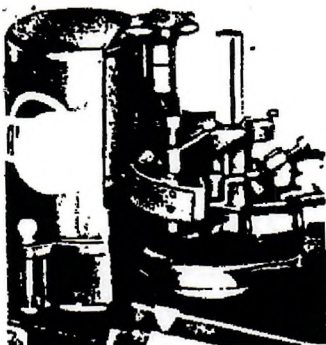


FILE NAME: AMMCO (AMC)

DATE: 1967

DOC#: AMC016

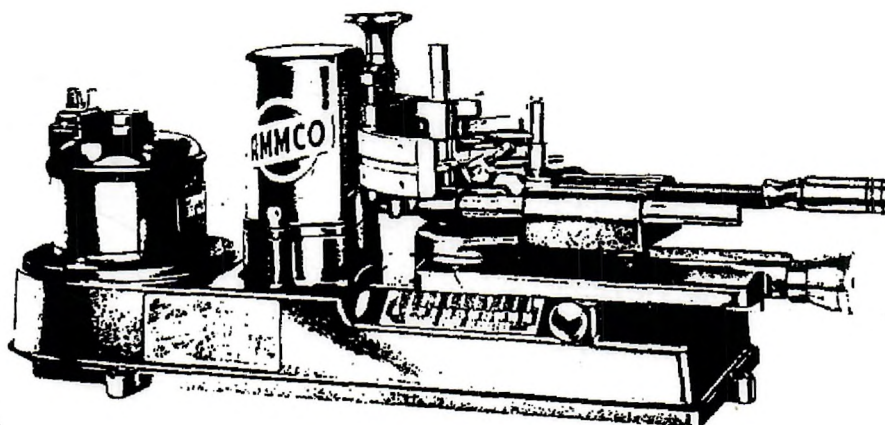
DOCUMENT DESCRIPTION: Product Description and Operating Instructions



OPERATING INSTRUCTIONS
MODEL 8000
"SAFE-ARC"
BRAKE SHOE GRINDER
 AND



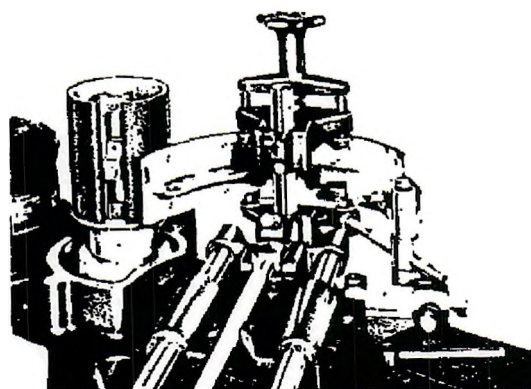
No. 8100 FIXED ANCHOR GRINDING SET



MODEL 8000 "SAFE-ARC" BRAKE SHOE GRINDER

I N D E X

SET-UP INSTRUCTIONS	2A
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BRAKE SHOE GRINDING AND RECONDITIONING	1-9



NO. 8100 FIXED ANCHOR GRINDING SET



AMMCO TOOL & MACHINE CO.

