4132-15	4 x 132	15
XH-6132-10	6 x 132	10	XH-6132-15	6 x 132	15

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PARTS LIST AND INSTRUCTIONS

BULLETIN S-3

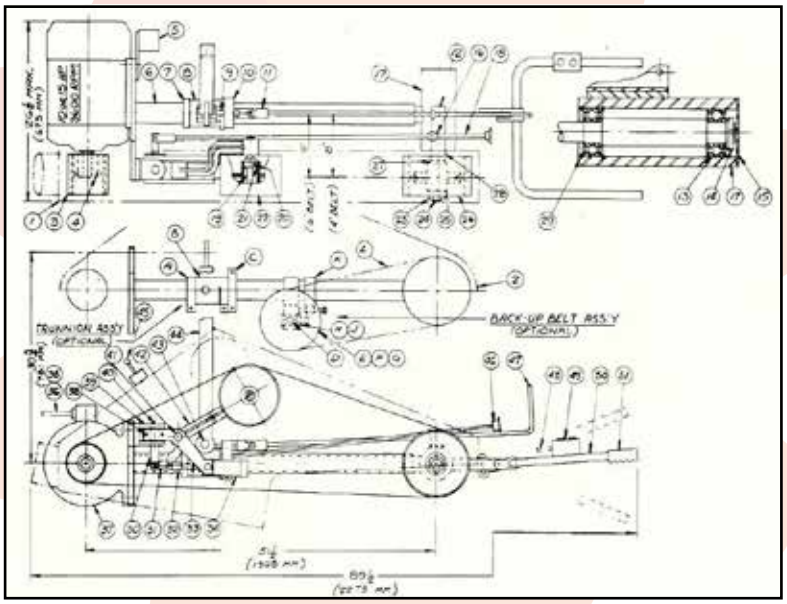
LUBRICATION
All ball bearings are sealed for life type. One Alemite fitting on the swivel housing requires periodic lubrication with a good grade of grease as use dictates.

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



ITEM	PART NO.	REQ'D	DESCRIPTION
1-A	M-11205-E-4	1	Enclosed Belt Guard -3" & 4" Wide Belt, if ordered
1-B	M-11205-E-6	1	Enclosed Belt Guard -6" Wide Belt, if ordered
2-A	M-11024-E-1	1	Band Belt Guard -3" & 4" Wide Belt, Standard
2-B	M-11O24-E-2	1	Band Belt Guard - 6" Wide Belt, Standard
3-A	R-54 -- 6" x 4"	1	Tire -- Drive Pulley
3-B	R-54 -- 6" x 6"	1	Tire -- Drive Pulley
4-A	M-11080-B	1	Hub -- Drive Pulley, 4" Wide Belt
4-B	M-11079-B	1	Hub -- Drive Pulley, 6" Wide Belt
5	M-11260-D-3	1	Counterbalance
6	M-11025-E-1	1	Beam
7	M-9831-B	1	Collar-- Locating
8	M-9830-C	1	Swivel Housing
9	M-10560-C	1	Bolt -- Swivel Clamp 5/8-11 Thd.
10	M-4642-B	1	Collar -- Swivel Clamp
11	M-11025-E-2	1	Nut -- Swivel Lock
12	M-11047-C	1	Bracket
13	W-308-PP	2	Ball Bearing
14	8H-08	1	Lock Nut
15	M-9056-B	1	Plate -- End
16	SC-50	2	Set Collar 10.D. x 1/2 I.D.
17	M11018-E	1	Ball Bearing Housing

ITEM	PART NO.	REQ'D	DESCRIPTION
18	M-11205-E-4	1	Rod -- Tracking
19	M-11026-C	1	Shaft -- Idler
20	RA100RR	2	Ball Bearing
21	5000-206	2	Snap Ring
22-A	M-9426-E-2	1	Idler Pulley -- 4" Wide Belt
22-B	M-9426-E-4	1	Idler Pulley -- 4" Wide Belt
23	M-16711-B	1	Nut 1-1/2-6 Thd. R.H.
24	M-9045-D	1	Spindle
25	R-54	1	Hub -- 10 x 1-1/2 Bore
26-A	R- 54-10" x 3"	1	Tire
26-B	R- 54-10" x 4"	1	Tire
26-C	R- 54-10" x 6"	1	Tire
27	M-9051-B-2	1	Spacer
28	M-9051-B-1	1	Spacer
29	5000-354	2	Snap Ring
30	M-11022-B	1	Bracket -- Tracking
31	2708-6A	1	Clevis -- Tracking
32	P/N49028	1	Clevis W/ Pin P/N 49006

