## **OPERATORS MANUAL**



MADE IN THE U.S.A.



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### LIMITED WARRANTY

This machine is warranted against defects in workmanship and materials under normal use and proper maintenance, for one year, after date of purchase from WRIGHT MACHINE TOOL CO. Any part which is determined to be defective, and is returned to WRIGHT MACHINE TOOL CO. (shipping costs prepaid) will be repaired or replaced, at the option of WRIGHT MACHINE TOOL CO.

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# **General Safety Rules**

Failure to follow the Safety Rules and other basic precautions, may result in serious injury.

**Always use eye protection:** - When operating this machine, eye protection should be worn. Grinding particles and the possibility of wheel breakage make eye protection necessary. Also face or dust mask if operation is dusty. Use adequate ventilation.

**Use ear protection:** - If operation is creating excessive noise.

**Disconnect power:** - To machine when NOT in use.

**Keep clear:** - Of cutting head and pinch points when machine is running.

**Mounting of cutter head: -** Should only be done by persons with mechanical aptitude and good knowledge of mounting, care, and inspection of cutters.

**Dress Properly:** - Do not wear loose clothing or jewelry. Nonskid foot wear is recommended. Wear protective hair covering to contain long hair.

**Avoid dangerous environments:** - Don't use in wet location. Keep work area well lit. Do not use this machine in the presence of flammable liquid or gasses.

**Keep children away:** - Do not let VISITORS contact this machine.

**Keep work area clean: -** Cluttered areas invite accidents.

**All electrical covers: -** Must be in place before applying electrical power to this machine. Electrical service must be locked out prior to removing any electrical covers or machine guards. Access to electrical components must be restricted to trained personnel only to avoid possible electrical shock.

**Voltage greater: -** Than specified on name plate can result in serous injury to user.

**Never stand on this machine: -** Serious injury could occur if the machine is tipped or if the cutter headl is accidently contacted.

**Follow safety precautions:** - For cutter head and material being cut. These items must also be compatible. This information is available on the Safety Data sheet for each of these products.



### **SPECIFICATIONS**

STANDARD VOLTAGE: 115 Volt, 1 Phase, 15 AMP, 60 HZ

OPTIONAL VOLTAGE: None

SHIPPING WEIGHT: 600 lbs

CRATE SIZE: L 50" X W 40" X H 69"

AIR REQUIREMENTS: None

MAXIMUM GUIDE LENGTH: 13"

MAXIMUM GUIDE THICKNESS: 2"





#### **FEATURES**

- 3/4 HP- 3450rpm Industrial Spindle Motor
- 1/8 HP Variable Speed Industrial Gear Motor
- Variable Feed Rate Forward And Return
- Max Feed Rate Of 41 Inches Per Minute
- Movable Clamp Arms
- Dust removal Duct (vacuum not included)
- 90° to 40° Of Angle Adjustment
- 13" Guide Length x 2" Guide Width
- HD Construction

### **Notice**

The GD-1 product and the information in this user guide are the proprietary property of Wright Machine Tool Co. or its licensors and may not be copied, disclosed, or used for any purpose not expressly authorized by the user thereof.

Wright Machine Tool Co. is constantly seeking ways to improve its entire product line of machinery, and therefor reserves the right to change this manual and hardware mentioned therein at any time without notice.

In no event will the provider of this equipment be liable for any incidental, consequential, or special damages of any kind or nature whatsoever, including but not limited to lost profits arising from or in any way connected with the use of the equipment or this user manual.

### SAFETY FIRST!





### **CONTROLS**

- 1. Start / Stop.
- 2. Emergency Stop.
- 3. Feed Rate Speed Control Fwd.
- 4. Feed Rate Speed Control Rev.







### **OPERATING PROCEDURES**

- 1. Plug into power outlet.
- 2. Adjust angle plate for angle of guide being dressed. Micro adjustments to the angle plate can be made with 1/4 inch bolts. Lock plate with handle on the right.
- 3. Adjust fence for width of guide, lock fence in position with both handles. Use dowl pin and adjustment screws to set fence for future use.
- 4. Clamp guide using screw clamps. "DANGER" Do not allow cutter head to make contact with clamps! Serious damage may occur.
- 5. Set right side limit switch to desired length for guide. Use 1/8" Allen wrench.
- 6. Pull start button. Keep button pulled until spindle motor and vacuum are up to full speed. Machine will start feeding when start button is released. machine may be stopped at any time by pushing the E-STOP or pushing the START/START button.

