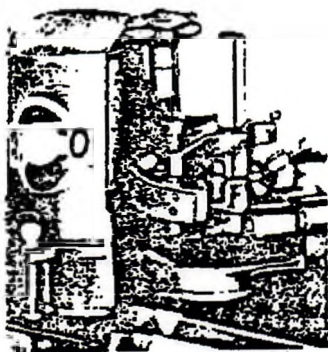


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DATE: 1967

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DOCUMENT DESCRIPTION: Product Description and Instructions

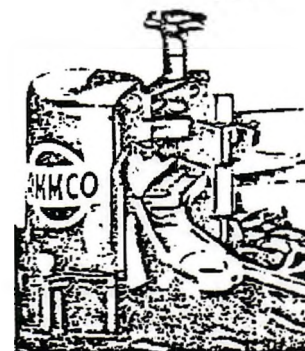


OPERATING INSTRUCTIONS

AMMCO MODEL 8000

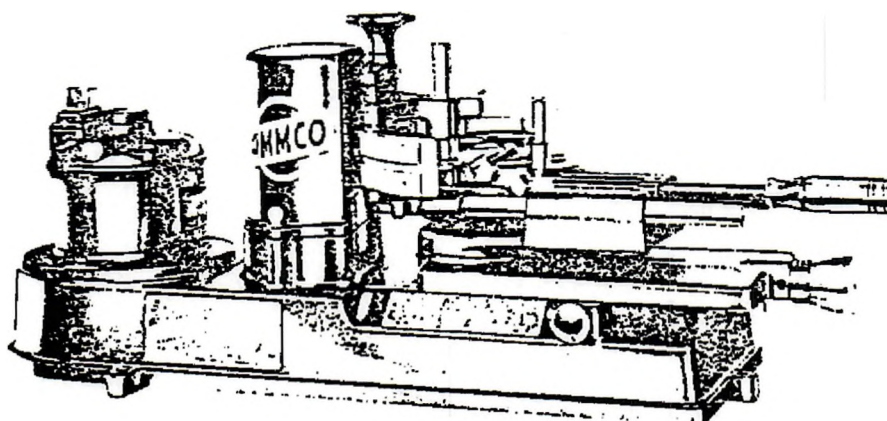
"SAFE-ARC"

BRAKE SHOE GRINDER



AND

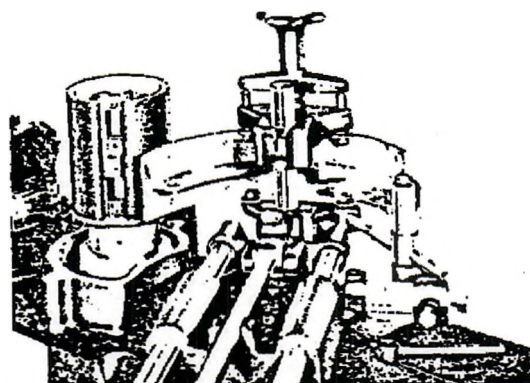
No. 8100 FIXED ANCHOR GRINDING SET



MODEL 8000 "SAFE-ARC" BRAKE SHOE GRINDER

I N D E X

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OPERATING INSTRUCTIONS	2A-7A
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BRAKE SHOE GRINDING AND RECONDITIONING	1-9



NO. 8100 FIXED ANCHOR GRINDING SET

AMMCO TOOLS, INC.

2100 COMMONWEALTH
AVENUE



NORTH CHICAGO
ILLINOIS

Specifications subject to change without notice.