ITEM	PART NO.	REQ'D	DESCRIPTION
33	M-11019-D	2	Arm -- Tracking
34	J733A1	1	Air Cylinder (Air Serv) 2 x 3
35	709 Type	1	Magnetic Starter and Heaters
36	SO Type	20'	Electric Cord
37	10 or 15 HP	1	Motor 360 RPM TEFC 220/440/3/60
38	M-11021-B	1	Block -- Mtg.
39	M-11020-C	1	Bracket
40	M-1101-B-2	1	Pin -- Swivel
41	M-11101-B-!	1	Pin -- Pivot
42	M-11023-D	1	Arm -- Tensioning

PC	PART NO.	REQ'D	DESCRIPTION
A.	M-11209-E-2	1	Collar
B.	M-11209-E-1	1	Trunnion
C.	M-11209-E-3	1	Collar Adj.
D.	M-1049-C	1	Shaft
E-1.	M-9436-E-2	I	Idler Pulley 4" Wide Belt
E-2.	M-9426-E-4	1	Idler Pulley 6" Wide Belt
F.	RA100RR	2	Ball Bearing
G.	500-206	2	Snap Ring

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ABRASIVE BELT SLITTER

BULLETIN SA-9

Reduce Your Abrasive Belt Inventory

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.

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WELD GRINDERS

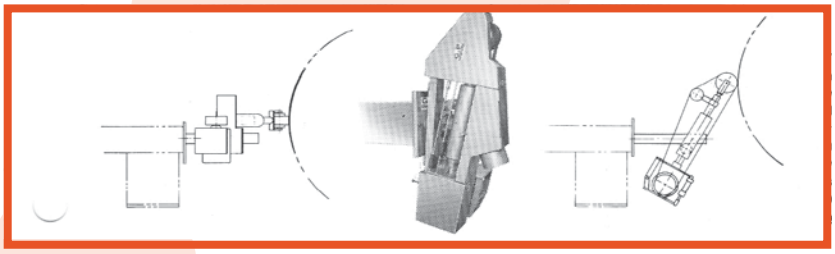
BULLETIN SA-11

ABRASIVE BELT GRINDERS FOR GRINDING WELD ON LARGE VESSELS

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.

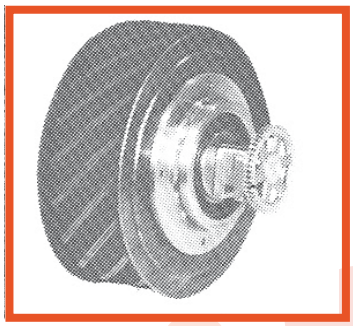


The grinder shown at left is designed for mounting on the end of the boom of a wielding manipulator. As shown in the line drawings, it can be used in one position for grinding longitudinal welds, or rotated 90 for grinding circumferential welds. This movement is controlled by a motor and speed reducer. Other units are available for internal grinding.

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.

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AIR POWERED GRINDER WITH WHEELS

BULLETIN SA-12

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.

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".