1967 AMMCO TOOL & MACHINE CO.

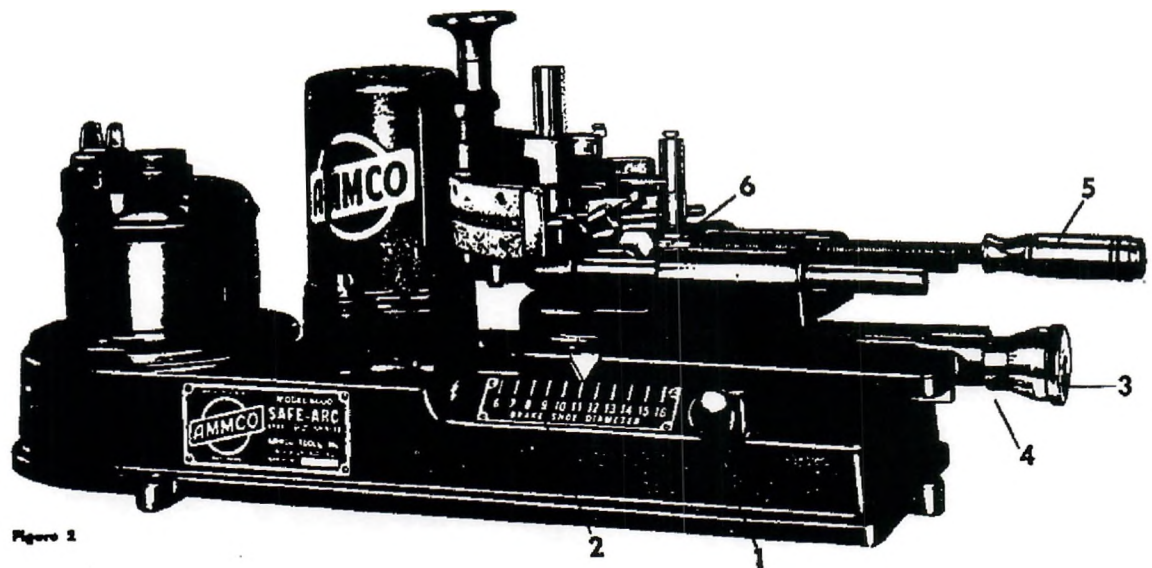
W

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).

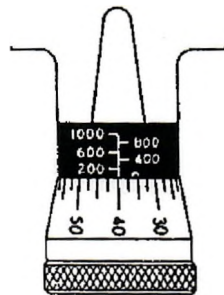


Figure 3

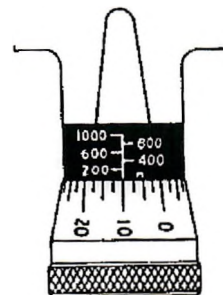


Figure 4

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.**

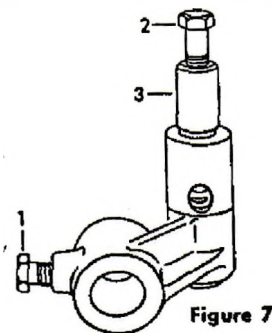
- E. Grind the shoe as in Section 6.

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).



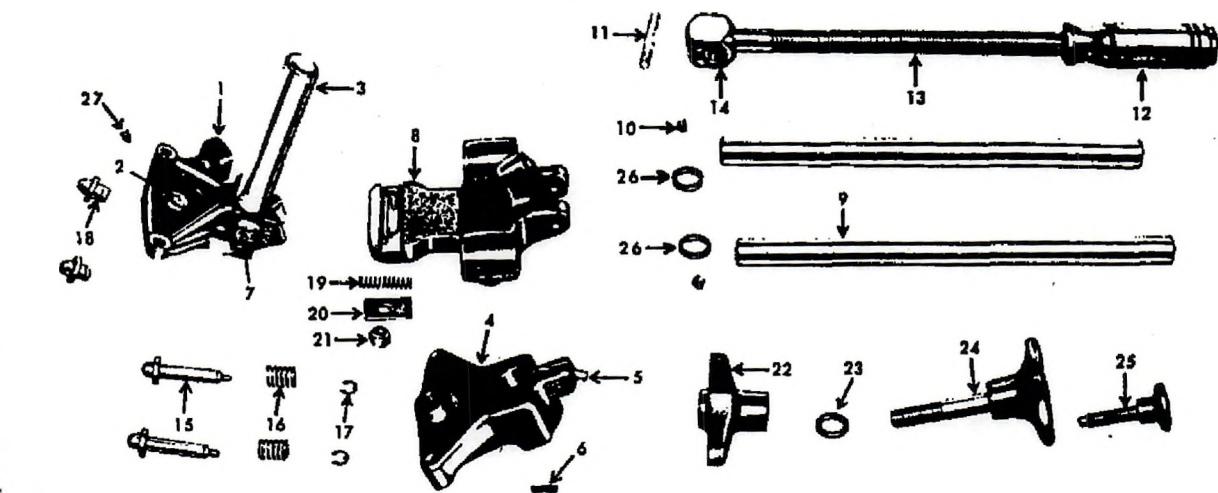
- D. Slide the Fixed Anchor Attachment (Figure 7) over Rods (C-E-Figure 6). Move the Handle (5-Figure 2) in and out until the Fixed Anchor Attachment is fully seated against the Shoe Positioning Sleeve and Gage Sleeve. Tighten Screws (1 and 2-Figure 7) firmly.
- E. Select the correct Anchor Sleeve (F-Figure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

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.