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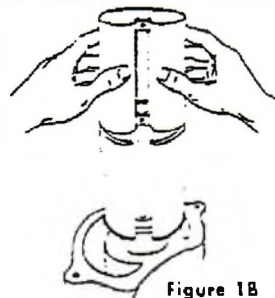
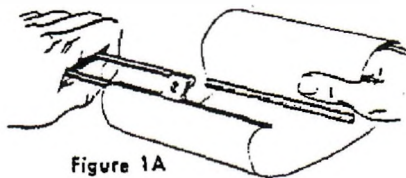


SET-UP INSTRUCTIONS

1. Place "Safe-Arc" on bench and bolt down.



2. Snap mouth of Dust Bag over lip of Dust Collector Elbow. Insert Elbow in exhaust hole and tighten Setscrew. Elbow can be turned so that Dust Bag will lie on the bench or hang down.

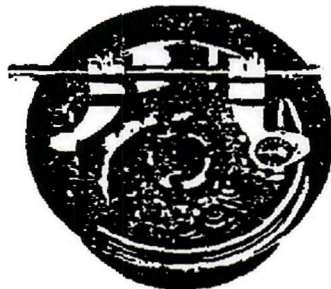


3. To replace Abrasive Belt remove the two Allen Screws from the Abrasive Belt Retaining Clip. Pull the Retaining Clip upward and away from the Belt or slip the Belt and Clip off the Arbor together.

When placing a new Belt on the Belt Retaining Clip, slide its molded retaining ends into Clip groove (Figure 1A). Place the Belt and Clip assembly over the Arbor (Figure 1B) with the back of the Belt contacting the Arbor first. Work the Belt onto the Arbor from the back forward and down until the Belt contacts the lower lip of the Arbor completely around its circumference. Reinstall and tighten the Retaining Clip Allen Screws. Work any looseness out of the Belt with your hands until the Belt is snug on the Arbor. **DO NOT OVER-TIGHTEN ALLEN SCREWS!**

OPERATING INSTRUCTIONS

1. Use AMMCO's Model 8500 "Safe-Mike" Brake Drum Micrometer to deter-

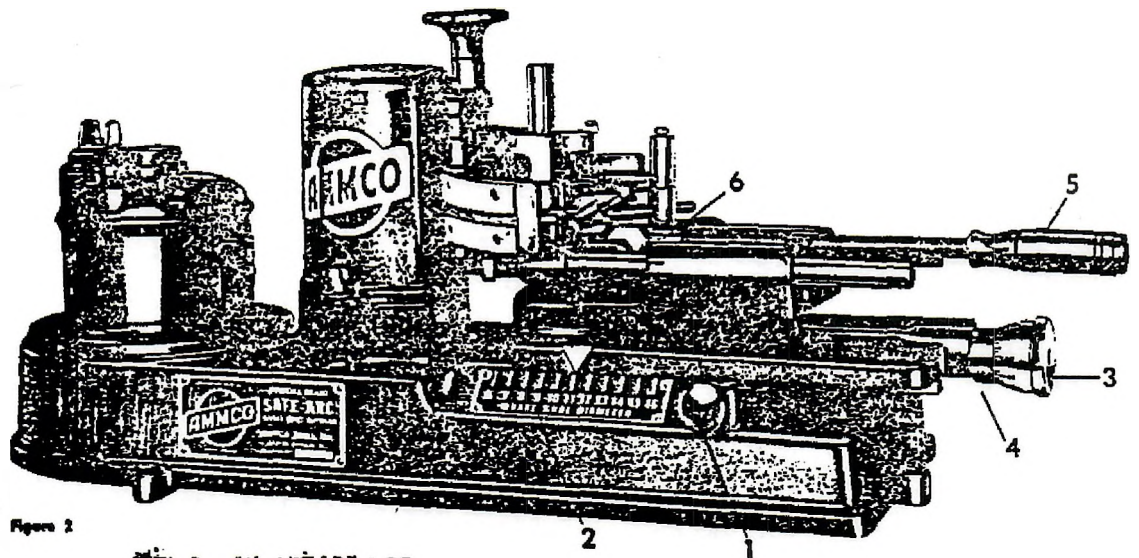


mine the diameter of the drum in which brake shoes to be ground are to be used.

