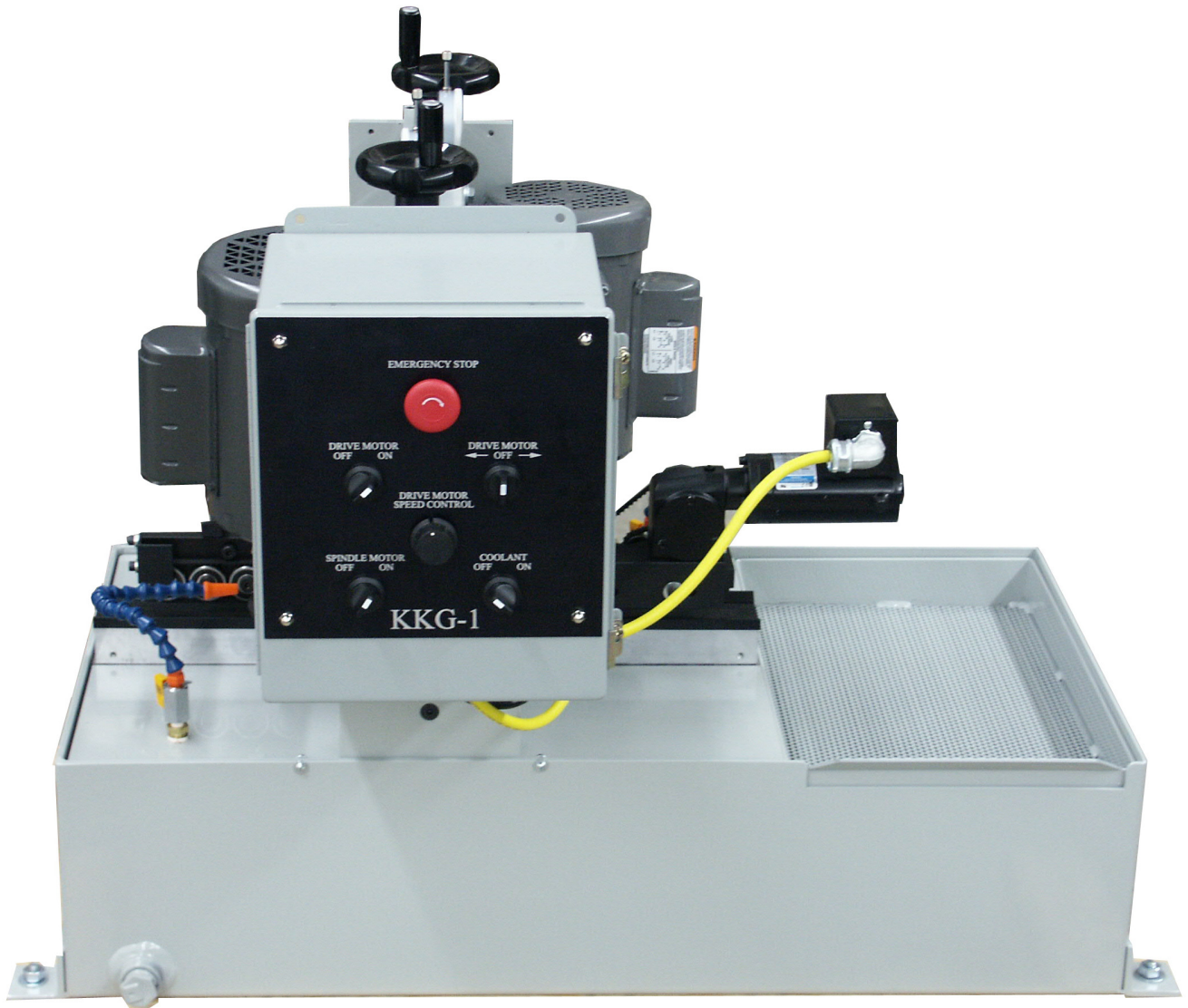

KEY KNIFE GRINDER

KKG-1



MADE IN THE U.S.A.

KKG-1 KEY KNIFE GRINDER

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KKG-1 KEY KNIFE GRINDER

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.

WRIGHT MACHINE TOOL CO., INC
365 Palmer Avenue
Cottage Grove, Oregon 97424

Phone (541) 942-3712
Fax (541) 942-0730



KKG-1 KEY KNIFE GRINDER

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 grinding wheels and pinch points when machine is running.

Saws are sharp: Wear appropriate personal protective equipment when handling saw blades.

Mounting of wheels: Should only be done by persons with mechanical aptitude and good knowledge of mounting, care, and inspection of grinding wheels. Wheels must be rated for the RPM of the machine.

Dress properly: Do not wear loose clothing or jewelry. Non-skid 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.



KKG-1 KEY KNIFE GRINDER

GENERAL SAFETY RULES (CONTINUED)

Voltage greater: Than specified on name plate can result in serious injury to user.

Never stand on this machine: Serious injury could occur if the machine is tipped or if the grinding wheel is accidentally contacted.

Follow safety precautions: For wheels, coolant and material being ground. These items must also be compatible. This information is available on the Safety Data sheet for each of these products.



KKG-1 KEY KNIFE GRINDER

COOLANT SAFETY

Proper coolant maintenance will increase grinder life and grinding performance, and possibly reduce any risks associated with health concerns. Lack of proper coolant maintenance can result in increased exposure to grinding grit, bacteria, and other by products of grinding that may lead to increased skin sensitivity in some individuals.

WARNING!

Coolants used in this machine must be designed to be used in wet grinding operations. Do not use automotive coolant. Check with the manufacturer of the coolant to make sure it is designed for use in wet grinding of saws.

Water based coolants are designed to operate at precise mixture ratios. Check with the manufacturer of your coolant to determine the proper mix ratio.

CAUTION

Residual cleaning solutions on the saw will easily be dissolved into the coolant tank and can dramatically affect the chemistry of coolant which can significantly reduce wheel life, coolant efficiency, and corrosion efficiency.

Maintain the coolant filters that were shipped with this machine. If you have any questions on how to maintain the filters, call the factory at 1-541-942-3712

Test your coolant at regular intervals. Contact the manufacturer of your coolant to determine when to test, and which tests to perform.

Warning signs of improperly maintained coolant:

1. Strong (foul) odor coming from the coolant.
2. Color change in the coolant.
3. Noticeable stickiness on the saw.
4. Rust developing on the machine and/or saw steel.
5. Unexplained skin rash.

If you detect any of these warning signs consult the coolant manufacturer at once. If you are having trouble contacting the coolant manufacturer, call Wright Machine Tool Co. Inc. at 1-541-942-3712



KKG-1 KEY KNIFE GRINDER

SPECIFICATIONS

KKG-1 KEY KNIFE GRINDER.

STANDARD VOLTAGE:	220 Volt, 1 Phase, 60 HZ
OPTIONAL VOLTAGE:	N/A
SHIPPING WEIGHT:	300 lbs / 136 kg
CRATE SIZE:	L 48" X W 60" X H 48"
AIR REQUIREMENTS:	NONE
SPINDLE MOTORS:	(2) 3/4hp Motor
STANDARD RPM:	3450 RPM



KKG-1 KEY KNIFE GRINDER

PRE SET UP (COOLANT)

Coolant capacity is 10 to 15 gallons. A rust inhibiting grinding coolant **MUST** be used or severe rust damage to machine can result. Mix coolant according to manufacturer's instructions.

COOLANT FILTERS: Clean coolant will increase grinding wheel life, improve grind finish and increase removal rates. Change coolant filter as necessary. Part # W-591.

RUST DAMAGE IS NOT COVERED BY THE WARRANTY

MOUNTING GRINDING WHEELS

All grinding wheels must be rated for the RPM of this machine. Wheels exposed to higher than rated RPM are dangerous.

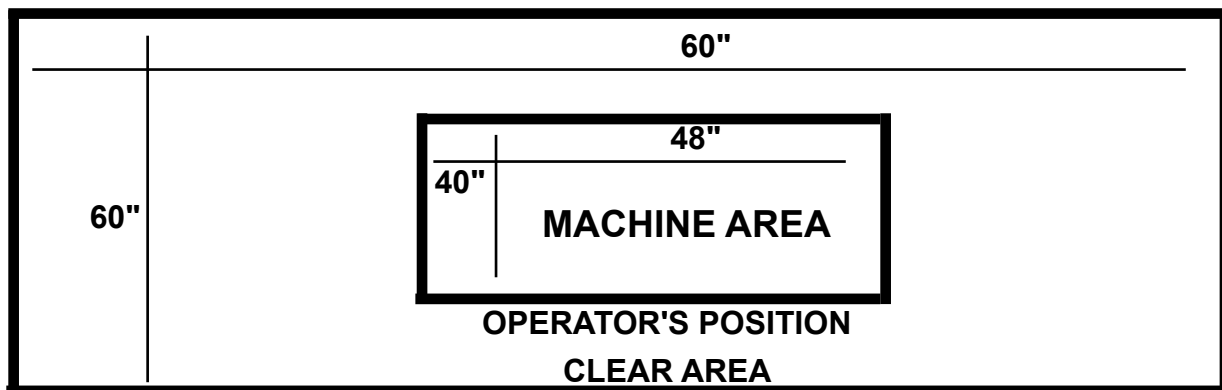
Mounting of the grinding wheel should only be done by persons with mechanical aptitude and good knowledge of mounting, care, and inspection of grinding wheels.

All grinding wheels must be rated for at least 3,450 RPM or the RPM of your machine, which ever is greater.

MACHINE INSTALLATION

Lifting this machine should only be done with a fork lift under Machine bottom. Machine weight is approximately 300 pounds.

RECOMMENDED FLOOR SPACE FOR MACHINE AND OPERATOR



KKG-1 KEY KNIFE GRINDER

INSTALLATION AND OPERATION INSTRUCTIONS

1. Electrical plug in: 220volt single phase.
2. Raise grinding wheels 1/2 inch above plastic guide.
3. Fill coolant tank with proper coolant.
4. Start drive motor and grinding wheel motors.
5. Pass knives through.

START UP ADJUSTMENT

1. Insert knife in and stop under the grinding wheel.
2. Lower the wheel until you lightly touch the knife.
3. Move your dial indicator to "0".
4. Bring the knife forward to the other motor and repeat step 2 and 3.
5. Run the knife out.
6. Lower both motors down (.003 to .005").
7. Note that each motor can pivot 0° to 10°. (4° to 5° is suggested)
8. Pass one knife through.
9. If results are different on each side, readjust the difference with the top dials.
Lowering the grinding motor .001" will not result in .001" on the lateral measurement.
10. Run the same knife until you are satisfied with the results.
11. Slower speed will give you a better cutting edge.

