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PROCEDURE TO SETUP SUPRA 1224PD SURFACE GRINDER

1. Unwrap the machine and check out machine for any physical damage. If so, report to your dealer as soon as possible. Touch-up paint is inside the toolbox. Use it as needed.



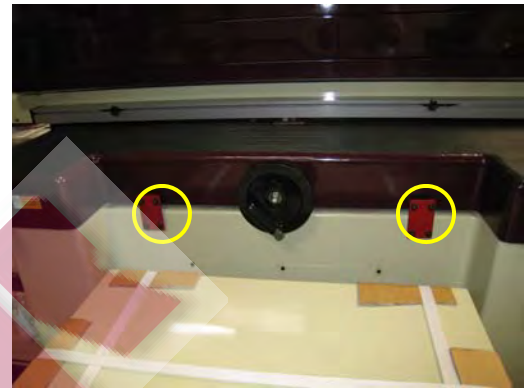
2. Unwrap control panel and remove supporting bracket.

3. Use a dead blow hammer to take out spindle support block. Move the table towards the operator. (Make sure away from safety limit switch.)

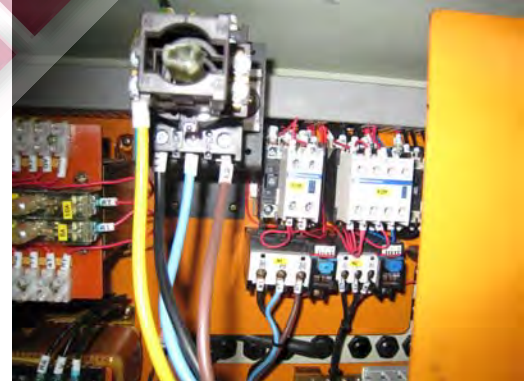


4. Move machine to appropriate location. Put leveling screw, nut and pad on machine (follow picture)

5. Remove the six transportation brackets



6. Check input power that will be used for the machine. Power required for our machines are: 230V three phase (3 Φ) or 460V three phase (3 Φ). Power must be first specified upon ordering. Please connect the power to R, S, T, Ground terminal as follows with minimum current of 45 amps (230V).



7. Hook up electronic conduct connectors, two from hydraulic system, one from magnetic separator and paper filter and one for the light.

8. Connect two corresponding hydraulic hoses: A-A and B-B.



9. Fill up hydraulic oil (minimum 30 gallons) and lubricating oil. Make sure filling gauge is at F.

10. Turn on control. Tap LCD Screen to activate control panel. Make sure all the motors are running clockwise (spindle motor, hydraulic motor, cross-feed motor, vertical rapid motor, and coolant pump motor). 1) Release (pull) emergency button. (See Fig. 1) 2) Press spindle (See Fig. 2 & 3), hydraulic (See Fig. 4 & 5) and coolant system buttons (See Fig. 6). to check rotation. 3) Check cross-feed motor by toggling in and out switch while function switch is in manual mode (See Fig. 7). 4) Check rapid vertical motor by pressing up button to take out the spindle support block and in the mean time down push buttons while function switch is in manual surface or plunging mode (See Fig. 8).





Fig. 1



Fig 2. Tap wheel with an object. Make sure the wheel is not cracked. The sound should be clear and consistent.

Fig.3 Push On and Off immediately. Make sure spindle rotation is clockwise.



Fig. 4



Fig. 5 Make sure hydraulic motor rotation is clockwise.



Fig. 6 Make sure the coolant pump is running clockwise..



Fig. 7 Make sure table crossfeed moving direction is correct.



Fig. 8 Make sure Rapid Up/Down direction is correct.