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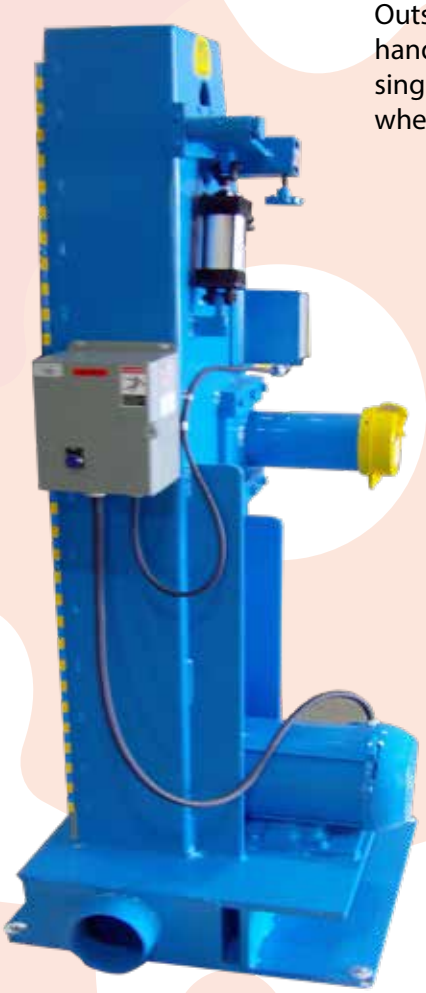
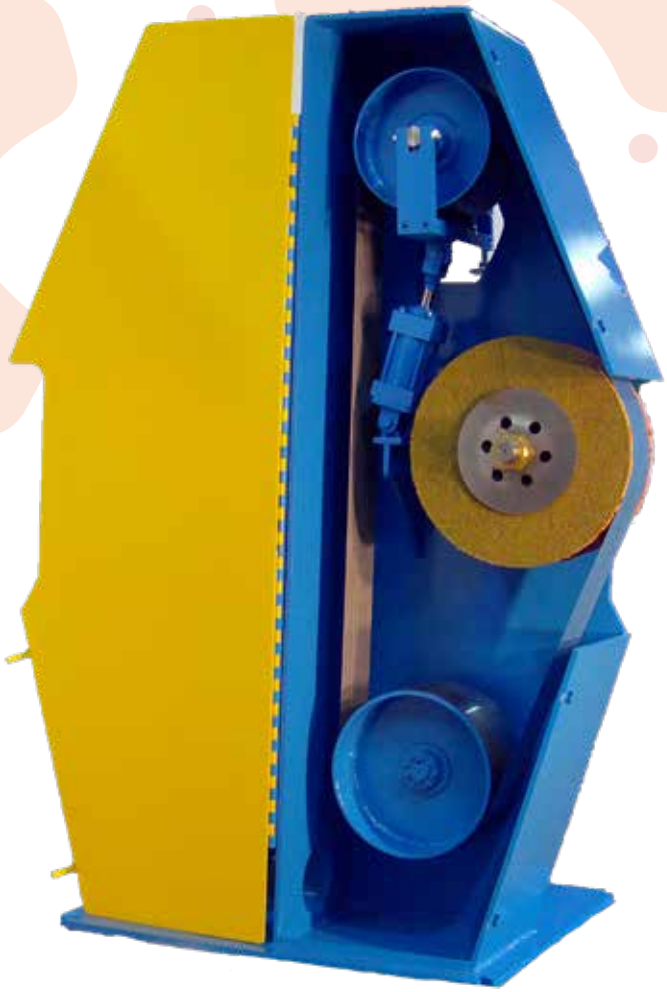
CONTOUR GRINDING

BULLETIN SA-15

Outstanding for production runs of such pieces as bicycle hubs, crank handles, ect., 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.





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.

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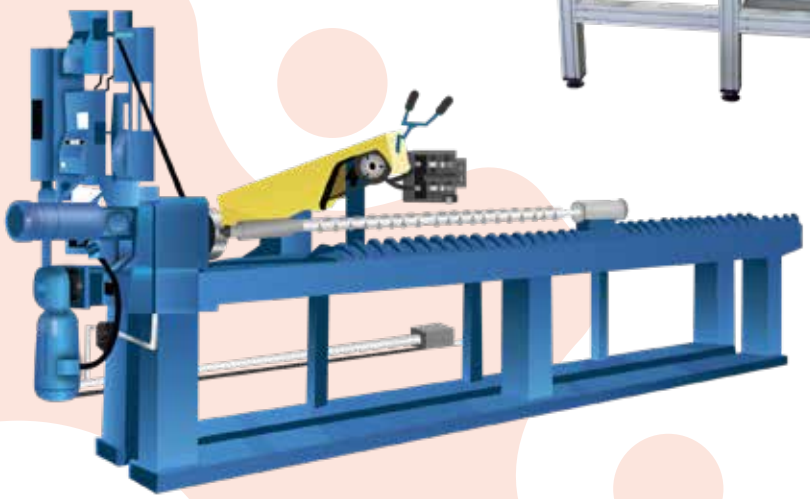
CYLINDRICAL POLISHING