NOTE:

Do not reverse the drive motor on motion. You must stop the grinder with the on/off switch then reverse.

NOTE:

Always raise grinding motors when installing a new knife slide then re-adjust grinding wheel height. It may be necessary to adjust belt track height when installing a new knife slide or changing to a different style slide.

NOTE:

Knives must be deburred on the bottom edges that contact the delrin knife slide.



KKG-1 KEY KNIFE GRINDER



ADJUST THESE FIVE SCREWS UNTILL KNIFE PASSES THROUGH SLIDE.
OVER ADJUSTMENT WILL CAUSE THE BELT TO ROLL OFF DRIVE BEARINGS.



KKG-1 KEY KNIFE GRINDER

CONTROL PANEL



Part Number

A-5680/A-6705

W-165-H

W-4528

W-4570

W-4570

W-4570

W-4571

Description

EMERGENCY STOP

SPEED CONTROL KNOB

CONTROL PANEL

COOLANT SWITCH ON/OFF

SPINDLE MOTOR SWITCH

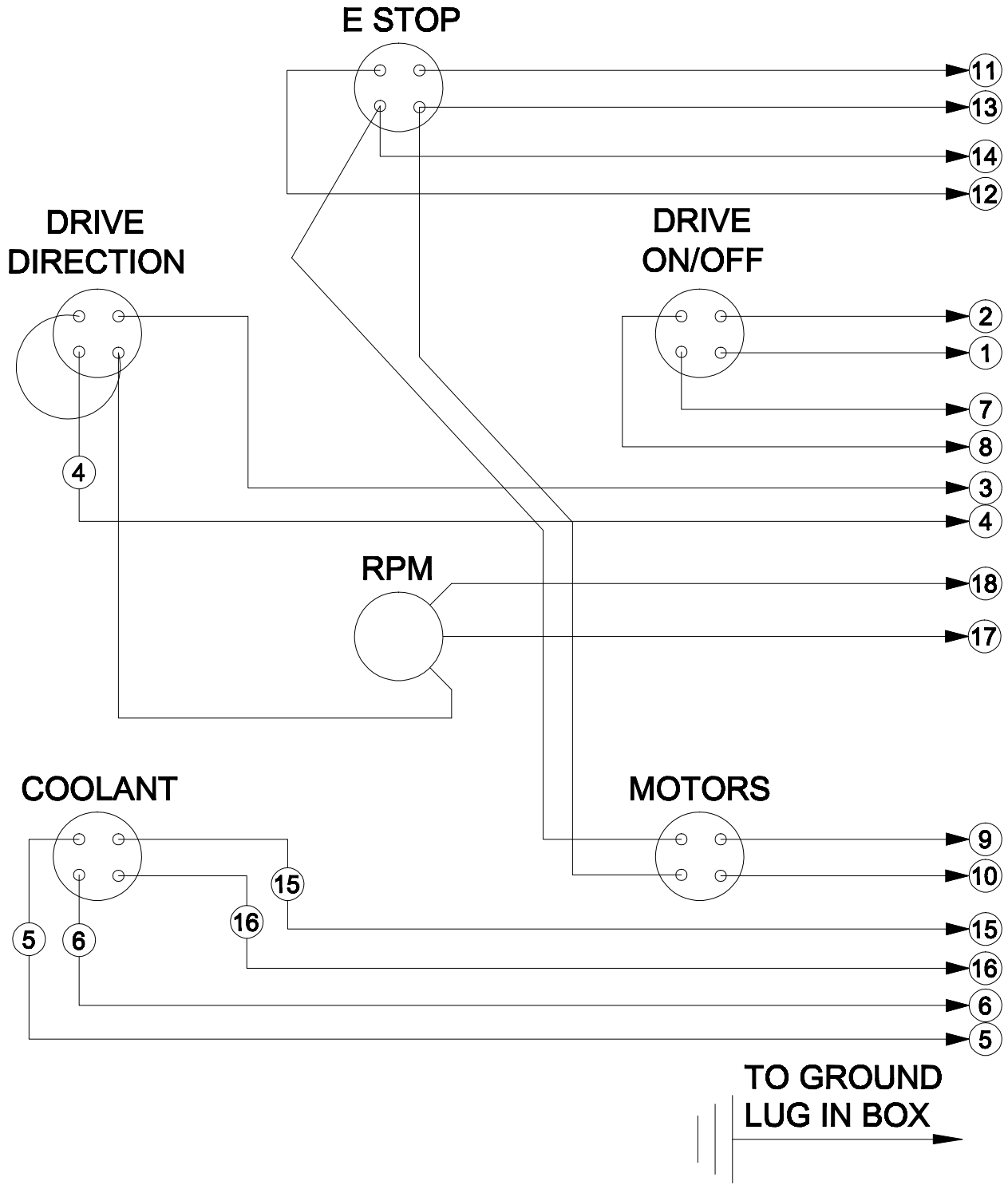
DRIVE MOTOR SWITCH ON/OFF

DRIVE MOTOR DIRECTION SWITCH



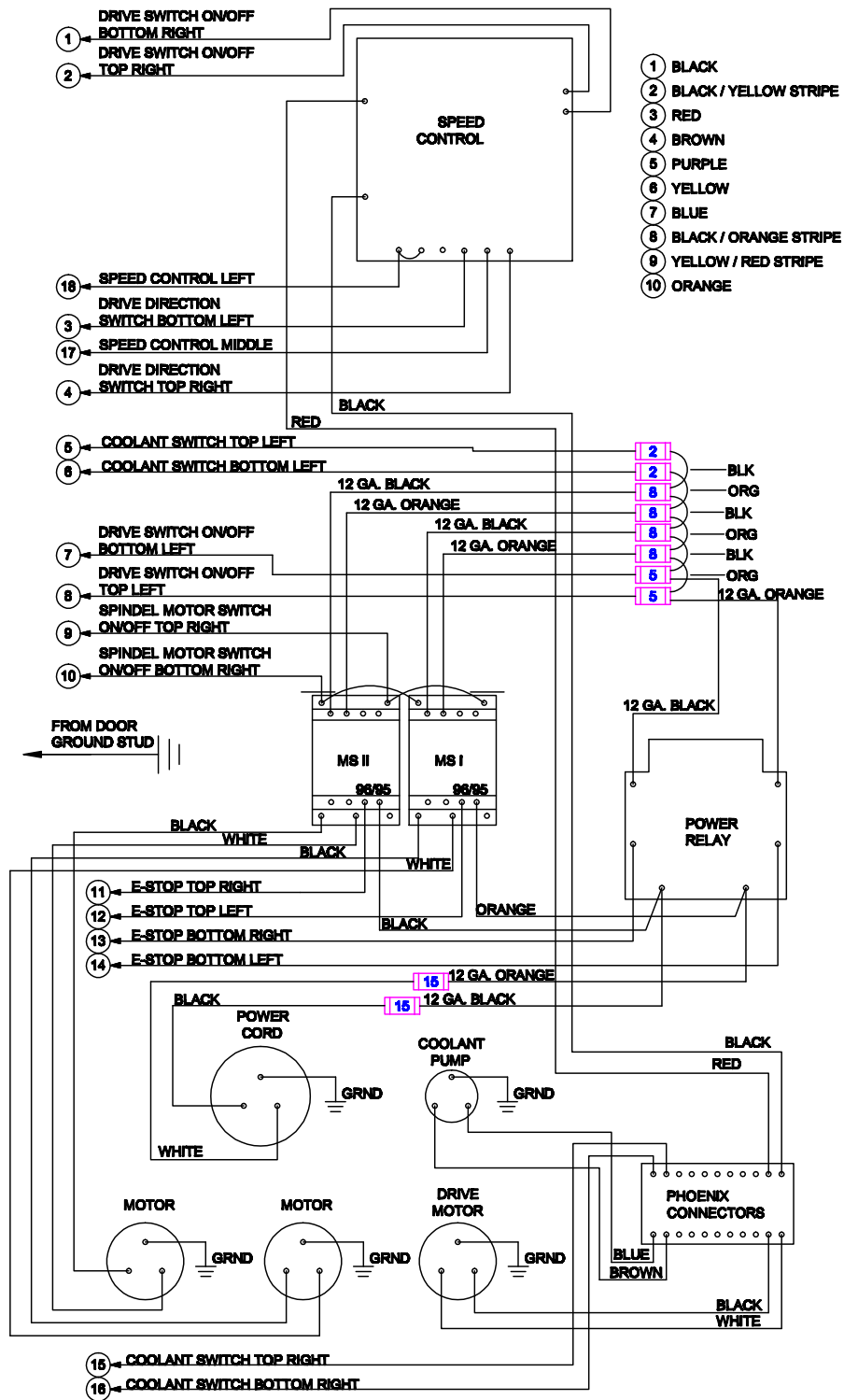
KKG-1 KEY KNIFE GRINDER

ELECTRICAL BOX DOOR WIRING DIAGRAM



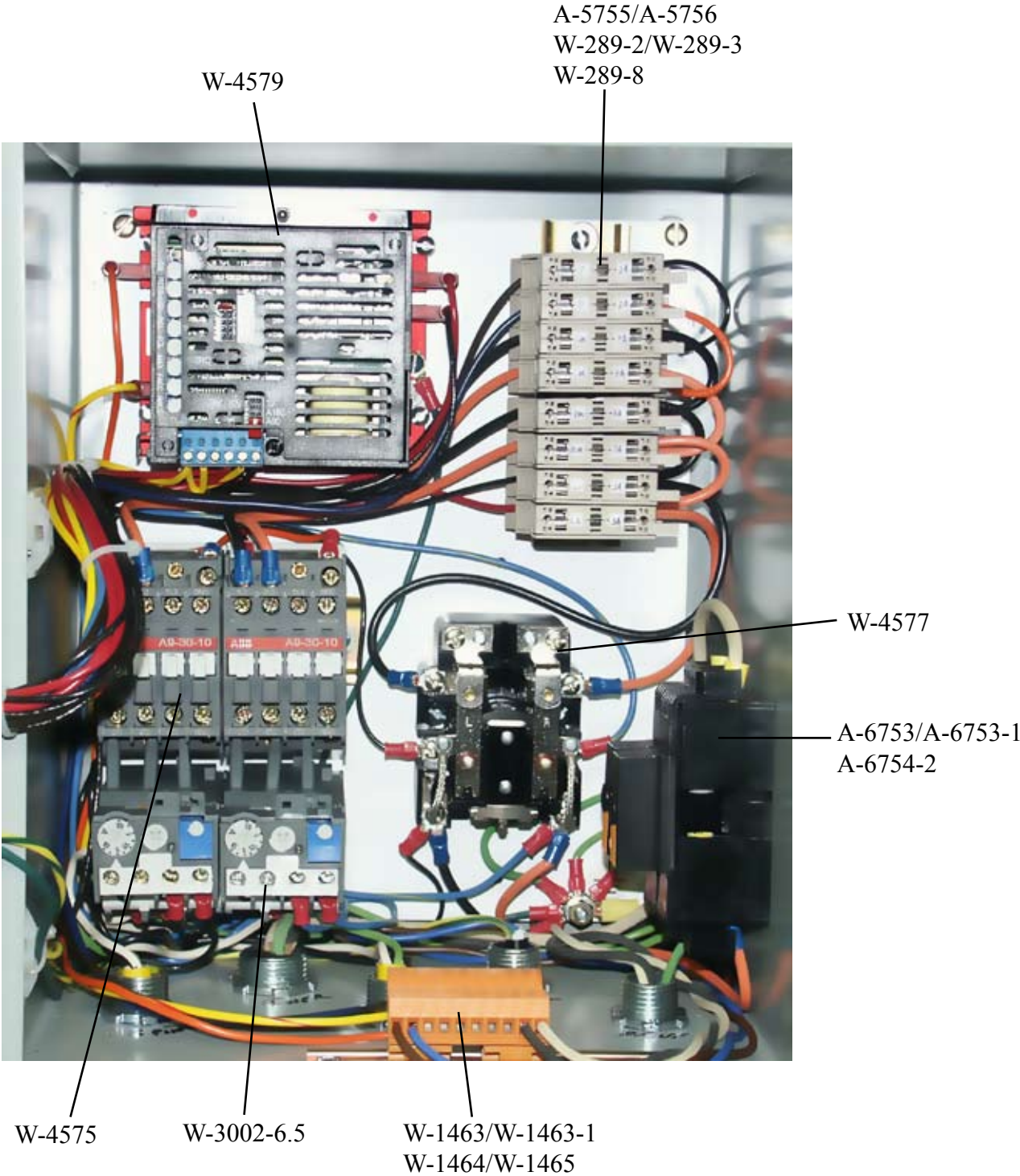
KKG-1 KEY KNIFE GRINDER

ELECTRICAL PANEL WIRING DIAGRAM



KKG-1 KEY KNIFE GRINDER

