

MAINTENANCE INSTRUCTIONS

HANCHETT



KNIFE GRINDER

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AK MAINTENANCE - QUICK REFERENCE GUIDE

A regular maintenance schedule should be implemented.
We recommend the following service schedule.

DAILY

Turn the handle on top of the Way Lube Filter a couple of turns.

This will clean the filter of any particles that accumulated the day before.

Check the flow of way oil to the base way.

Adjust the flow as necessary by turning the valve located in the access hole in the base below the oil holes in the ways.

Grease the knife bar caps until clean grease is squeezed out the side of the caps.

The previous days grinding grit and coolant will work its way under the cap. This greasing will flush the grit out.

Ensure proper lube oil and coolant levels.

WEEKLY

Open the drain valve on the side of the way oil tank.

This will drain any water that has accumulated. Close the drain once oil is present.

Grease the knife bar turning mechanism.

Coolant, as well as everyday use will wash this grease away.

Lubricate the drive rack with an open gear lube.

We recommend a Kendall Oil SX-12X or equivalent.

Open the valve on the bottom of the way oil filter.

This will allow the contaminants to be drained from the valve housing.

MONTHLY

Grease the Cross Slide and Crossfeed Nut.

These fittings are all located on the side of the Cross Slide.

It may be necessary to move the Cross Slide back and forth to get the fittings to accept the grease.

Grease the Wheel Dresser.

Check the leveling blocks to make sure they are supporting weight.

THREE MONTHS

Grease the Grinding Spindle bearings.

Grease the Electric Motors if they can be greased.

Clean the coolant tank.

Drain the old coolant from the tank.

Remove the swarf and contamination that has settled on the bottom of the tank.

Clean the tank and refill with fresh Red Anchor II Synthetic Grinding Compound.

SIX MONTHS

Clean the Way Oil Lube Tank.

Drain the tank of all oil.

The return lines should be flushed with solvent.

The supply lines can be cleaned by air pressure.

Plug the holes leaving open only the hole in the way you are cleaning.

Blow all lines back to the tank before cleaning tank.

Clean all the sludge out of the oil pockets.

Clean out the tank. Fill the system with fresh Mobil Vactra #4.

Check the level of the machine.

Adjust the base leveling blocks as necessary.

Quick Reference Lubrication and Service Sheet For Hanchett AK Style Knife Grinders

Way Oil

Way oil should be replaced every 4 months with Mobil Vactra 4 Oil. When changing the way oil, clean the Cuno filter by first changing the oil then removing the drain plug on the filter. Turn on the oil pump and let old oil and sludge clear out until clean oil appears. Additionally, remove the 6 cap screw bolts on the top of the check valve, the cover, the check valve spring, and the poppet. These parts should be cleaned and re-installed. The poppet should move freely inside the shaft hole. The lube pump should deliver 9 lb to 12 lb pressure as measured by the gauge. If more is needed the spring of the check valve can be stretched. Just a little stretch will increase the pressure considerably. If less is needed the spring can be cut. After the oil has been changed all of the distribution ports should be re-adjusted to be sure a small amount of oil is delivered to the ways.

* Water should be drained from the way oil tank daily through the pet cock located on the bottom of the tank.

Transmission Oil

The transmission oil should be replaced every 6 months with Mobil Vactra BB. If the oil is foaming, water has been mixed with the oil and replacement is necessary. Replace the seals & gaskets as needed to stop water infiltration. The oil level should be above the top most gear in the transmission. No other service is required.

Hydraulic Oil

The Hydraulic fluid should be replaced every 6 months with Mobil DTE 26 hydraulic fluid. When changing this fluid the filter located on the bottom of the return pipe should be removed and cleaned. The pump should deliver between 450 PSI and 700 PSI during normal operation. (At times the pressure can peak around 1200 PSI at reversals)

Grease Fittings

All grease fittings should be greased once every two weeks using BR-2 or EP-2 Grease. Be sure to grease all motors. Grease the spindle bearings with Lubriko M-6 Grease.

Coolant

The coolant tank should be completely drained and cleaned every 4 to 6 months. Be sure to clean on the bottom of the coolant pump as swarf will build up in the screen. Water can be added to maintain the proper mixture level. To test the proper mixture proceed as follows: Replace the coolant with the proper level to the most exact mixture possible. Before moving any of the coolant, test the coolant with a pH strip. Keep this strip as a guide for the future. At a later date test the coolant again with a pH strip and compare to the reference strip. Add coolant and/or water to bring to the correct mixture.

Other

Adjust side shields on chuck housing so that 1/2" of brush is cutting into the knives. Be sure that all lock downs are tightened on the knife bar before grinding.

OILS AND LUBRICANTS REQUIRED FOR AK KNIFE GRINDERS

Way Oil

SA00540J	1 Gallon Jug	Mobil Vactra #4 Way Oil
SA00541T	5 Gallon Jug	Mobil Vactra #4 Way Oil
SA01061S	55 Gallon Drum	Mobil Vactra #4 Way Oil

Hydraulic Oil

SA00544K	1 Gallon Jug	Mobil DTE 26 Oil
SA00545W	5 Gallon Jug	Mobil DTE 26 Oil
Call For Info	55 Gallon Drum	Mobil DTE 26 Oil

Coolant

SA00470S	1 Gallon Jug	Red Anchor Coolant
SA00471K	5 Gallon Jug	Red Anchor Coolant
SA00534H	55 Gallon Drum	Red Anchor Coolant

Coolant - Synthetic

COOLRA201	1 Gallon Jug	Red Anchor II Coolant
COOLRA205	5 Gallon Jug	Red Anchor II Coolant
COOLRA255	55 Gallon Drum	Red Anchor II Coolant

Transmission Oil

SA00542C	1 Gallon Jug	Mobil Vactra BB Way Oil
SA00543S	5 Gallon Jug	Mobil Vactra BB Way Oil
Call For Info	55 Gallon Drum	Mobil Vactra BB Way Oil

Grease

JDD0013F	1 Cartridge	Molykote BR-2 (General Purpose)
SAA0163Q	Call For Info	Lubriko M-6 (Spindle Bearings)