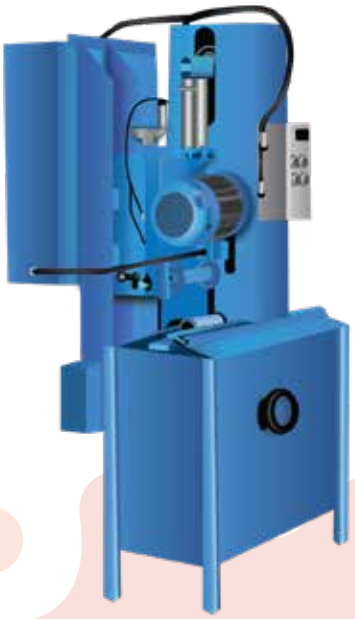
BULLETIN SA-21

CUSTOM BUILT EQUIPMENT - FOR POLISHING

ROUND BARS

TUBING





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DATA FORM

BULLETIN SA-21

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 REQUIRMENTS_____

FINISH REQUIRED_____

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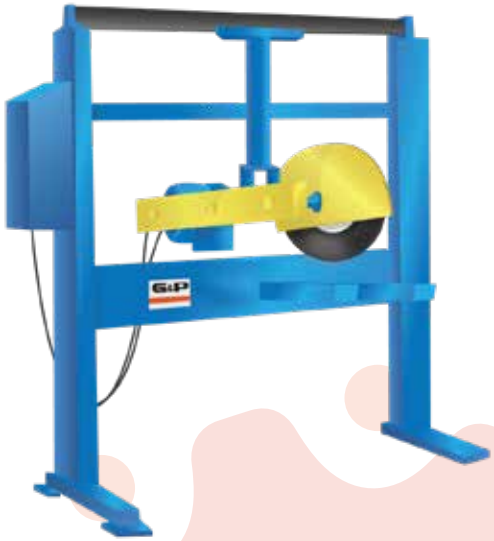
HARDWHEEL SWINGFRAME GRINDER & CUTOFF MACHINES

BULLETIN SG-1

MANEUVERABLE & BALANCED

CUSTOM-MADE EQUIPMENT

G&P Machinery can design and build special equipment to meet your requirements



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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 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

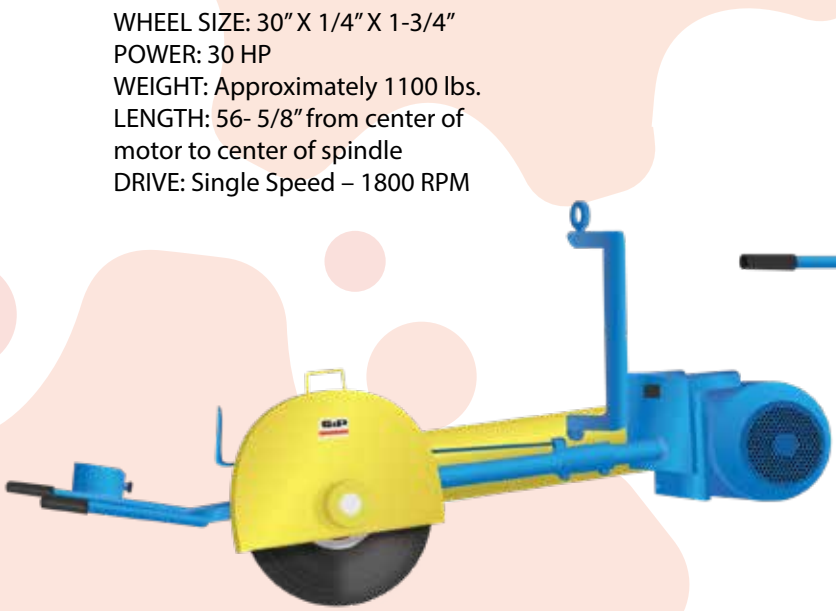
MODEL S30 C30
WHEEL SIZE: 30" X 1/4" X 1-3/4"
POWER: 30 HP
WEIGHT: Approximately 1100 lbs.
LENGTH: 56- 5/8" from center of motor to center of spindle
DRIVE: Single Speed – 1800 RPM

