

# Flywheel Grinder Maintenance

1. Machine needs to be level to maintain correct Table Lube on the ways below the turntable. Producing the best possible finish and fastest grinding times.
2. Must always have oil in the automatic oiler on the back right corner of the machine.
3. Coolant tank needs to be completely dumped and cleaned, then refilled with correct mixture of synthetic grinding coolant and water. (Every 30 flywheel grinds).
  - 3.1 Keep a 5-gallon mixture nearby and before each grind make sure the coolant in the tank is filled to 1 inch from the top of the coolant tank.
4. The insert in the center of the turntable needs to be removed and replaced every 30 flywheels. These inserts have Loctite red on the threads so you may need to provide a little heat to break them free when changing.
5. Clean the center hole after every grind. This will save the threads on your hold down bolts. (This hole is approximately 2 inches deep)
6. Wipe down the machine after each use. Even though the coolant is rust inhibitor, you will end up with a rusty machine if not cleaned regularly.
  - 6.1 It's especially important to keep the table surface and all flange adapters clean. Dirt and grit can affect the quality of your grind.
7. Never direct the coolant nozzle under the table edge. This can contaminate the table lube making the machine not perform correctly.
8. Twice a year apply leadscrew lubricant to the column leadscrew via the back panel.
  - 8.1 After each grind it is good practice to run the column up and back down to help keep the column leadscrew fully lubricated.
9. Excessive play in the column movement (Dropping) can be adjusted at the leadscrew nut. (call me or see the manual for instructions).
10. Call me if you have any questions about problems or how to repair the machine.

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