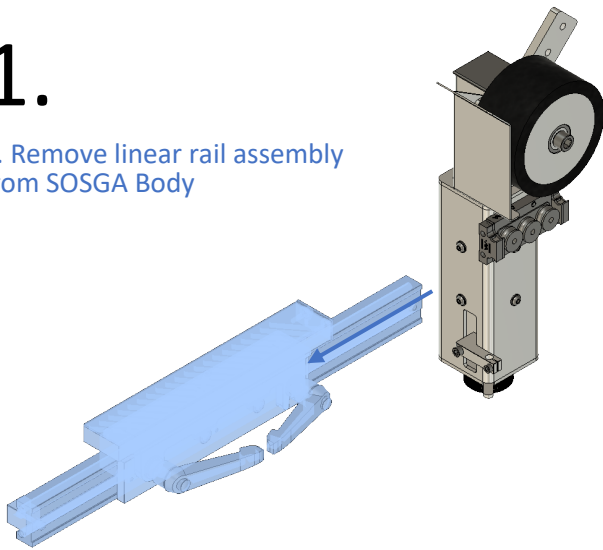


SOSGA Rail Adjustment Instructions

1.

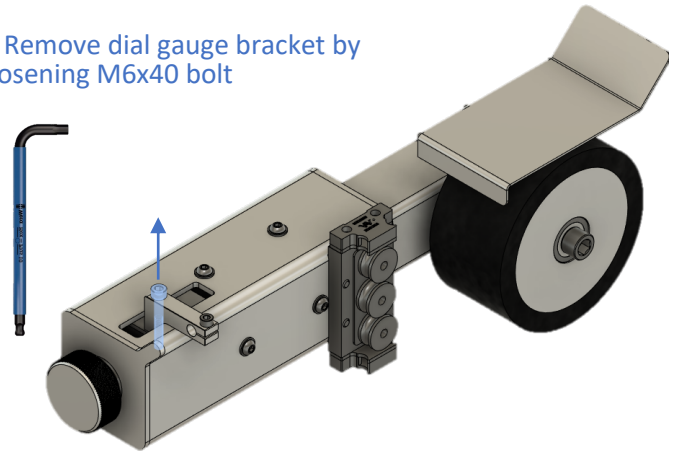
1. Remove linear rail assembly from SOSGA Body



2.

-H5 hex / allen key

1. Remove dial gauge bracket by loosening M6x40 bolt

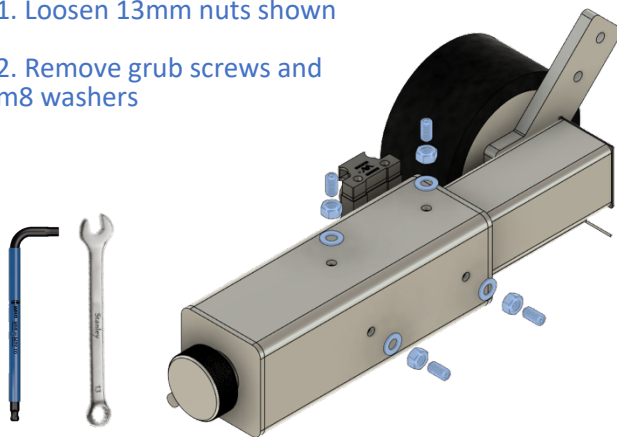


3.

