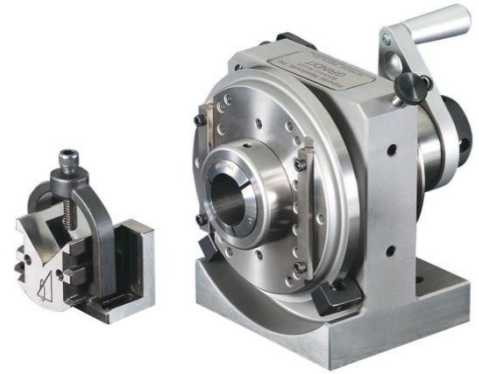


## Grindit

With this spin fixture you are able to: spin grind, install radii and angles, use on a milling machine, submerge in fluid and use for inspecting angles or roundness.

### **Topside Shotpin**

The topside Shotpin allows lock-in indexing every 15 degrees, repeatable within 10 arc seconds. To use, twist the topside thumbscrew allowing the Shotpin to drop into place.



### **Adjustable Stops**

Two adjustable stops are standard. Using additional stops more than 30 repeatable angles can be used with one setup. Install the stops at the top center of the fixture since the stop must be tipped to attach to the OD of the faceplate. Use a stop when arcing to an angle so your grinding wheel does not hit the adjoining flat.

### **Locking An Angle Using A Stop**

Loosely install a stop onto the perimeter of the faceplate. Slide the backside Shotpin into the stop. Using a sine plate, set the angle.

### **Zero Null Benefit**

Loosening 4 socket head cap screws on rear of the unit allows a +/- 8 degree adjustment from zero setting.

### **Spindle**

The spindle is guaranteed to 50 millionths TIR for one year from purchase date. The faceplate is guaranteed +/- .0003" square over 3 3/4".

### **5C Insert**

The standard 5C insert is ground to fit a particular fixture. The serial number is engraved onto the insert.

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### Lubrication

Re-lube the fixture every six months if it is used for dry grinding. If you use the fixture in a wet environment re-lube weekly using LPS Thermplex Aqua Bearing Grease. A 1/4-28 grease port can be found on the side of the fixture.

### Submersion

The fixture can be safely used in a wet environment or submerged into fluid by attaching an air regulator into the grease port and supplying 2 pounds of air pressure. Electrical grounding of the fixture is required in an EDM environment.

### Motor

The 1/15 hp variable speed, reversible 2500 rpm motor will produce a zero to 800 rpm spindle speed. We recommend **not** to exceed **60%** of the speed setting control for continuous operation. Momentary use above this speed is permissible, but attention should be paid to the temperature of the spindle.

<b><u>Specifications:</u></b>	
Spindle roundness	50 millionth TIR
Deflection	+-.0003" 3-3/4" Out
Topside shotpin	10 arc-second repeatability
Center height	3.004" +- .002" from bottom
Thru hole	1-1/4" plus
Weight	14 lbs
Base size	3-1/2" x 4"
Height	5"
Bottom holes	2-1/2" centers
Material	A2
V-Block capacity	1-1/2"

### **Available Accessories**

Precision Three Jaw Chuck

4" Magnetic Chuck

Quick Mount Adapter for Magnetic Chuck