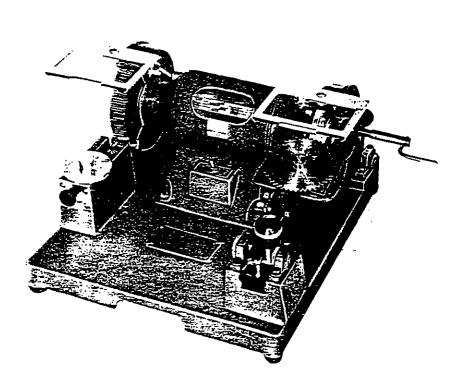
# PARTS AND SERVICE MANUAL

# UNIVERSAL BLADE GRINDER



INSTALLATION
OPERATING
MAINTENANCE INSTRUCTIONS
PARTS LIST



BEST& DONOVAN 5570 Creek Road, Cincinnati, OH 45242, USA TOLL FREE: TELEPHONE: TELEX: CABLE: FAX:

1-800-553-2378 (513) 791-9180 275-189 WEPCO 513-791-0925

# Universal Blade Grinder

## INSTALLATION INSTRUCTIONS



Inspect your Best & Donovan Universal Blade Grinder for possible damage as soon as you receive it. If you discover any damage, notify carrier's agent at once and request him to inspect the damage, also notify Best & Donovan.

NOTE:

Carefully read the following instructions before attempting to assemble and operate.

# OPERATING INSTRUCTIONS

Maintenance personnel should gather all maintenance and parts list information on the B & D Universal Blade Grinder. They should read and understand all maintenance and servicing instructions then file it where it is easily retrievable.

Preventive maintenance is the first step of good maintenance. A periodic check should be made to replace worn parts. A worn part replaced in time may save extensive repairs later.

THIS IS A PRECISION MACHINE made up of precision parts and should be handled with care. Do not squeeze parts in holding device or otherwise misuse. Too much pressure exerted in holding device may cause distortion of part. Be sure you have the correct tools and fixtures before assembling (or disassembling) this machine.

IT IS IMPORTANT that all parts are thoroughly cleaned and inspected before assembling.

BEFORE DISASSEMBLING a machine, the area around the work bench should be clean and free from metal chips and other foreign matter. It is a good practice to spread a clean cloth on the work bench to prevent the loss of small parts.

The Best & Donovan Universal Grinder is designed to sharpen blades for B & D Air and Electrically Operated Dehiders. It will produce an exact tooth form with a minimum of operator judgment and skill. The grinding wheel is shaped in such a fashion as to grind the entire tooth in one pass.