-H4 hex / allen key
-13mm spanner/socket

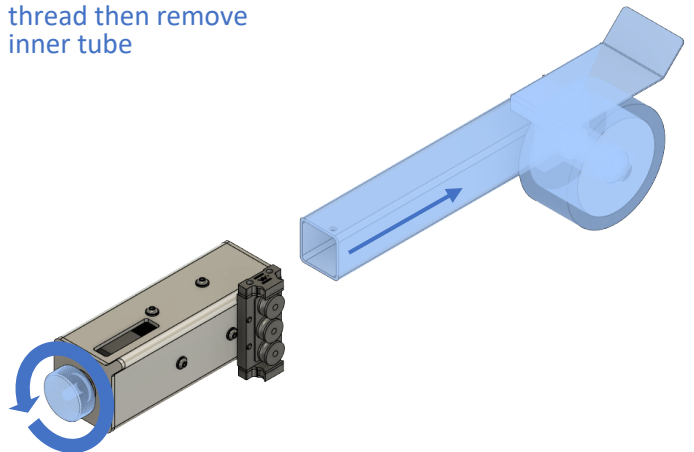
1. Loosen 13mm nuts shown

2. Remove grub screws and m8 washers



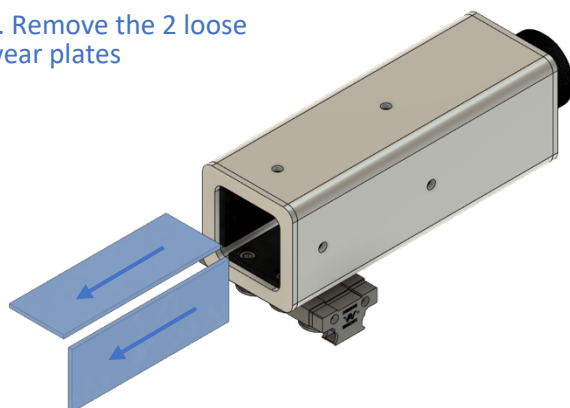
4.

1. Wind out SOSGA thread then remove inner tube



5.

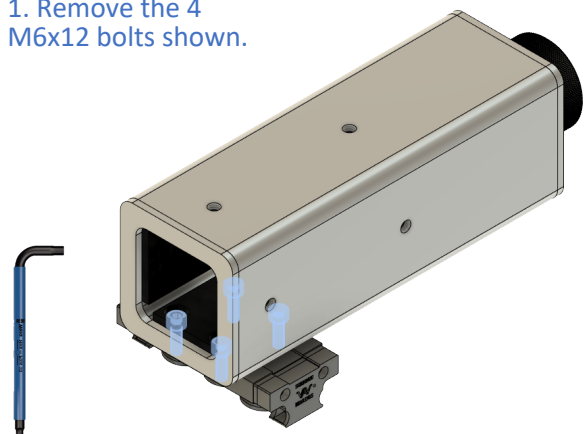
1. Remove the 2 loose wear plates



6.

-H5 hex / allen key

1. Remove the 4 M6x12 bolts shown.



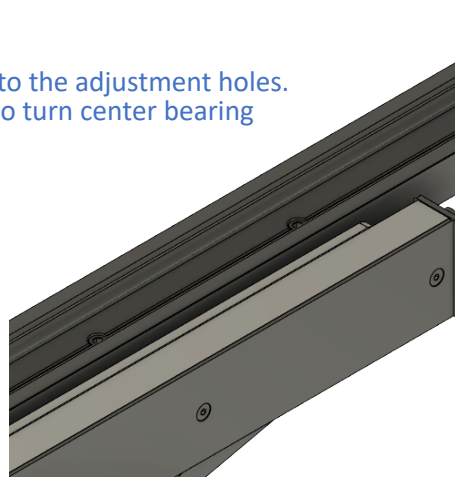
- 6.** -H2 hex / allen key
-2x 3mm drill bits
-Adjustable spanner

1. Slide block on and off the linear rail to feel adjustment. Block should require gentle push to 'pop' last bearing onto rail. If block slides on freely, bearings are too loose.

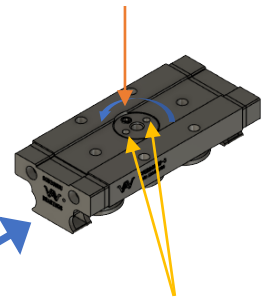
BE CAREFUL NOT TO OVERTIGHTEN AS THIS WILL CAUSE ALIGNMENT ISSUES ONCE RE-ASSEMBLED

2. Loosen locking grub screw

3. Insert 2x 3mm or 1/8" drill bits into the adjustment holes. Use adjustable wrench on drill bits to turn center bearing cam (VERY small adjustments).