2. Release Slide Lock (G-Figure 6) and pull out Slide Index Pin (1-Figure 2). Move Slide Table to proper drum diameter on Drum Size Scale (2-Figure 2). Adjust Micrometer Dial (3-Figure 2) to zero setting. Seat Slide Index Pin by turning it.
3. AMMCO recommends grinding to an arc .030" smaller than the actual drum diameter. See page 9 of Brake Shoe Grinding and Reconditioning section.

EXAMPLES:

A. If the drum is 11.040" diameter, set the Slide Table at 11" and turn the



Micrometer Dial (3-Figure 2) clockwise from zero setting to .040" (Figure 3). This setting would grind the shoe to exact drum diameter. To undersize grind by .030", as recommended, back off (turn counterclockwise) .030", which will give you a reading of .010" (Figure 4).

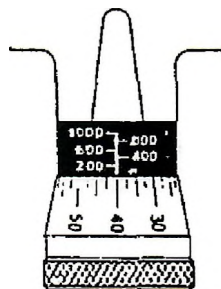


Figure 3

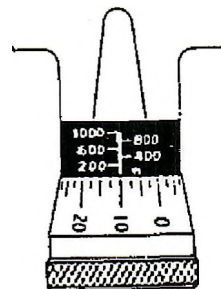


Figure 4

B. The Micrometer Dial has a full 1" of travel and thus can be set for ANY diameter within its full range. Each full revolution of the Micrometer gives you .200" travel. Thus, if you wish to set your "Safe-Arc" for a 9.500" diameter drum, set the Slide Table at 9" and turn the Micrometer Dial clockwise past the .400" position on the Micrometer Barrel (4-Figure 2) to .100" on the Micrometer Dial.

C. Tighten Slide Lock (G-Figure 6) before grinding.

4. GRINDING SHOES FOR NON-SERVO AND WAGNER SERVO COMPOUND BRAKES. This would include the Center Plane and Lockheed brakes

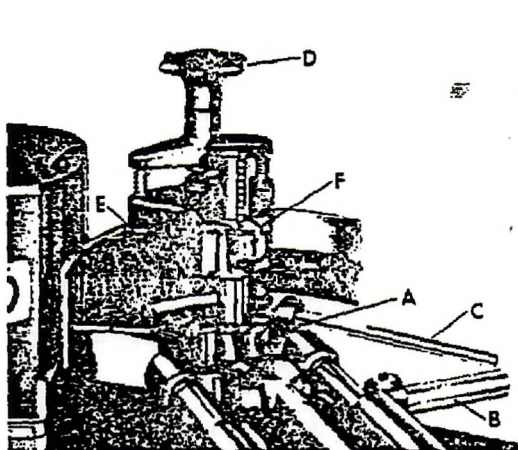


Figure 5

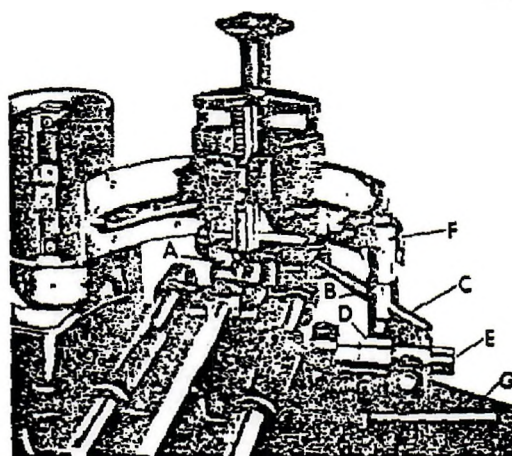


Figure 6

used on Chrysler products and the Wagner self-centering brake used on some models of Studebaker and Rambler. It is recommended that shoes for Bendix Duo-Servo adjustable anchor brakes be ground against a **FIXED ANCHOR** as described in Section 5.

