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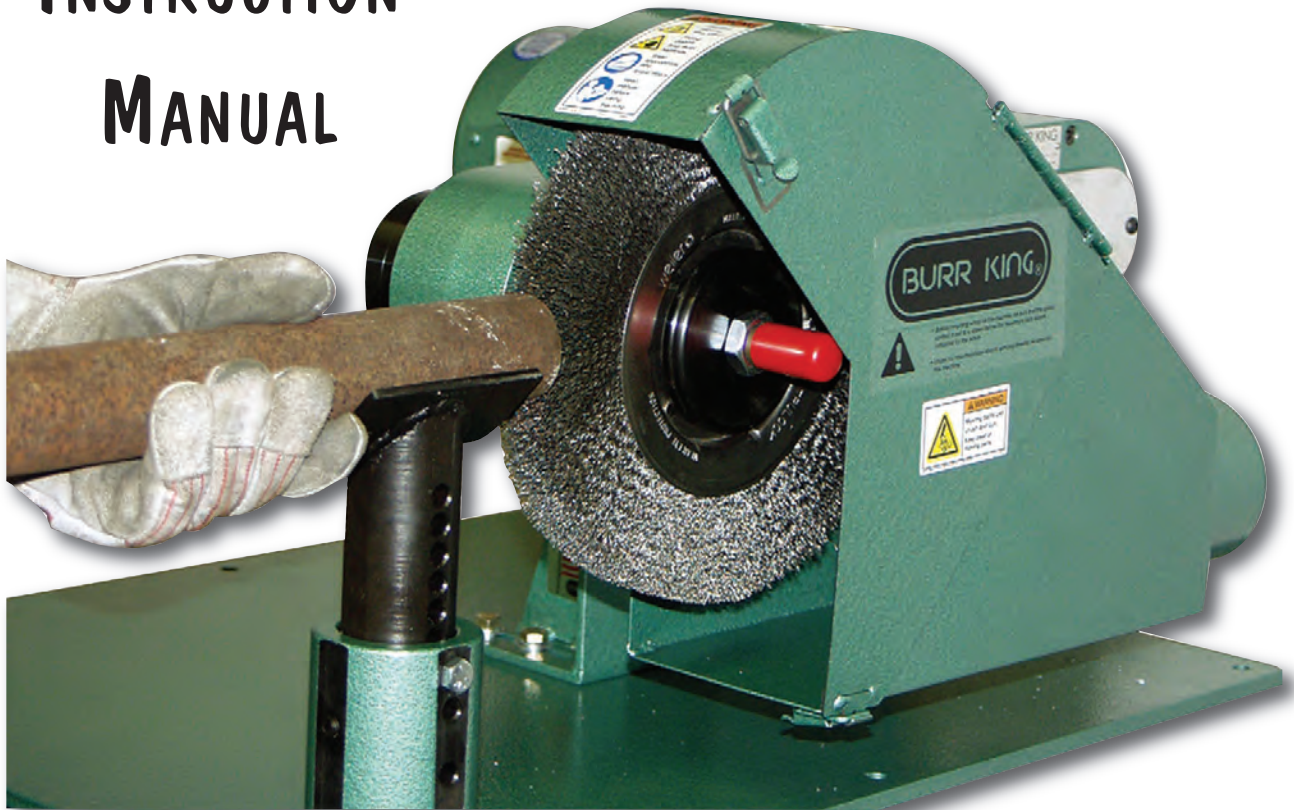
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MODEL 1050

INSTRUCTION

MANUAL



MADE IN U.S.A.



- * GRINDERS
- * BUFFERS
- * VIBRATORY
- * DISC GRINDERS

BURR KING

MODEL 1050

TUBE FINISHER /

SINGLE SPINDLE LATHE



June, 2007

Burr King Manufacturing Company, Inc. warrants the below product to be free in material and workmanship. The period of warranty is 1 year (90 days for vibratory bowls of 20 quart and lesser volume) from the date of purchase. No warranty is provided for products that have been modified, abused, handled carelessly, where repairs have been made or attempted by others, or for freight damage. No warranty is provided for three phase electric motors, controllers, etc. when the motors, controllers are not protected by magnetic starters that were supplied and installed by Burr King Manufacturing Company, Inc. No other warranty, written or verbal is authorized by Burr King Manufacturing Company, Inc.