Loosen this locking screw prior to adjusting



Insert drill bits into these holes to spin assembly

4. Make small adjustments in either direction.

3. Test by sliding onto rail after each adjustment and re-adjust until correct tolerance is achieved.

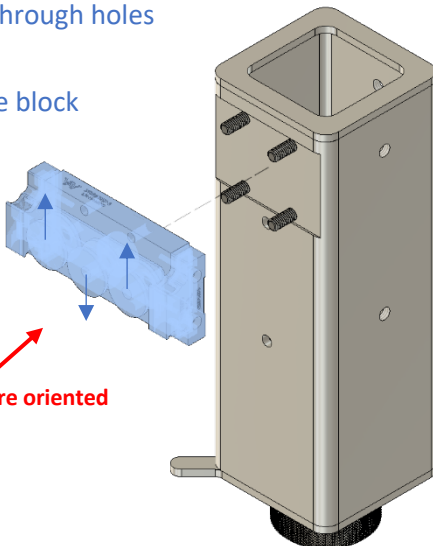
4. Re-tighten locking grub screw

SOSGA Re-assembly Instructions

- 7.** -4* 6x12 SHCS

1. Insert bolts through holes as shown.

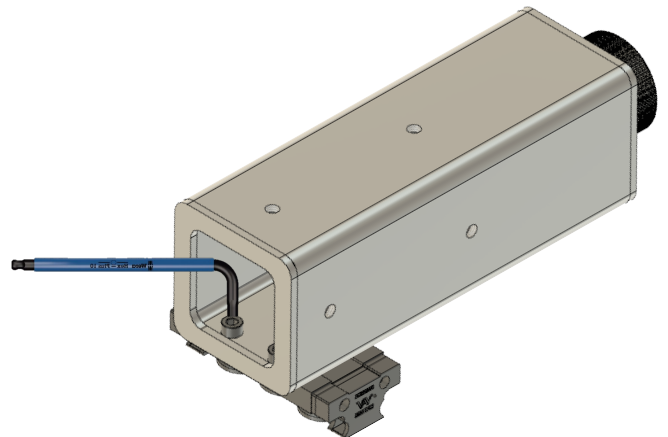
2. Offer up slide block



Ensure rollers are oriented as shown

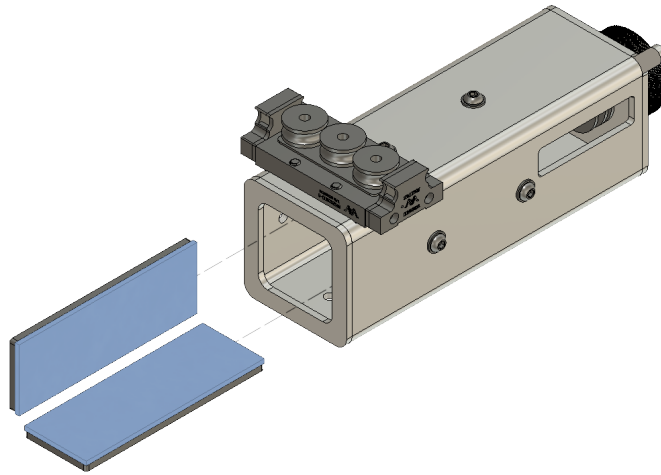
- 8.** -H5 hex / allen key

1. Install M6x12 bolts tightly



9. -wear plates

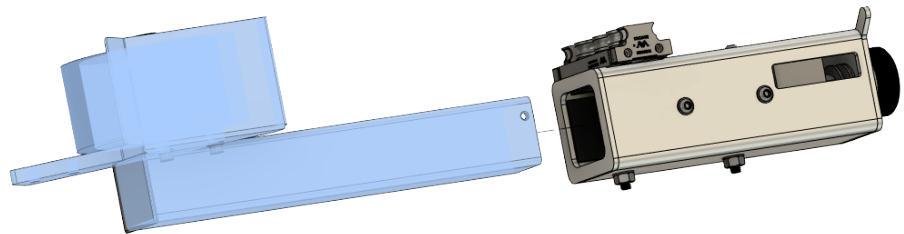
1. Re-install wear plates as shown



10. - 1* SOSGA inner tube

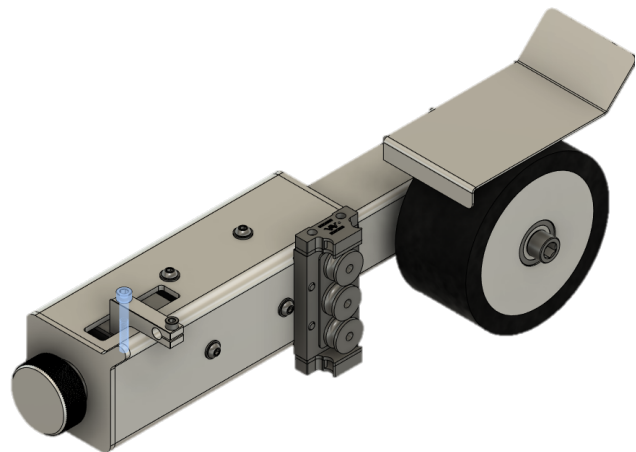
1. Slide inner tube into SOSGA body.
2. Wind knob to thread tube in.

