

INSTRUCTIONS

Attaching Table Kit (001-962) to the Power Hone model B

This table kit allows the GRS Power Hone (model B only) to be converted to an Accu-Finish SERIES ONE.

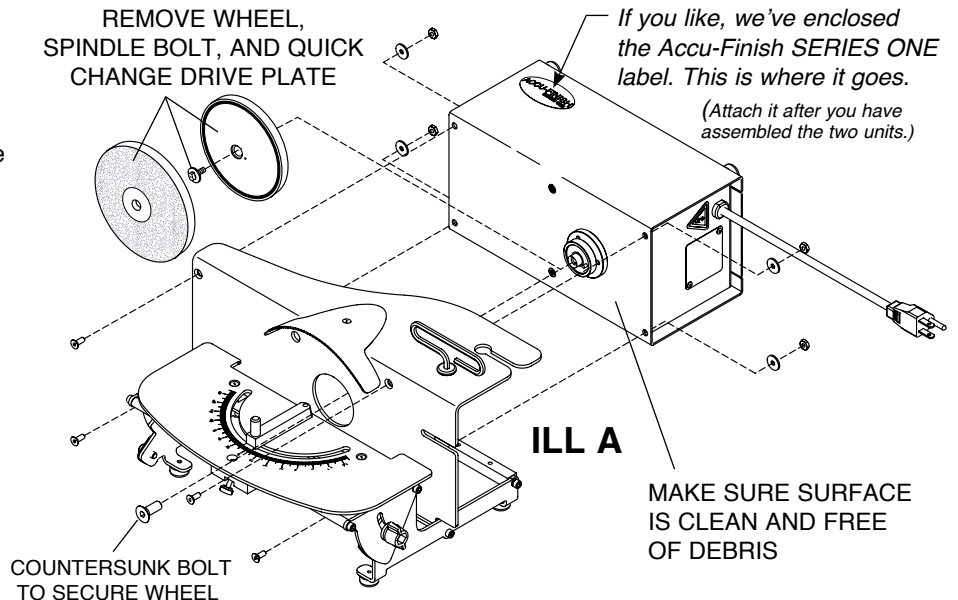
Unplug machine and remove the grinding wheel. Using a 3/8" wrench remove the Spindle Bolt from the center of the Quick Change Drive Plate and lift off plate. Clean the top surface to make sure it is free from all dirt and debris. Notice a hole located at each corner on the top. These are the attachment holes for the table assembly. Turn the Power Hone on its side position the body into the table assembly as shown in **ILL A**. Align the holes as shown and attach with the four 10-32 x 1/2" flat head socket screws, washers and nuts. Make sure there are no obstructions between the two surfaces. When attached, the top of the Power Hone and the inside back of the table assembly should be flush together.

Remove the bottom two rubber feet from the Power Hone (See: **Detail - B**). Press the bolts out of the rubber feet and replace the bolts back in the holes they came out of.

Now, pivot open the machine to the horizontal position by releasing the main body with the lever located under the machine. Mount the finest grit diamond wheel you have. Return the body to the vertical position and lock it back into place. To calibrate the table, start with the side table angle first. Loosen the table locking knobs (one located at each end of the table) until it move freely. Using a square pressed tight against the wheel (See: **ILL C**), lift the table against the other side of

the square and tighten the table locking knob. Double check that the table is truly square with the wheel.

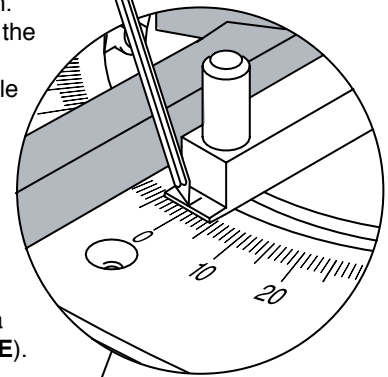
REMOVE WHEEL,
SPINDLE BOLT, AND QUICK
CHANGE DRIVE PLATE



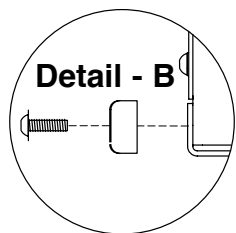
NOTE: Depending on the size of your square it may require the wheel guard be removed. Loosen the bolt that holds the adjustable "zero" mark (See: **ILL C - arrow**) with a hex wrench. Align the mark on the tab with "0" degree on the scale and tighten bolt snugly.

Calibrate the table protractor with the table angle set at 0°. Loosen the tool guide so it moves easily. Place the square against the wheel as shown in **ILL D**. Press the tool guide against the square and lock into position. Double check that all is square. Now, you will need to make a mark that registers with the "0" degree mark on the table. You can use a metal scribe or stamp a mark with hammer and chisel (See: **Detail - E**). Before doing so, triple check to make sure the tool stop is square with the wheel.

