

PRF-812DW & PRF-822DW Piston Ring Filer Instructions

GOODSON

Tools and Supplies for Engine Builders

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Please read instructions before using

Prepared February 2014

1. Attention before use: Remove contents from box and check for any damage that may have accrued from shipping and to check and make sure all pieces are there (Fig.1).
2. For shipping purposes the piston ring hold down knob & washer (Fig. 1b) is removed along with the diamond dressing tool.
3. Take piston ring hold down knob with washer and assemble them on the stud sticking out of stainless steel table (Fig. 2). Thread on a few threads. **DO NOT TIGHTEN!**
4. Before using the powered ring filer for the first time and anytime the wheel gets loaded or replaced, you will want to side dress the grinding wheel with the enclosed diamond dressing tool.
5. Install diamond dressing tool into the slot underneath the piston ring. Hold down the knob (Fig. 3) and tighten (Caution do not over tighten, just snug).
6. Once the diamond is secure, lift ring stop up (Fig.4) and tilt table down bringing the diamond close to the grinding wheel. Use the knurled adjustment knob to feed the diamond into the grinding wheel. Once the diamond is close but not touching the grinding wheel, turn machine on. Feed the diamond into grinding wheel slowly (approximately .001" at a time) with the knurled adjustment knob swiping table back and forth as to dress complete wheel. Only remove enough to clean complete wheel and remove the diamond.
7. Lower ring stop (Fig.4) and install piston ring & square piston ring end up against the ring stop and tighten piston ring hold down knob (Fig.5&6).
8. Adjust the eccentric up against the inside of piston ring and tighten (Fig.7). This will keep piston ring in position during the grinding process.
9. Raise the piston ring stop, (Fig.8) then tilt table down and adjust knurled adjustment knob until ring just touch's the grinding wheel (Fig.9). Now you can zero the dial indicator (Fig.10).
10. Now you are ready to grind the piston ring. Turn the power switch on and sweep the table back and forth using the entire wheel surface. Feed the piston ring in using the knurled adjusting knob to the amount needed to be removed.
11. You can remove the same amount off of each piston ring as long as you leave all adjustments the same. Remove piston ring and put the piston ring stop down, install next piston ring squaring up against stop. Lift stop up and grind piston ring. You will remove the same amount that was removed from the last ring.

CAUTION: ALWAYS WEAR EYE PROTECTION WHEN USING THE GOODSON POWERED PISTON RING GRINDER.

Replacement Parts:

Grinding Wheel	Part No. PRF-1002
Diamond Dresser	Part No. PRF-812D
Deburring Wheel	Part No. PRF-DW