Tip* tilt body 45° as shown to keep wear plates in place while inserting inner tube



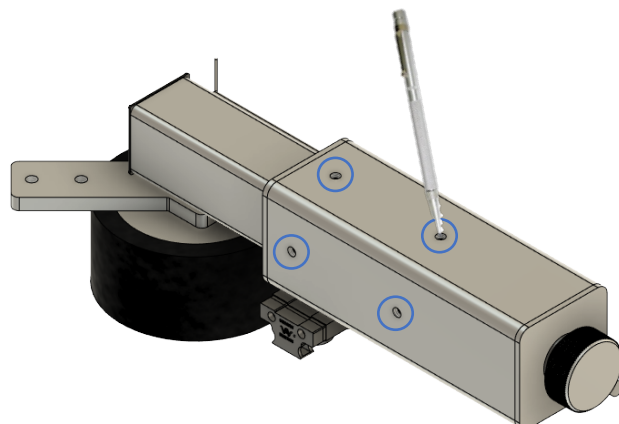
11. - H5 Hex / allen key

1. Re-install dial gauge bracket and 5x40 bolt. Ensure bracket is square to body.



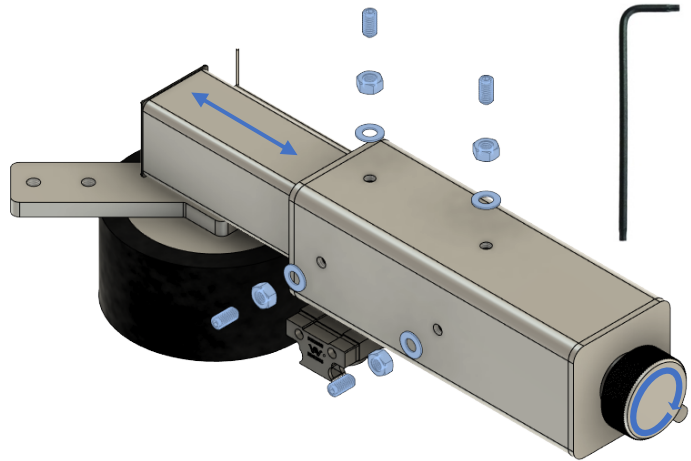
12. - Scribe or small screwdriver

1. Use scribe or small screwdriver to slide wear plates so that the holes line up with holes on the SOSGA body.



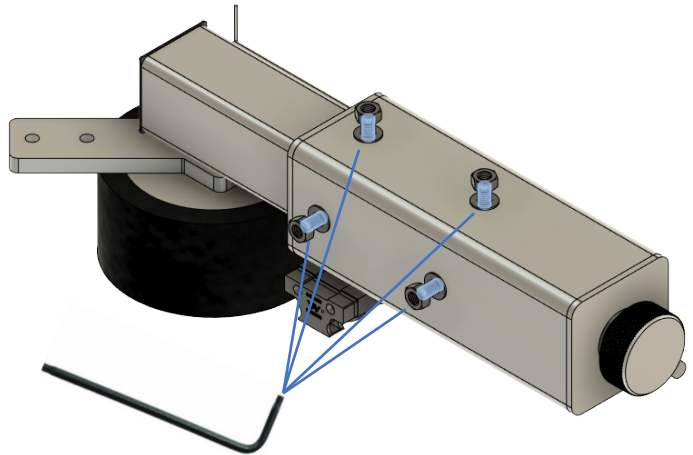
13. - H4 Hex / allan key

1. Install grub screws until lightly seated.
2. Install M8 washers & M8 nuts but leave backed off.
3. Wind SOSGA most of the way in



