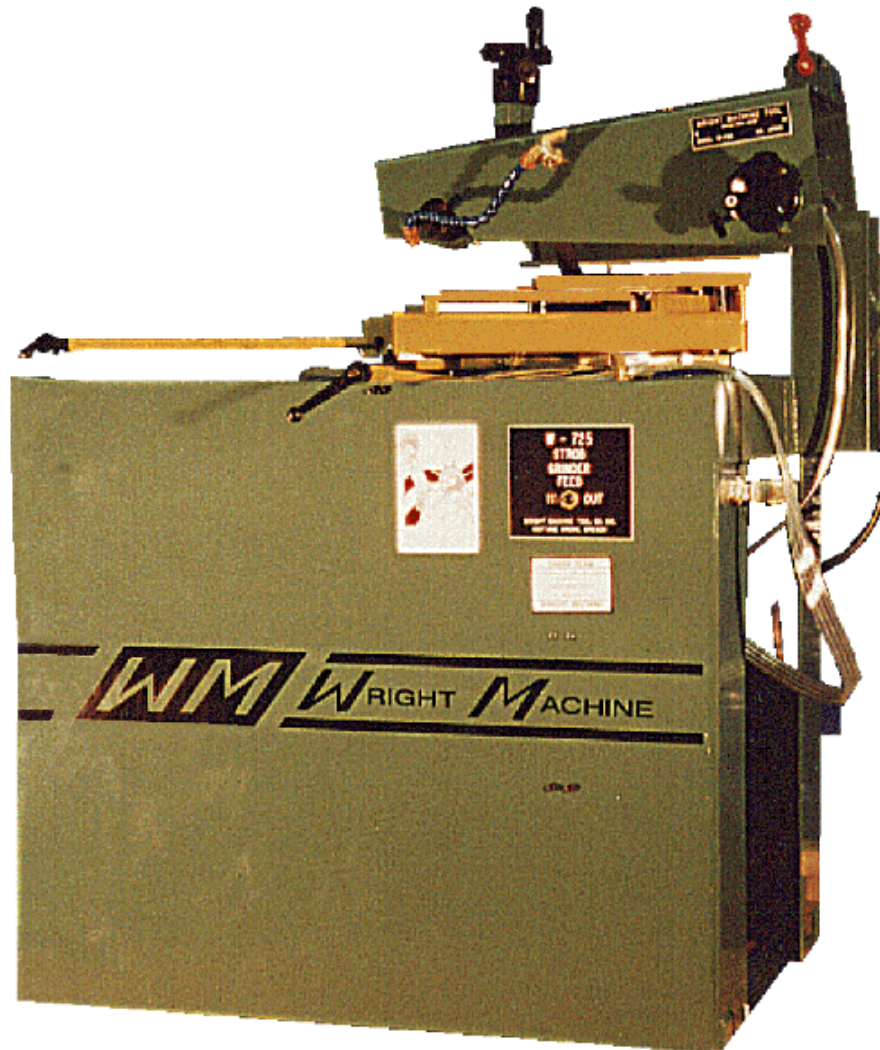


**W** RIGHT

**M**ACHINE

# W-725 STROB GRINDER



## OPERATOR'S MANUAL

MADE IN THE U.S.A.



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# W-725

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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 in material or workmanship and returned to WRIGHT MACHINE TOOL CO., shipping costs prepaid will be repaired or replaced, at WRIGHT MACHINE TOOL CO. option.

# W-725

## Strob Tooth Face or Side Grinder

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

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



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# W-725

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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 is 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.



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# W-725

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## 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.



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# W-725

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## SPECIFICATIONS

W-725 Semi-Automatic Side or Face Grinder for Strob Teeth.

|                           |   |
|---------------------------|---|
| <b>STANDARD VOLTAGE:</b>  | 230 Volt, 1 Phase, 60 HZ<br>or 200 Volt, 1 Phase, 50 HZ |
| <b>OPTIONAL VOLTAGE:</b>  | As Requested  |
| <b>SHIPPING WEIGHT:</b>   | 700 lbs   |
| <b>CRATE SIZE:</b>        | L 44" X W 44" X H 62"                                   |
| <b>AIR REQUIREMENTS:</b>  | 2 CFM at 80 psi   |
| <b>STANDARD SAW SIZE:</b> | 6" to 36"   |
| <b>SPINDLE MOTOR:</b>     | (1) 3/4hp 3450 RPM Motor                                |



# W-725

## PRE SET UP COOLANT

Coolant capacity is 5 gallons. A rust inhibiting grinding coolant **MUST** be used or severe rust damage to machine can result. Mix coolant according to manufacturer's instructions.