ELECTRICAL PANEL



KKG-1 KEY KNIFE GRINDER

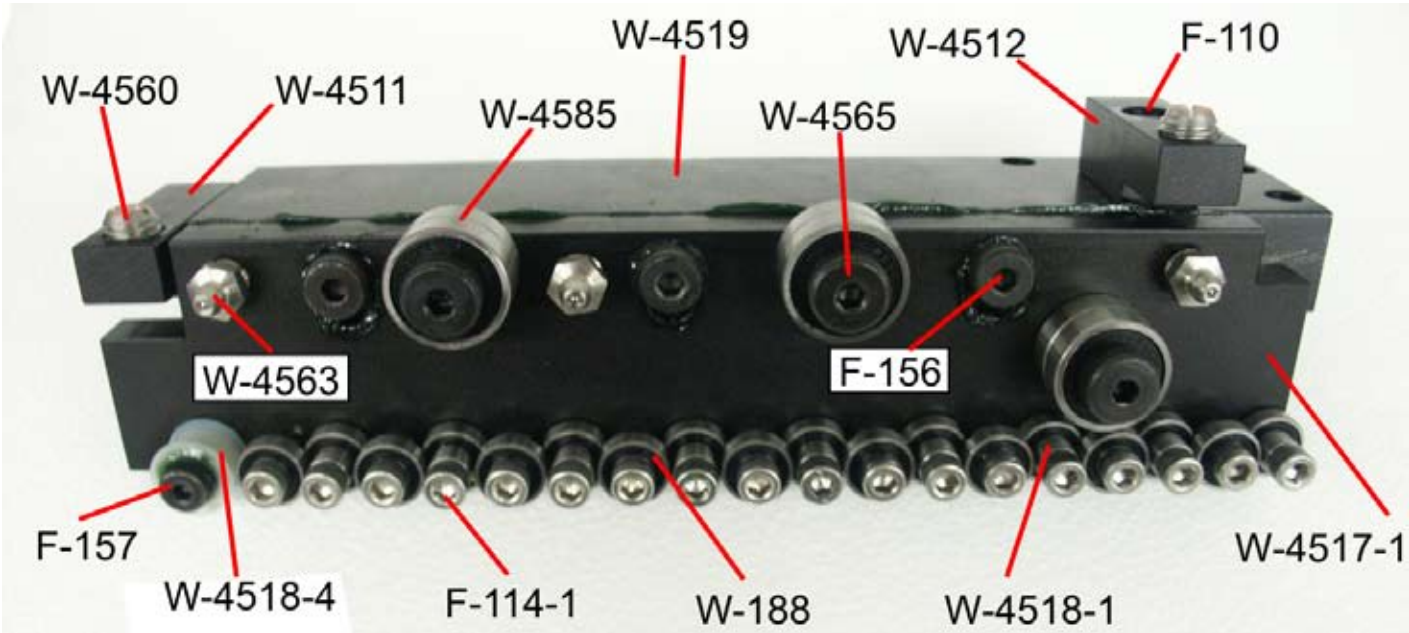
ELECTRICAL PANEL PARTS LIST

QTY	PART NUMBER	DESCRIPTION
8	A-5755	FUSE BLOCK
1	A-5756	END COVER
.66	A-6753	FUSE BLOCK
2	A-6753-1	FUSE BLOCK COVER
2	A-6754-2	15 AMP FUSE
2	W-289-2	2 AMP FUSE
2	W-289-3	3 AMP FUSE
4	W-289-8	8 AMP FUSE
1	W-1463	FEMALE TERMINAL BLOCK
2	W-1463-1	ADAPTER FEET FOR TERMINAL
1	W-1464	MALE TERMINAL BLOCK
.5	W-1465	PHOENIX TRACK
2	W-3002-6.5	OVERLOAD RELAY
2	W-4575	MOTOR STARTERS
1	W-4577	POWER RELAY
1	W-4579	SPEED CONTROL DRIVE



KKG-1 KEY KNIFE GRINDER

REAR DRIVE ASSEMBLY



KKG-1 KEY KNIFE GRINDER

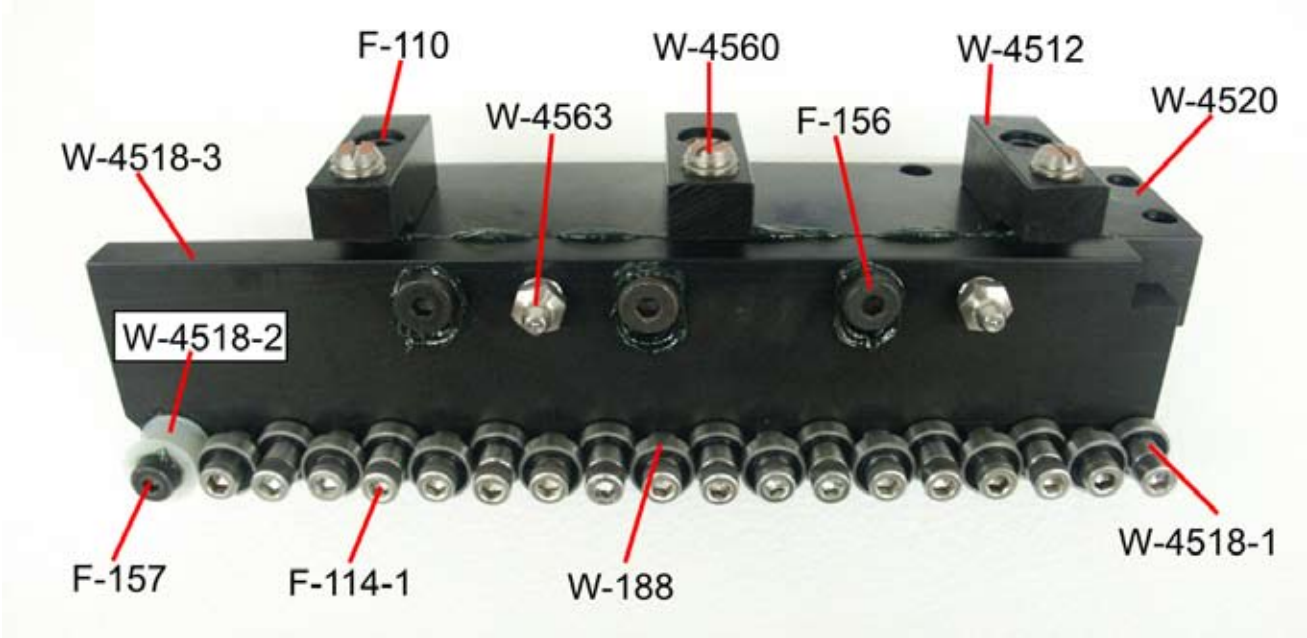
REAR DRIVE ASSEMBLY CONT,

QTY	PART NUMBER	DESCRIPTION
9	F-61-M	# 12 WASHER
1	F-110	1/4-20 SHCS
18	F-114-1	1/4-20 X 1 SHCS
3	F-156	3/8 X 1/2 SHOULDER BOLT
1	F-157	5/16 X 1/2 SHOULDER BOLT
18	W-188	BEARING
1	W-4511	GUIDE BLOCK "A"
1	W-4512	GUIDE BLOCK "B"
1	W-4517-1	REAR BEARING SUPPORT
9	W-4518-1	SPACER
1	W-4518-2	BELT GUIDE
1	W-4519	BACK BEARING BRACE
2	W-4560	BALL NOSE SPRING PLUNGER
3	W-4563	1/8 GREASE ZIRK
3	W-4565	8mm X 1.25 SHOULDER BOLT
6	W-4585	GUIDE BEARINGS