Detail - E
MAKE REGISTER MARK

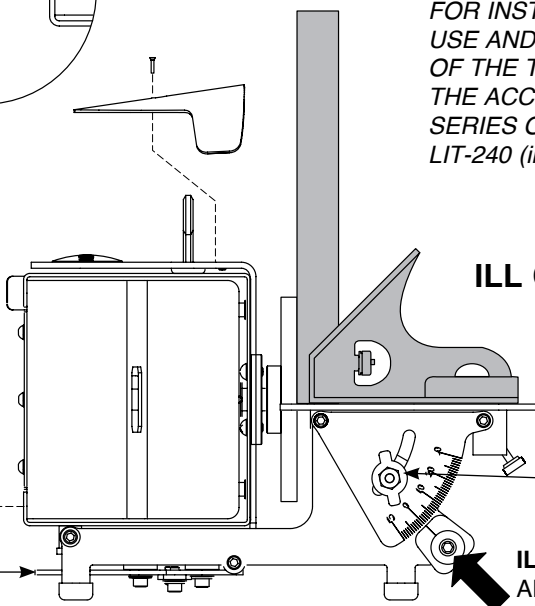


FOR INSTRUCTION ON
USE AND MAINTENANCE
OF THE TABLE SEE
THE ACCU-FINISH
SERIES ONE MANUAL
LIT-240 (included)



REMOVE
BOTTOM
TWO
RUBBER
FEET.
REPLACE
BOLTS.

UNIT
RELEASE
LEVER



ILL C

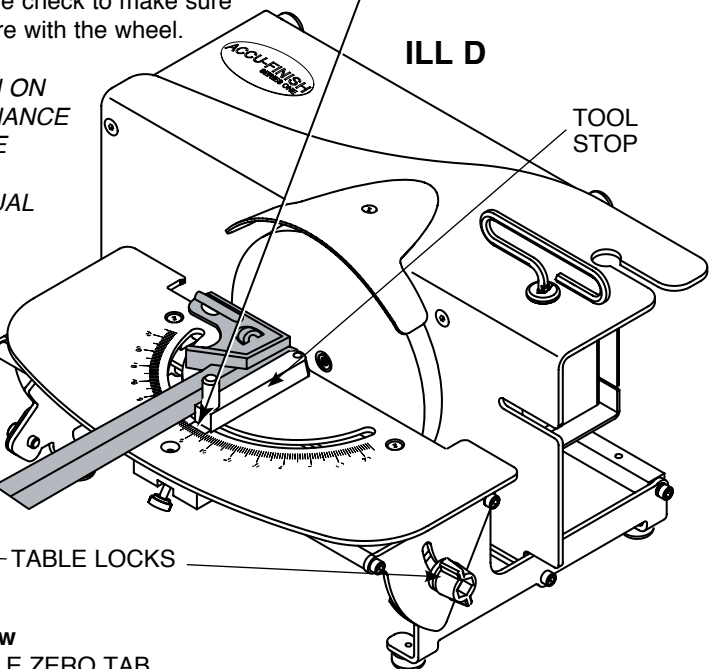
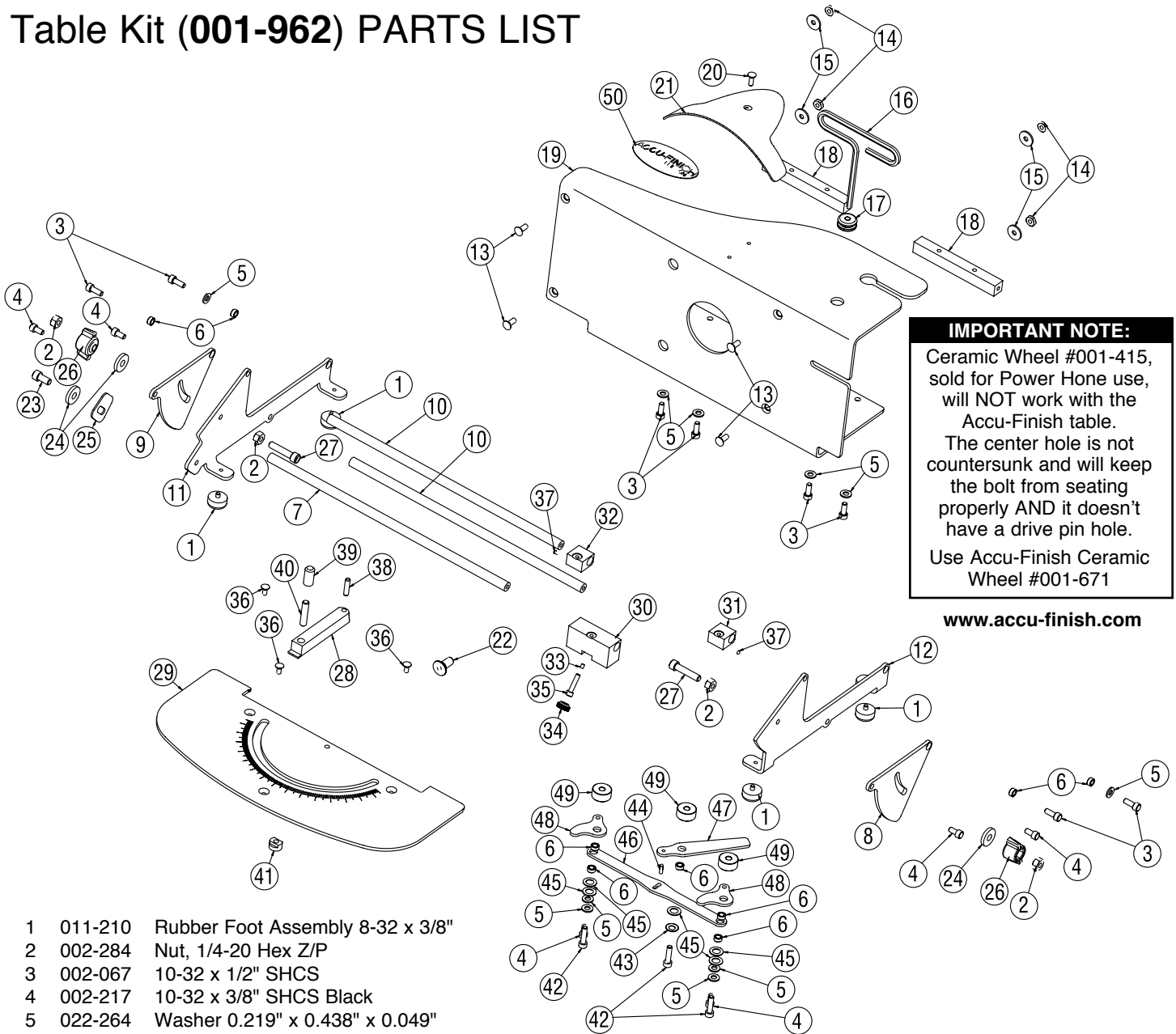


