

Oneway Balancing System

(66B04.24+)

The following instructions were provided by the manufacturer.

Instructions:

1. Install three (3) hex nuts in the groove of the balance flange.
2. Install the three (3) button-head screws with washers into the nuts from step 1.
3. Set the three screw/washer/nut assemblies at 120° from each other and snug up using the 5/32" wrench supplied.
4. Insert the balance flange through the wheel to be balanced and screw on the balance nut.

Note: *Make sure to match the left-hand threaded flange with the left-hand threaded nut and the right-hand threaded flange with the right-hand threaded nut.*

5. Set the flats into a vise (or similar) and tighten the nut by rotating the grinding wheel with two hands to a tight 25-30 foot pounds.

You are now ready to begin the balancing process.

6. Slide this assembly onto the bearings of the balance fixture. Keep the grooves with the screws facing away from the base. Make sure there is a small amount of clearance between the base and the wheel and flange assembly. Wait until the wheel stops rotating.
7. Move all three screws, keeping them at 120 degree spacing until the wheel stops with the screw at top dead centre; other two screws at 8 o'clock and 4 o'clock respectively.
8. Now you can start balancing by moving the two weights from the 8 o'clock and 4 o'clock positions toward the 12 o'clock position in small increments.
9. After each move, rotate the assembly 1/4 turn to the right or left and allow the assembly to settle. When the wheel stays put in any radial position, then the wheel has balanced.
10. Finish tightening all three screws and then mount the wheel to the grinder.
11. When mounting the wheel and flange to your grinder, be sure to remove the "dished" washers and replace them with the machined washers supplied. These are installed **before** the wheels to increase the shoulder the flange assembly sits against.

Notes:

1. For **Baldor Grinders**, the following washers are available: 6" Baldor Grinder (order part no. 2895), 7" Baldor Grinder (order part no. 2894), & 8" Baldor Grinder (order part no. 2835).
 2. For **Delta 8" Variable Speed**: Two extra 5/8" washers are required; 1 machined washer that we can provide, and the extra washer can be your normal store-bought hardware store 5/8" washer. To install: Remove the Delta washers and spacers. Slide the machined 5/8" first and then the store-bought 5/8" washer on to the shaft. Mount the RH flange to the left side of the grinder with the weights of the balancing kit towards the motor side. Install speed nut and guard.
 3. If the wheel does not rotate freely on the balance fixture, you may wash out the bearings with mineral spirits or any solvent that dissolves grease, blow out with air and re-lubricate with light oil such as sewing machine oil or number 10 motor oil thinned 50/50 with mineral spirits.
 4. Do not remove the bearing shields as this may damage the balls or racers and allow minor dirt particles to enter. This will cause stickiness that makes them useless for the intended purpose.
 5. If your wheel fits loose which may be a problem; 1 or 2 wraps of clear adhesive (Scotch) tape around the shaft bushing or balance flange may improve balanced running.
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