

TOOL GRINDER HYDRAULIC CONTROL VALVE SETTINGS

Position X on spool between 2 and 3 as shown. With nut loose adjust spool for two second dwell then holding spool in position turn nut clockwise as far as possible and secure with set screw.

Use no dwell at high table speeds.

The position of X as shown on the drawing is relative.

Open dwell valve to maximum setting. Set reversing screw and stop screw points far enough apart so that stop screw will not bump positive stop at end of stroke at desired table speed.

Also be certain that reversing blocks are not set out toward end of table so far that table will hit the end of cylinder.

