

FIG. 1 - A Front View of the No. 12 Centrifugal Grinding Machine

The life and accuracy of a precision grinding machine is dependent largely upon proper maintenance and operation. As this handbook is written for the purpose of instructing the operator in the proper method of caring for the LANDIS TOOL No. 12 Centrifugal Grinding Machine, we request that it be placed in his hands.

At the time of issuance, this booklet was completely up to date. However, since improvements in design are continually being made, it is possible that some corrections included in this book may vary slightly from the machine delivered to you. This would indicate that major changes have been made so that the machine will better fulfill your needs.

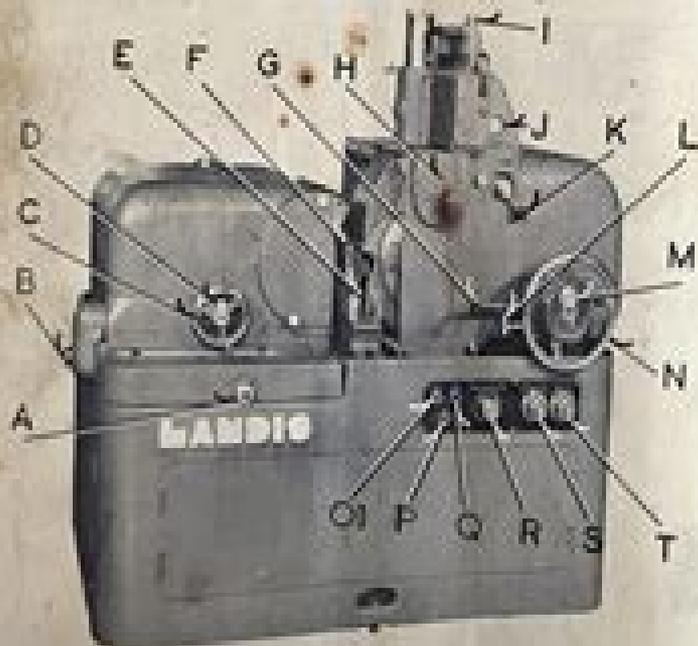


FIG. 1 - A Front View of the No. 12 Centrifugal Grinding Machine

T-33

THE OPERATOR'S DUTIES

- 1 - Adjusting screw used for aligning the regulating wheel with the grinding wheel. The sides of both wheels should be aligned for each set-up. **WARNING!** The hydraulic pump must be running when adjusting the screw. Turn selector valve (P) to "cut-out" and make sure that Master stop button (I) has been pushed.
- 2 - Regulating wheel base adjust screw, for setting or correcting taper. A rim on the wheel base is graduated in inches per foot and in degrees, while the adjust screw outer is graduated in minutes. One complete turn of the screw equal to 15 minutes. Total amount of travel available is 7". When making an adjustment it is suggested that the final adjustment be made by turning the screw in a clockwise direction to take up the backlash. For example, when moving the base from 2 minutes to 4 minutes, it is necessary to turn the screw in a counterclockwise direction for a distance of 4 minutes and then in a clockwise direction in 2 minutes in order to take up the backlash and obtain an exact setting of 4 minutes. Provision has been made at (R), Figure 1, for mounting an indicator to enable the operator to obtain repeat settings accurately.
- 3 - Regulating wheel base handwheel. Used to traverse regulating wheel toward or away from work. Each dial graduation equals 0.002" on the diameter of the work.
- 4 - Regulating handwheel locking knob. Turn knob in a clockwise direction to lock handwheel in position. The handwheel should be locked when the regulating wheel is in grinding position and while the regulating wheel is being dressed.
- 5 - Work guide and support slide. Guide jaws and support blade are adjustable for different size work.
- 6 - Grinding wheel dresser diameter holder. The height of the dresser may be adjusted by positioning dresser after loosening two clamping screws on the slide.
- 7 - Quick setting wheel feed lever. Operates from the left rear of the grinding wheel feed handwheel toward the operator and provides for a rapid infeed screw, work of approximately 0.002" to 0.003". Used for plunge grinding.
- 8 - Grinding wheel dresser diameter observation door. Do not open when dressing the wheel.
- 9 - Grinding wheel lead adjustment knob. Each dial graduation equals 0.001".
- 10 - Dressing wheel indicator for use in checking the grinding wheel lead adjustment and returning dresser slide to horizontal position.
- 11 - Coolant control valve. This three stage valve is provided so that the operator may direct the coolant on the dresser during the dressing operation, on the work during the grinding operation, or cut off the flow entirely.
- 12 - Lever clamping knob. Clamps handwheel to stop ring so that the quick setting lever (I) may be used.
- 13 - Fine grinding wheel feed knob. Each dial graduation equals 0.0001" on work diameter. Handwheel (I) must be clamped to the stop ring by knob (I) before the fine feed can be used.
- 14 - Grinding wheel infeed handwheel. Each dial graduation equals 0.001" on work diameter.
- 15 - Master stop button, stops all electric motors.
- 16 - Operation selector switch. This switch has three positions: "Spring" in the right, "Grind" in the center, and "Reverse" in the left. In the "spring" position the hydraulic pump runs and the wheels are stationary. In the "grind" position the hydraulic pump is stopped and the wheels are running. In the

# Landis Instruction Manual

**C Cleary**



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