KKG-1 KEY KNIFE GRINDER

FRONT DRIVE ASSEMBLY



KKG-1 KEY KNIFE GRINDER

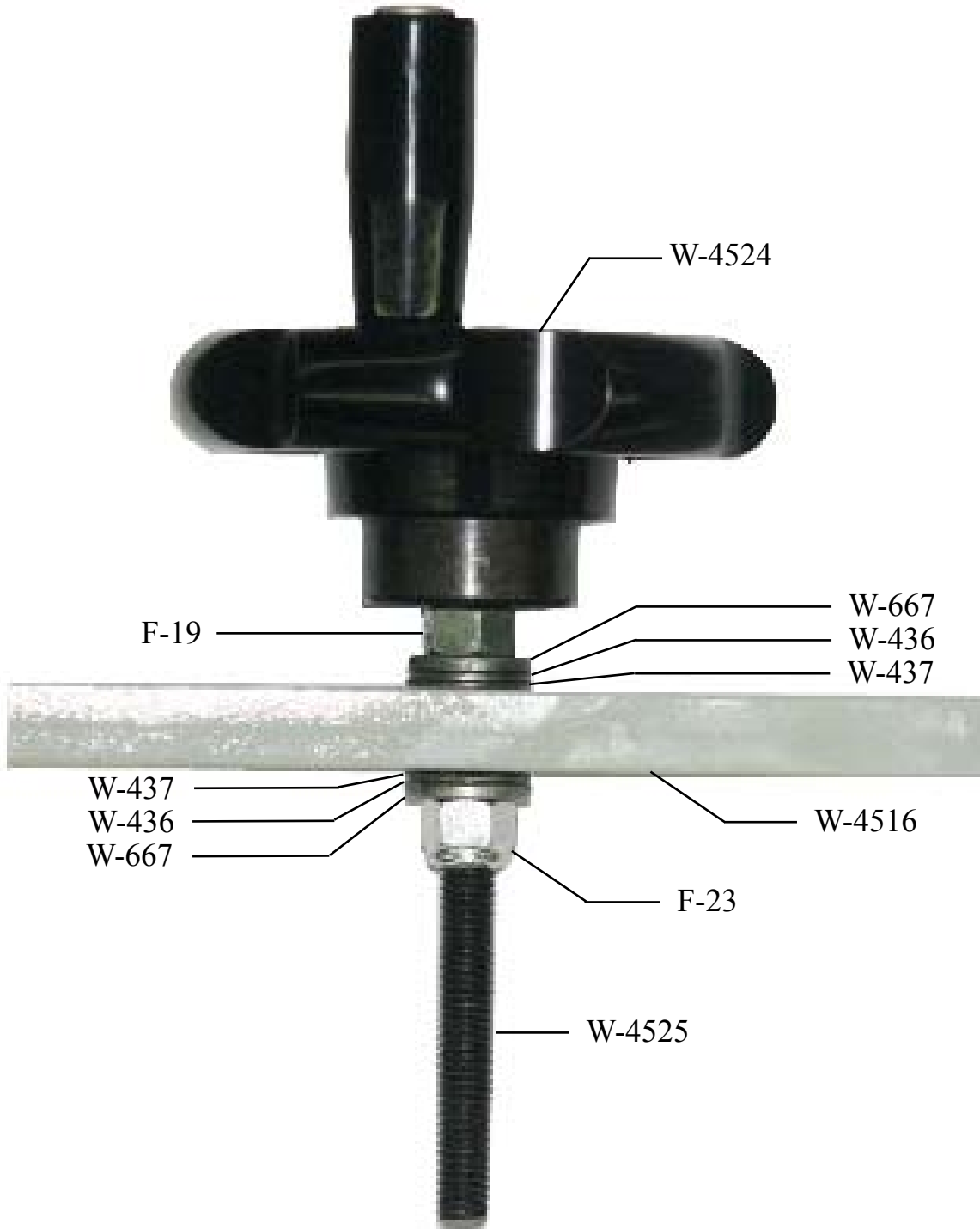
FRONT DRIVE ASSEMBLY CONT,

QTY	PART NUMBER	DESCRIPTION
3	F-110	1/4-20 SHCS
18	F-114-1	1/4-20 X 1 SHCS
3	F-156	3/8 X 1/2 SHOULDER BOLT
1	F-157	5/16 X 1/2 SHOULDER BOLT
3	W-4512	GUIDE BLOCK "B"
9	W-4518-1	SPACER
1	W-4518-3	BELT GUIDE
1	W-4518-3	FRONT BEARING SUPPORT
1	W-4520	FRONT BEARING BRACE
3	W-4560	BALL NOSE SPRING PLUNGER
2	W-4563	1/8 GREASE ZIRK
18	W-188	BELT TENSIONER BEARINGS



KKG-1 KEY KNIFE GRINDER

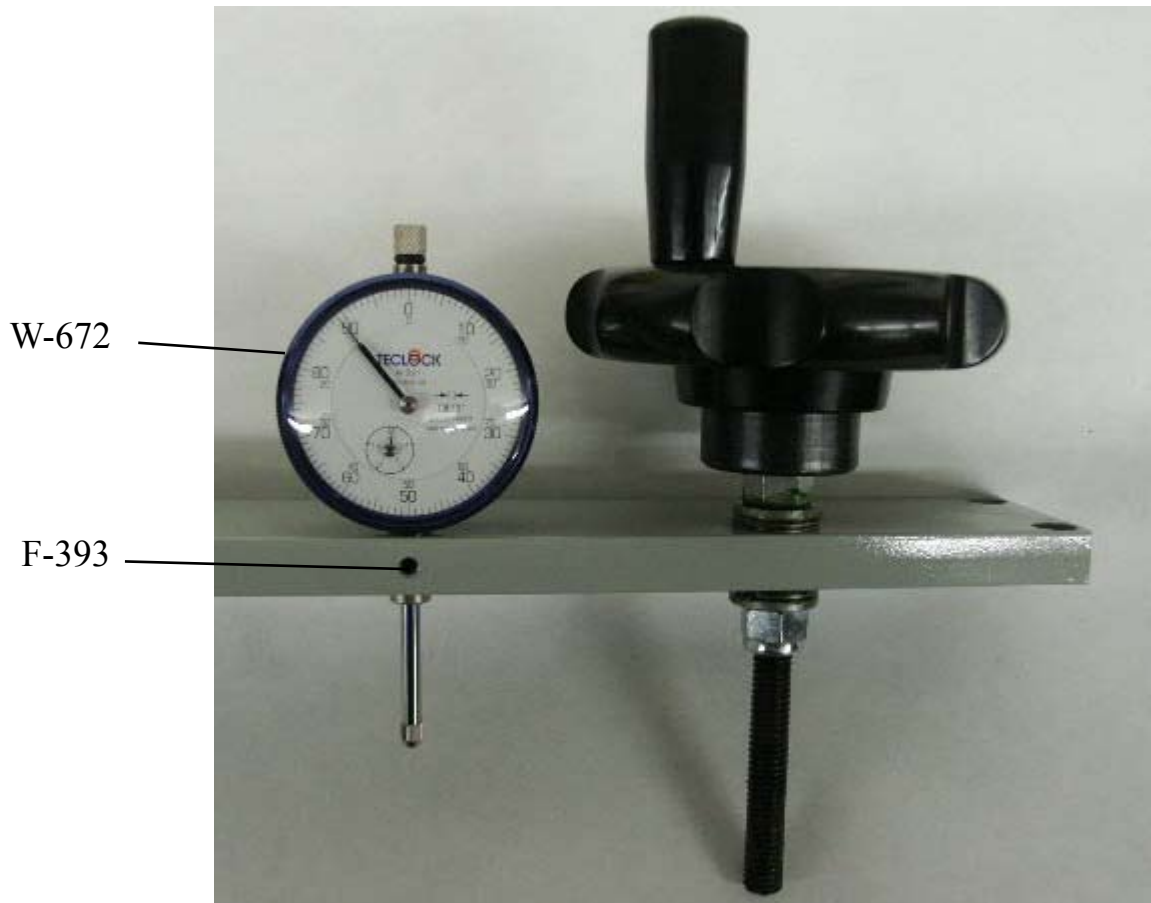
MOTOR ADJUSTMENT HANDLE



KKG-1 KEY KNIFE GRINDER

MOTOR ADJUSTMENT HANDLE CONT,

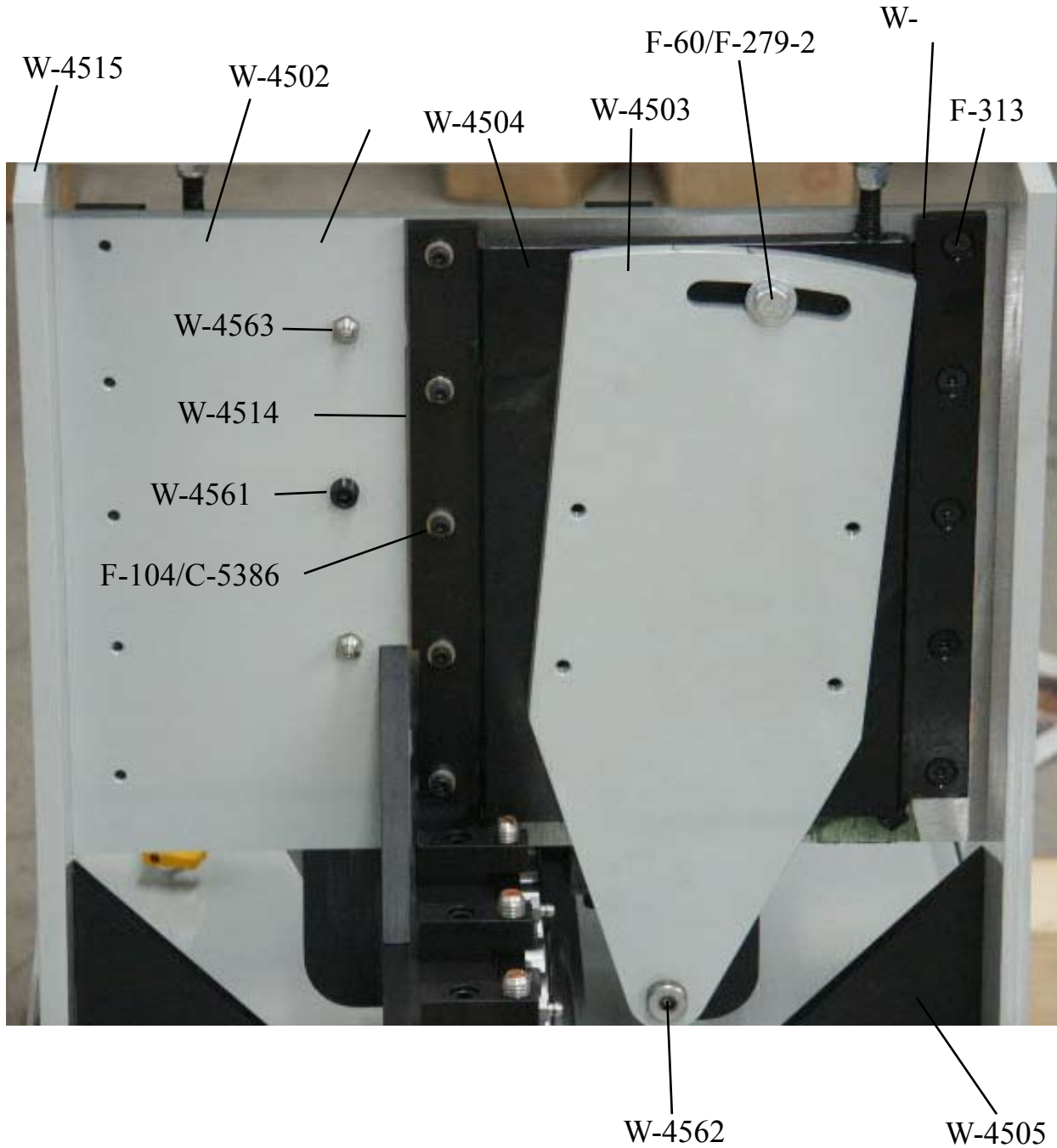
QTY	PART NUMBER	DESCRIPTION
2	F-19	3/8-16 NUT
2	F-23	3/8-16 NYLOCK NUT
2	F-393	10-24 SET SCREW
4	W-436	3/8 BEARING
4	W-437	THIN 3/8 GROUND WASHER
4	W-667	THICK 3/8 GROUND WASHER
2	W-672	DIAL INDICATOR
1	W-672-E	INDICATOR EXTENSION (AS NEEDED)
1	W-4516	INDICATOR / HANDLE SUPPORT
2	W-4524	HANDLE
2	W-4525	THREAD ROD