- A. Tighten Screw (A-Figure 5) securely into the V-groove in the Lower Shoe Clamp. Fixed Anchor Attachment (Figure 7) must be removed.
- B. Back off the Clamping Knob (D-Figure 5) until the Upper Locating Buttons (E-Figure 5) are retracted all the way up. Depress the Thumb Lever (F-Figure 5) and raise the Upper Shoe Clamp until the shoe will fit between the Upper and Lower Locating Buttons.
- C. Place the shoe on the Lower Locating Buttons with the edge of the shoe table on the flat section and the back of the shoe table against the Button. Center the LINING in the Shoe Clamp — NOT the shoe itself. It is important that the locating and clamping buttons be firmly seated and in direct contact with the shoe platform. Any brake lining protruding beyond the edge of the platform must be removed.
- D. Push the Upper Shoe Clamp down until the Upper Locating Buttons con-

tact the upper shoe table. Be sure that the shoe is fully seated back in the Shoe Clamp and tighten the Clamping Knob securely. SEE THAT DIRT, BURRS, OR OVERFLOW BONDING MATERIAL DO NOT INTERFERE WITH CORRECT SEATING OF THE SHOE AGAINST THE LOCATING BUTTONS.

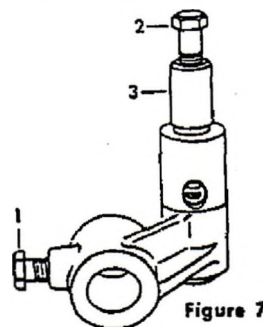
- E. Grind the shoe as in Section 6.

ALL CENTER PLANE BRAKE SHOES WITH SPRING LOCATING NIBS CAN BE GROUND ACCURATELY BY PLACING THE ANCHOR OR LARGE END OF THE SHOE TOWARDS THE DUST BAG SIDE OF THE GRINDER AND BY POSITIONING THE SHOE IN THE CLAMP SO THAT THE LINING SEGMENT WILL BE UNIFORMLY GROUND.

5. GRINDING SHOES FOR FIXED ANCHOR BRAKES.

(No. 8100 Fixed Anchor Grinding Set is not standard equipment with the Model 8000 Brake Shoe Grinder.) It is recommended that shoes for adjustable anchor as well as fixed anchor Bendix Servo brakes be ground using this method.

- A. Loosen Screw (A-Figure 6) until Shoe Clamp Assembly swivels freely and fully without contacting Screw.
- B. Select Shoe Positioning Sleeve (B-Figure 6) corresponding to the No. 8030 Specification Chart or the diameter of the drum to which the shoe is being ground. Slide it over Rod (C-Figure 6) until it contacts Stop Pin.
- C. Select the correct Gage Sleeve (D-Figure 6) from the No. 8030 Specification Chart. Slide it over Rod (E-Figure 6).



- D. Slide the Fixed Anchor Attachment (Figure 7) over Rods (C-E-Figure 6). Move the Handle (5-Figure 2) in and out until the Fixed Anchor Attachment is fully seated against the Shoe Positioning Sleeve and Gage Sleeve. Tighten Screws (1 and 2-Figure 7) firmly.
- E. Select the correct Anchor Sleeve (F-Figure 6) from the No. 8030 Specification Chart and slip it over the Anchor (3-Figure 7).

- F. Place the shoe in the Shoe Clamp as in Section 4 above, except that the shoe anchor eye must be firmly seated against the Anchor Sleeve (F-Figure 6).

NOTE: ONLY ONE SET OF LOCATING BUTTONS WILL CONTACT THE BRAKE SHOE WHEN GRINDING FROM THE ANCHOR POSITION. ON MOST SHOES IT WILL BE THE BUTTONS CLOSEST TO THE ANCHOR, BUT ON SOME THE BUTTONS FARTHEST FROM THE ANCHOR. BE SURE THAT THE SHOE IS FULLY SEATED IN THE SHOE CLAMP. TIGHTEN THE CLAMPING KNOB SECURELY.