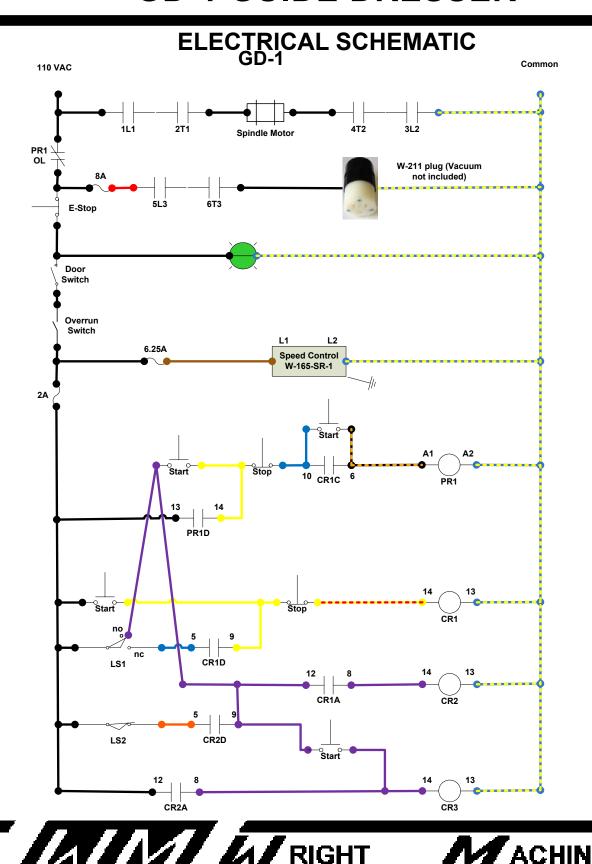
During operation cutter will travel from home position at the left side of machine to the right side limit switch, then reverse feed to return to the home position.

If machine is stopped for any reason (door switch, stop switch, E-stop, or power loss) machine will return to the home position by pulling the start knob. Feed motor will return the cutter head without energizing the spindle. Machine is then ready for normal operation.

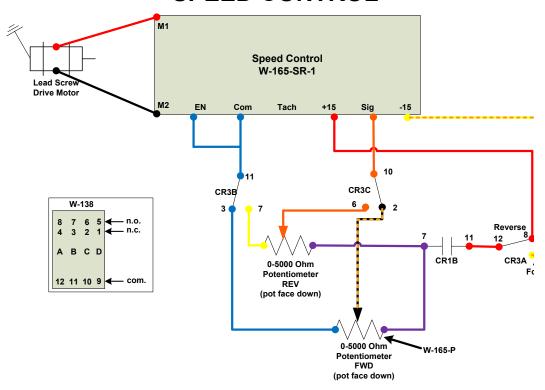
In the event of spindle motor overload, overload relay will automatically open motor and control circuit. Overload relay will reset after a cooling down period. Machine can then be returned to home position and normal operation resumed.







### **SPEED CONTROL**



Turn speed control pots FACC & RACC fully counter clockwise for instant start & stop.

<u>Jumpers</u>		
J1A	115 V	Line voltage
J1B	115 V	
J2	1.7A	Armature current
J3	A90	Motor armature voltage
J4	15V	Analog input voltage (15V for potentiometer control)
J5	SPD	For speed controll or torque
J6	RTS	Regenerate or coast to stop





