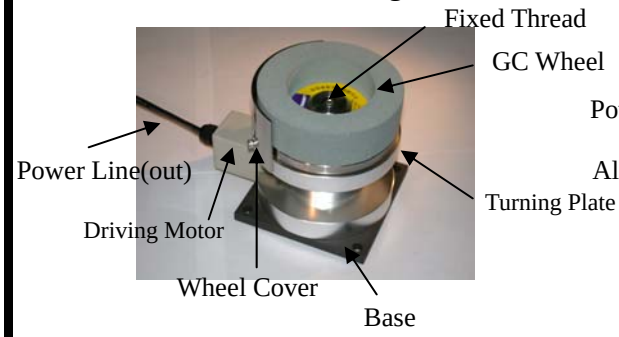
COVER'S PC-1000SH *Instruction Manual*

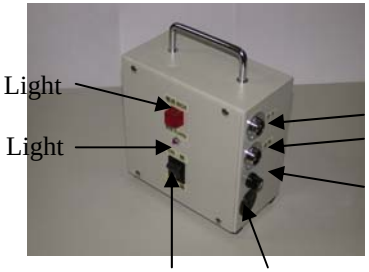
Powered Conditioning Tools for Resinoid Superabrasive Wheels

◆ 、Main Structures & Names：

• GC Conditioning



• Power Supply



◆ 、Installation Procedure：

1. To select the suitable grit size of GC wheel (reference★ **note 1**)，and make wheel bottom match with turning plate，lock tightly with fixed thread，then adjust wheel cover at the highest position，and fix tightly with two threads.
2. Make GC conditioning sets fix magnetically on surface grinder table(or lock on L shape sets of cylindrical grinder).
3. Insert power line(out)into power supply (out)and turn tightly.
4. Insert power line(in)into power supply (in)and connect with AC power.
5. Switch on power supply，and make sure red light on and GC wheel is Rotating stably.

◆ 、Conditioning Procedure：

1. To paint the rim face of Dia & CBN wheel (Abbrev. In BD wheels) equably with G.E ink.
2. Make BD wheel gradually close to the rim's top of GCwheel,and rotating BD wheel and GC wheel at same time until light touch mutually, and make sure the center line of BD grinding wheel face should be consistent with the spindle of GC wheel(see **Fig.1**),then let BD wheel feed back about 10 μ .
3. Fill up the coolant with dropper in order to be dropped during Conditioning process.
4. Switch on power supply and grinder to implement conditioning process.
5. BD wheel is implemented conditioning process in depth of cut 5~10 μ and feed rate 200~600mm/min.,the feed range of BD wheel can not out of diameter of GC wheel.But for super thin(0.3~1.0mm)BD wheels, please select the down cut conditioning way(reference★**Note 2**),in order to avoid the risk of wheels broken during the conditioning process.
6. To close the coolant system during all conditioning process, and replacing with coolant dropper, make the coolant be dropped into the grinding face of GC wheel little by little to create the loose and slurry condition between BD and GC wheels, in order to implement conditioning process fast and precisely.
7. While the conditioning voice is displayed smoothly and stably, stop BD wheel and observe its rim face to make sure whether the original marks of G.E ink be removed completely or not until it is finished entirely.

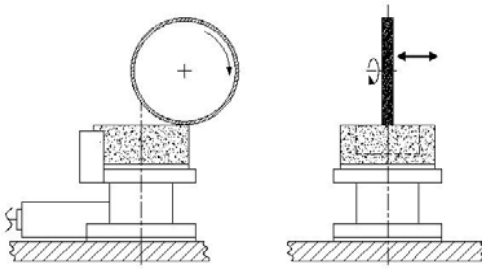


Fig.1

◆ 、Warning：

1. Please make sure the utilized voltage mach with power supply.
2. Please select correctly the most suitable grit size of GC wheel according to the grit size of BD wheel which will be conditioned(reference★ **note 1**).
3. This tools possesses the special accessories for protecting overload,when the BD wheel's depth of cut is over ,the buzzer on power supply will alarm operator , if the overload is continuously pass over 5 seconds ,then power will be closed automatically ,but you can switch the power again after 3 seconds ,it will go on working.

★ **note 1**：Compareable Grit Size Table of BD Vs. GC wheel

BD wheel	GC wheel
#100~#200	#120
#200~#325	#220
#325~#600	#320
#600~#1000	#600
#800~#1200	#800

★**Note 2**：Comparision of Down Cut Vs. Up Cut

Contents	Down Cut	Up Cut
Definition	Same Direction (↻↻)	Opposite Direction (↻↺)
Speed	Slow	Fast
Flatness	Better	Good
Roughness	Better	Good