# PARTS LIST

1 6380000 B & D UNIVERSAL BLADE GRINDER 2 6580100 Pillow Blocks 3 6380200 1½ x 3³* Dowel Pin 4 6380300 Knurled Nut 5 6380400 Grinder Base 6 6380500 Blade Holder Arm 7 6380600 Blade Holder Arm 8 6380700 Blade Holder Hinge 8 6380700 Blade Holder Hinge 9 6380800 Grinding Wheel 11 6381000 Tipping Fixture 12 9902194 1½ x 4³* Dowel Pin 13 6381200 Wheel Dresser Shaft 14 6381300 Crank Handle 15 6381400 Wheel Dresser Arm 16 6381400 Flexible Wheel 17 6381600 Flexible Wheel 17 6381600 Flexible Wheel 18 6381400 Flexible Wheel 19 6381600 Flexible Wheel 20 6381500 Glicker Support Bracket 21 6382000 Clicker Support Bracket 22 6382100 Adjusting Stud 23 6382200 Stud Locating Block 24 6382300 Knurled Knob 25 6382400 Vertical Adjusting Spring Bracket 26 6382500 Locating Post 27 6382600 Adjusting Stud 28 6382700 Spring Or Spring Bracket 29 6382800 Adjusting Spring Bracket 29 6382800 Mounting Spring Bracket 29 6382800 Adjusting Sorew for Tipping Blade 30 6382800 Adjusting Sorew for Tipping Blade 31 6383200 Flexible Spring Bracket 29 6382800 Adjusting Sorew for Tipping Blade 30 6382800 Mounting Sracket for Tipping Blade 31 6383000 Adjusting Sorew for Tipping Blade 33 6382800 Mounting Sorew for Tipping Blade 34 6383300 Electric Motor 110v-1-PHS0-80 CYC 35 6383400 Winder Sorew 36 9901300 Winder Sorew 37 6383800 Flex Head Sorew 38 6383700 Blade Mounting Bracket for Tipping Blade 40 9901298 Winder Sorew 40 9901298 Winder Sorew 40 9901298 Winder Sorew 41 6383800 Pillow Block Top Sorew 42 6383900 Glicker Support Washer 43 6383900 Flex Wheel Sorew 44 6384100 Wheel Hex Nut 45 6384400 Wheel Hex Nut 46 6384500 Flex Wheel Support Washer 47 6384400 Wheel Hex Nut 48 638400 Flex Wheel Support Washer 49 638400 Flex Wheel Support Washer 49 638400 Flex Wheel Support Washer 49 638400 Flex Wheel Support Washer	Item No.	Part Number	Name
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3         6380200         ½ x 3" Dowel Pin           4         6380300         Knurled Nut           5         6380400         Grinder Base           6         6330500         Blade Holder Arm           7         6380600         Blade Holder Hinge           8         6380700         Blade Holder Hinge           9         6380800         Grinding Wheel           10         6380900         Thumb Screw           11         6381000         Tipping Fixture           12         9902194         ½ x x" Owel Pin           13         6381200         Wheel Dresser Shaft           14         6381300         Wheel Dresser Arm           15         6381400         Wheel Dresser Arm           16         6381500         Flexible Wheel           17         6381600         Crush Oresser           18         6381700         48 Tooth Gear           20         6381800         Center Aligning Post           21         6382000         Clicker Support Bracket           21         6382000         Clicker Support Bracket           22         6382100         Adjusting Stud           23         6382200         Stud Locating Block	2	6380100	
4 6.380300 Knurled Nut 5 6.380400 Grinder Base 6 6.380500 Blade Holder Arm 7 6.306000 Blade Holder Arm 8 8.6380700 Blade Holder Hinge 9 6.380800 Grinding Wheel 10 6.380900 Thumb Screw 11 6.380900 Thumb Screw 11 6.381000 Tipping Fixture 12 9902194 Y2 x x" Dowel Pin 13 6.381200 Wheel Dresser Shaft 14 6.381300 Wheel Dresser Shaft 14 6.381300 Wheel Dresser Fixture 15 6.381400 Wheel Dresser Fixture 16 6.381500 Flexble Wheel 17 6.381600 Crush Dresser 18 6.381500 Flexble Wheel 17 6.381600 Crush Gear 19 6.381800 Center Aligning Post 20 6.381900 Clicker Support Bracket 21 6.38200 Clicker Support Bracket 21 6.38200 Stud Locating Block 22 6.382100 Adjusting Stud 23 6.382200 Stud Locating Block 24 6.382200 Knurled Knob 25 6.382400 Vertical Adjusting Spring Bracket 26 6.382500 Adjusting Post 27 6.382600 Adjusting Spring Bracket 28 6.382700 Spring for Blade Adjustment 29 6.382800 Mounting Bracket for Tipping Blade 29 6.382800 Adjusting Screw for Tipping Blade 30 6.382800 Flex Holder 31 6.383000 Adjusting Screw for Tipping Blade 33 6.382800 Flex Holder 34 6.38300 Flex Holder 35 6.383400 Flex Holder 36 6.383500 Flex Holder 37 6.382800 Adjusting Screw for Tipping Blade 38 6.383700 Flex Holder 39 6.383800 Flex North Tipping Fixture 30 6.383900 Flex Holder 31 6.383900 Flex Holder 32 6.383900 Flex Holder 33 6.383900 Flex Holder 34 6.383900 Flex Holder 35 6.383400 Flex Holder 36 6.383900 Flex Holder 37 6.383800 Flex Holder 38 6.383900 Flex Holder 39 6.383900 Flex Holder 40 9901298 M-"-20 x 1" Allen Cao Screw 40 9901298 M-"-20 x 1" Allen Cao Screw 41 6.383900 Flex Wheel Flange Washer 44 6.384100 Wheel Hax But 46 6.384300 Wheel Hax But 46 6.384400 Wheel Flange Washer 47 6.384400 Holder 48 6.384500 Flex Wheel Support Washer 49 6.384600 Flex Wheel Support Washer		6380200	½ x 3" Dowel Pin
5         6380400         Grinder Base           6         6380500         Blade Holder Arm           7         6380600         Blade Holder Hinge           8         6380700         Blade Holder           9         6380800         Grinding Wheel           10         6380900         Thumb Screw           11         6381000         Tipping Fixture           12         9902194         ½ x x" Owel Pin           13         6381200         Wheel Oresser Shaft           14         6381300         Crank Handle           15         6381400         Wheel Dresser Arm           16         6381500         Flexible Wheel           17         6381600         Crush Dresser           18         6381700         48 Tooth Gear           20         6381800         Center Aligning Post           21         638200         Clicker Support Bracket           21         638200         Clicker Support Bracket           21         638200         Clicker Support Bracket           22         6382100         Adjusting Stud           23         6382200         Knurled Knob           24         6382300         Knurled Knob			Knurled Nut
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11		6380900	Thumb Screw
12 9902194		6381000	Tipping Fixture
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14		6381200	Wheel Dresser Shaft