During the warranty period Burr King Manufacturing Company, Inc (or its authorized suppliers or agents) will replace or repair the below product without charge if the product is found by Burr King Manufacturing Company, Inc. to be defective. To receive warranty services you must contact Burr King Manufacturing Company, Inc. and receive authorization fir warranty service. Unless otherwise authorized by Burr King Manufacturing Company, Inc. Products (see * below) must be returned to the factory to receive warranty service.

*Motors, speed controllers, and certain other accessories are warranted by their respective manufactures. To receive warranty service on these items you must contact a brand label service center that supports the product in need of service. Burr King Manufacturing Company; Inc. will assist you in locating a service center.

For the first thirty days after purchase, and when Burr King Manufacturing Company, Inc. authorizes warranty service, we will pay normal and necessary surface freight charges both ways (except for items in *). After thirty days the customer is responsible for all freight charges. Where possible Burr King Manufacturing Company, Inc. may elect to make on site service and/or repairs necessary to return the product to serviceable condition.

To assure prompt warranty service it is necessary that you complete and return the below warranty information to Burr King Manufacturing Company, Inc. please **FAX** or **MAIL** at your convenience.

Product model: _____ Serial number: _____
Date Purchased: _____ Purchased from: _____
Address: _____ City: _____ State/Prov: _____ Postal code _____

Your company name: _____
Address: _____ City: _____ State/Prov: _____ Postal code _____
Phone: _____ Fax: _____ Email: _____
Your name: _____ Title: _____

How did you learn about Burr King products?

Trade show ___ Web ___ Industrial Distributor ___ Advertisement ___ Other _____ Which one: _____

What is the intended use of this product? _____

Please indicate the general work types performed at your company, check all that apply:

Fabrication ___ Machining ___ Casting ___ Molding ___ Welding ___ Finishing ___ Assembly ___ Research ___ Other ___

Please indicate the primary product focus of your company; check all that apply.

Aircraft/Missile ___ Automotive ___ Contract machine ___ Contract Fabrication ___ Agricultural ___ Maintenance ___ Recreational ___
Job shop ___ Foundry ___ Construction ___ Arts ___ Orthopedic ___ Dental ___ Medical ___ Other _____

Please tell us what we can do to improve our products:

May we contact you? Yes ___ No ___

Thank you for purchasing Burr King products!

**REGISTER ONLINE @
WWW.BURRKING.COM**



December 2005

Operating instructions for the Model 1050 tube finisher

The Model 1050 tube finisher is a single spindle finishing machine. It is designed to use cotton, nylon, flap, wire, and other finishing and/or de-burring wheels. Your Model 1050 may be fixed speed (single or three phase), or variable speed single phase depending on the configuration ordered. The Model 1050 has an integrated dust collection adapter that will connect to a dust collection system with a recommended minimum capacity of 500 CFPM.

Stone, vitreous, or other type grinding wheels must not be used on the Model 1050. For maximum effectiveness, and operator safety use wheels manufactured by well-respected manufacturers.

- Use wheels that are the proper size and type for your machine.
- Do not use wheels that are old and/or excessively worn.
- Do not operate the finishing wheel in a reverse rotation. The spindle must rotate CCW when viewed from the right side (opposite of the motor).
- Do not exceed the maximum recommended buffing wheel speed (see the manufacture's instructions), or the 2000 RPM spindle speed for which your Model 1050 is designed to operate, whichever is less.
- Do not use your Model 1050 with the factory-supplied guards removed, or with the wheel guard door(s) open.