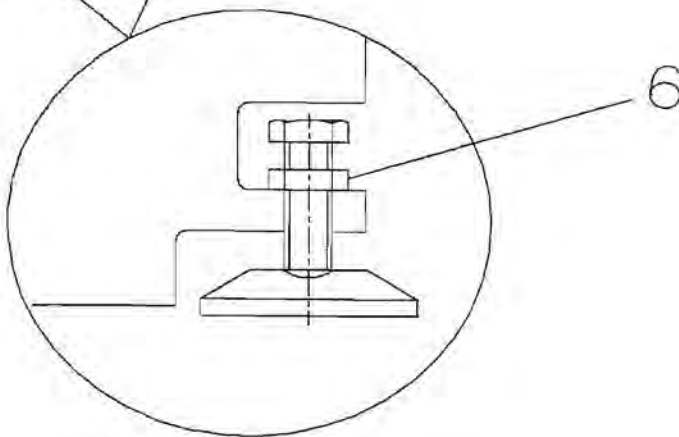
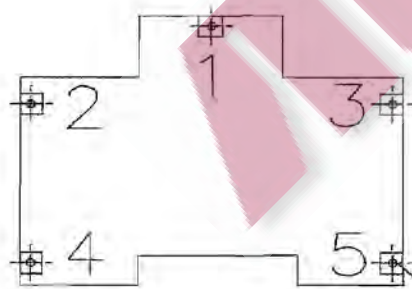
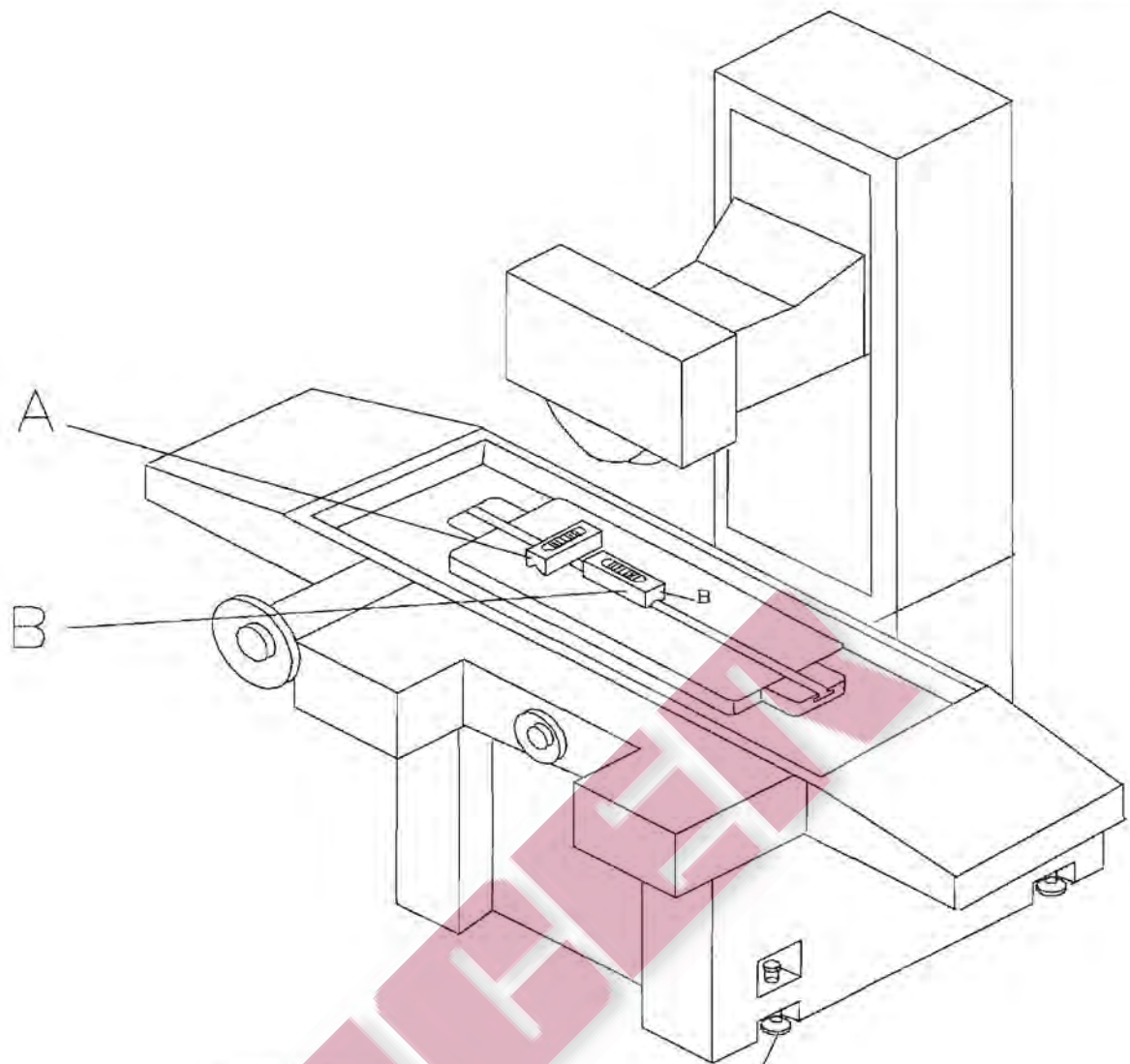
If opposite direction, please turn off main power by pushing emergency button. Switch any two power lines that go into the machine.

4.5 : Adjust the leveling of machines

Please adjust the leveling very carefully because the first installation will affect the precision and the life of machine. And surely will affect the precision of your work piece.

The accuracy of the level gauge is 0.02mm/M or 0.0008in/40in, and please adjust the level of machine within 0.02mm/M. The procedure of adjustment is as below:

- (1) : As the drawing shown below, put the leveling gauge on the table. Make sure the table is in the center of machine. Place level gauge (A) in crosswise direction, and put the level gauge (B) in the longitudinal direction.
- (2) : Check with chapter 4.4.2. Adjust the fixing bolts NO. 4,5, until the bubble of level gauge (B) comes to the center, then adjust the fixing bolt (1) until the bubble of level gauge (A) comes to the center on the level gauge.
- (3) : Screw tight the fixing nuts (NO. 6) on the leveling bolts NO.1,4,5.
- (4) : Screw tight the leveling bolts NO. 2,3. Make sure they have touched leveling blocks, and the bubble of the level gauge on the machine doesn't move, then screw tight the nut NO. 6.
- (5) : Turn the hand wheel of the table. Make the table move left or right, then check if the bubble of level gauge (B) is still within 0.02mm/M.
- (6) : Turn the hand wheel of saddle. Check the bubble on level gauge (A), to see if it is still within 0.02mm/M.
- (7) : If the bubble of level gauge in procedure (5) & (6) is over 0.02mm/M, please adjust according procedure (1), (2),(3), &(4).
- (8) : Please use hammer to slightly tap the leveling pads again after all the procedure had done. This is to ensure all leveling bolts are firmly supported.



3.2

12. For auto lube pump, we recommend you use way oil #2 or for hydraulic oil, use Mobil DTE 25 or follow the manual suggestion.



13. Read through the operation manual and choose the correct wheel for application.
14. Ready to run your grinder: please read through the Supra 1428/1632/1640AHD manual to familiarize yourself with all functions, features and controls.
15. Should you have any questions or comments, please contact your local dealer first. They will then refer you to Acer 714-632-9701 (west coast) or 732-752-9100 (east coast) for further assistance.

WHEELER