When grinding a Brake Shoe with oversize lining to a near standard size drum in some instances you will find there is not enough clearance between the Shoe Clamp and Abrasive Sleeve to install the shoe. When this occurs, use the slotted end of the Shoe Positioning Sleeve (B-Figure 6). The slot should fit around the Stop Pin. Only use the slot when necessary.

6. BRAKE SHOE GRINDING.

- A. Move shoe against Abrasive Belt by lifting Handle (5-Figure 2) out of threaded half-nut and pushing forward. Re-engage Handle in half-nut and back off until shoe is barely clear of Abrasive Belt. Swing Handle away from you (toward Dust Bag) and start Motor.
- B. For smoother cutting, advance feed, using Handle, only when the Handle is on the Dust Bag side of Machine — clear of Abrasive Belt. Grinding Scale (6-Figure 2) is graduated in thousandths. Do not remove more than .005" on any one cut. Move Handle evenly and do not try to grind too fast.
- C. Continue grinding until lining cleans up across its full arc — then stop. Additional grinding will only waste lining.

MAINTENANCE

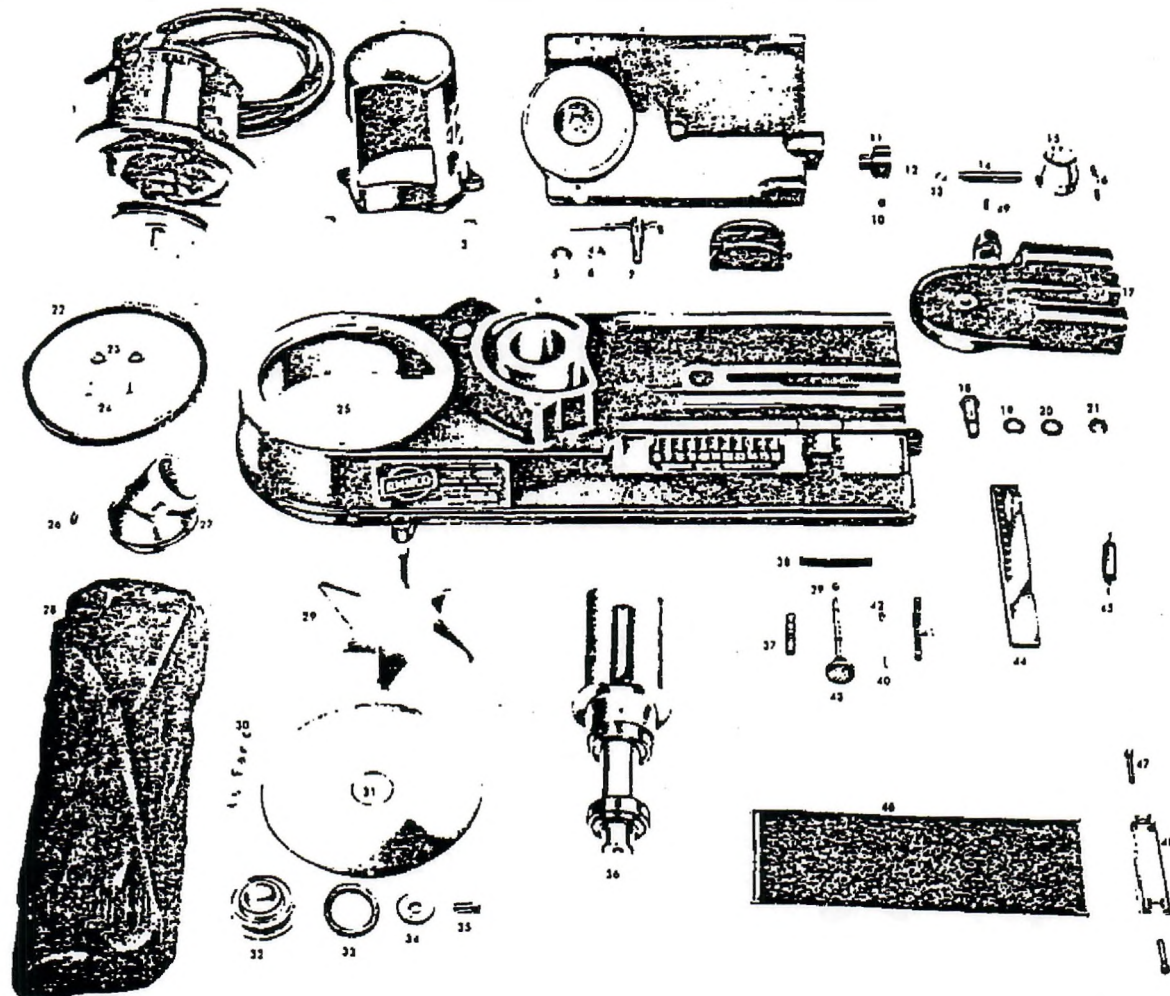
1. Frequently clean all exposed metal parts with a rag dampened with light machine oil.
2. The Swivel Table has a grease fitting. Periodically lubricate with multi-purpose chassis grease.
3. Use a few drops of light machine oil in the oil fittings at either side of the Slide Table once a week.
4. Oil the stud projecting down from the Lower Shoe Clamp casting weekly.
5. Empty Dust Bag frequently to assure maximum efficiency of vacuum system.