15 6381400 Wheel Dresser Arm 16 6381500 Flexible Wheel 17 6381600 Crush Dresser 18 6381700 48 Tooth Gear 19 6381800 Center Aligning Post 20 6381900 Clicker Soring 21 6382000 Clicker Soring 22 6382100 Adjusting Stud 23 6382200 Stud Locating Block 24 6382300 Knurled Knob 25 6382400 Vertical Adjusting Spring Bracket 26 6382500 Locating Post 27 6382600 Adjusting Post 28 6382700 Spring for Blade Adjustment 29 6382800 Mounting Bracket for Tipping Blade 30 6382900 Tipping Slide & Holder 31 6383900 Adjusting Screw for Tipping Blade 30 6382900 Electric Motor Tipping Fixture 31 638300 Adjusting Nut on Tipping Fixture 32 6383100 Adjusting Nut on Tipping Fixture 33 6383200 Eye Shied 34 6383300 Electric Motor Ti0V-1-PH50-60 CYC 35 6383400 Wa'' ID Washer 36 9901300 Wa'' 20 x 1" Allen Cap Screw 37 6383500 Flat Head Screw 39 6383700 Base Mount Head Screw 40 9901288 Va''-20 x 1" Allen Cap Screw 41 6383900 Glard Plate Screw 42 6383900 Glard Plate Screw 43 6383900 Glard Plate Screw 44 6384100 Wheel Hang Washer 45 638400 Wheel Hex Nut 46 6384300 Heel Hex Nut 47 6384400 Inside Wheel Spacer		6381300	Crank Handle
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19		6381600	Crush Dresser
19	18	6381700	
20   6381900   Clicker Support Bracket		6381800	Center Aligning Post
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23         6382200         Stud Locating Block           24         6382300         Knurled Knob           25         6382400         Vertical Adjusting Spring Bracket           26         6382500         Locating Post           27         6382600         Adjusting Post           28         6382700         Spring for Blade Adjustment           29         6382800         Mounting Bracket for Tipping Blade           30         6382900         Tipping Slide & Holder           31         6383000         Adjusting Screw for Tipping           32         6383100         Adjusting Nut on Tipping Fixture           33         6383200         Eye Shield           34         6383300         Electric Motor 110V-1-PH50-60 CYC           35         6383400         ¼" ID Washer           36         9901300         ¼" "10 Washer           37         6383500         Flat Head Screw           38         6383600         3/16 x ½ Round Head Screw           39         6383700         8/32 Round Head Screw           40         9901298         ½"-20 x ½" Allen Cap Screw           41         6383800         Pillow Block Top Screw           42         6383900         Guard Pl		6382100	Adjusting Stud
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37 6383500 Flat Head Screw 38 6383600 3/16 x 1/8 Round Head Screw 39 6383700 8/32 Round Head Screw 40 9901298 1/4 "-20 x 1/4" Allen Cap Screw 41 6383800 Pillow Block Top Screw 42 6383900 Guard Plate Screw 43 6384000 5/16 - 18 Hex Bolt 44 6384100 Wheel Flange Washer 45 6384200 Wheel Hex Nut 46 6384300 Wheel Hex Nut 46 6384400 Inside Wheel Spacer 48 6384500 Flex Wheel Support Washer 49 6384600 Base Mounting Leg (Rubber)		6383400	1/4" ID Washer
37         6383500         Flat Head Screw           38         6383600         3/16 x % Round Head Screw           39         6383700         8/32 Round Head Screw           40         9901298         ½"-20 x ¾" Allen Cap Screw           41         6383800         Pillow Block Top Screw           42         6383900         Guard Plate Screw           43         6384000         5/16 - 18 Hex Bolt           44         6384100         Wheel Flange Washer           45         6384200         Wheel Hex Nut           46         6384300         Wheel Adaptor Bushing           47         6384400         Inside Wheel Spacer           48         6384500         Flex Wheel Support Washer           49         6384600         Base Mounting Leg (Rupber)	36	9901300	
38       6383600       3/16 x % Round Head Screw         39       6383700       8/32 Round Head Screw         40       9901298       ½ "-20 x ¾" Allen Cap Screw         41       6383800       Pillow Block Top Screw         42       6383900       Guard Plate Screw         43       6384000       5/16 - 18 Hex Bolt         44       6384100       Wheel Flange Washer         45       6384200       Wheel Hex Nut         46       6384300       Wheel Adaptor Bushing         47       6384400       Inside Wheel Spacer         48       6384500       Flex Wheel Support Washer         49       6384600       Base Mounting Leg (Rupber)		6383500	
39       6383700       8/32 Round Head Screw         40       9901298       ½"-20 x ¾" Allen Cap Screw         41       6383800       Pillow Block Top Screw         42       6383900       Guard Plate Screw         43       6384000       5/16 - 18 Hex Bolt         44       6384100       Wheel Flange Washer         45       6384200       Wheel Hex Nut         46       6384300       Wheel Adaptor Bushing         47       6384400       Inside Wheel Spacer         48       6384500       Flex Wheel Support Washer         49       6384600       Base Mounting Leg (Rupber)		6383600	·
40 9901298 % "-20 x %" Allen Cap Screw 41 6383800 Pillow Block Top Screw 42 6383900 Guard Plate Screw 43 6384000 5/16 - 18 Hex Bolt 44 6384100 Wheel Flange Washer 45 6384200 Wheel Hex Nut 46 6384300 Wheel Adaptor Bushing 47 6384400 Inside Wheel Spacer 48 6384500 Flex Wheel Support Washer 49 6384600 Base Mounting Leg (Rupber)		6383700	
41       6383800       Pillow Block Top Screw         42       6383900       Guard Plate Screw         43       6384000       5/16 - 18 Hex Bolt         44       6384100       Wheel Flange Washer         45       6384200       Wheel Hex Nut         46       6384300       Wheel Adaptor Bushing         47       6384400       Inside Wheel Spacer         48       6384500       Flex Wheel Support Washer         49       6384600       Base Mounting Leg (Rupber)		9901298	
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47         6384400         Inside Wheel Spacer           48         6384500         Flex Wheel Support Washer           49         6384600         Base Mounting Leg (Rubber)			
48         6384500         Flex Wheel Support Washer           49         6384600         Base Mounting Leg (Rubber)			
49 6384600 Base Mounting Leg (Rubber)			
<u></u>	50	6384700	Blade Holder Magnets

