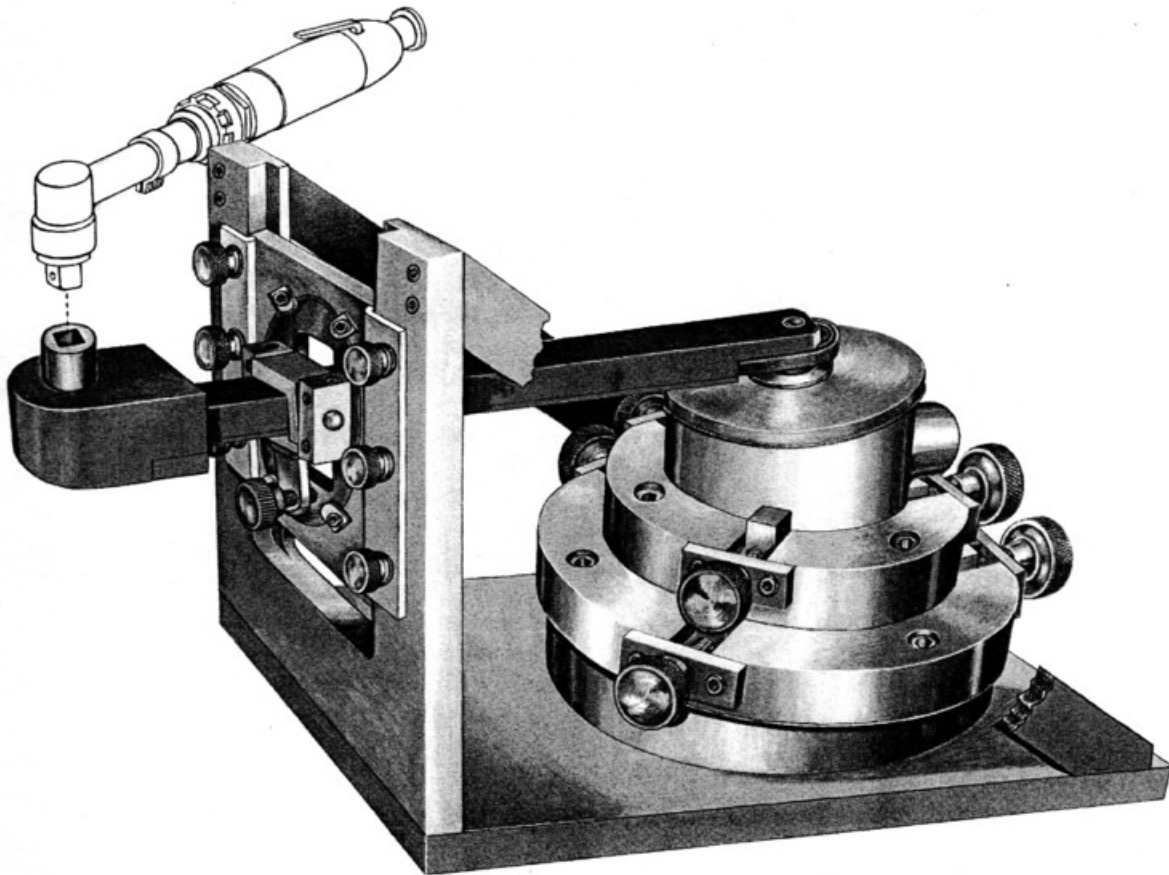


Grimsley's Wedge Refinisher
For Refinishing Gate Valve Wedges
Sizes 1" to 12"
Model WR-112
Patent No. 4,378,661



GRIMSLEY'S HOUSE OF TOOLS, INC.

Specializing in Portable Tools

**Grimsley's Portable Machine Fixture
Model WR-112
Refinishing Gate Valve Wedges, Sizes 1" thru 12"
To be used with Grimsley's Model VR-360 Machine**

Description

The Grimsley's Wedge Refinisher is especially useful in refinishing wedges while overhauling gate valves.