### MOUNTING GRINDING WHEELS

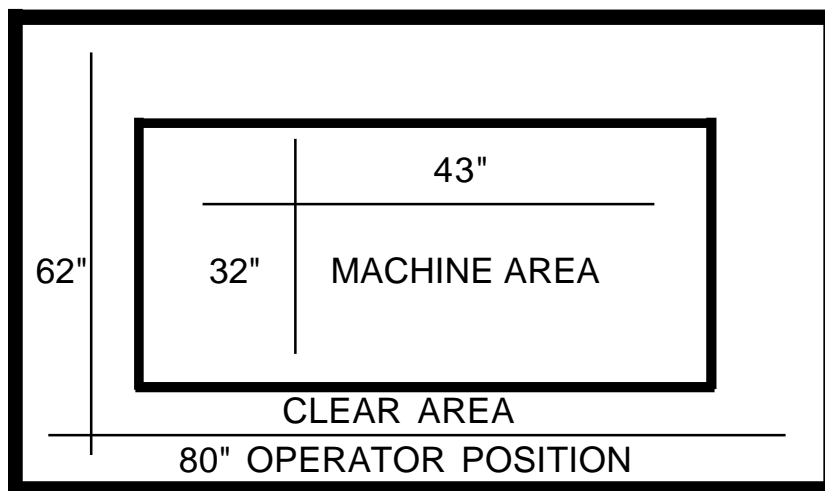
**All grinding wheels must be rated for the RPM of this machine. Wheels exposed to higher than rated RPM are dangerous.**

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.

### MACHINE INSTALLATION

Lifting of this machine should be done with fork lift under the coolant tank. Machine weight is approximately 500 pounds.

### RECOMMENDED FLOOR SPACE FOR MACHINE AND OPERATOR



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# W-725

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## SET UP FOR SIDE GRINDING

1. Mount the saw on the table using the alignment key between the face of the strob tooth and the table plate. Turn the saw lock handle until the two lock arms move down locking the saw in proper place. Remove the alignment key. For side grinding the table must be turned counterclockwise until it is perpendicular to the grinding wheel.
2. Move the power feed handle to IN. When the strob is under the grinding wheel move power feed handle to center position which is stop.
3. Start grinding motor so the wheel turns away from the face of the strob tooth.
4. Turn the side depth hand wheel until the OD of the wheel touches the strob tooth. The side depth hand wheel is the one pointing straight up. Then feed in the required amount.
5. Move the power feed handle to IN and let the table move until the strob tip is past the wheel. Stop table there and set the travel stop so the table will travel no further on the next saw.
6. Move the power feed handle to out and grind the tip until the strob is clear of the grinding wheel.
7. Remove the saw, turn the saw over and re-clamp the saw using the alignment key to align the strob with the opposite table plate.
8. The side clearance should be approximately the same as the side previously ground without moving the side depth hand wheel.





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# W-725

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## SET UP FOR FACE GRINDING

1. The saw table must be rotated clockwise until it parallels the grinding wheel.
2. The saw is mounted so the face of the strob is facing to the left side of the machine.
3. Use the side depth hand wheel to lower the wheel through the strob slot.
4. Use the face width hand wheel to move the head until the wheel touches the face of the strob.
5. Set the travel stop so the wheel will not hit the end of the strob slot.
6. Move the power feed handle to IN until the travel stop is hit, then move to OUT until the wheel is clear of the strob slot.
7. NOTE: THE W-725 IS DESIGNED TO ROUGH IN (1) PASS , AND FINISH BACK THE OPPOSITE DIRECTION IN (1) PASS ONLY .



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## W-725

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### MAINTENANCE

The drive belt should be inspected and cleaned every 3 months.

The coolant tank should be completely cleaned at least every 6 months. Remove all the sludge from the bottom of the tank.

All bare metal surfaces should be cleaned and oiled regularly.