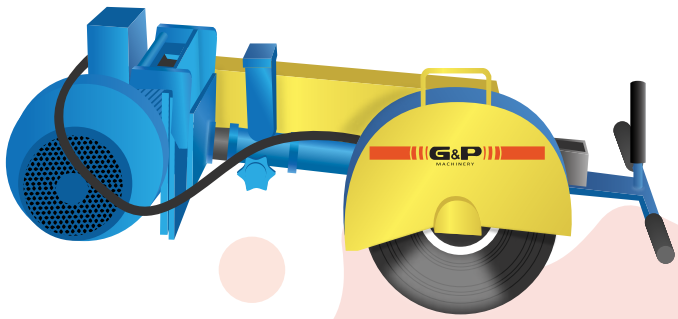
MODEL S10 G5
WHEEL SIZE: 10" X 1" X1"
POWER: 5 HP
WEIGHT: Approximately 220 lbs.
LENGTH: 24- 3/4 " from center of motor to center of spindle
DRIVE: Single speed – 3600 RPM
WHEEL SPEED: 9500 SFPM

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 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 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





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IDLER PULLEYS

BULLETIN T-10

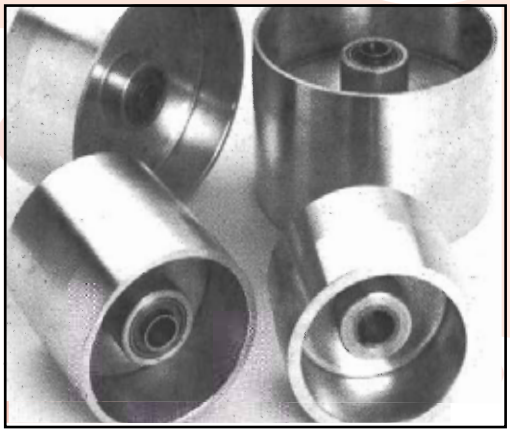
Machined, cast aluminum pulleys equipped with heavy duty sealed-for –life ball bearings. Available size shown in chart below.

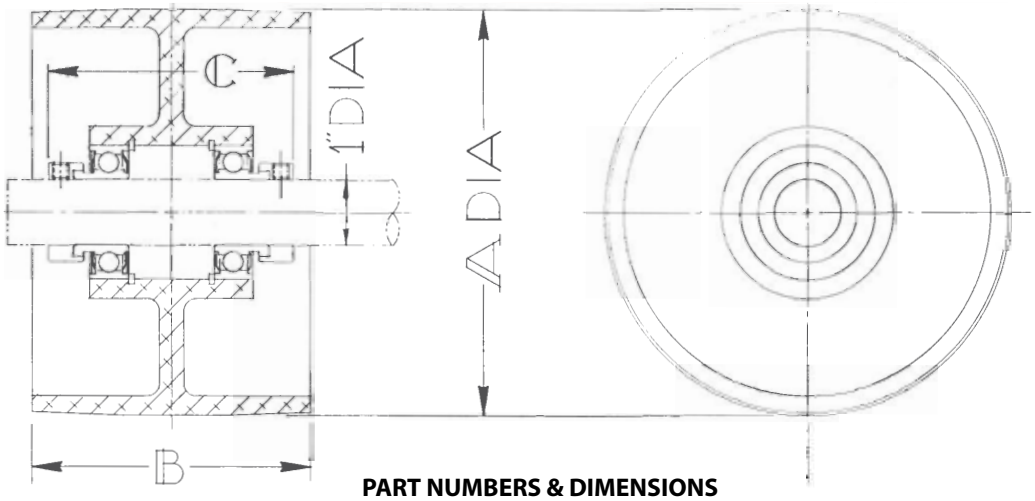
-Aluminum pulleys with keyway also available in 6" dia. X 3 ¼" or 4 1/4 "width.