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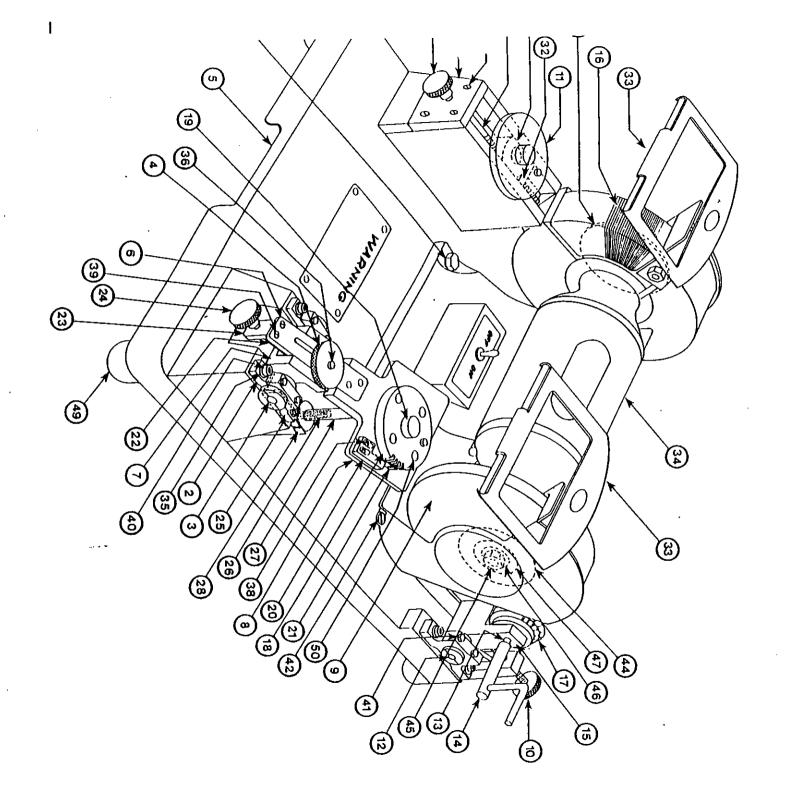
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# PARTS LIST