Oil level in the oil pot should get no lower than 1 inch from the top when the table is full out. If the oil level gets below 1 inch add a thin hydraulic oil to the oil pot.



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# W-725

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## PARTS LIST

### W-725 Strob Grinder

| <u>DRAWING</u>       | <u>PAGE</u> |
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| GRINDING HEAD        | 10          |
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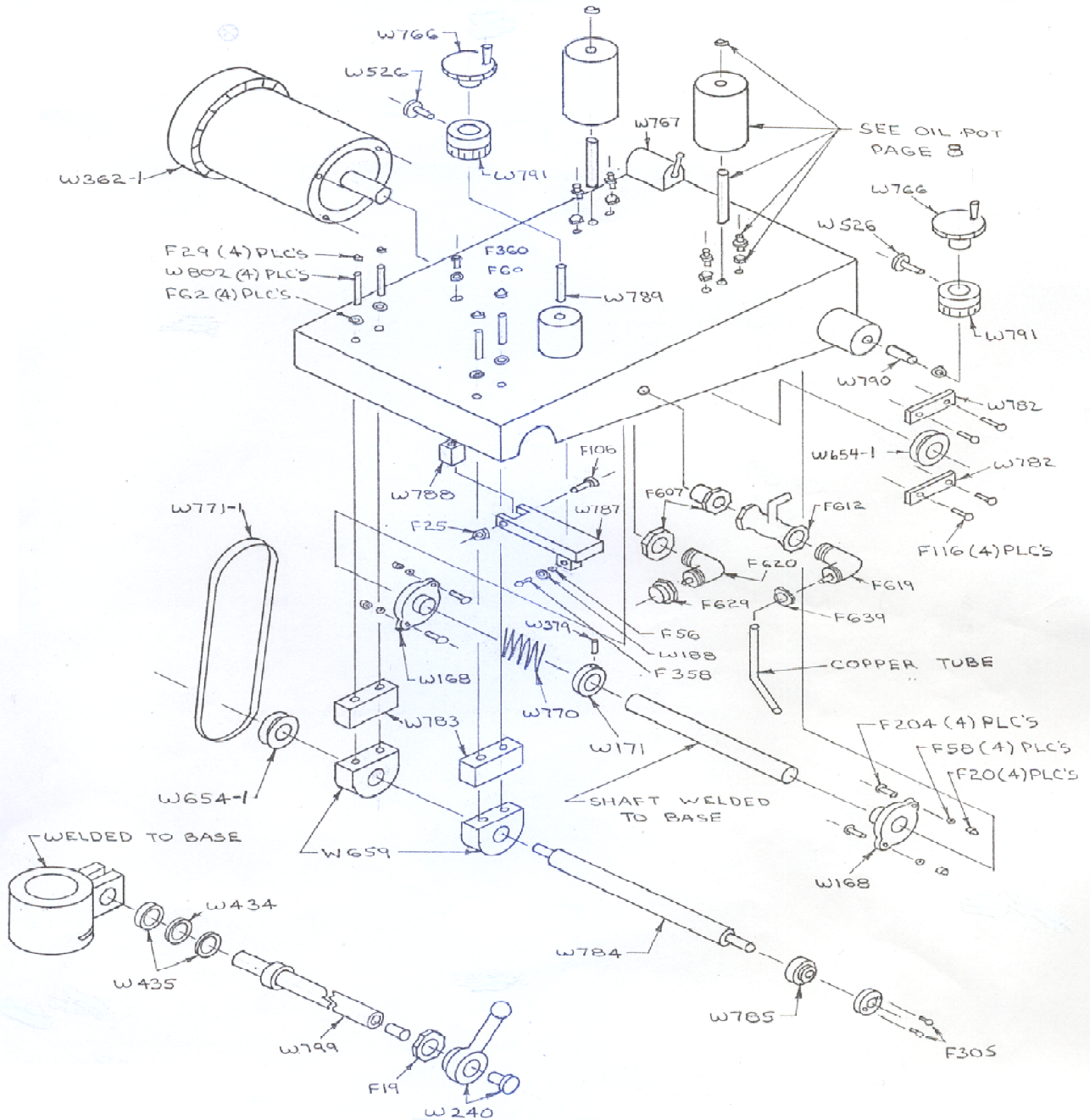
# W-725

