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Information of Engine Parts

Ref. No. : HSP-B1906 Date of Issue : Oct 2019

Engine Type : All

Grinding wheel of Exhaust valve grinding machine (Maker : WAKEFIELD)

Recently, seat face with high hardness applied to exhaust valve spindle of the main engines because of reducing generation of dents and blow-by exhaust gas during operation. We introduce the grinding wheel (model number :710) with fewer holes than standard one (model number :709), assuming that it takes a long time to grind the seat face with the grinding machine, especially in large bore main engines. Grinding time can be shortened by using the grinding wheel model number :710.

Exhaust valve grinding machine



Standard grinding wheel
(model number :709)



Grinding wheel
(model number :710)



Note:

Since the grinding wheel (model number :710) has fewer holes and is more easily clogged. So we sell dresser and dresser assembly bar together as a tool for reproducing of grinding face (refer to the instructions attached). If there is a tendency of chattering during grinding, it is recommended to reduce the grinding depth of the grinding wheel (refer to the grinding machine's instruction manual).

For more information or purchase order, please contact our representative or following our sales office.

Hitachi Zosen Corporation Marine Machinery & SCR systems Business unit

Sales dept.	Tokyo	TEL +81-3-6404-0142	E-mail de-tokyo@hitachizosen.co.jp
	Osaka	TEL +81-6-6569-0502	E-mail de-hzds@hitachizosen.co.jp
	Shanghai	TEL +86-21-6887-2525	E-mail zixun_hitz@hitachizosen.com.cn
	Singapore	TEL +65-6863-1490	E-mail de-sin-branch@mml.is.hitachizosen.co.jp

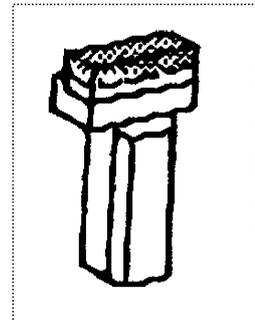
For technical queries, please also contact:

Service department	TEL +81-6-6569-0508	E-mail de-support@hitachizosen.co.jp
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WAKEFIELD EXHAUST VALVE GRINDING MACHINE TYPE 'SEG' DRESSING

dresser



1. Position the Dresser Assembly Bar (23-2) so that the Diamond Dresser (23-3) is in line with the Grinding Wheel (23). Position the Diamond Dresser to contact the Grinding Wheel.
2. Start the Grinding Motor (18) and move the Grinding Wheel back and forth over the Dresser by manipulating the Grinding Feed Handle (6-1). Increase Dressing Feed by manually pushing the Dresser harder against the Grinding Wheel (23). See Sketch.
3. It is important that the whole width of the Grinding Wheel is dressed off to the same diameter.



6-1	Grinding Feed Handle
6-2	Cutting Feed Handle
23	Grinding Wheel
23-1	Grinding Wheel Cover
23-2	Dresser Assembly
23-3	Diamond Dresser

4. It might become necessary to dress the grinding wheel several times during the grinding operation. Make sure that the dressing is done when the grinding wheel does NOT contact the seat surface of valve spindle or bottom piece.