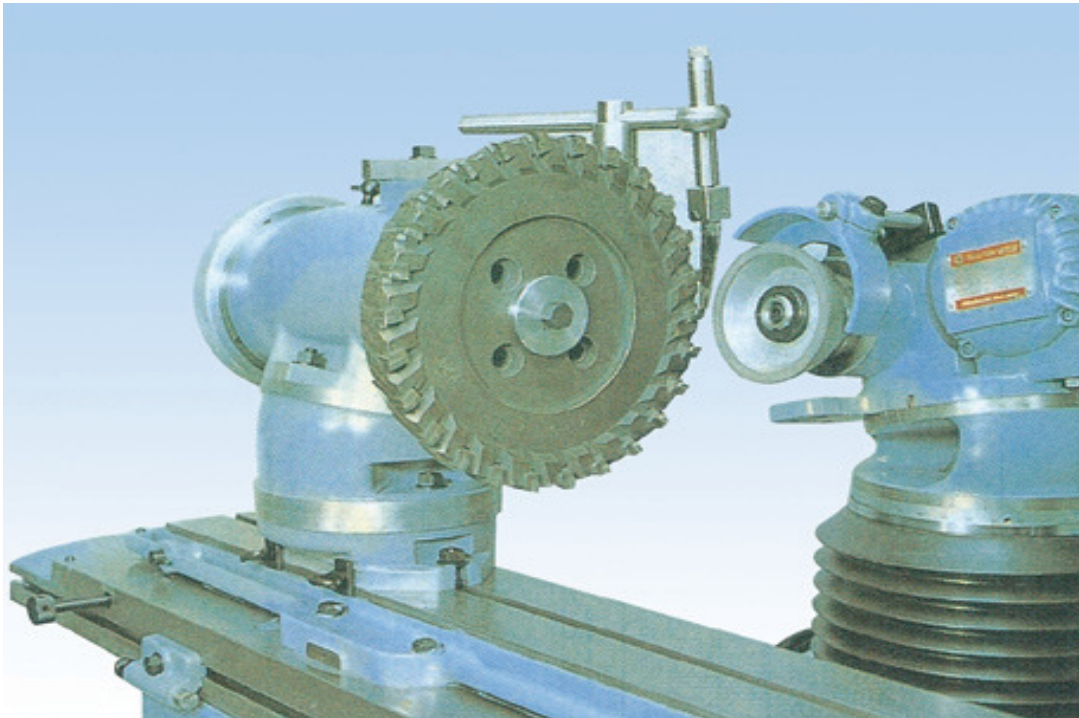


8. Special Accessories

8.1 Face Milling Cutter Grinding Device



1. Introduction

This device is included and bed base and a horizontal rotating platform and rotatable 15 ° seat angle formed by the working head. Such institutions can be very simple to do perspective, increase or decrease. Not only that, this excellent design allows M-40 can grind larger knives and tools.

2. Product Specifications

Grinding radius	0 - 50 mm (0 - 2 in)
Maximum diameter (To worktable)	190 mm (7 - 7/16 in)
Max.grinding radius (To worktable)	45 mm (1 - 3/4 in)
Total stroke horizontal Spindles	
A Type	50 - 175 mm (2 - 6 - 7/8 in)
B Type	105 - 230 mm (4 - 1/8 - 9 in)
Lateral rotation of the deviation	0 - 50 mm (0 - 2 in)
Horizontal rotation angle of Spindles	90°
Vertical Spindles rotation angle	±15°
Spindle taper	B & S 12 (or M.T.5)

Index plate (standard)	24 slots
Spindle drive	
Spindle speed	450 rpm
Motor	65W(1/12HP) 4 pole

3. Installation

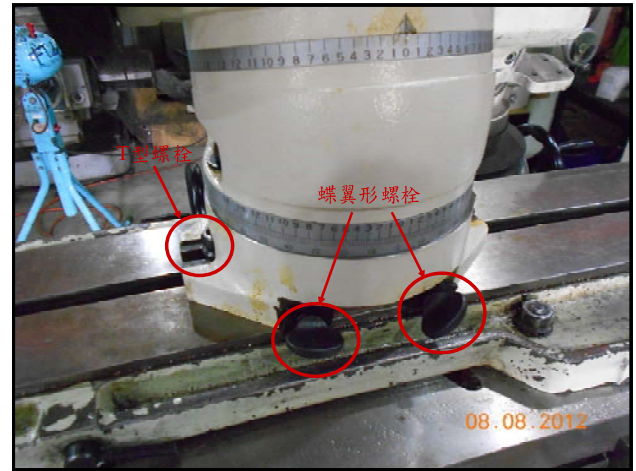
(a) A Face milling cutter grinding device placed bed table.



(b) Then the T-screw into the M-40 BED stage of the T-slot.