## GRINDING HEAD

| <u>PART #</u> | <u>DESCRIPTION</u> | <u>PART#</u> | <u>DESCRIPTION</u>     |
|---------------|--------------------|--------------|------------------------|
| F-19          | NUT                | W-168        | 1" FACE BEARING        |
| F-20          | NUT                | W-171        | COLLAR                 |
| F-25          | NUT                | W-188        | INDEX BEARING          |
| F-29          | NUT                | W-240        | HANDLE                 |
| F-56          | WASHER             | W-362-1      | MOTOR                  |
| F-58          | WASHER             | W-434        | BEARING                |
| F-60          | WASHER             | W-435        | BEARING                |
| F-62          | WASHER             | W-526        | HANDLE                 |
| F-106         | SCREW              | W-654-1      | PULLEY                 |
| F-116         | SCREW              | W-659        | BEARING                |
| F-204         | BOLT               | W-766        | KNOB                   |
| F-305         | SCREW              | W-767        | SWITCH (REVERSING)     |
| F-358         | SCREW              | W-770        | SPRING                 |
| F-379         | SET SCREW          | W-771-1      | BELT                   |
| F-607         | FITTING            | W-782        | MOTOR MT BAR           |
| F-612         | SHUT OFF VALVE     | W-783        | BEARING SPACER         |
| F-619         | ELBOW              | W-784        | SPINDLE                |
| F-620         | ELBOW              | W-785        | WHEEL HUB              |
| F-629         | BAND               | W-787        | INFEEED ARM            |
| F-639-1       | BAND               | W-788        | INFEEED ARM MOUNT      |
|               |                    | W-789        | LEAD SCREW (SIDE)      |
|               |                    | W-790        | LEAD SCREW (FACE)      |
|               |                    | W-791        | GRADUATED COLLAR       |
|               |                    | W-799        | BEARING BLOCK MODIFIED |
|               |                    | W-802        | STUD                   |