6. To adjust V Belt tension, loosen two Hex Head Bolts securing Motor and move Motor to obtain about 1/4" slack in V Belt. Re-tighten Bolts.

CAUTION

1. Use only AMMCO Abrasive Belts. Results positively cannot be guaranteed if substitute Belts are used.
2. Be careful not to let the Shoe Clamp hit Abrasive Belt when a shoe is not loaded in it.
3. Do not tamper unnecessarily with Setscrews in the Micrometer Dial.
4. Taking too heavy cuts will slow down motor. This will drastically reduce dust collection efficiency. Do not remove more than .005" on any one cut. Also, do not try to cut too fast.

PARTS LIST MODEL 5000 SAFETY GRINDER
Please give Serial No. of Shoe Grinder when ordering parts.

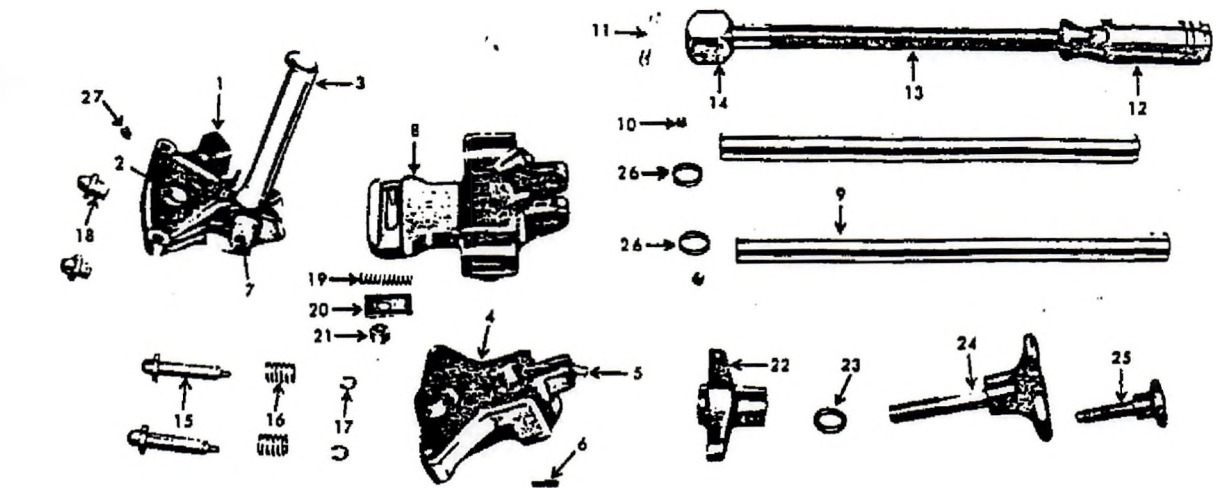


Key Part No.	Description
1 6014	1 1/2 H.P., 110 Volt, 60 Cycle, 1 Phase Motor.
3231	Switch Cord and Pulley Assembly
7206	1 1/2 H.P., 110 Volt, 60 Cycle, 1 Phase Motor
6118	Cord and Plug Set for 110 Volt, 1 Phase Motors
6077	Pulley for 1 1/2 and 1 1/2 H.P., 60 Cycle Motors
2740	Cord Grip for 110 Volt Cord
1163	On-Off Switch Plate
3813	Switch Mounting Plate
3387	Switch Guard
5805	1 1/2 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
5806	1 1/2 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
5807	1 1/2 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
5808	1 1/2 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
4428	1 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
3403	1 H.P., 110-220 Volt, 60 Cycle, 1 Phase Motor
3607	1 H.P., 220-440 Volt, 60 Cycle, 1 Phase Motor
3404	1 H.P., 220-440 Volt, 60 Cycle, 1 Phase Motor
7210	Cord and Plug Set for 220 Volt, 1 Phase Motors
3187	Cord Grip for 220 Volt Cord
2126	Pulley for 1 1/2 and 1 1/2 H.P., 60 Cycle Motors
1163	Pulley for 1 H.P. Motors