Prior to operating the Model 1050 please take time to do the following:

1. Insure that you have received all of the items that you ordered. Compare the packing slip with your purchase order, and of course with the physical items received.
2. Verify that there is no obvious shipping damage. If shipping damage is discovered notify the freight carrier of your intention to file a freight damage claim; they will assist you.
3. Verify that the AC power that is identified on the machine matches the AC power that you intend to operate the machine. Do not modify the Model 1050 wiring or other electrical controls without the advice of the factory or a competent electrician.
4. Do not modify or defeat any AC wiring safety feature. In example, do not remove the grounding pin on the AC plug.
5. Read the Operator, and Operating Area Safety Instructions carefully. Insure that all persons who will operate the Model 1050, or who will work in the vicinity of the Model 1050 read understand, and comply with these instructions.
6. Insure that the Model 1050 is located in an area that provides safe access to the machine such that operators have clear and unobstructed working space. The work place should be free from floor obstructions, trip points, and other faults that may reduce operator safety.
7. Insure that the Model 1050 AC power source is properly sized for wire, and properly fused. All wiring, circuit breakers, fuses, and connections must conform to national electrical and local codes.

8. All three phase electrical installations must include a magnetic starter. Magnetic starters protect motors from “double phasing”, overheating, etc. thereby reducing the risk of damage to the equipment and/or fire hazard to your facility. Three phase motors are not warranted if used without a magnetic starter or other suitable device.

Functional operating instructions for the Model 1050 buffer

The Model 1050 was fully tested and verified to comply with requirements prior to shipping from the factory. No adjustments should be necessary. You should perform the following steps:

1. With the machine securely bolted to its table, pedestal, and/or floor point connect the AC power to its source.
2. Insure the buffing wheels are firmly tightened to the spindle. A finishing wheel running in reverse rotation can unscrew from the spindle, creating a serious personnel safety hazard. Insure that the Model 1050 spindle operates CCW when viewed from the right side of the machine. The right spindle has a right-hand thread.
3. Your model 1050 has been shipped to you with 1 cap plug on each end of the spindle it is very important that once you have selected the wheel you will be using on your machine that you cut the plug to the size of the exposed thread. Failure to do so may expose the operator to risk of injury should clothing or loose objects become snagged on the exposed area.
4. Engage the motor. The wheel should rotate smoothly in a CCW direction with the front face of the finishing wheel moving toward the floor. If either of these conditions are not met turn the machine OFF immediately.
5. If the Model 1050 runs in reverse direction you must correct this by changing the main drive motor rotation direction. **FIRST DISCONNECT THE MACHINE FROM ITS AC POWER SOURCE. A COMPETENT ELECTRICIAN SHOULD PERFORM ALL ELECTRICAL WORK ON THE MODEL 1050.**

All single phase Model 100 buffers are set up for correct rotation at the factory. The phasing of your “in-house” electric service will effect three phase Model 1000 rotation.

If your Model 1050 is equipped with variable speed control the wheel speed can be adjusted using the speed control that will be mounted on the motor or on a separate control box.

Maintenance

FIRST DISCONNECT THE MACHINE FROM ITS AC POWER SOURCE.

Every thirty days or if the drive belt slips check the drive belt tension To adjust the belt tension:

- Remove the two screws that secure the aluminum cover plate on the right side of the main casting.
- Loosen (do not remove) the two elastic nuts (use a 9/16 inch socket) inside the main frame near the rear drive pulley. Use care not to nick or otherwise damage the pulley. The pulley has a series of shallow groves that drive the Micro-V flat drive belt if so equipped. Any damage to the groves will shorten belt life significantly.
- Pull the main frame forward in respect to the motor. The frame will slide across the motor face with the above elastic nuts loose.
- The belt is properly tensioned when a force of approximately 5 pounds will deflect the belt approximately ¼ inch near the center of the belt track.
- Tighten the two elastic nuts and reinstall the cover plate.
- Vacuum or otherwise remove dust and debris build-up regularly from the machine.

Note that the 1050 machine can accommodate finishing wheels to 2 inches in width but never larger than 10 inches in diameter. When mounting a wheel on the machine adjust the position of the wheel in respect to the angle steel work support. Loosen the bolts that secure the motor stand and the frame brace and slide the machine left or right as necessary to center the wheel.

There are no other maintenance actions required. All bearings are sealed for life and require no lubrication.

Remember for operator safety and the continued effectiveness of your Model 1050:

Do not defeat the safety guards and other safety provisions of the Model 1050.