# W-725



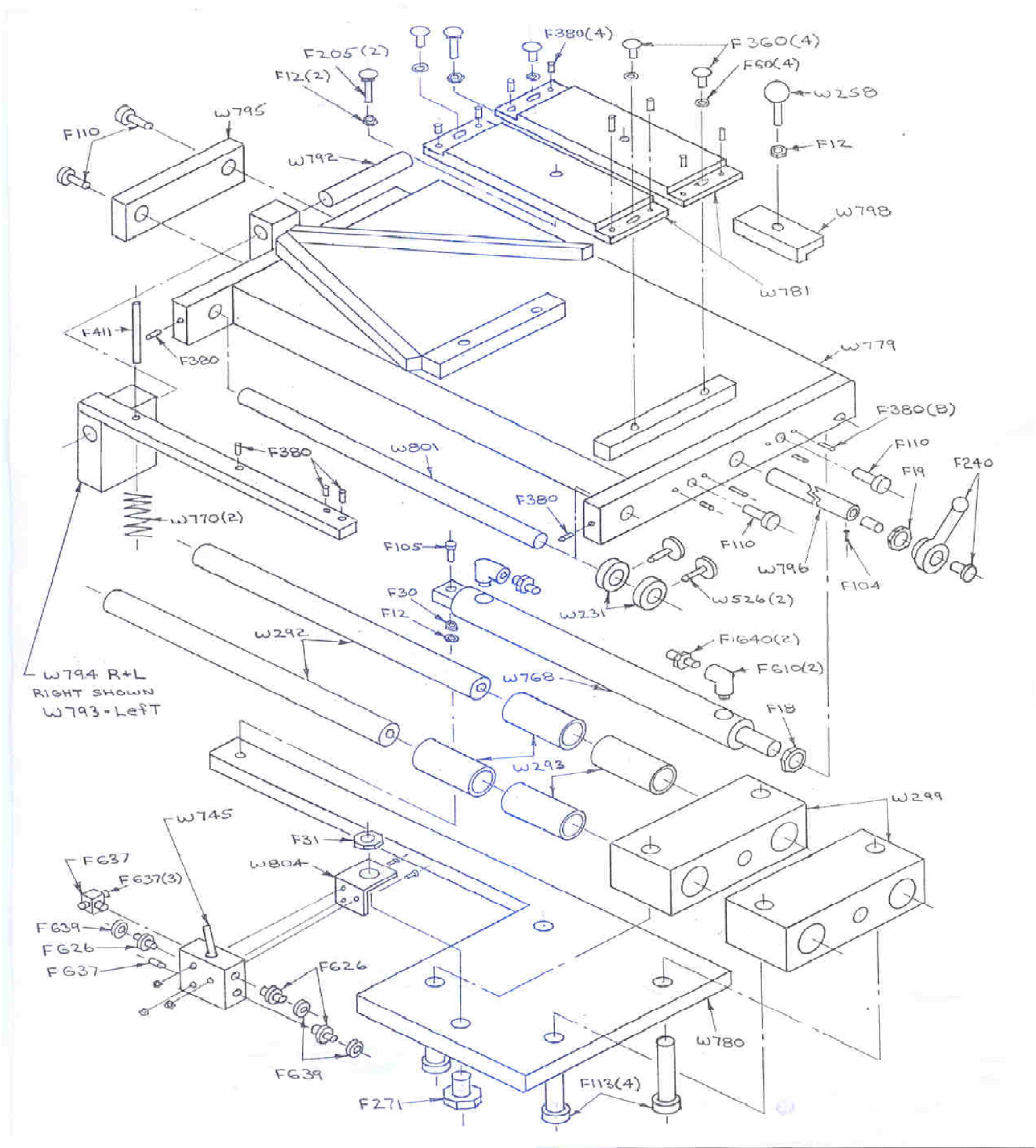
# W-725

## TRAVERSE BED

| <u>PART #</u> | <u>DESCRIPTION</u> | <u>PART#</u> | <u>DESCRIPTION</u> |
|---------------|--------------------|--------------|--------------------|
| F-12          | NUT                | W-231        | 1/2" COLLAR        |
| F-18          | NUT                | W-240        | HANDLE             |
| F-19          | NUT                | W-258        | BALL               |
| F-30          | NUT                | W-292        | HEAD SHAFT         |
| F-31          | NUT                | W-293        | HEAD BEARING       |
| F-60          | WASHER             | W-299        | BEARING BLOCK      |
| F-104         | SCREW              | W-526        | HANDLE             |
| F-105         | SCREW              | W-745        | SWITCH             |
| F-110         | SCREW              | W-768        | 12" STROKE CYL.    |
| F-113         | SCREW              | W-770        | SPRING             |
| F-205         | BOLT               | W-779        | TABLE              |
| F-271         | SCREW              | W-780        | BEARING MT PLATE   |
| F-360         | SCREW              | W-781        | TABLE BED PLATE    |
| F-380         | SET SCREW          | W-792        | SAW CLAMP PIN      |
| F-411         | ROLL PIN           | W-793        | SAW CLAMP LEFT     |
| F-610         | ELBOW              | W-794        | SAW CLAMP RIGHT    |
| F-626         | CONNECTOR          | W-795        | SAW CLAMP BAR      |
| F-637         | T FITTING          | W-796        | SAW CLAMP SCREW    |
| F-639-1       | BAND               | W-797        | TABLE LOCK SCREW   |
| F-640         | BARB FITTING       | W-798        | GUIDE KEY          |
|               |                    | W-801        | STOP SHAFT         |
|               |                    | W-804        | SWITCH BRACKET     |