TABLE LOCKS

ILL C - arrow
ADJUSTABLE ZERO TAB

Table Kit (001-962) PARTS LIST



IMPORTANT NOTE:
 Ceramic Wheel #001-415, sold for Power Hone use, will NOT work with the Accu-Finish table. The center hole is not countersunk and will keep the bolt from seating properly AND it doesn't have a drive pin hole. Use Accu-Finish Ceramic Wheel #001-671

www.accu-finish.com

- 1 011-210 Rubber Foot Assembly 8-32 x 3/8"
- 2 002-284 Nut, 1/4-20 Hex Z/P
- 3 002-067 10-32 x 1/2" SHCS
- 4 002-217 10-32 x 3/8" SHCS Black
- 5 022-264 Washer 0.219" x 0.438" x 0.049"
- 6 011-440 Pivot Bushing
- 7 011-438 Guide shaft for AF1
- 8 011-428 Pivot plate RH
- 9 011-429 Pivot plate LH with markings
- 10 011-439 Guide shaft for AF1
- 11 011-436 Left hand frame part AF1
- 12 011-435 Right hand frame part AF1
- 13 002-492 10-32 x 1/2" FHSCS
- 14 002-109 Nut, 10-32 Hex Z/P
- 15 002-247 Washer, 0.191" x 0.628" x 16 gauge
- 16 002-310 3/16" T handle
- 17 022-244 3/16" ID Rubber Grommet
- 18 011-442 Pivot block for Power Hone body
- 19 011-437 Mounting Bracket for AF1
- 20 002-993 Screw, 8-32 x 7/8" FHMS
- 21 011-431 AF1 Wheel Guard
- 22 002-293 5/16-18 FHSHCS x 0.625"
- 23 002-107 1/4-20 x 1/2" SHCS Black
- 24 022-307 Washer, 0.275" x 0.75" x 0.125"
- 25 011-430 Adjustable Zero Tab
- 26 022-906 Mico plastics part 29WN014B (black)
- 27 002-900 1/4-20 x 1 1/8" SHCS
- 28 001-240 Tool Guide

- 29 011-427 Table - stainless steel for AF1
- 30 011-441 Front slide block
- 31 001-144 Right hand slide block
- 32 001-160 Left hand slide block
- 33 011-443 Nylon pill for friction and to prevent shaft damage
- 34 022-056 Knob
- 35 002-398 8-32 x 3/4" SHCS
- 36 002-175 8-32 x 3/8" FHMS
- 37 002-171 2 Type U Drive Screw
- 38 002-178 Pin, dowel 3/16" x 3/4"
- 39 001-149 Knurled Knob
- 40 001-357 Stud, 1/4-32 x 1 1/8" long
- 41 011-444 T-nut
- 42 002-567 10-32 x 3/4" SHCS Black
- 43 022-301 Belleville washer
- 44 002-770 Pin, driv-lok 1/8" x 3/8" Type H
- 45 022-189 Washer, flat plastic
- 46 011-433 Tie bar
- 47 011-434 Lever to work lock linkage
- 48 011-432 Locking tab
- 49 011-445 Spacer for locking tab and handle
- 50 011-447 Accu-Finish oval label

GLENDO
CORPORATION

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www.accu-finish.com
www.GrsTools.com