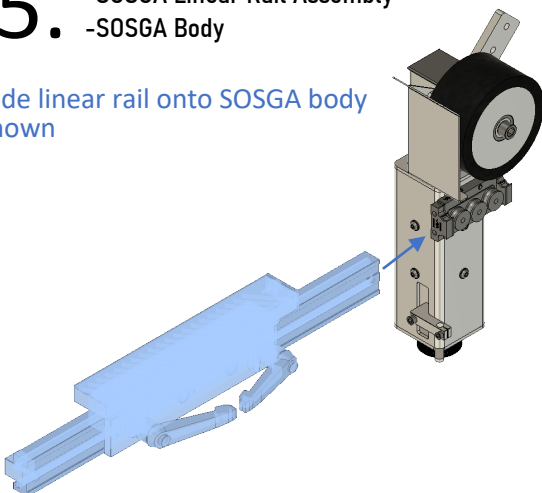
14. - H4 Hex / allan key

1. Adjust tension on grub screws (being careful to maintain even pressure between all 4 screws). Make small adjustments, testing after each adjustment, until tension on SOSGA knob matches tension prior to disassembly.
2. Once correct pressure is achieved, tighten M8 nuts to lock adjustment screws.

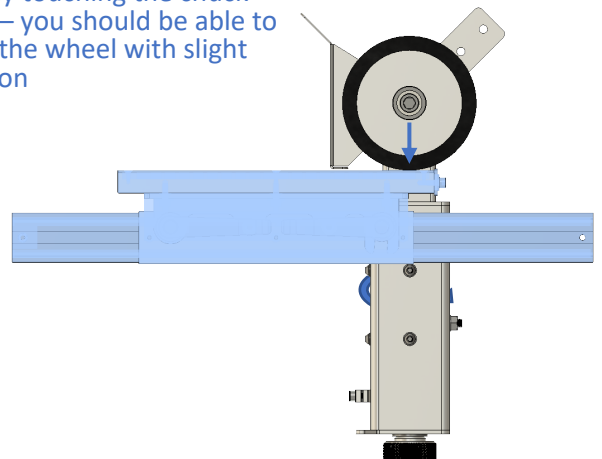


15. -SOSGA Linear Rail Assembly -SOSGA Body

1. Slide linear rail onto SOSGA body as shown

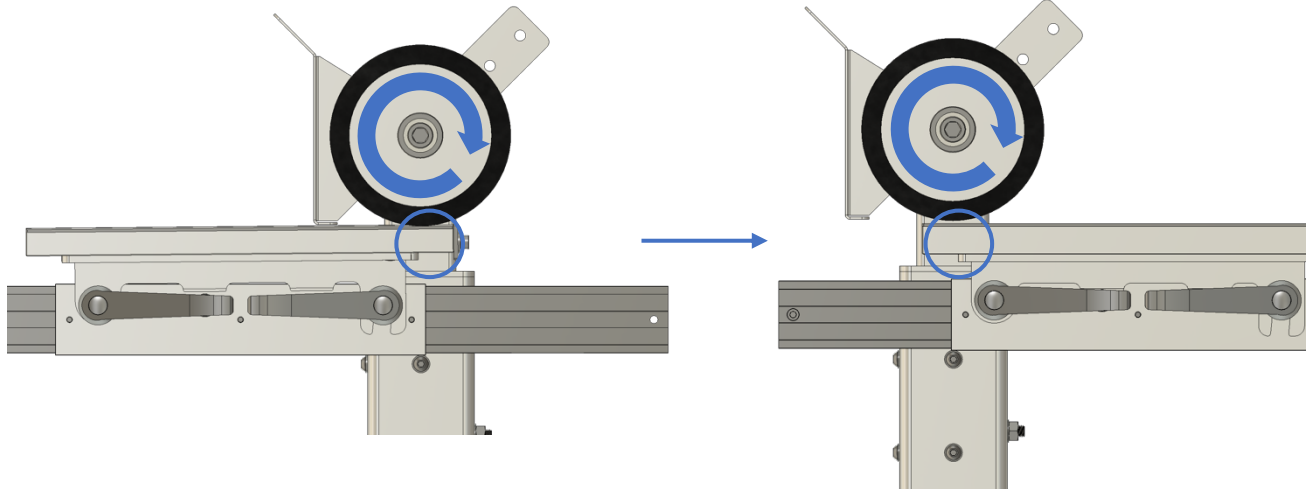


2. Wind SOSGA until wheel is lightly touching the chuck face – you should be able to spin the wheel with slight friction



16. 1. Check that the wheel is parallel to the chuck. To do this, rotate wheel at either end of chuck – resistance / drag on the wheel should be equal on both sides of the chuck.