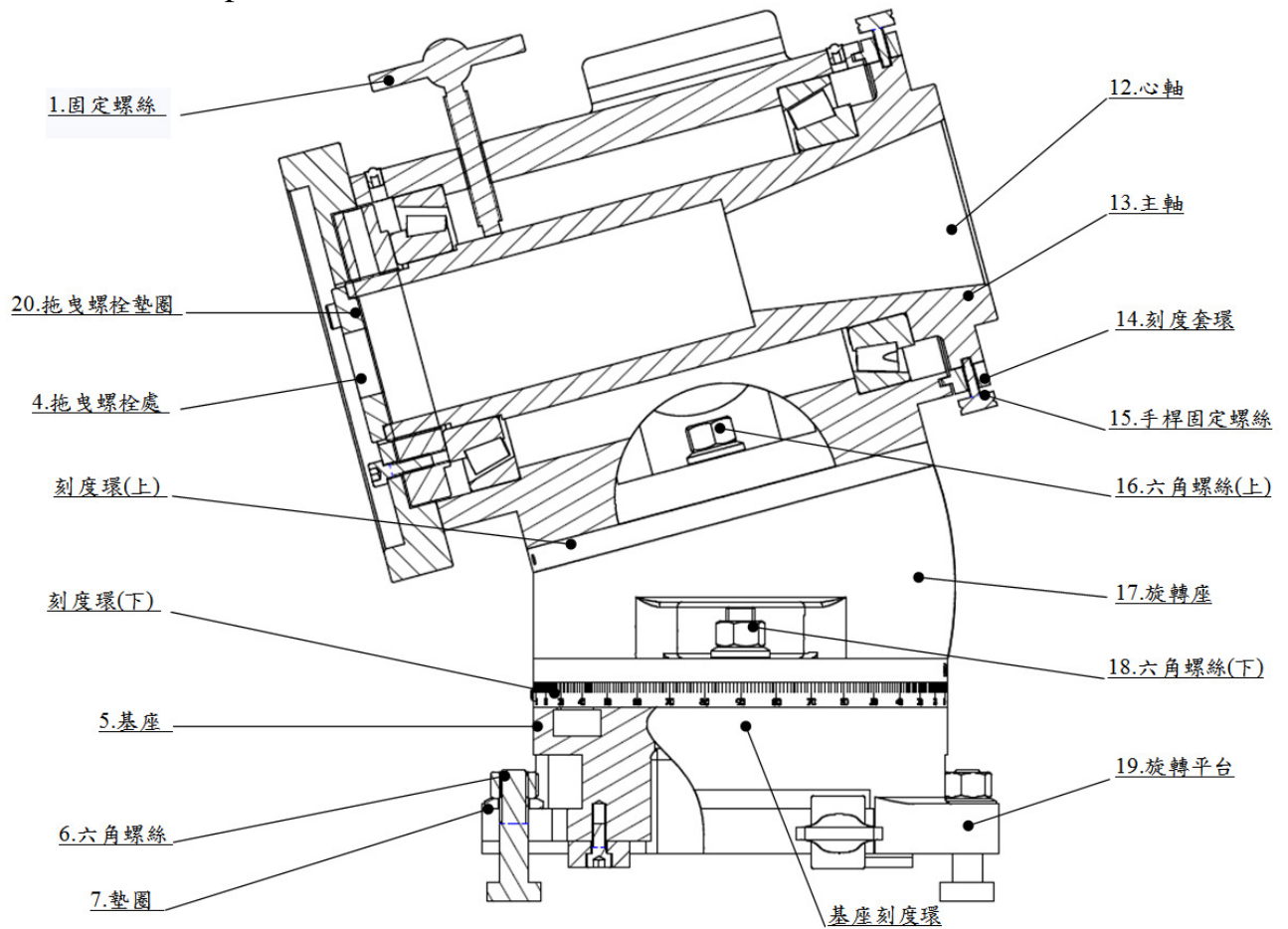
(c) the T-bolts and butterfly-wing locking bolt.



(d) Assembly is completed.



4. Method of operation



The base is provided (5) the turntable and the corresponding (17) of the base. The base can be rotated 360 ° turn in relation to the base (5) and locking hex nut (16). Opportunity Spindles housing base can be turned through 360 degrees in relation to turn base and locking hex nut (16). As an upper surface of the turning base inclined 15 °, Spindles housing can be tilted in the vertical plane $\pm 15^\circ$.

Spindles (13) by two tapered roller bearings, spindle taper is based on the Japanese JIS610150 (ASA no.50). To set Face milling cutter, handle (12) of the spindle and the ballot draw back the bolt (4). (10) and (11) respectively, hex bolts and washers fastening grinding handlebar.

From the clearance angle of $\pm 15^\circ$ is set scale ring (14) is given, which is fixed to the spindle by a lock screw (15), the spindle housing B is fixed to the spindle Spindles locking screw (1). The inside of the ring pattern (3) of the knurling, so that the spindle can be manually turned easier (cutting edge cases feed grinding).

Face Milling Cutter Grinding Device List

項目	品號	品名	規格	數量
1	M130040**	Base		1
2	M130020**	Rotating seat		1
3	M130010**	WorkHead		1
4	M130030**	Scale ring (Top)		1
5	M130031**	Scale ring (Down)		1
6	M130180**	Bolts		4
7	M130060**	Central axis		1
8	M130090**	Scale dust ring		1
9	M130070**	Handwheel		1
10	M451060**	Hand pole screws		2
11	M130080**	Fixing nut		1
12	GB020075	Tapered Roller Bearings	30215	1
13	GB020062	Tapered Roller Bearings	30214	1
14	M130110**	Screws		1
15	M130120**	Washer		1
16	M450030**	Bond		2
17	M450060**	Clamping block		2
18	M450070**	Butterfly Bolts		2
19	M450080**	T-bolt		2
20	GF011990	Hexagon head screws Order	M6*12	2
21	M490103**	Washer		6
22	GF030360	Hex nut	M12	6
23	GF012003	Hexagon head screws Order	M6*20	3
24	GF010780	Hex screws	M5*6	3
25	M130050**	Base scale ring		1
26	GB050131	Oil beads	Φ 1/4	2