NO. 8050 STANDARD CLAMP ASSEMBLY

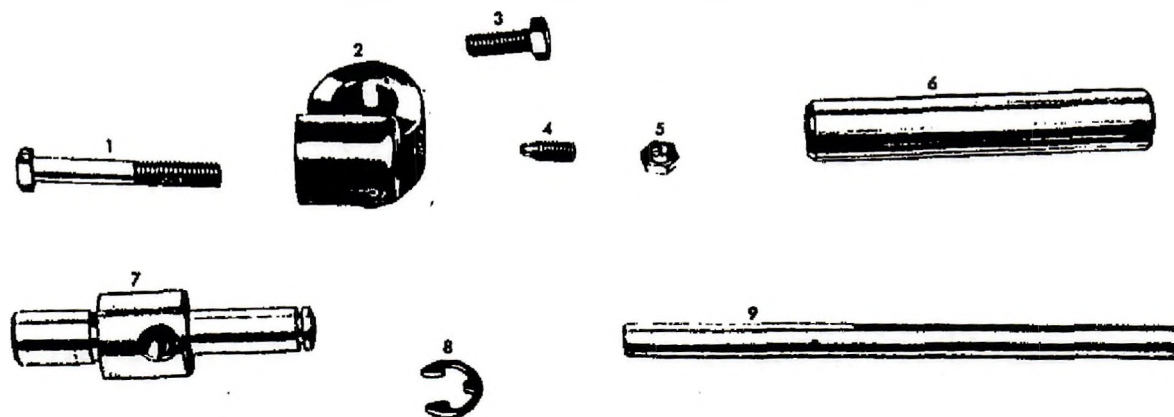


Key Part No.	Description
8050	Standard Clamp Assembly
8031	Clamp and Rod Assembly
1 • 8073	Lower Shoe Clamp
2 • 8074	Pivot Stud
3 • 8052	Rod and Ratchet Key
4 • 8076	Upper Shoe Clamp
5 • 8077	Ratchet Pawl
6 • 8108	Pawl Retaining Pin
7 • 8068	Pawl Spring
8 • 5523	Roll Pin
9 • 8055	Clamp Base Assembly
10 • 8070	Clamp Base
11 • 4096	Roll Pin 3/4" x 3/16"
12 • 6106	Roll Pin 5/8" x 1/8"
13 • 2092	Guide Rod
14 • 219	Set Screw
15 • 2022	Retaining Pin
16 • 8037	Operating Lever and Handle Assembly
17 • 8084	Operating Lever Handle

Key Part No.	Description
17 • 8085	Operating Lever
18 • 2084	Swivel Block Spring
19 • 312	Steel Ball (2 Required)
20 • 8040	Swivel Block
21 • 8043	Upper Clamp Button
22 • 4081	Button Spring
23 • 5520	Button Retaining Ring
24 • 4016	Lower Clamp Button
25 • 6110	Button Lock Ring
26 • 8064	Clamp Centering Spring
27 • 8066	Clamp Washer
28 • 6105	Stop Nut
29 • 8082	Shoe Clamp Hood
30 • 7124	Fiber Washer
31 • 4056	Shoe Clamp Screw and Knob
32 • 4055	Centering Knob
33 • 2364	Rubber Cushion
34 • 6104	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.	Description
8101	Anchor Pin and Adjusting Rod Assembly
1 • 3661	Positioning Rod Lock Screw
2 • 8108	Anchor Casting
3 • 4122	Anchor Casting Lock Screw
4 • 3522	Locating Screw
5 • 3528	Jam Nut

Key Part No.	Description
6 • 8107	Anchor Adjusting Rod
7 • 8106	Anchor Pin
8 • 3619	Anchor Pin Retaining Ring
9 • 8102	Pivot Rod and Pin
10 • 4202	Pivot Rod Pin

Gage Sleeves, Anchor Sleeves, and Pivot Rod Spacers for the 8100 are listed in the Ammco Price List.

ADDENDA TO INSTRUCTIONS FOR
MODELS 880 AND 8000 BRAKE SHOE GRINDERS

1. THE RECOMMENDED .030'' CAM GRIND MENTIONED IN POINT 3 ON PAGE 3A HAS NOW BEEN BUILT INTO THE MICROMETER SETTING OF YOUR BRAKE SHOE GRINDER. THEREFORE, DISREGARD THE EXAMPLE ''A'' ON PAGE 3A.
2. SET THE MICROMETER DIAL (3-FIGURE 2) TO THE DIAMETER OF THE DRUM IN WHICH THE SHOES ARE TO BE USED. DOING THIS WILL AUTOMATICALLY GIVE YOU THE THE CURRENT CAM GRIND.