## DRESSING THE GRINDING WHEEL

To dress out the wheel with the diamond form dresser, shut off machine. Turn the large black knob in back of the machine on its' eccentric cam until high point of the dresser just touches the wheel by turning the clicker wheel on top of the wheel guard.

Turn dresser on eccentric shaft so that it does not touch the wheel. Turn on the machine and by turning the dresser knob and the clicker wheel, dress out the grinding wheel until the wheel has the complete form of the form dresser.

When wheel is dressed, turn dresser so that it does not touch the wheel.

ELECTRIC GRINDER MUST BE TURNED OFF DURING DRESSING.

DO NOT ATTEMPT TO DRESS GRINDER WITH GRINDER MOTOR RUNNING.

## DRESSING SIDES OF WHEEL

Due to the manufacturing tolerance inherent in producing grinding wheels, the thickness will vary from one wheel to the next. If the grinding wheel is too thick, it will produce a gouge or score at the bottom of the gullet of the tooth or possibly, in extreme cases, on the cutting edge adjacent to the bottom of the gullet. If a groove appears at either of these points the wheel must be thinned slightly. This is accomplished by touching the sides of the wheel at outer edge with carborundum dressing stick provided. It is seldom necessary to remove more than a sixty-fourth from side of the wheel.

## GRINDING

Level base of grinder with carpenters level. Start grinder and place blade on right hand fixture with recessed side up and with pin through one hole in blade. Lower arm until blade just touches grinding wheel. The blade should just draw a spark. If blade does not touch wheel, turn adjusting screw at bottom front of right hand fixture clockwise. If contact between wheel and blade is too heavy, turn knob counter clockwise, bringing blade away from wheel. Heavy grinding is not necessary. Next, change vertical adjustment until bubble on level on arm is between the lines. Properly adjusted, bubble will be between lines and blade in light contact. After touching first tooth to wheel, lift arm and move blade around one click of the indexer. Touch wheel with tooth. Repeat until all teeth are sharpened. Repeat with other blade of pair. All blades bear serial numbers and should be ground in pairs. Do not adjust grinder between blades of a pair. This will bring them to the exact same diameter. As blades and grinding wheels wear down, vertical and horizontal adjustments must be changed. Turn adjusting wheels until blade is just in contact with wheel. Check small level on arm to see if bubble is between lines. If not, change vertical adjustment to make it so. When properly adjusted, bubble will be between lines and blade will be in light contact with wheel.

## BLUNTING BLADE TIPS

The tips of the teeth should be slightly blunted and both blades of a pair brought to the same diameter. Always keep blades in pairs. The blunting is accomplished by putting a pair of blades face to face on the left hand fixture of the grinder. Bring blades up to sanding wheel. Rotate blades all around while in light contact with sanding wheel. This slightly blunts tips and brings blades to same outside diameter.

Motor

### DEBURRING

Blades must be deburred on cutting edge or feather edge will roll over in use. Deburr by brushing cutting edge vigorously with nylon brush, such as a toothbrush.

Morot	
Current	.110V. A.C. 50 or 60 cycles
	3450 RPM
Dimensions	
Width	15"=381 MM
Length	18"=457.2 MM
Height	9"=228.6 MM
Shipping Weight	approx. 45 lbs. = 204.1 KGS