2. If chuck is not parallel to wheel and requires adjustment, proceed to step 3.

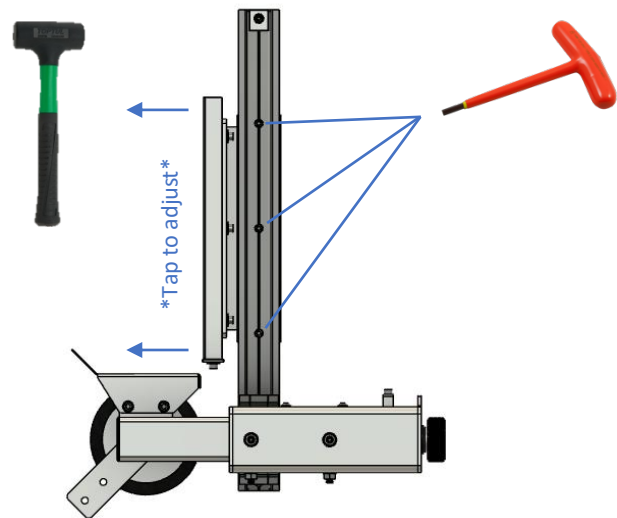


17. -H4 Hex / allen key
- Rubber hammer

1. Loosen off the 3 bolts in the linear rail.

2. Tap end of the chuck to adjust as necessary to make chuck parallel to wheel.

3. Re-tighten bolts, repeat step 2 to check adjustment and repeat as necessary until chuck is parallel.

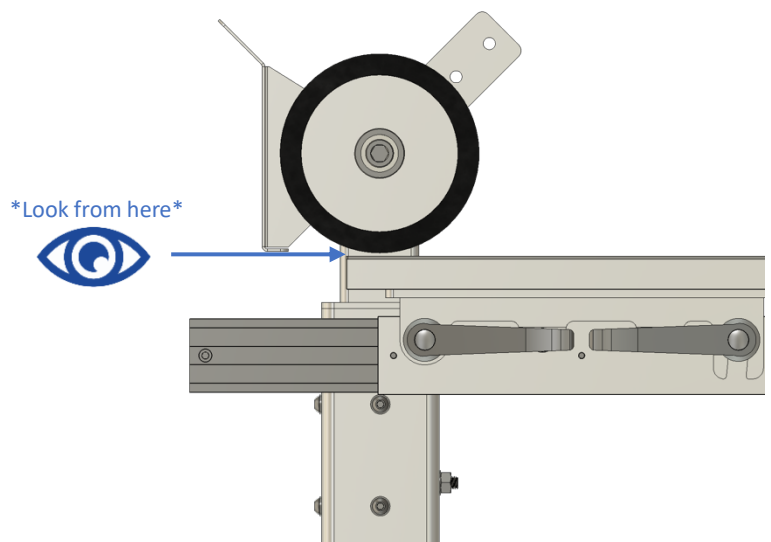


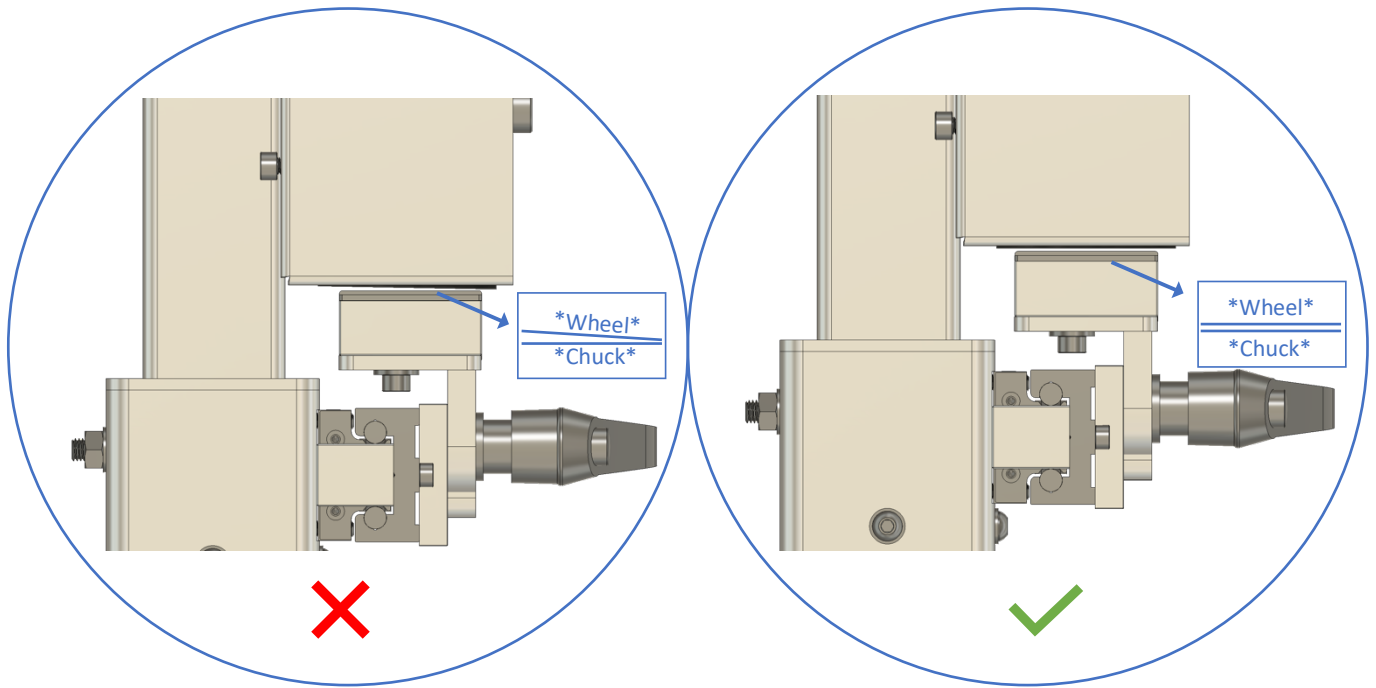
18.

