

Instructions For Motorized Machine

Measure the rough bung with the slide-rule and adjust the bung hook to the correct notch setting. Lift the centering pin and prop up the loop on the motor casing. By pressing the balance lever, adjust the opening between the wide polishing wheel and the bung hook. Then clamp the bung in the notch. The edge screw is turned via contact with the balance lever and, according to the roughness of the bung, is either left as is or loosened 1 to 3 screw notches. After app. 2 seconds, after the rolling wheel has come to a stop, turn off the machine, tighten the edge screw by 3 screw notches so that the rolling wheel is no longer touching the bung, and turn it on for another 2 seconds for a fine polishing job.

Hold the designated piece, wheel, or shaft to be polished with your thumb and middle finger and set the centering pin by guiding it with your index finger in the loop. Turn the motor on and let it run for 1 to 2 seconds. The designated piece to be polished should be securely fastened so that it can't turn with the polishing wheel. When polishing **minute wheels with second friction**, secure the shaft with a carriage so that it doesn't rotate. For bungs with a 3,6 mm or larger diameter, the piece can be rolled without using corner pressure for centering. If the motor belt happens to slip with thick, rough bungs, secure the wheel, turn on the motor and let it run a bit before letting the wheel rotate.

Pocket watch and wristwatch minute wheels must be fastened to a shortened pin hook, held between thumb and index finger, and centered with the centering pin.

When rolling soft bungs, set the balance spring on very low tension - for hard bungs, tighten the tension with the regulating button. For thin bungs with a minimum diameter of 0.4 mm, set the regulating button on the lowest tension, position the corner screws so that they are touching the balance, and roll for only 1 second.

Plastic bungs can be rolled normally.

If you want to roll or create conical bungs, you should: choose smaller notches for bungs that gradually get thinner externally; choose larger notches for bungs that gradually get thinner internally.

The rolling wheel should not scrape along the hook, otherwise the bung will not turn out smoothly. Keep the rolling wheel comb oiled while rolling to prevent the wheel from slipping. Keep the felt well-oiled. In case the felt becomes littered with polishing shreds, remove the felt, clean it thoroughly, and oil it before replacement. In order to remove the felt, screw the rolling wheel to the middle setting and release the wire spring.

Always keep the edge nuts tightly fastened.

To prevent soiling, cover the machine with a plastic bag when not in use.

To change the rolling wheel:

Remove oilers, loosen the balance spring by pulling out the regulating knob, unscrew the grooved nuts. Pull up the rolling wheel while simultaneously moving the balance back and forth.

To oil the rolling wheel bearings:

Clean the bronze bearing shaft of the rolling wheel as well as the rolling wheel bore hole with a cloth that has been dipped in gasoline.

Coat the bronze shaft including the groove and the rolling wheel bore hole with thick pendulum oil.

The bore holes and teeth of new rolling wheels have been pre-oiled.

Place rolling wheel on bronze shaft and screw on the grooved nuts.

The oil should fill the air hole at the top of the grooved nut.

Careful: Hard metal cracks easily if bumped with a hard object.

Adjusting the height of the rolling wheel:

Check the height of the rolling wheel: if there is a slight gap between the rolling wheel and the hook, the rolling wheel should be only a slight bit above the hook.

Place a straight slide-rule on the top of the hook that also touches the end of the rolling wheel. If the rolling wheel height isn't correct, the height of the balance has to be adjusted. Adjust the balance by turning the two screws near the balance bearing. The top screw is painted red. The lower screw can be adjusted by using flat-nosed pliers or an Allen key. Keep in mind the height of the balance.

If you own two rolling wheels and they vary somewhat in height, choose the setting for the flatter rolling wheel. Since the wheel can stand a bit higher, this spares you from having to readjust the height every time you change wheels.

Since the bore holes vary by $\frac{1}{2}$ of a 100th, the rolling wheel may get caught on the bronze shaft. Should this happen, send the rolling wheel back so we can replace it with a wheel with slightly larger bore holes.