Do not reach inside the safety guards while the machine is running. To do so is hazardous.

Do not use fluids in your finishing process unless your Model 1050 is designed for liquid operation (NEMA 4, 4X). To do so may create an electrical safety hazard.

Do not use your Model 1050 to polish explosive materials unless it is equipped with explosion proof electrical devices and motor.

Do not mix alloys in your buffing. To do so may create an explosion hazard.

Do not use stone or vitreous wheels on the Model 1050. To do so will create an operator safety hazard.

Do use eye, hand, face, arm, leg, feet and body protection that is adequate to protect against flying debris, forcibly ejected work pieces, etc.

Do not wear loose fitting, or hanging clothing that might become entangled in the rotating wheels, or shafts.

Do train operators and others in safe operating practices.

Additional safety warnings for the 1050 single side machine:

Danger: A gap (nip point) exists between the face of the finishing wheel and the angle steel work support. This gap is necessary for the operation of the machine; however, it does create a nip point that can cause serious bodily injury. KEEP CLEAR OF THIS GAP.

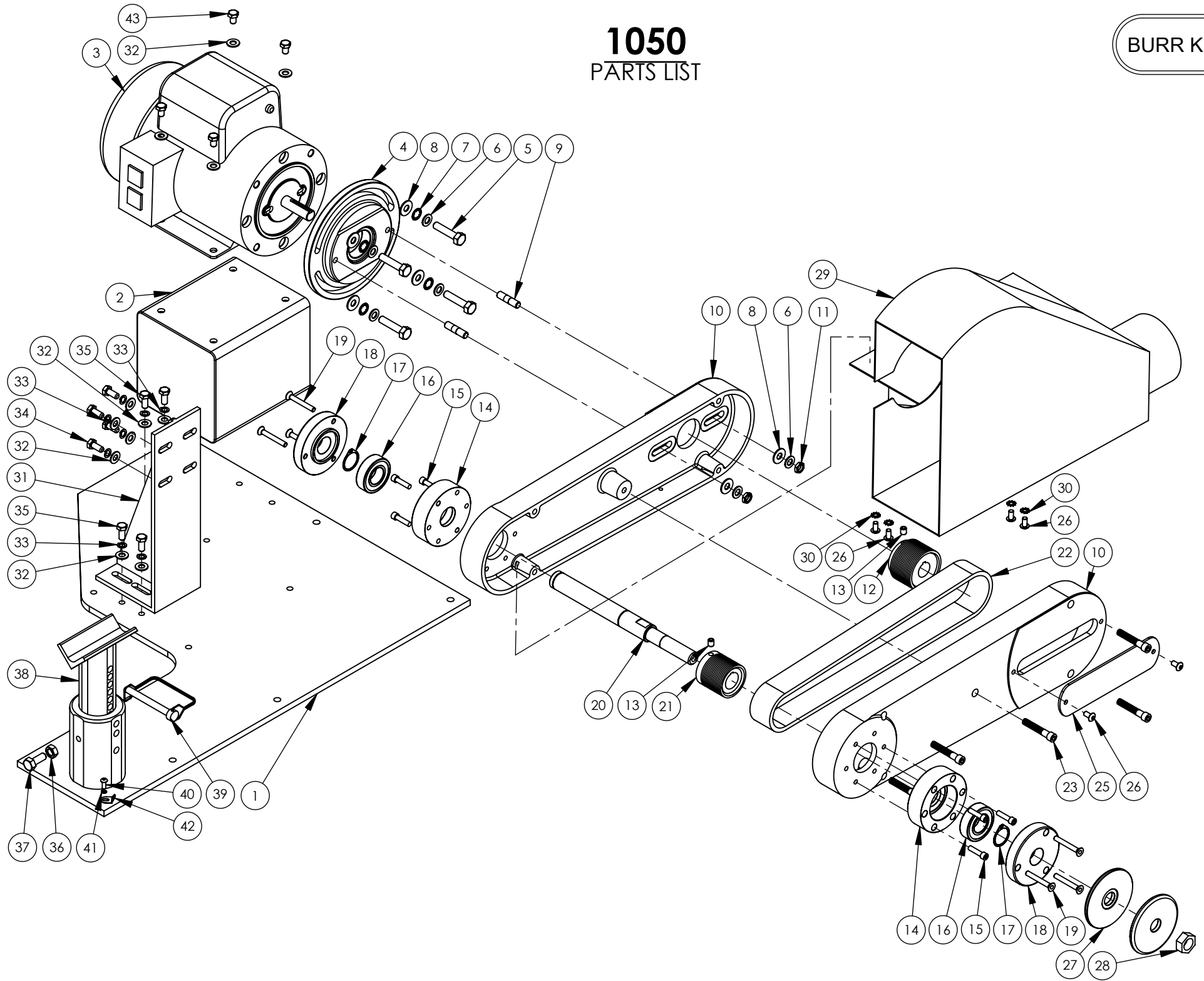
Wire wheels can and do shed wire particles that can puncture skin and other body tissue. Never operate this machine without using proper personnel protection. Consult with your safety officer!