-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

PART NUMBERS AND DIMENSIONS

PART NO.	DIM A	DIMB	DIMC	PART NO.	DIMA	DIMB	DIM C
M-9426-E-8	6	2 ¼	3 ½	M-9426-E-5	6	6 ¼	5 ¾
M-9426-E-6	6	2 ¾	3 ¾	M-9426-E-9	9	3 ¼	5 ¾
M-9426-E-7	6	3 ¼	3 ¾	M-9426-E-2	9	4 ¼	3 ¾
M-9426-E-1	6	4 ¼	3 ¾	M-9426-E-4	9	6 ¼	5 ¾
M-9426-E-11	6	5 ¼	5 ¾	M-9426-E-3	9	8 ¼	5 ¾

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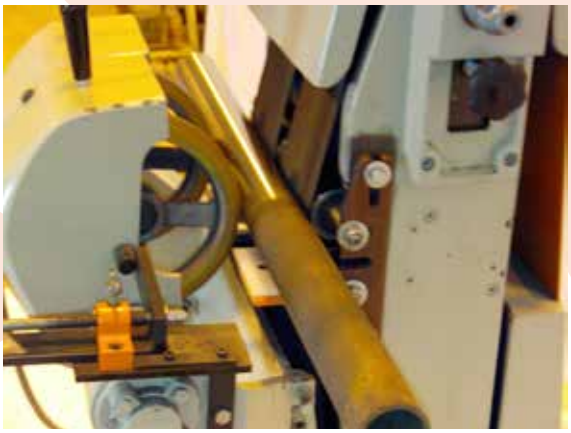
PHONE (317) 898-0750 • FAX (317) 899-1627

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.

G&P MACHINERY

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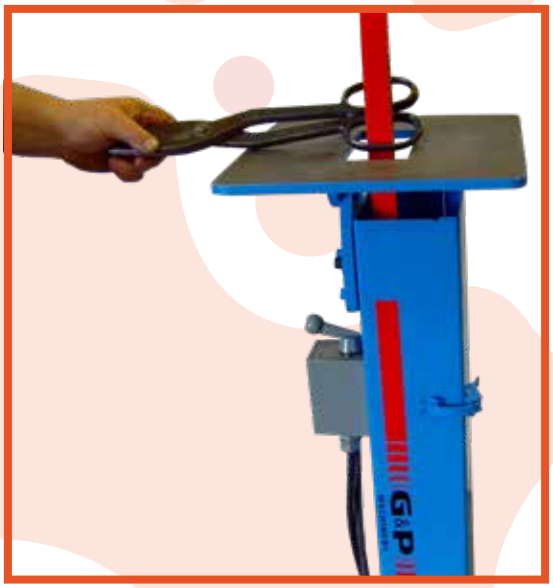
TS-90D MULTI-PURPOSE ABRASIVE BELT GRINDER

