

GRINDER & POWERLOCK

Daily Operation Reminders

Revision 2



WEINIG

1. No one is allowed to work with this WEINIG grinder without proper training from a certified WEINIG technician, or someone currently within the company that has been trained in similar fashion.
2. Visually inspect the tool before inserting into the grinder. Make sure that the tool is not damaged, and that the tool has the proper rotation and RPM rating for the application.
3. Cleanliness is EXTREMELY important. It is a good practice to soak cutterheads in Cutterguard (or an ultrasonic cleaner) after each production run, in order to remove wood dust and resin from the surface of the tool, bottom of the knife pockets, corrugations, and gibs.
4. Ensure that knives and clamping wedges have the same thickness, and **MUST** be balanced within 0.1 gram (0.0035 oz.) of each other for proper performance. Follow these procedures for balancing knife steel:
 - a. After the steel is cut to length, balance to the tolerance listed above.
 - b. Complete the rough grind on the knives.
 - c. Remove the knives from the cutterhead, rebalance to the acceptable tolerance, and then reinstall into the cutterhead. Properly torque gib screws at this time.
 - d. Complete the finish grind on the knives.
5. For true running accuracy of PowerLock tooling, it is essential that knives be installed according to the attached leaflet "PowerLock Knife Installation Procedures".
6. The runout from one knife to the other should never exceed 0.02mm (0.001"). In addition, the maximum offset that is allowed in regrinds to 90 deg. profiles is 0.030", and only for correct dimensioning. Check this runout with the OCMS or similar measuring stand.
7. Review weekly your instruction and safety manuals for both the Rondamat grinder and PowerLock tooling. Also, review the more specific instructions on the handling of PowerLock tools as shown in the WEINIG Tooling & Supplies catalog.