6012	Dust Cover Hood
2307	Thumb Screws
6021	Slide Sub Assembly
6021	Slide Sub Assembly
117	Gills Oiler
2030	Stud
2363	Groove Pin
2031	Spherical Washer
2509	Stop Nut
5024	Slide Clamp Stud
2020	Cross Pin
2032	Slide Clamp Shoe
6100	Micrometer Barrel Lock Screw
6020	Micrometer Assembly
6113	Micrometer Barrel (No. 6226 for Metric Grinder)
6451	Micrometer Stud Retaining Ring
6021	Micrometer Stud
6021	Micrometer Stud
6117	Micrometer Dial Lock Screw
6013	Swivel Base Casting
6046	Swivel Base Stud
6126	Swivel Base Tension Washer
2052	Swivel Base Washer

Key Part No.	Description
21 2309	Swivel Base Stop Nut
6104	Adjusting Rod Lock Screw
6110	V-Belt for 1 1/2 and 1 1/2 H.P., 60 Cycle Motors
2181	V-Belt for 1 1/2 and 1 1/2 H.P., 60 Cycle Motors
3181	V-Belt for 1 H.P. Motors
228	Motor Mount Washer
237	Motor Mount Screw
6023	Main Base
2018	Elbow Retaining Screw
6127	Dust Bag Elbow
2044	Dust Bag
6120	Exhaust Fan
3501	Cover Retaining Screws
6020	Fan Cover
6120	Spindle Pulley
32	Dust Seal
2202	Spindle Pulley Washer
2201	Left Hand Pulley Retaining Screw
2204	Arbor, Spindle and Bearing Assembly
6013	Arbor and Spindle Assembly
6107	Upper Bearing
6112	Lower Bearing
6016	Heating Spacer
2015	Lock Pin Spring
2004	Lock Pin Retaining Ring
2131	Leaf Spring
2130	Steel Ball
2275	Retent Pin
2277	Pin Spring
1044	Spring Retaining Screw
6000	Adjusting Key, Pin and Knob Assembly
6000	Adjusting Key
520	Adjusting Key Spring
6007	Adjustive Belt (Available in Cartons of 10 and
6115	Backstop Retaining Screw
6011	Belt Retaining Clip
6022	Inchometer Setting Plate (No. 6226 for Metric
6021	Grinder)
306	Name Plate
5817	Plate Retaining Drive Screws
5817	Lock Screw

*The word "in" in parenthesis in part description indicates that the complete unit is to be replaced.

