



CUTTER & TOOL GRINDER
TOOL GRINDING EXPERT

PP-6025W

Operation Manual



UNIVERSAL CUTTER AND TOOL GRINDER



To users:

1. Please check the machine and its accessories according to the packing list.
2. Do read through the manual before operating the machine.
3. Be sure to install and test the machine according to the instructions.
4. Read through the manual to learn about its performance, operation requirements and maintenance. If you have any questions about it, please contact the company.

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Attached:

Certificate of approval
Packing List

Cautions for the installation and maintenance of the straight guide rail

II. Parameters

1. MAX. Grinding Diameter	250mm
Inner bore of the grinding work piece	10-50mm
2. Elevating Distance of Wheelhead	150mm
3. Rotating Angle of Wheelhead	360° (vertical/horizontal)
4. Horizontal travel of the operating Table	330mm
5. Longitudinal travel of the Operating Table	150mm
6. Grinding Wheel Size	Φ 150 × Φ 32 × 16/50mm
7. Speed of Grinding Wheel	4200/7000RPM
8. Hores Power and Voltage of Motor	3/4HP, 1/2HP
9. Total Power	1HP, 3/4HP
10. Height of the head holder	135mm
11. Taper hole of the main spindle of the head holder	Morse#4
12. The max. Hold capacity of the head and back holder	230mm
13. Area of the Operating Table	130 × 680mm
14. Net/Gross Weight	212kgs/225kgs
15. Package Size	730 × 710 × 715mm



III. General Description

The universal cutter sharpeners of PP-6025W series are applicable to sharpen various cutters. It has many accessories of various functions, from which users can select and set up the desired ones according to cutters to sharpen.

The machine is able to grind various drilling bits, screw tap, end-milling cutters, R-type milling cutters, R type turning tools, hobbing cutters, circular paper cutters, cones, and columns, inner bore, etc.

The machines base, made of semi-steel, has higher stability. The lengthwise operating table, made of high precise rolling straightline guide rails, can move easily and flexibly.

The grinding head support is made of a double-rotating bracket, which can rotate in horizontal and vertical planes, and adjust the grinding wheel in 3-D.

Since the head can rotate 360° in the horizontal plane, the grinding wheel can be changed rapidly.

The column structure of the machine enables it to lower and raise the grinding wheel.

Accurate movement by applying dial indicator on it.

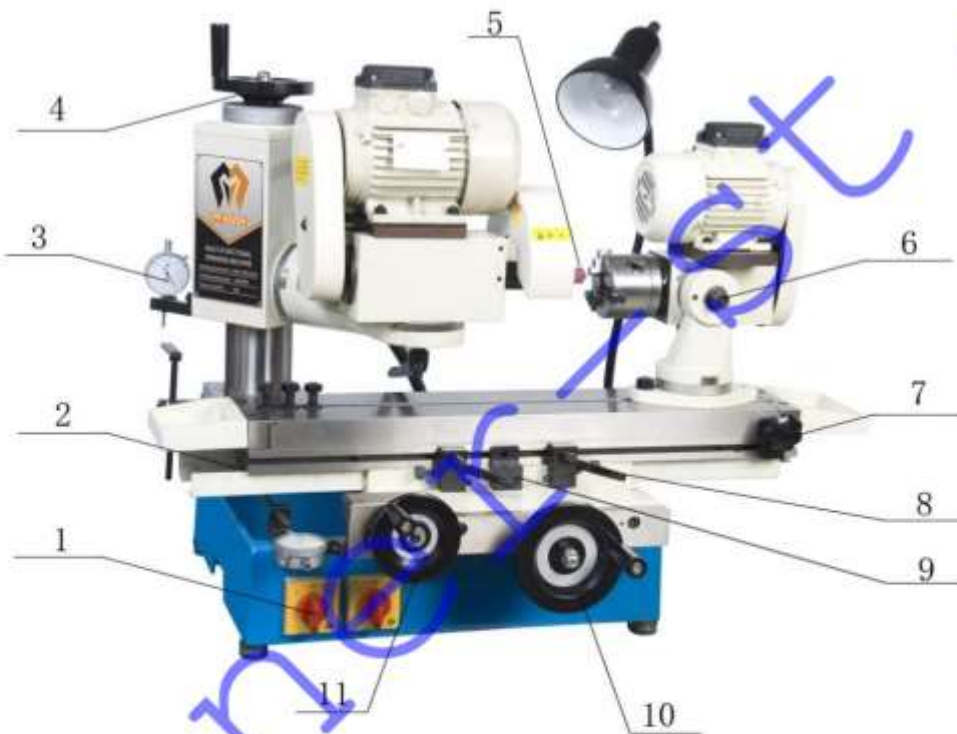
The grinding head could be transformed to internal cylindrical grinding device.

