

GROB INC.

Installation and Maintenance

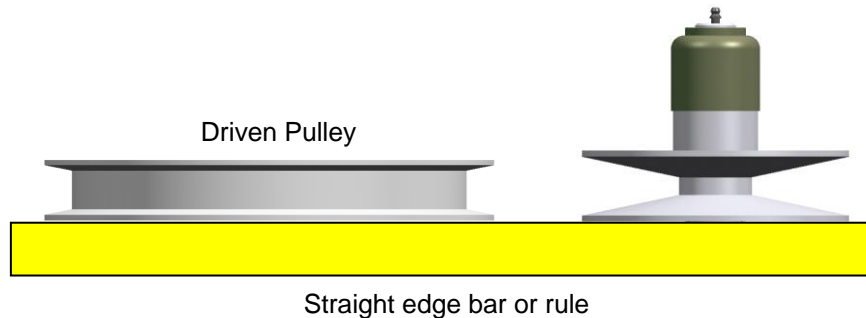
for

Vari-Drive Motor Pulley #18246

Installation

Caution: Make sure Line Switch is on OFF.

- 1 Check motor shaft and key.
- 2 Before placing key on shaft, make sure pulley slides freely. Use a fine grade of emery cloth to remove any burrs or rust. Oil motor shaft for easy future removal of pulley. *DO NOT FORCE PULLEY ON SHAFT.*
- 3 Mount Pulley on motor shaft. Position its proper alignment to the driven pulley by using a straight edge bar or rule as shown below.



Note: *Alignment must be accurate to avoid undue belt vibration or wear*

- 4 When the alignment is correct, tighten the two self locking set screws.
- 5 REPLACING BELT: Turn speed crank to move motor towards gear box until it stops.
- 6 Use a wooden wedge to spread the sheaves apart far enough to permit belt to go on both pulleys. Remove wedge and rotate pulley until belt is tight. *DO NOT PRY THE BELT ON.*
- 7 The belt should run level between the faces of the sheaves. If one side rides high with belt on an angle, investigate immediately.
Belt alignment may be the cause, or a defective belt.

(over)

MAINTENANCE

- 1 The face of the disc and belt should be kept clean and free from grease or other liquids.
- 2 **IMPORTANT:** The pulley should be run through its speed range after each several hours of operation in order to lubricate all working surfaces.
- 3 **LUBRICATION:** The lubricant to be used should be a premium lithium based grease. Grease pulley after approximately 40 hours of operation.

CAUTION: DO NOT OVER GREASE. One or two cubic inches of grease is sufficient. Too much grease could spread to belt.

Item Number	Document Number	Title	Quantity
1	#1652-B	Alemite Grease Fitting	1
2	I8241-A	Vari-Drive Shaft	1
3	5100-I25	External Retaining Ring	1
4	I8242-A	Vari-Drive Retainer	1
5	I8243-A	Vari-Drive Cup Shield	1
6	I8252-A	Spring	2
7	I8239-B	Vari-Drive Sheave, Front	1
8	I8240-B	Vari-Drive Sheave, Rear	1
9	1/4-20 x 1/4	Set Screw-Cup pt. with Thread Lock	2

3" Max.

I8351-A Key

GROB INC. GRAFTON, WIS.

Vari-Drive Pulley Assembly
for 4V Band Saws

First Used On	
Model	Serial No.
4V-18	1160
4V-24	638
4V-36	1061

NO. REQ'D	PATT. NO.	MATERIAL	HEAT TREATMENT	DRN. KS	TR.	CH.	DATE	SCALE	O.K.	Rev I	DWG. NO.
							1-29-01	1:2			I8246-A