# W-725



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# W-725

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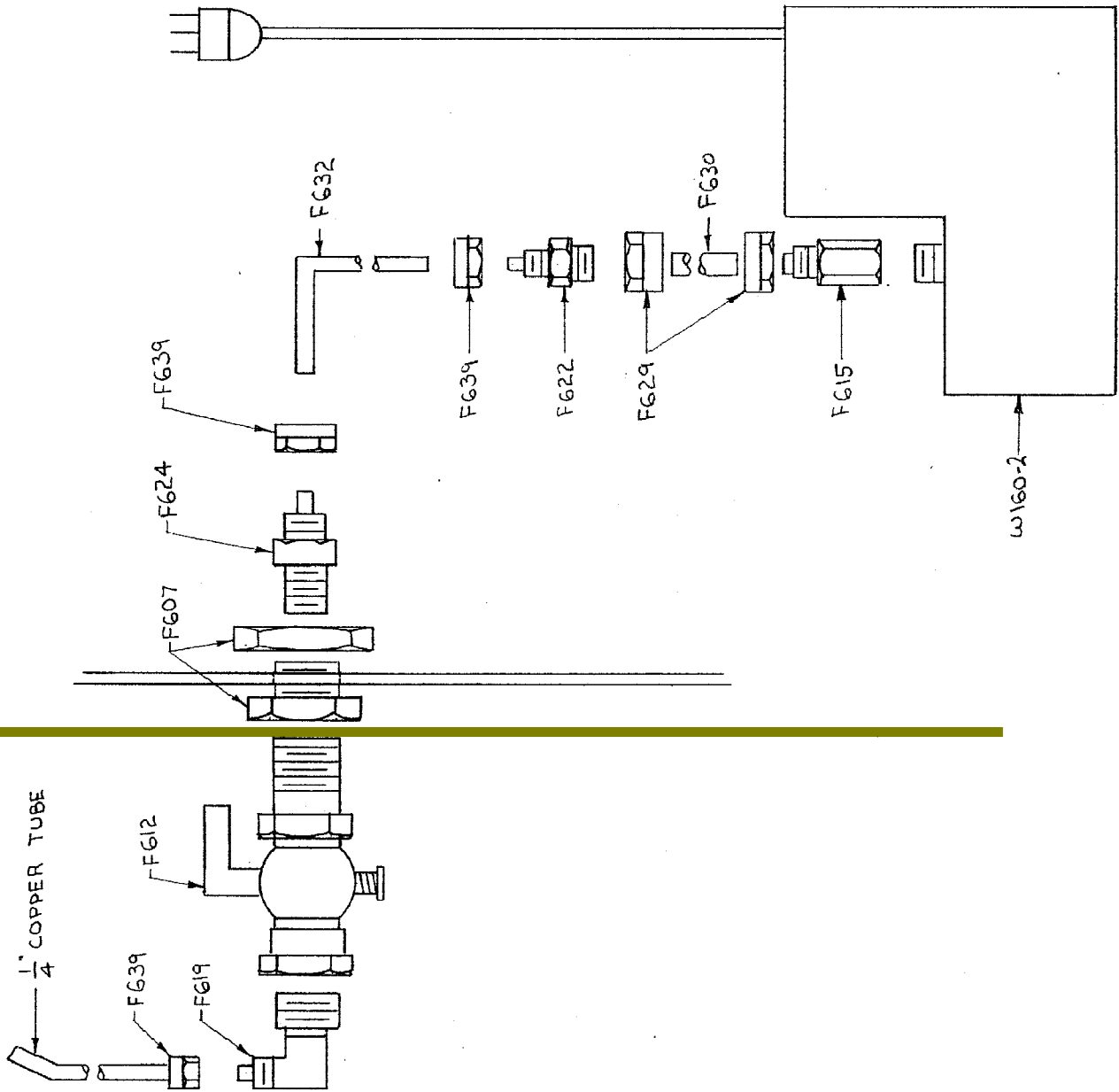
## COOLANT DIAGRAM

| <u>PART #</u> | <u>DESCRIPTION</u> |
|---------------|--------------------|
| W-160-2       | COOLANT PUMP       |
| F-607         | FITTING            |
| F-612         | SHUT OFF VALVE     |
| F-619         | ELBOW              |
| F-622         | CONNECTOR          |
| F-624         | CONNECTOR          |
| F-629         | BAND               |
| F-630         | TUBING             |
| F-632         | TUBING             |
| F-639         | BAND               |