WM **W**RIGHT **M**ACHINE

KKG-1 KEY KNIFE GRINDER

MOTOR ADJUSTMENT & SUPPORT



KKG-1 KEY KNIFE GRINDER

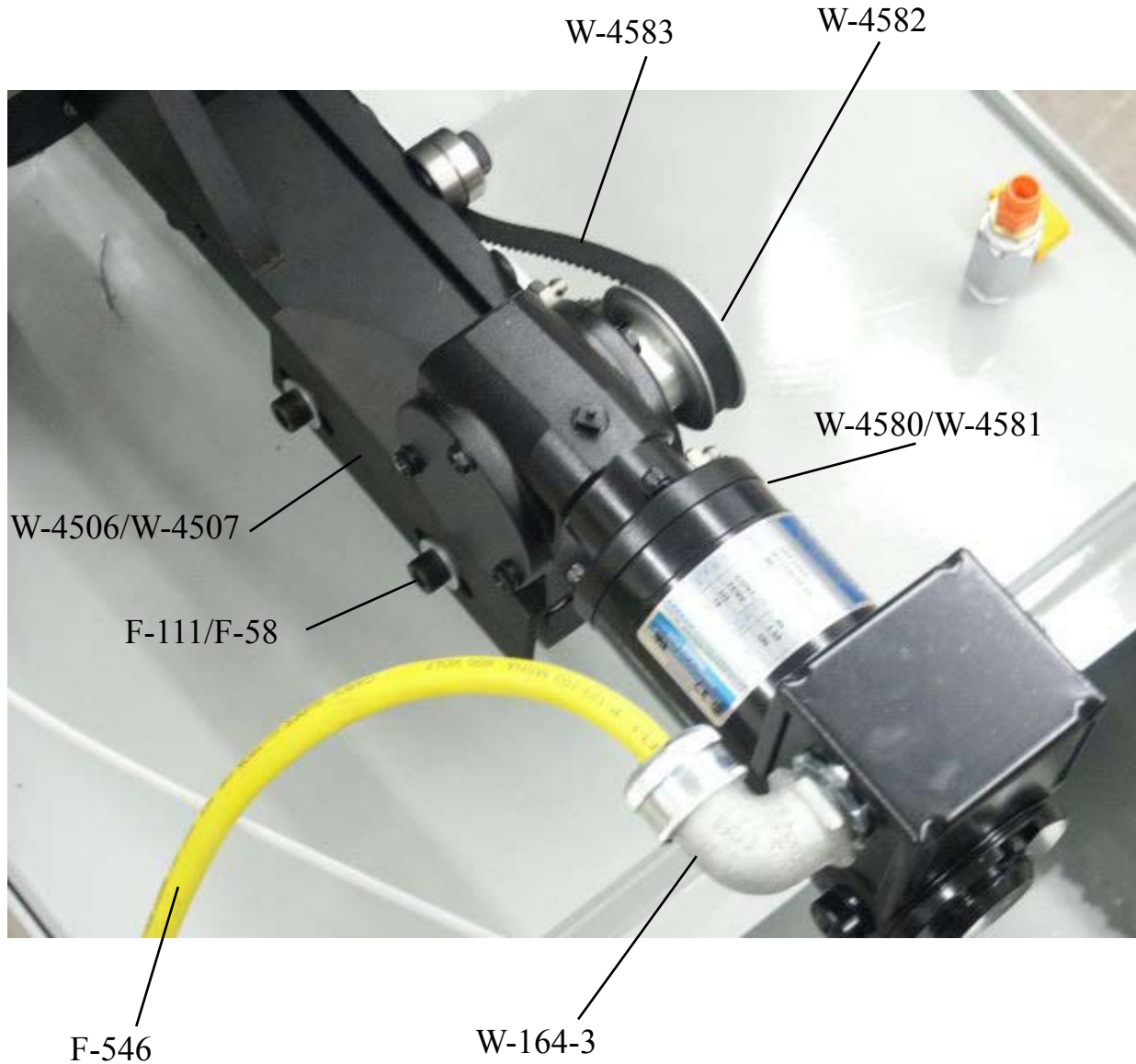
MOTOR ADJUSTMENT & SUPPORT CONT,

QTY	PART NUMBER	DESCRIPTION
2	F-60	5/16 WASHER
10	F-104	1/4-20 X 1 SHCS
2	F-279-2	3/8-16 X 3/4 HEX
10	F-313	1/4-20 X 3/4 FHCS
10	C-5386	SPACER
1	W-4502	BASE PLATE
2	W-4503	MOTOR SUPPORT
2	W-4504	MOTOR PLATE ADJUSTMENT
4	W-4505	BRACE
2	W-4513	OUTSIDE SLIDE
2	W-4514	INSIDE SLIDE
2	W-4515	LATERAL SUPPORT
2	W-4561	1/2-13 SET SCREW
2	W-4562	3/8-16 SHOULDER BOLT
4	W-4563	1/8 GREASE ZIRK



KKG-1 KEY KNIFE GRINDER

DRIVE MOTOR PARTS LIST



KKG-1 KEY KNIFE GRINDER

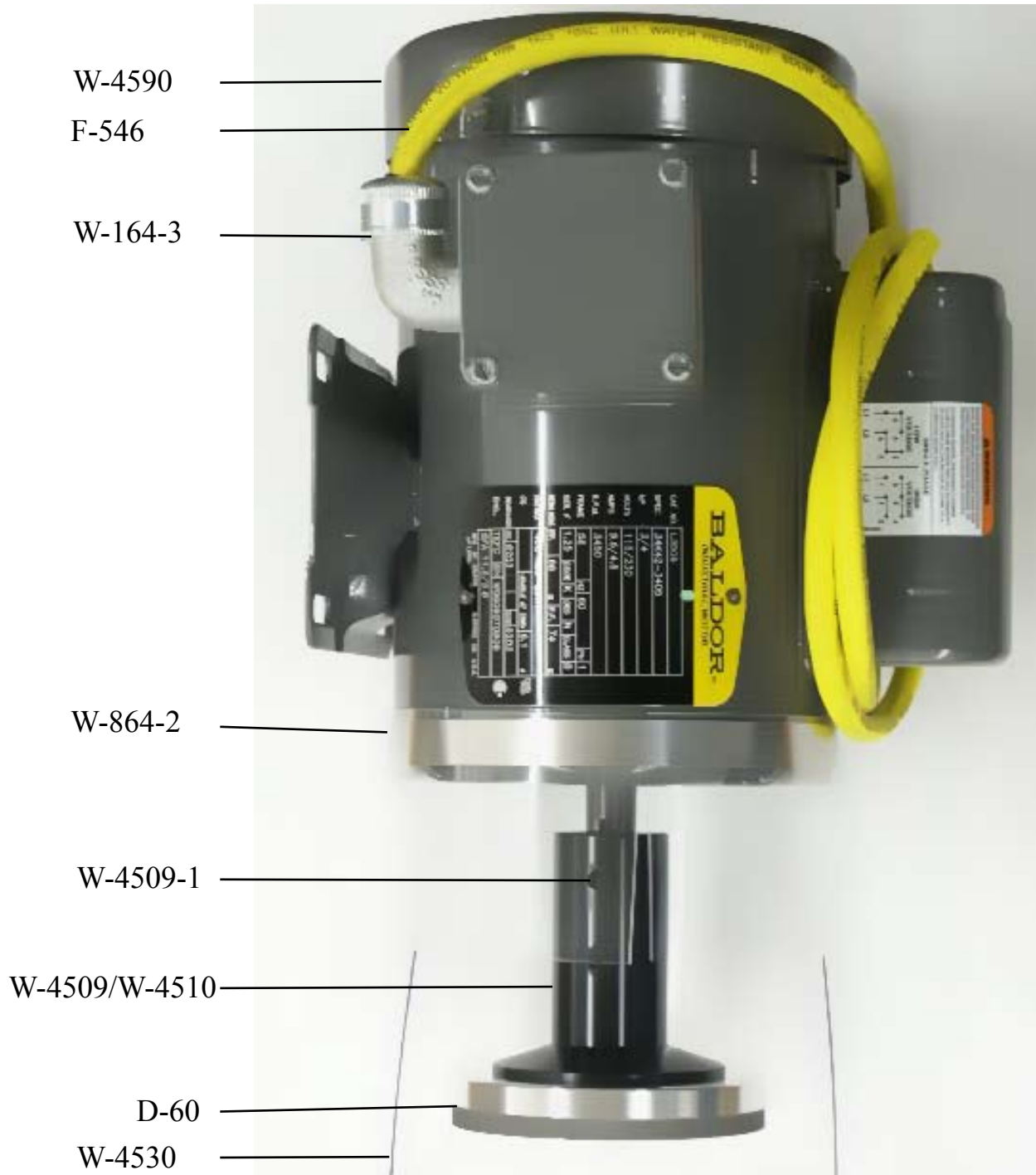
DRIVE MOTOR PARTS LIST CONT,

QTY	PART NUMBER	DESCRIPTION
2	F-58	1/4 WASHER
2	F-111	5/16-18 X 1 SHCS
1	F-546	POWER CABLE
1	W-164-3	CORD GRIP
1	W-4506	MOTOR SUPPORT SPACER
1	W-4507	MOTOR SUPPORT
1	W-4580	DRIVE MOTOR
1	W-4581	MOTOR BOX
1	W-4582	DRIVE MOTOR PULLEY
1	W-4583	DRIVE BELT.



