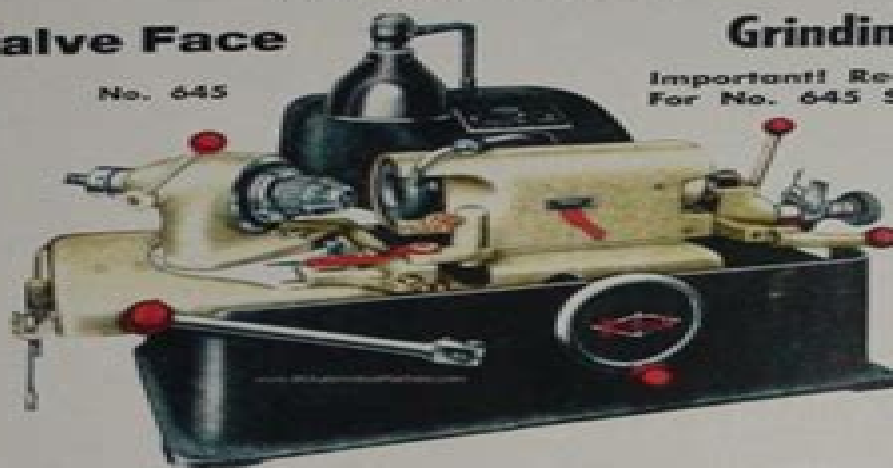




PARTS LIST INSTRUCTIONS

Sioux Valve Face

No. 645



Grinding Machines

Important! Read Carefully
For No. 645 Serial 40,001 up.

Prepare Machine For Operation

- 1.—Wipe off the shipping grease, clean thoroughly.
- 2.—Remove the Hex nut which locks the chuck slide during shipping.
- 3.—Remove the cardboard packing from under the motor.
- 4.—Lubrication—put a few drops of light machine oil in each oil cup including motor, the grinding head is permanently lubricated and sealed.
- 5.—Coolant—Use Sioux No. 250 Grinding Oil or No. 632 Concentrated soluble oil. Capacity 2 quarts.
- 6.—Run the machine a while to warm it up, seat the belts in the pulley grooves and produce smoother operation.

Very few valve stems are perfectly straight and round, therefore, do not expect to test the accuracy of your machine by grinding and then rechucking valves, as this method of testing is not practical.

Wet grinding is for all kinds of valves, gives smoother, more accurate and finished jobs. Reduces wheel dressing to a minimum.

Keep the chuck clean, it is advisable to place a rubber shield on valve stem when grinding to prevent the coolant from getting into the chuck. Avoid splashing the coolant away, a small stream is sufficient to keep the valve cool. Natural evaporation must be expected as the coolant flies off the grinding wheel in a fine mist.

Precision built, for best results, keep in a heated shop, about 70 degrees is satisfactory.

SIoux TOOLS INC.
SIoux CITY, IOWA, U.S.A. 51102

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LL Leslie



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