### **ELECTRICAL BOX COMPONENTS**

1) W-165-SR-1 DC DRIVE

1) W-738 / W-737-1 CUBE RELAYS 3) A-5755 FUSE HOLDER

1) W-4982 RELAY

1) W-1462-1/2/3 TERM BLOCK

### **CONTROL COMPONENTS**

2) W-165-P SPEED CONTROL POTENTIOMETER

3) W-738 / W-737-1 CUBE RELAYS 3) A-5755 FUSE HOLDER

1) W-194-GE START STOP SWITCH 3) W-194-3-GE CONTACT BLOCK NC

1) A-5680 E-STOP

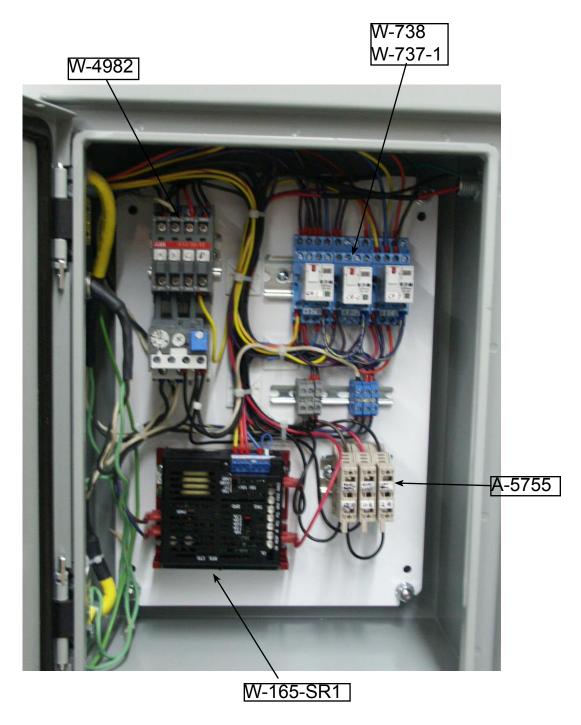
1) A-6705 CONTACT BLOCK, E-STOP

1) W-4975 CONTACT BLOCK NC





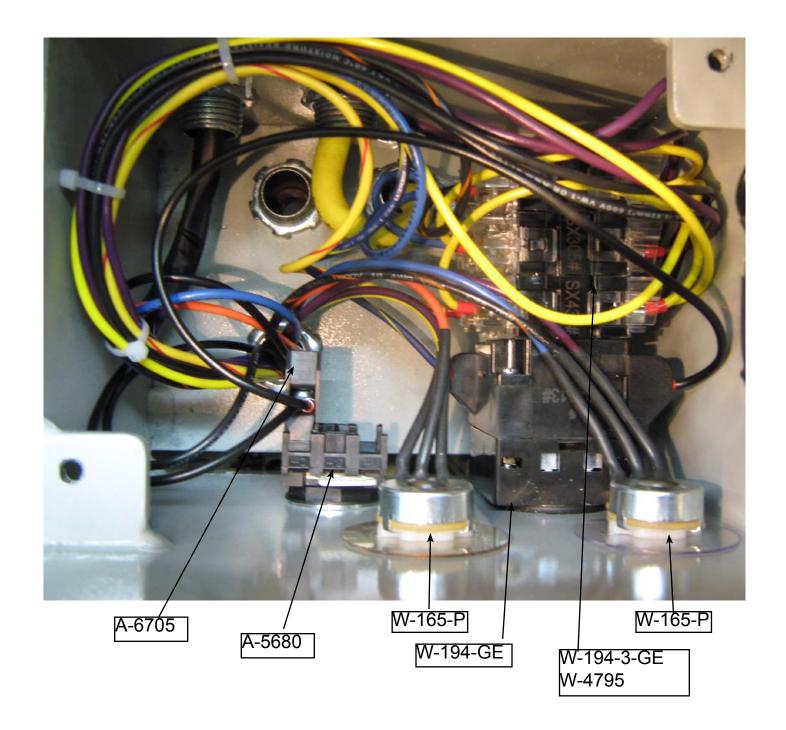
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### **CONTROL COMPONENTS**





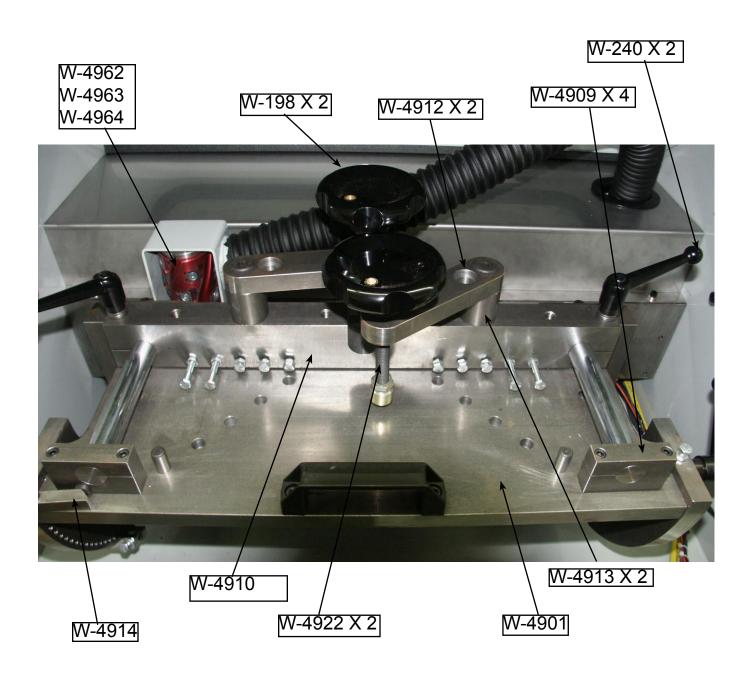


### **PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	W-4901	GUIDE TABLE
1	W-4902	RIGHT TABLE SUPPORT
1	W-4903	LEFT TABLE SUPPORT
1	W-4904	SUPPORT BAR
2	W-4905	PILLOW BLOCK MOUNT
1	W-4906	SPINDLE MOTOR MOUNT
1	W-4907	MOTOR ADAPTER PLATE
1	W-4908	DRIVE BLOCK
4	W-4909	TABLE CLAMPS
1	W-4910	GUIDE REST
1	W-4911	SPINDLE PLATE
2	W-4912	CLAMP ARM
2	W-4913	CLAMP SPACER
1	W-4914	STOP BLOCK
3	W-4915	FIXED ANGLE BLOCK
1	W-4916	DRIVE SHAFT
1	W-4917	RIGHT LIMIT SWITCH MOUNT
1	W-4918	LEFT LIMIT SWITCH MOUNT
1	W-4919	LIMIT SWITCH BAR
2	W-4920	TABLE PIVOT BLOCK
2	W-4921	DRIVE NUTS
2	W-4922	CLAMP ROD
1	W-4923	LIMIT SWITCH TARGET
1	W-4924	CUTTER SHAFT
1	W-4925	CUTTER CAP
2	W-4932	PIVOT ATTACHMENT
2	W-4933	GUIDE ADJUSTMENT SHAFTS
1	W-4960	SPINDLE MOTOR
1	W-4962	SPIRAL CUTTER
12	W-4963	CUTTER INSERTS
12	W-4964	TORX SCREWS
1	W-4965	DC GEAR MOTOR
1	W-4970	SPINDLE DRIVE BELT
2	W-4972	SPINDLE PILLOW BLOCK BEARING











#### PARTS LIST CONTINUED