KKG-1 KEY KNIFE GRINDER

SPINDLE MOTOR



KKG-1 KEY KNIFE GRINDER

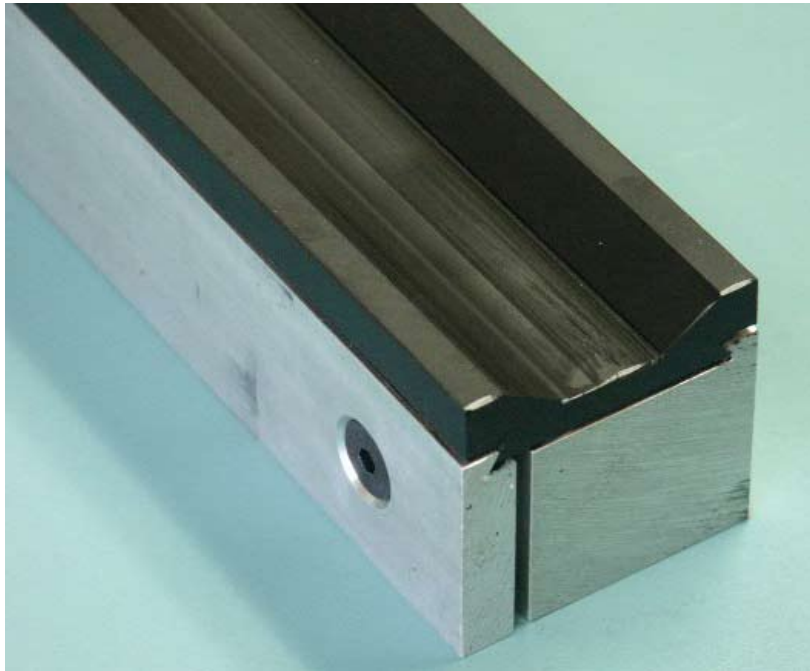
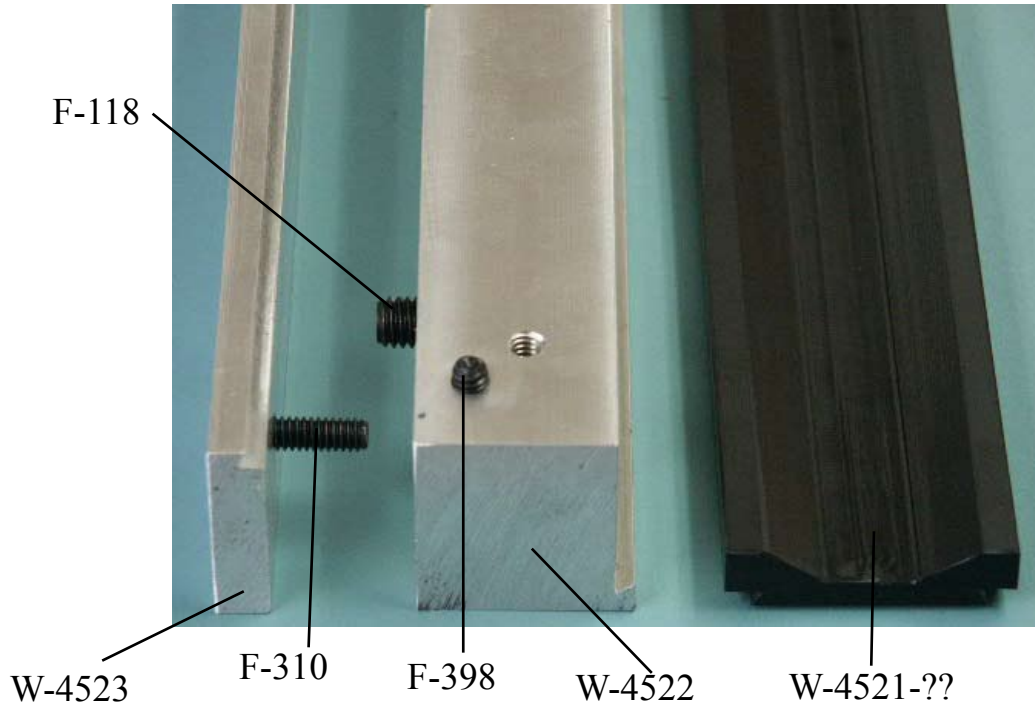
SPINDLE MOTOR CONT,

QTY	PART NUMBER	DESCRIPTION
2	D-60	GRINDING WHEEL
2	F-546	POWER CABLE
2	W-164-3	CORD GRIP
2	W-864-2	HOSE CLAMP
2	W-4509	SPINDLE HUB
4	W-4509-1	SET SCREW
2	W-4509-3	SPINDLE HUB SPACER
2	W-4510	GRINDING WHEEL WASHER
2	W-4530	SPLASH GUARD
2	W-4590	SPINDLE MOTOR



KKG-1 KEY KNIFE GRINDER

KNIFE TRACK AND HOLDER



KKG-1 KEY KNIFE GRINDER

KNIFE TRACK AND HOLDER CONT,

QTY	PART NUMBER	DESCRIPTION
3	F-118	3/8-16 X 1-1/4 SHCS
3	F-310	1/4-20 X 1 FHCS
3	F-398	1/4-20 X 1 SET SCREW
1	W-4521	KNIFE SLIDE
1	W-4521-2	KNIFE SLIDE
1	W-4521-3	KNIFE SLIDE
1	W-4522	KNIFE SLIDE HOLDER 2.0 width
1	W-4523	KNIFE SLIDE CLAMP

OPTIONAL SLIDES

QTY	PART NUMBER	DESCRIPTION
1	W-4521-A	KNIFE SLIDE 1.5 width holder
1	W-4521-1	KNIFE SLIDE 2.0 width holder
1	W-4521-2A	KNIFE SLIDE 1.5 width holder
1	W-4521-5	KNIFE SLIDE 1.5 width holder
1	W-4521-7	KNIFE SLIDE 2.0 width holder
1	W-4521-10	KNIFE SLIDE 1.5 width holder
1	W-4521-10A	KNIFE SLIDE 2.0 width holder
1	W-4521-11	KNIFE SLIDE 1.5 width holder
1	W-4521-11A	KNIFE SLIDE 2.0 width holder
1	W-4521-12	KNIFE SLIDE 1.5 width holder
1	W-4521-12A	KNIFE SLIDE 2.0 width holder
1	W-4521-14	KNIFE SLIDE 1.5 width holder
1	W-4521-15	KNIFE SLIDE
1	W-4521-16	KNIFE SLIDE 1.5 width holder
1	W-4521-17	KNIFE SLIDE 1.5 width holder
1	W-4521-18	KNIFE SLIDE 1.5 width holder
1	W-4521-19	KNIFE SLIDE 2.0 width holder
1	W-4521-20	KNIFE SLIDE 2.0 width holder
1	W-4521-22	KNIFE SLIDE 1.5 width holder
1	W-4521-23	KNIFE SLIDE 2.0 width holder
1	W-4521-24	KNIFE SLIDE 2.0 width holder

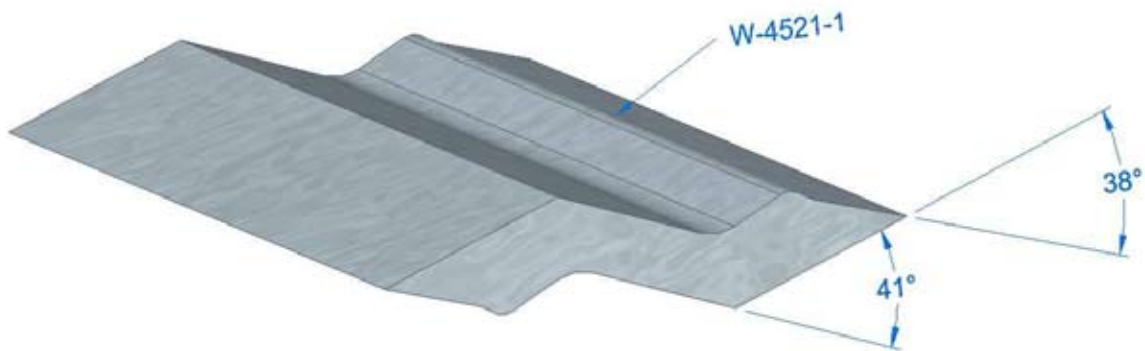
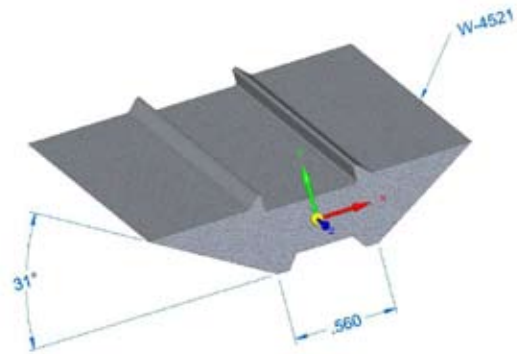
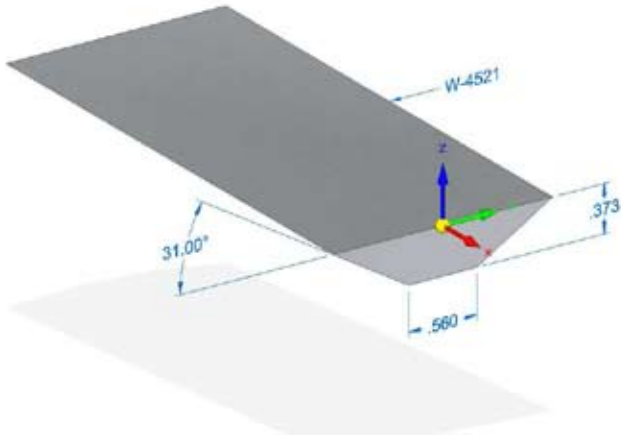
OPTIONAL HOLDERS