# W-725



# W-725

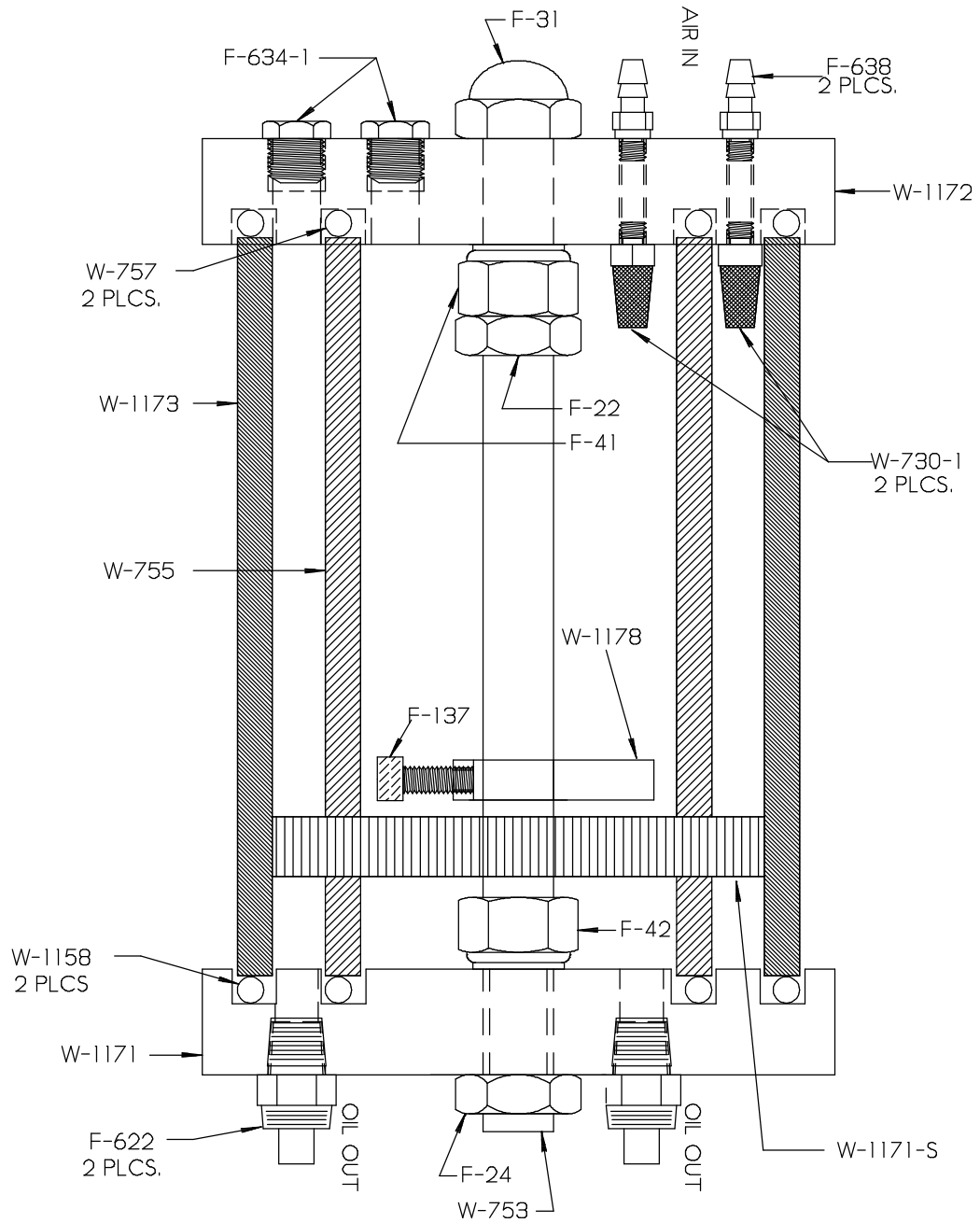
## OIL POT (W-1171-A)

| <u>PART #</u> | <u>DESCRIPTION</u> |
|---------------|--------------------|
| F-22          | NUT                |
| F-24          | NUT                |
| F-31          | NUT                |
| F-41          | NUT                |
| F-42          | NUT                |
| F-137         | SHCS               |
| F-622         | OIL FITTING        |
| F-634-1       | PLUG               |
| F-638         | AIR FITTING        |
| W-730-1       | AIR FILTERS        |
| W-753         | STUD               |
| W-755         | INNER TUBE         |
| W-757         | O-RING             |
| W-1158        | O-RING             |
| W-1171        | END CAP BOTTOM     |
| W-1171-S      | SPRING             |
| W-1172        | END CAP TOP        |
| W-1173        | OUTER TUBE         |
| W-1178        | BAFFLE             |



# W-725

## OIL POT (W-1171-A)



# W-725

230V 1 PHASE  
60/50 HZ 15A

