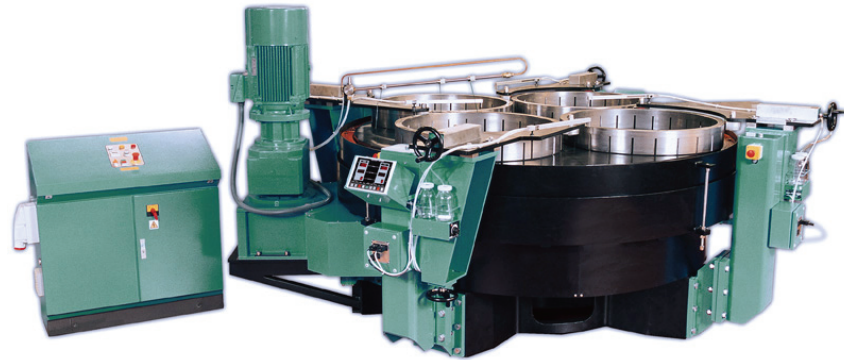




MODEL 84

PRECISION OPEN FACE LAPPING MACHINE



- The Lapmaster Model 84 machine for standard duty applications is equipped with four work stations.
- The machine includes a fabricated base assembly with segment support plate, splash trough and four equally spaced pillars. The four roller yokes and splash trough are mounted off pillars. The yokes can be positioned independently inboard or outboard for conditioning ring placement required to maintain a flat lap plate. The four conditioning rings are driven by the friction of the rotating lap plate and guided on the O.D. by the yokes and bearing assemblies.
- A thirty gallon capacity floor standing slurry tank and pump assembly is included. The abrasive distribution system will have the continuous agitation feature which permits the pump to keep running after the lap plate times out. This insures that the abrasive is kept in proper suspension at all times even between lap cycles. Also included, is a four feed slurry distribution feature which supplies a regulated flow of abrasive and vehicle equally to all four work stations on the lap plate.
- Automatic timing device to permit setting a pre-determined lapping cycle for machine operation.
- Non-hardened cast alloy segmental lapping plate 84" in diameter approximately 5" thick. Also, four 35" O.D. x 32" I.D. 7" high non-hardened cast alloy conditioning ring assemblies with serrated and lapped conditioning surfaces.
- One (1) Main Drive Motor, 40 H.P., 230/460 Volt, 60 cycle, 3 phase.
- Special high torque gear reducer.
- Electrical controls, 110 volt, single phase, 60 cycles actuated through a transformer for operation on 230 or 460 volts. Wired to National Electrical Code Standards unless otherwise specified.
- Equipped with a power factor controller for energy conservation. Attachment automatically adjusts the drive motor voltage to meet the load requirements while maintaining full motor speed and torque availability. Also provides smooth, stepless acceleration through the gear reducer, reduces motor operating temperatures and eliminates sudden, high torque start up.
- As an option, this machine can be equipped with a bridging support and pneumatic lift mechanism to raise and lower the concentrically grooved pressure plates and to provide additional down pressure. This equipment consists of an air cylinder mounted on each of the four stations. Each cylinder is individually controlled.
- Four (4) micarta workholder blanks. 32" diameter x 1/2" thick.



MODEL 84

STANDARD TOOLING

- Cast iron serrated lapping plate. (Dimensions as above.)
- Four cast iron serrated conditioning rings. (Dimensions as above.)
- Starter sample of Lapmaster abrasive
- Starter sample of Lapmaster lapping vehicle
- Set of Allen keys.
- Operation and maintenance manual.
NOTE: No pressure weights or felt pads are supplied as standard, as for most work using this size of machine sufficient lapping load is obtained from the weight of the components themselves. These items can be offered on request.

AVAILABLE OPTIONS

- 3 ring model.
- Variable speed lap drive (using frequency inverter).
- Water cooled lap plates.
- Non-standard voltages.

SPECIFICATIONS

LAP PLATE DIAMETER	2434 MM	84 INCHES
DIAMETER OF LAP PLATE CENTER RECESS	457.2 MM	18 INCHES
WEAR LIFE	100 MM	4.0 INCHES
MATERIAL	CAST IRON	
LAP PLATE IS MADE UP OF 16 INDIVIDUAL SEGMENTS BOLTED TO A SUPPORT PLATE TO FORM A SERRATED PLATE		
MAXIMUM SINGLE POINT LOADING ON LAP PLATE	2700 KG	6000 LBS.
NUMBER OF CONDITIONING RINGS	4	
INNER DIAMETER OF CONDITIONING RING	813 MM	32 INCHES
OUTER DIAMETER OF CONDITIONING RING	889 MM	35 INCHES
WEAR LIFE OF CONDITIONING RING	89 MM	3.5 INCHES
WORKING HEIGHT OF MACHINE	1520 MM	59.8 INCHES
WIDTH OF MACHINE	2600 MM	102.4 INCHES
LENGTH OF MACHINE	2600 MM	102.4 INCHES
ABRASIVE TANK CAPACITY	31 U.S. GALLONS	
WASTE TANK CAPACITY	37 LITERS	9.6 U.S. GALLONS
MAIN DRIVE MOTOR	30 KW	40 HP
ABRASIVE PUMP AND MOTOR	3/4 HP	