QTY	PART NUMBER	DESCRIPTION
1	W-4522-8	KNIFE SLIDE HOLDER
1	W-4523-1	KNIFE SLIDE HOLDER 1.5 width

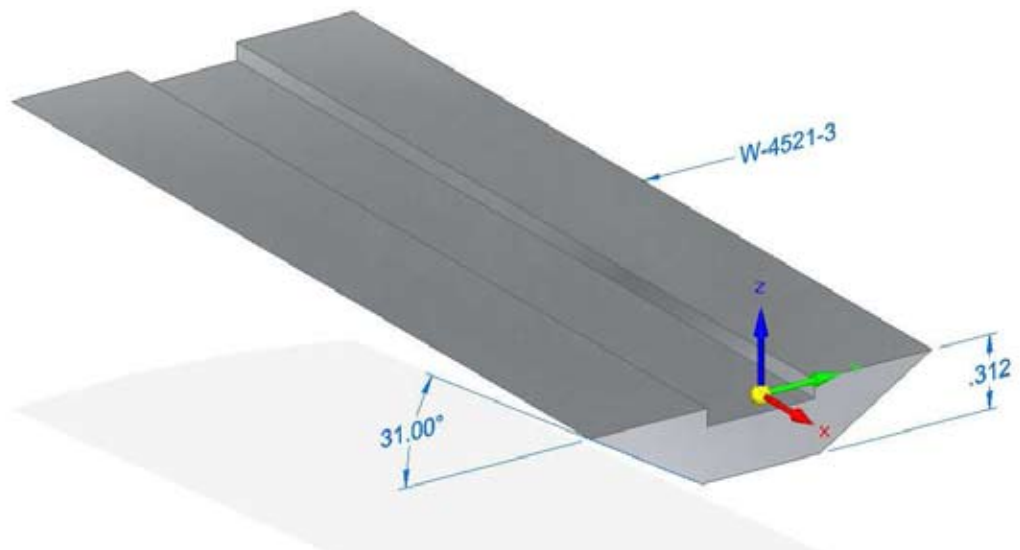
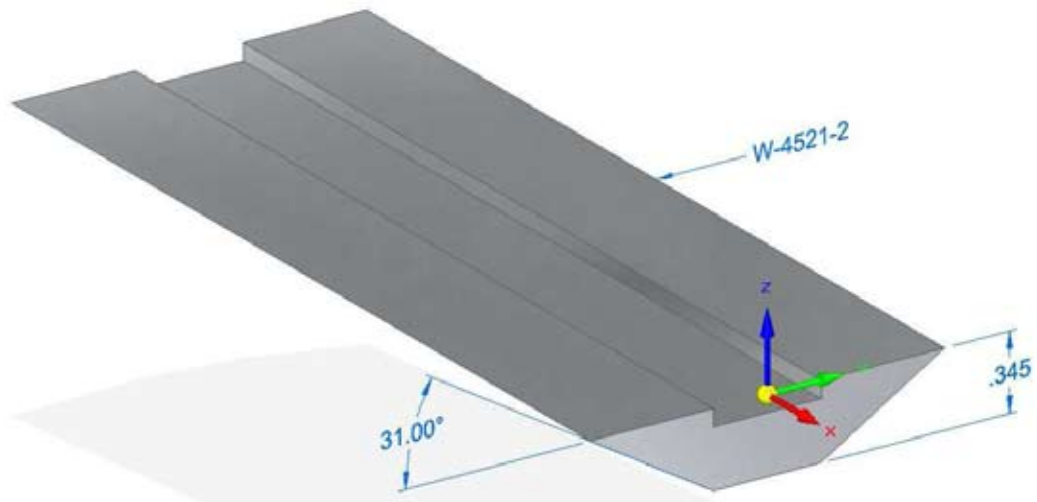


KKG-1 KEY KNIFE GRINDER

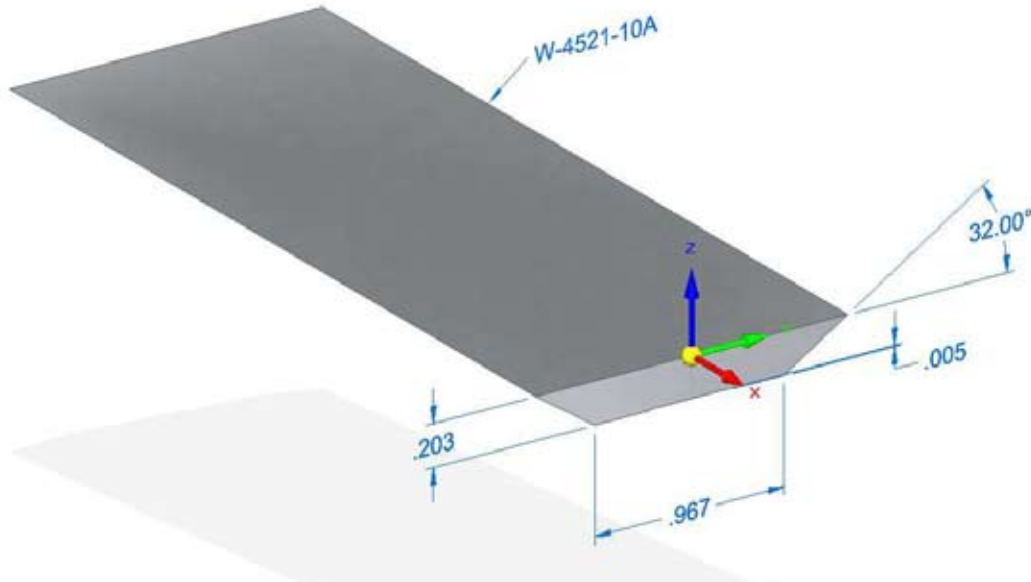
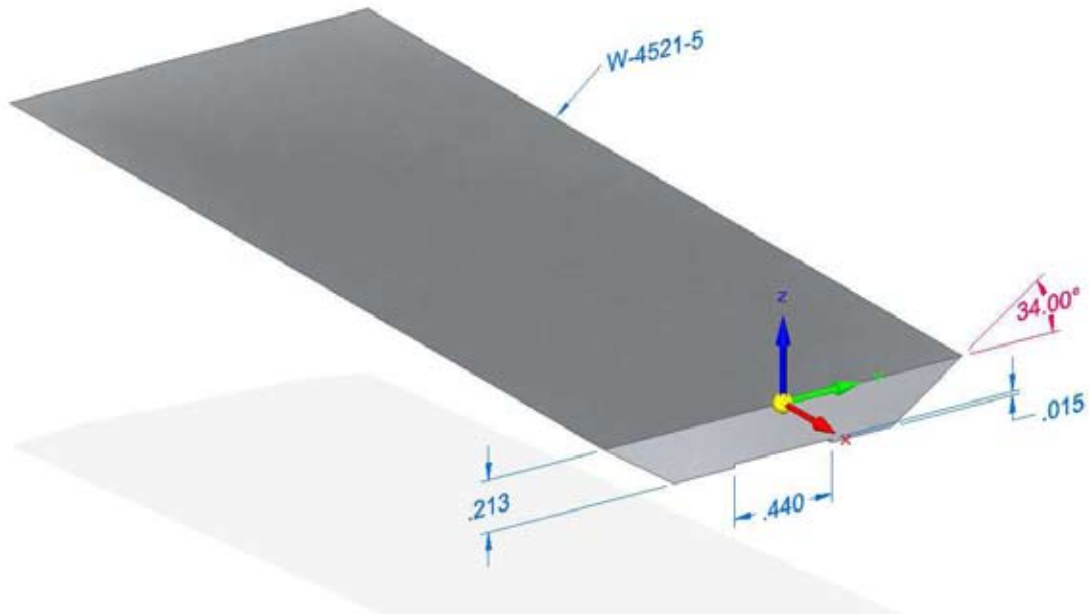
OPTIONAL KNIVES