1. Wind SOSGA knob out until wheel is approximately 1-2mm off chuck.

2. Look at gap between wheel and chuck to check for parallel. Gap should be the same on either side of wheel (see illustration on next page for example).

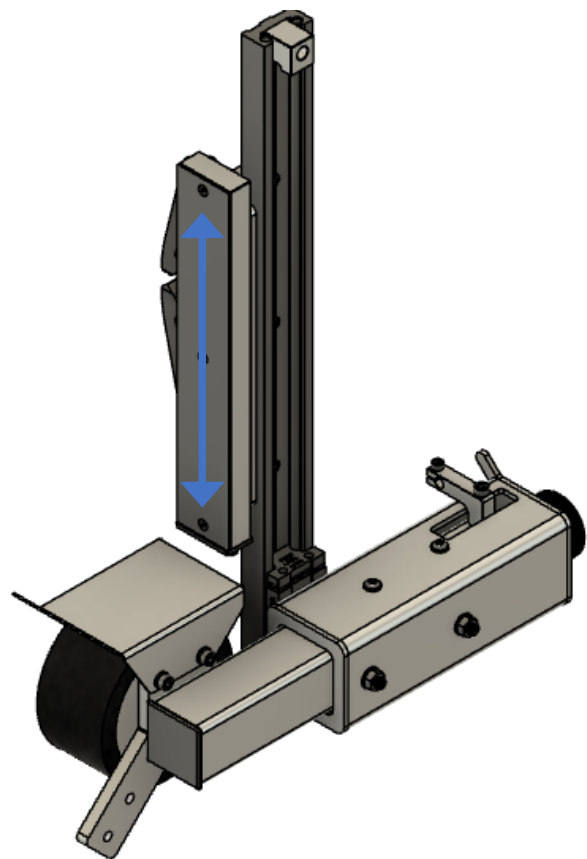
3. If gap is uneven, linear rail bearing is likely too tight. This may require re-adjustment. If further assistance is required, call your distributor or the team at 84 Engineering on 0448 431 822.





19.

1. Once SOSGA is correctly adjusted, re-mount to belt grinder and re-grind the chuck face using the following steps.
2. Ensure the taper tang adjustment arm is set to zero and is hard against the roll pins and that the adjustable handles are tightened.
3. Using a new 40-50 grit belt, flatten the magnetic chuck face using small increment passes
4. Once the magnetic chuck face has been trued, refine the finish using a new 120 grit belt.
5. Use the belt tracking adjustment to move the position of the belt to overlap the edge of the magnetic chuck face to ensure the full surface area of the magnetic chuck face is ground.
6. Chamfer the edges of the magnetic chuck face with a fine hand file.



If you have any further questions or issues, please feel free to contact your local distributor or the 84 Engineering team:

- Email: team@84engineering.com.au
- Phone: 0448 431 822
- Use the 'contact us' page at 84engineering.com.au