The machine comes with grinding discs suitable for use with all manufacturers gate valves, sizes 1" through 12", and a carrying case with all discs and the necessary allen wrenches to operate the machine. (Grimsley's model VR-360, acts as an driving mechanism for this machine.)

To operate the Wedge Refinishing Machine, the angled vice support on riser should at all times remain bolted to the base plate. The large clamp body, holding vise for 8" through 12" gate valves, is to remain bolted to the riser (angled vice support). The large clamp body will hold wedges (gates) from 8" through 12". This clamp must be used when refinishing valve gate from 8" through 12".

To refinish 6" gate valves and smaller, bolt the small clamp (holding vise for 1" through 6" gate valves) to the larger clamp body. The 3 clamping devices should be snug against the gate to hold the gate steady to eliminate turning of the gate valve while refinishing.

Install the VR-360 Valve Grinding Machine through the back of the Wedge Machine. Install the proper size disc with stick on abrasive and adjust up or down to suit the height size of the gate valve being refinished, i.e., level the reseating machine (VR-360) to eliminate binding while grinding. The stick on abrasive to be chosen according to the amount to be ground off the gate and the finish desired.

NOTE: The abrasive machine VR-360 is the same machine used from grinding 3" to 6" gate valve seat in line.

Operation

The entire operation is very simple and requires only a few minutes to re-surface both sides of the gate valve. Choose from the many grit sizes of stick on abrasives (commercial stock). This is determined by the amount of metal to be removed from gate to remove all nicks or scratches and also to give a polished finished. Cut the abrasive to suit the disc chosen for the job. (Note: When making the abrasive to cover the disc leave approximately 1/8" oversize).

When grinding, lift grinding disc from face of gate to observe the results you are obtaining. The desired results can be obtained by using a cast iron disc and grinding compound. Snap on cast iron disc are available from Grimsley's House of Tools, Inc. (Note: If using cast iron disc and grinding compound, lift the disc frequently to allow the compound to cover the disc in an even manner).

There is very little adjustment and/or alignment necessary to complete the job in a very few minutes. This is a one man job.

Steps necessary to grind a gate:

1. Keep the wedge or gate machine made up at all times, i.e. have vice support plate and both sizes of holding vice bolted down and ready for use. The most popular sizes being reworked will be in the 1" to 6" range, therefore, keep size vice ready at all times.
2. Install the wedge in the vice holding mechanism and tighten vice enough to keep the wedge secure while grinding.
3. Install the model VR-360 valve reseating machine in the rack through the adjustable support plate. Raise plate up high enough to turn the machine 180 degrees with the proper size disc (depending on what size gate being finished) turned up. This will allow the abrasive to be installed (stick on). Then, turn the machine back 180 degrees with the disc parallel to the gate wedge.
4. Adjust the VR-360 machine up or down to assure that there is no binding between the disc and the body of the VR-360 and the disc.
5. When the proper height is determined, lock machine in place by tightening the holding cap screws.
6. Install air motor and run the machine to make sure there is no binding before actually starting the grinding process.

7. With grinding machine running full speed, use the feed nut to put pressure on the grinding disc. Release and tighten, as necessary, while in the process of grinding. To determine when and approximately how much of the wedge is being ground, keep pressure on the disc with the feed nut.
8. Back the disc away from the wedge and examine for finish obtained. If desired finish is accomplished, remove the VR-360 and the job is accomplished.
9. If there are more gate wedges to grind, just insert another wedge and start the procedure over.
10. When all refinishing is accomplished, clean up VR-360 machine and return to carrying case.

Maintenance

Maintenance of the Wedge Refinisher is negligible. Clean by removing any abrasive grit from the holding vise and adjusting screws. Equipment should be thoroughly cleaned after each use, sprayed with water displacing rust inhibiting chemical before storing in storage case. If machine is to be used in a contamination area, clean in accordance with Government specifications.

GRIMSLEY'S HOUSE OF TOOLS, INCORPORATED WILL NOT BE RESPONSIBLE FOR DAMAGE CAUSED BY IMPROPER USE OR STORAGE OF THEIR EQUIPMENT.

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