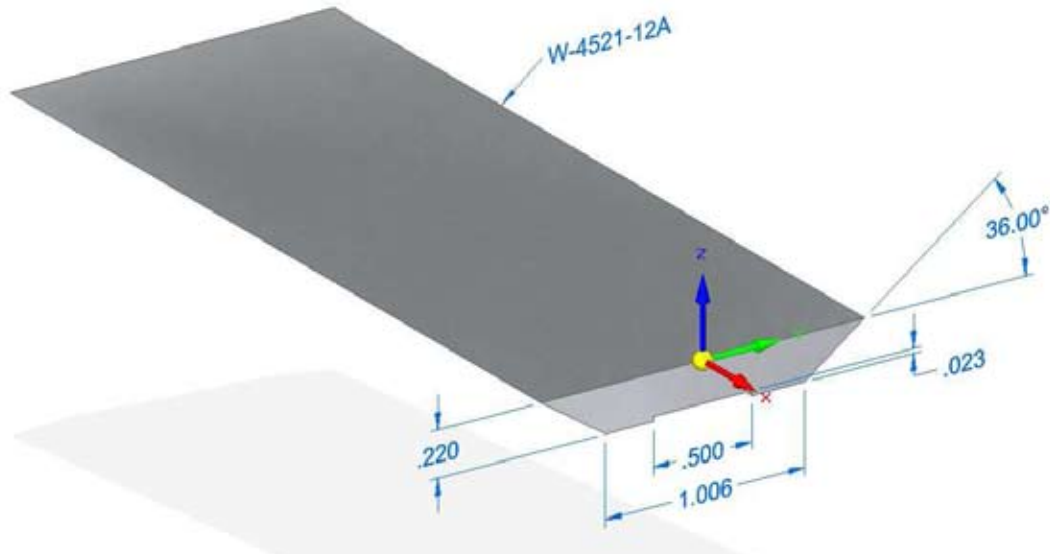
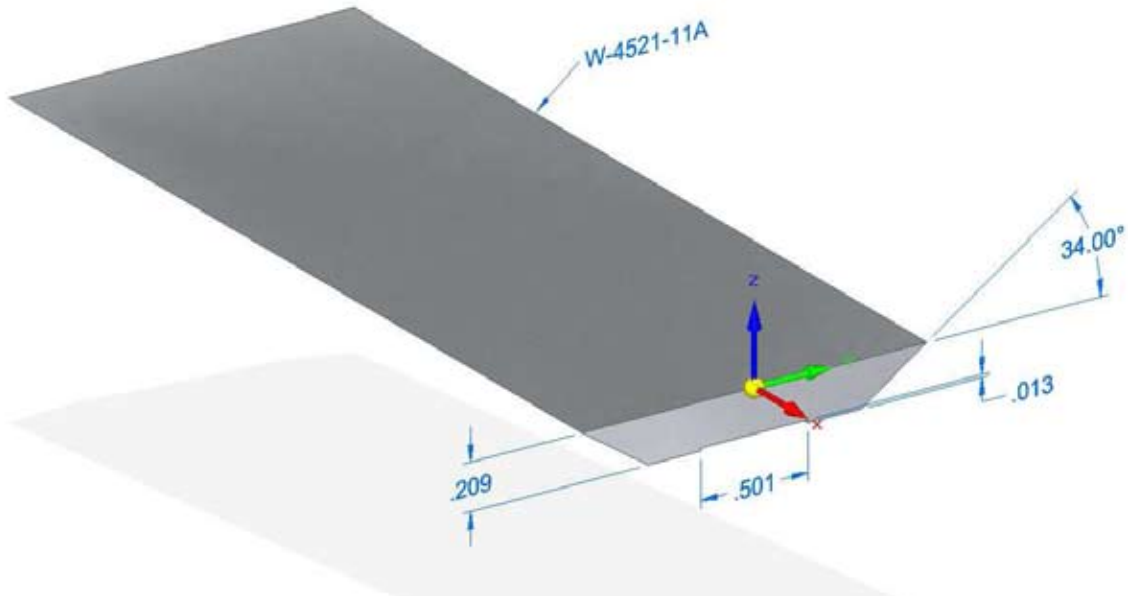
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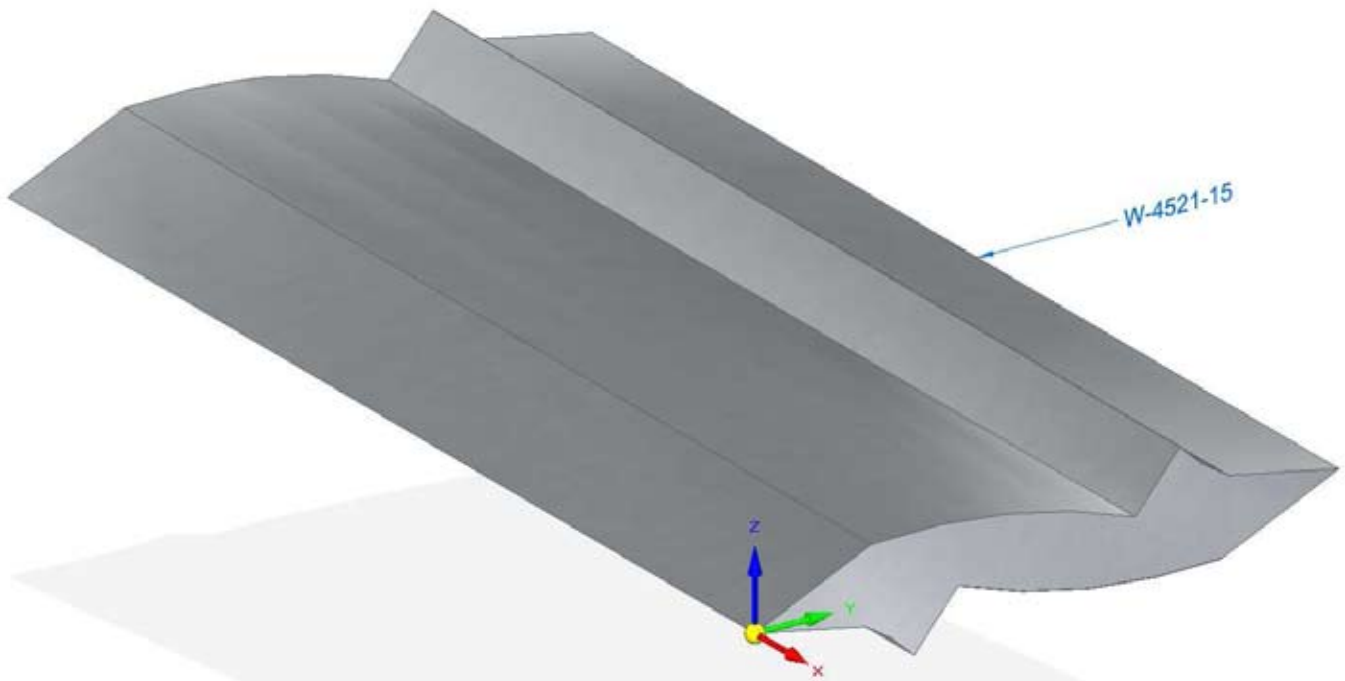
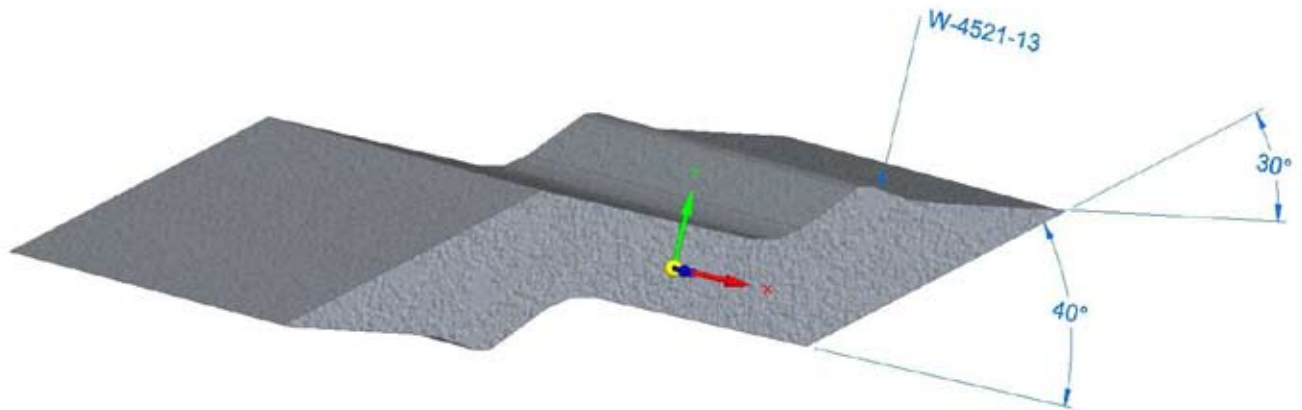
KKG-1 KEY KNIFE GRINDER



KKG-1 KEY KNIFE GRINDER

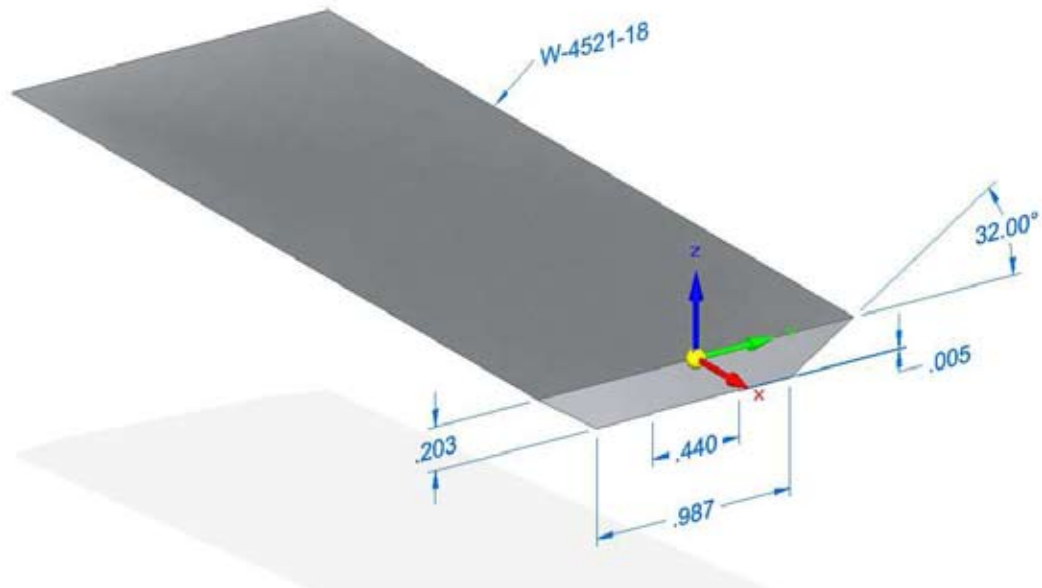
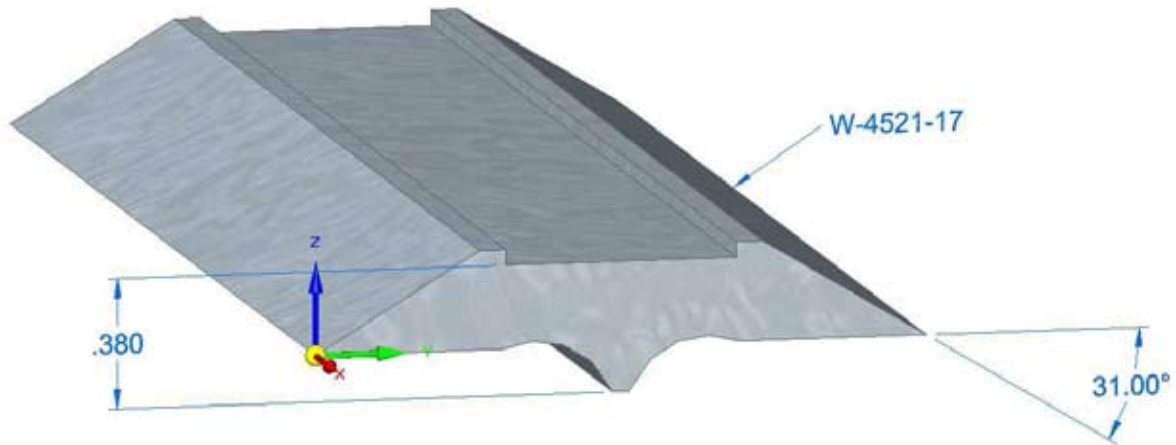


KKG-1 KEY KNIFE GRINDER



WM **W** RIGHT **M**ACHINE

KKG-1 KEY KNIFE GRINDER



KKG-1 KEY KNIFE GRINDER