Applying the gearbox to fulfill the exchange of two different speeds thus to fit for different working situation.

The steel wire rope is applied on the working table so that it could travel horizontally freely and without any gap.

IV. Operation Instructions

Figure of Operation Position and Description



1. Power Switch
2. Linear Guide
3. Dial Indicator
4. Hand Wheel of Adjusting Grinding Head Position
5. Internal cylindrical grinding device
6. Electric Principal Axis Grinding Attachment
7. Rotating Handle of Operating Table
8. Right Stopper for Lengthwise Adjustment of Operating Table
9. Left Stopper for Lengthwise Adjustment of Operating Table
10. Lateral Moving Handle of Operating Table
11. Lengthwise Moving Handle of Operating Table



V. Cautions

I. Preventative Measures

1. Only professionals with electrician licenses are authorized to install or repair electrical appliances.
2. Be sure the voltage indicated on the nameplate of the motor conforms to that of the power supply.
3. The power plug of the machine tool and each contact of the socket should be reliable and firm. It is forbidden to have loose or bad contact.
4. Only use authorized power cords. Don't pull the power cord from the socket violently. The power cord should be away from hot, oily, or sharp places.
5. The power supply should be cut off by turn off the switch on the left side of the machine tool as soon as any fault or abnormal sound is detected, then have it checked and repaired
6. Never leave the tool run unattended. Don't leave the tool until it is powered off and stops.
7. Keep the operating place clean and tidy. Don't operate it in any damp, untidy, dim, flammable, and explosive place. Keep children or visitors away from the tool to avoid accidents.
8. Keep it under its max. cutting capacity to avoid accidents.
9. No operator should wear loose clothes, ornaments, and gloves. Long hair should be fixed with a hair pin and tucked in a cap, otherwise, it may be rolled into the machine.

10. All workpieces should be held and clamped tightly and reliably in processing. Never hold one with your hand, if so, you cannot operate the machine with two hands.
11. Keep the surface of guide rails clean, and prevent sand and dusts from entering the guide rails.
12. Never operate the machine when you feel tired, or after you drink alcohol or take anesthetics.
13. Only replace damaged parts or accessories with those having the same performance. It is optimal to use those from our company.

II. Adjust and Operate

1. Before starting the machine, add lubricants in each part and ensure that all locking mechanisms are in proper locking and power supply is proper.
2. Release the locking handle on the support before adjusting the grinding wheel, and then rotate the handle wheel and move the support to have the grinding wheel in the desired position, and then have the locking handle on the support locked properly.
3. Sand should be removed from the machine after operation, and apply engine oil on uncoated surface to prevent it from becoming rusty.



