



The Welding Accessory Experts™

Short Tungsten Grinding Kit

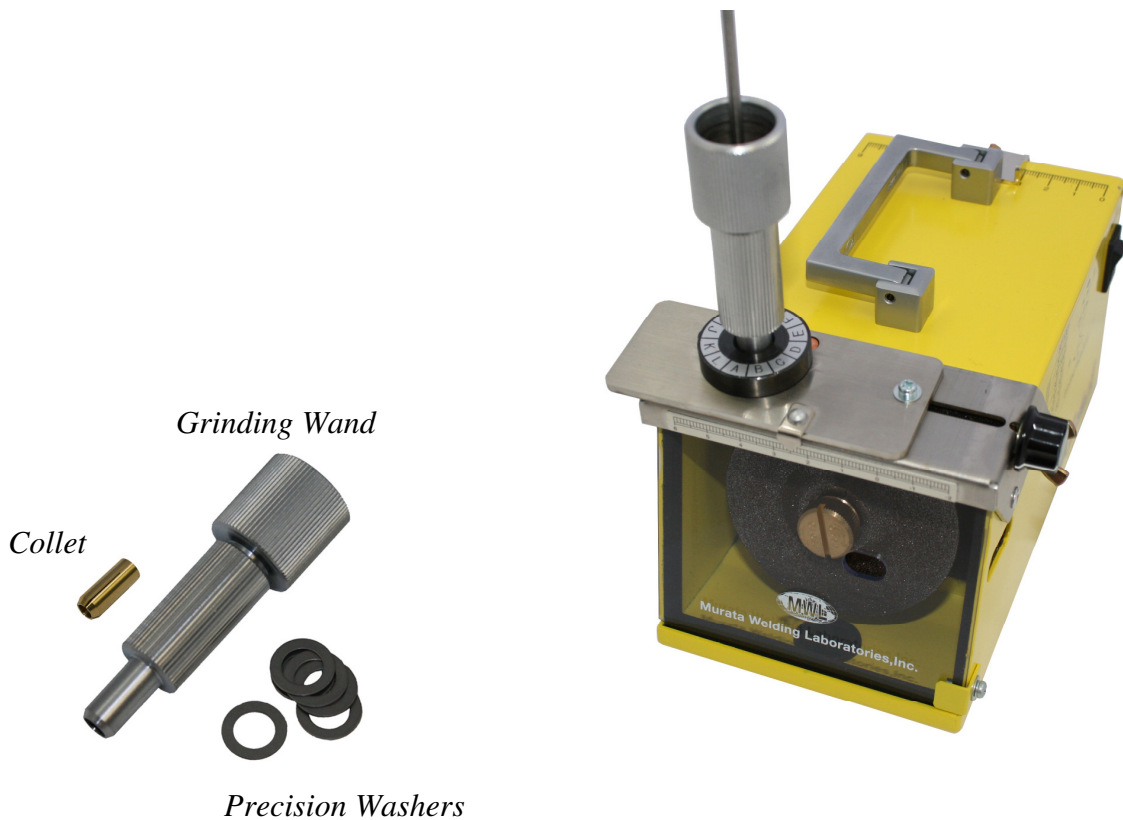
For

MWL-MT-10M Turbo 4

&

MWL-MT-11M Super Turbo Heavy

Tungsten Electrode Grinders



Operations Guide



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Thank you for purchasing Arc-Zone.com's Short Tungsten Grinding Kit for the Turbo Series tungsten electrode grinders. Please read your tungsten grinder user manual completely before operating, and contact an Arc-Zone.com technician with any questions.

Important Safety Notes:

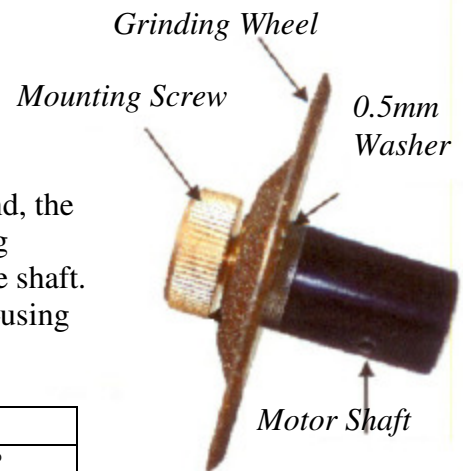
- Never open the transparent safety cover during operation.
- Never operate your tungsten grinding machine on uneven/unstable surfaces or in any position other than upright.
- Always wear proper hand and eye protection when operating this machine.
- Always take precautions for the safety of others in the immediate area while this machine is in operation.

Set-Up Procedures:

1. Set the grinding angle to less than 20° and remove the Transparent Safety Cover from your tungsten grinder.
2. Remove the Grinding Wheel.
3. Insert the appropriate number of washers.
4. Re-install grinding wheel and safety cover.

Installing the appropriate number of washers:

Depending on the diameter of the tungsten electrodes being ground, the attitude of the grinding wheel will need to be adjusted by inserting precision washers between the grinding wheel and the motor drive shaft. Note: these washers are engineered precisely for this procedure—using alternate washers may affect the quality of the grinding process.



Electrode Diameter	Angle		
	20°	30°	40°
1/16" (1.6mm)	6 Washers	6 Washers	6 Washers
3/32" (2.4mm)	5 Washers	6 Washers	6 Washers
1/8" (3.2mm)	4 Washers	5 Washers	6 Washers

Use the Electrode Gauge at the rear of the machine to set every electrode at the exact same position in the grinding wand—this will give you the exact grind specifications on every electrode. See the reference chart below for suggested set-up specifications.

Electrode Diameter	Angle		
	20°	30°	40° +
1/16" (1.6mm)	15mm	19mm	20mm
3/32" (2.4mm)	27mm	27mm	29mm
1/8" (3.2mm)	30mm	30mm	29mm