BULLETIN TS-90D

SHARPENS CUTTING DIES

MULTI-PURPOSE



FOR GRINDING-DEBURRING-SANDING

1 H.P. Totally Enclosed Motor - 2750 SFPM Belt Speed

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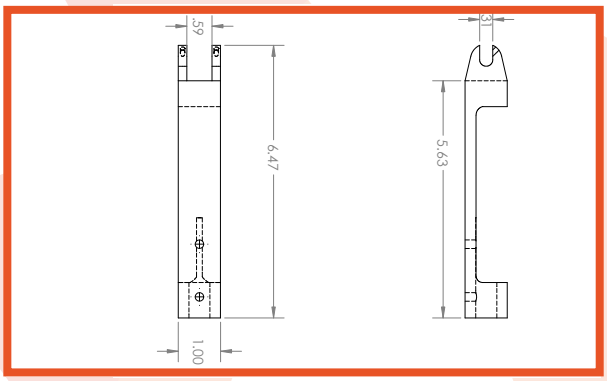
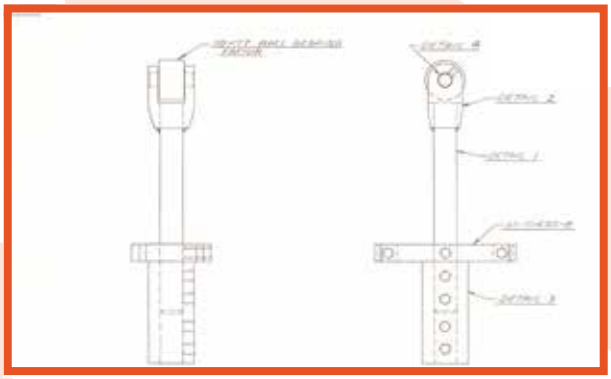
MULTI-PURPOSE ABRASIVE BELT GRINDER

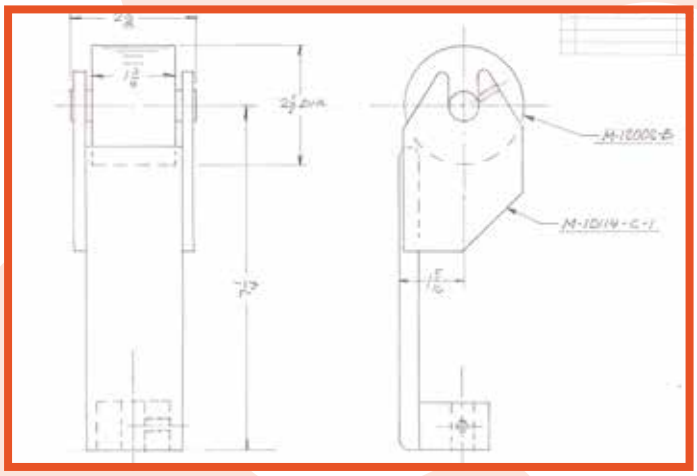
BULLETIN TS-90D



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 ¼" 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.

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WOLFHEAD™ SANDING AND POLISHING WHEELS

BULLETIN W4

ELIMINATE COSTLY HAND SANDING WITH THE SANDING WHEEL THAT FOLLOWS CONTOURS

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METAL WORKING

BULLETIN W4

Blending operation on fabricated stainless part

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.

Satin finishing a stainless part

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.

Close-up of blending operation

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.