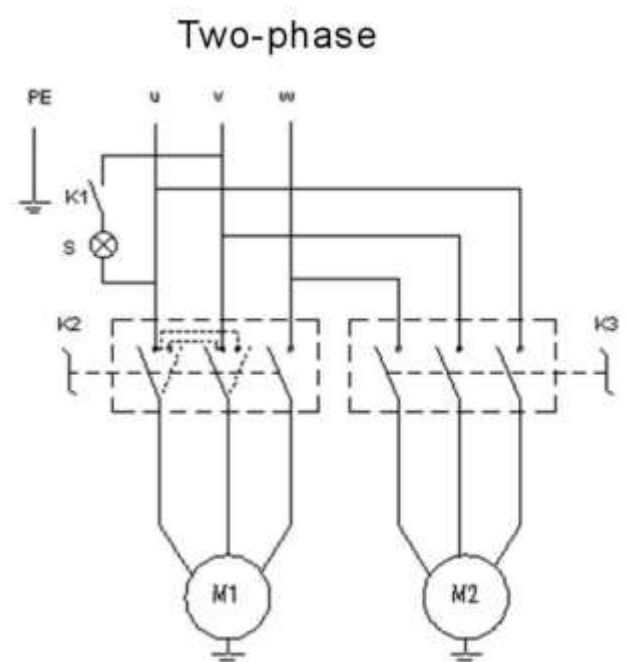
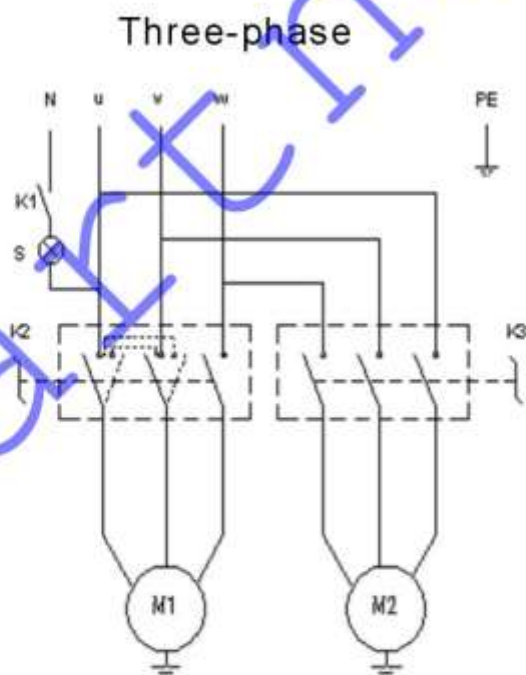
VI. Electrical Description

The electrical system of the grinding machine includes a 3/4HP (0.55KW) grinding motor, motor of head holder, control switch, and connecting cables. And its starting and stopping are controlled by the switch. The power of the electrical motor of the machine is 380V/240V, 50Hz, 2800r/min. (110V/220V 60Hz is optional) The lead wire of the head holder motor is equipped with an aviation plug to facilitate operation.

The power supply should be the same with the requirements of the motor.

It must be reliably earthed. A leakage protector is necessary!


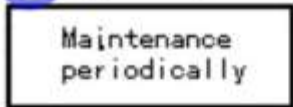

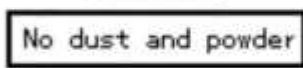

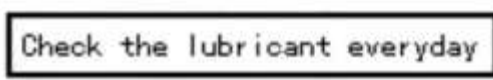
Figure of Wiring the Machine Tool is as shown in the following:



Cautions for the installation and maintenance of the straight guide rail

As the ball leads crew is a kind of very high precise product, Please pay strict attention to the following items:

I Maintenance

- ※ If the product cannot be used within one month after you buy it, please do the antirust treatment periodically. The period for the treatment should be adjusted according to the difference of the regional humidity.


- ※ Please check the guide rail monthly. If the surface of the ball lead screw is polluted by the dust and metal powder, please clean it by kerosene first and then add the lubricant oil.


- ※ The ball lead screw must have the lubricant oil on it all the time. If the rust or damage is led by without the lubricant, then we cannot do the maintenance for it free.



II Installation

The installation of the nut of the ball lead screw has strict technical requirements, so please do not dismantle the nut by yourself, for fear that it will damage the ball screw, and thus lead to the breakdown of the whole machine.

The machine must be used in a clean environment and put the protecting cover outside the machine in order to prevent the incoming dust and metal powder, or it will affect the accuracy and life-span of the machine.



No dismantle



No dust and powder

Certificate of Approval



Machine Name Universal Cutter Sharpener
Machine Model PP-6025W
Collet Capacity 250mm
Factory No. _____

The machine tool is inspected to up to the standard and is approved for delivery.

Checked by: _____

Chief Engineer: _____

Person in Charge: _____

Date: (M) (D) (Y)