NO. 8050 STANDARD CLAMP ASSEMBLY

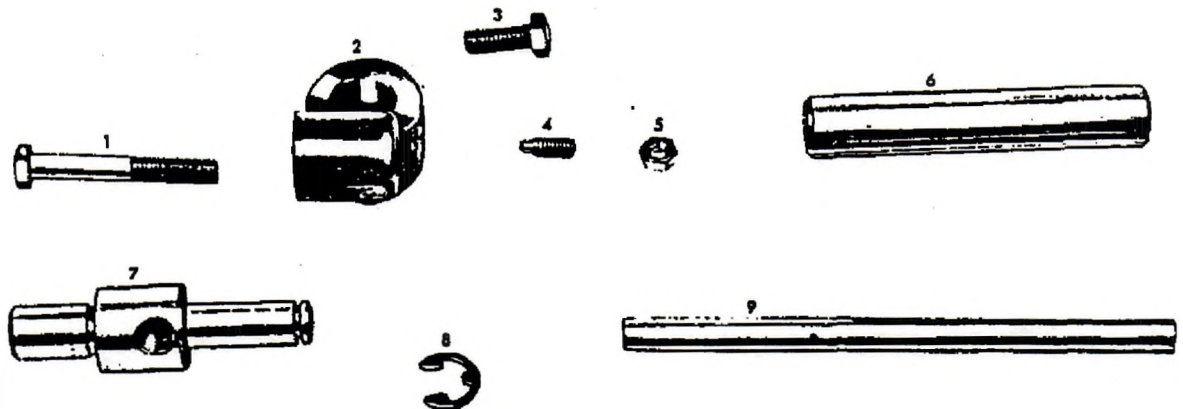


Key Part No.	No.	Description
	8050	Standard Clamp Assembly
	8051	Clamp and Rod Assembly
1	8073	Lower Shoe Clamp
2	8074	Pivot Stud
3	8052	Rod and Ratchet Key
4	8076	Upper Shoe Clamp
5	8077	Pawl Retaining Pin
6	8048	Pawl Spring
7	8063	Roll Pin
8	8065	Clamp Base Assembly
9	8070	Clamp Base
10	4006	Roll Pin 3/4" x 3/16"
11	4100	Roll Pin 5/16" x 1/8"
12	2002	Guide Rod
13	210	Set Screw
14	2022	Retaining Pin
15	8037	Operating Lever and Handle Assembly
16	8064	Operating Lever Handle

Key Part No.	No.	Description
11	8085	Operating Lever
12	2064	Swivel Block Spring
13	313	Steel Ball (2 Required)
14	8040	Swivel Block
15	8048	Upper Clamp Button
16	8061	Button Spring
17	5520	Button Retaining Ring
18	8010	Lower Clamp Button
19	8110	Button Lock Ring
20	8044	Clamp Centering Spring
21	8046	Clamp Washer
22	8107	Stop Nut
23	8062	Shoe Clamp Hood
24	7124	Fiber Washer
25	8060	Shoe Clamp Screw and Knob
26	8015	Centering Knob
27	2864	Rubber Cushion
28	4104	Set Screw

*If this part requires replacement, it is recommended the complete No. 8051 Clamp and Rod Assembly be replaced.

NO. 8100 FIXED ANCHOR GRINDING SET



Key Part No.	No.	Description
	8101	Anchor Pin and Adjusting Rod Assembly
1	3441	Positioning Rod Lock Screw
2	8104	Anchor Casting
3	4122	Anchor Casting Lock Screw
4	3322	Locating Screw
5	3828	Jam Nut

Key Part No.	No.	Description
6	8107	Anchor Adjusting Rod
7	8106	Anchor Pin
8	3810	Anchor Pin Retaining Ring
9	8102	Pivot Rod and Pin
	4202	Pivot Rod Pin

Gage Sleeves, Anchor Sleeves, and Pivot Rod Spacers for the 810 are listed in the Ammco Price List.