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WOODWORKING

BULLETIN W4

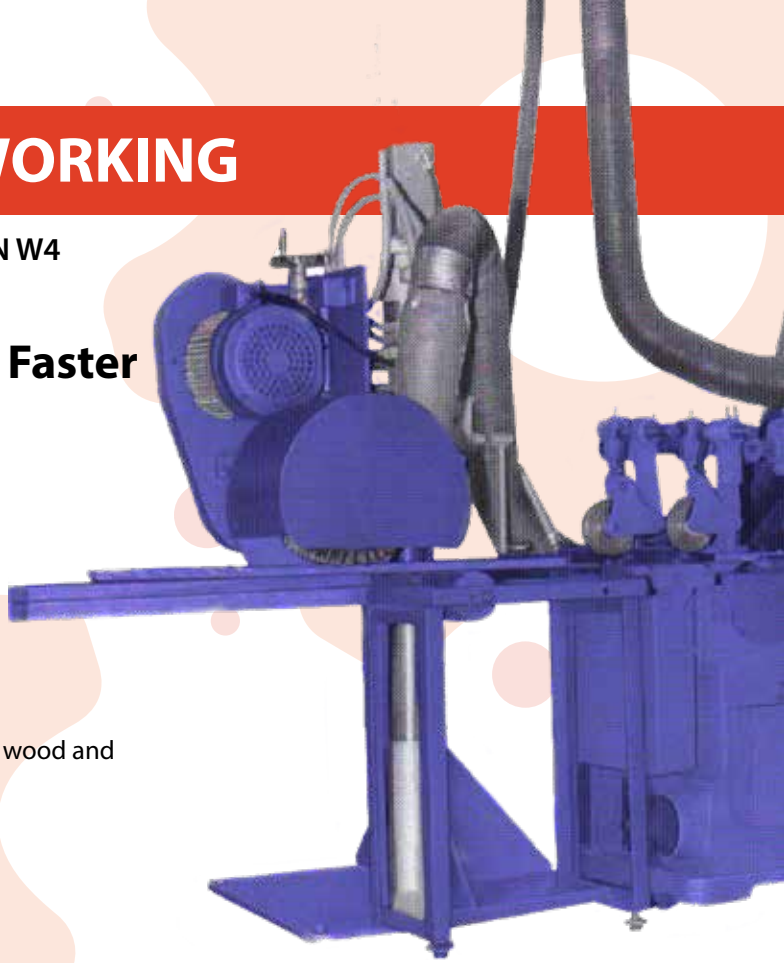
Better, Easier, and Faster

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



Sanding the intricate surface of a chair leg

Sanding mouldings as they exit the moulder

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!

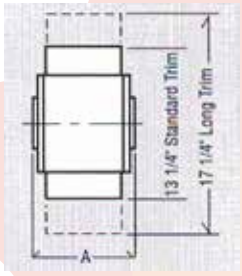
The choice between a 32 brush wheel and a 16 brush wheel is often determined by the speed of the equipment available for driving the wheel. For most applications, recommended speeds are 1200 rpm for the 32 brush wheel, and 1800 rpm for the 16 brush wheel.

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.

WOLFHEAD™ SPECIFICATIONS

BULLETIN W4

32 Brush



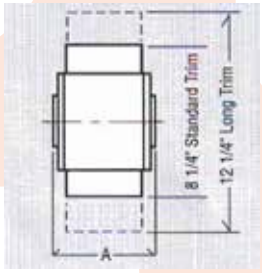
32 Brush
Standard Trim
2" Width

32 Brush
Long Trim
2" Width

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
W1001-1" (25.4)	2 3/4" (70)	3/4" (19)-1 1/2" (38)	1200	1200	1800	1800
W1002-2" (50.8)	4 1/2" (114)	3/4" (19)-1 1/2" (38)	1200	1200	1800	1800
W1004-4" (101.6)	6 1/2" (165)	1" (25)-1 1/2" (38)	1200	1200	1800	1800
W1006-6" (152.4)	8 1/2" (216)	1 1/4" (32)-1 1/2" (38)	1200	1200	1800	1800

(Metric dimensions in parenthesis)

16 Brush



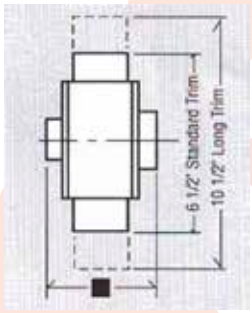
16 Brush
Standard Trim
2" Width

16 Brush
Long Trim
2" Width

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" (25.4)	2 3/4" (70)	5/8" (16)-1 1/4" (32)	1800	1800	3000	3000
WH-1042-2" (50.8)	4 1/2" (114)	3/4" (19)-1 1/4" (32)	1800	1800	3000	3000
WH-1044-4" (101.6)	6 1/2" (165)	3/4" (19)-1 1/4" (32)	1800	1800	3000	3000
WH-1046-6" (152.4)	8 1/2" (216)	3/4" (19)-1 1/4" (32)	1800	1800	3000	3000

(Metric dimensions in parenthesis)

12 Brush



Model Number and Abrasive Width	Length through Bore Dim ■	Bore Size	Recommended Speed (RPM) Standard Brushes	Recommended Speed (RPM) Long Trim Brushes	Maximum Speed (RPM) Standard Brushes	Maximum Speed (RPM) Long Trim Brushes
SH-1061-1" (25.4)	■	□	2500-3200	2500	3500	2500
SH-1060-1 1/2" (38.1)	■	□	2500-3200	2500	3500	2500
SH-1062-2" (50.8)	■	□	2500-3200	2500	3500	2500

(Metric dimensions in parenthesis)

■ 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.