Post these or equivalent instructions such they are available for ready operator reference.

1050

PARTS LIST

BURR KING



1050			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	99-0024	BASE PLATE ASSEM.	1
2	99-0025	SUPPORT, MOTOR	1
3	MOTOR	CALL FACTORY	1
4	908	ADAPTER, C-FACE MOTOR	1
5	1-0003	BOLT, 3/8-16 x 1 1/4 HEX HEAD	4
6	17	WASHER, 960-616, AN	6
7	5-0014	WASHER, LOCK 3/8, INTERNAL STAR	4
8	42	WASHER, SAE, 3/8	6
9	920	STUD 3/8"x1 1/2", DOUBLE	2
10	99-0040	FRAME, ASSEMBLY	1
11	39	NUT, 3/8-24, JAM, ESNA, NTE	2
12	*20-0007 *20-0013	PULLEY, MICRO-V, 16G 2.4 x .875 PULLEY, 8 GROOVE/J, 2.5D x .984	1
13	25	SCREW, SET, 5/16-18 X 3/8, ALLEN	2
14	1033	MOUNT, BEARING	2
15	2-0026	SCREW, 1/4-28 x1, ALLEN CAP	6
16	11-0004	BEARING, BALL 62052RS TPI LLU	2
17	10-0003	CIRCLIP, 1" DIA	2
18	1034	SHROUD, BEARING, MOUNT	2
19	1-0021	SCREW, 1/4-28 x 1 3/4 ALLEN	6
20	1028-1	SHAFT	1
21	*20-0008 *20-0014	PULLEY, MICRO-V, 16G 1.98 x .984 PULLEY, 8 GROOVE/J, 2D x 5/8	1
22	*1039 *1039-1	BELT, MICRO-V, 16 GROOVE, 360J16 BELT, MICRO-V, 8 GROOVE, 360J8	1
23	2-0027	SCREW, 5/16-18 x 2, SHCS	5
25	1035-4	PLATE, LOGO	1
26	2-0028	SCREW, 1/4-28x1/2 BH	6
27	1030	FLANGE, WHEEL	2
28	1031	NUT, 3/4 x 16 RH, HEX	1
29	1029-8	GUARD, WHEEL	1
30	5-0008	WASHER, 1/4, LOCK, EXTERNAL	4
31	99-0026	BRACKET, SUPPORT	1
32	4	WASHER, 5/16 SAE ZINC PLTD	12
33	5-0017	WASHER, 5/16 LOCK, SPLIT	8
34	1-0044	BOLT, 5/16-24 x 3/4 HEX HEAD	4
35	37	BOLT, 5/16-18x3/4 HEX HEAD GRD5	4

1050			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
36	12B	NUT, 3/8-16, HEX, FULL, GRD 5	1
37	1-0001	BOLT, 3/8-16 x 1 HEX HEAD	1
38	99-0030	WORKREST SUPPORT ASSEM.	1
39	6-0015	PIN, SNAP, SAFTY 3/8" x 3"	1
40	9	SCREW, 10-24x1/2 BH	1
41	5-0035	WASHER, #10, LOCK, HIGH COLLAR	1
42	2061-1	CLIP	1
43	2	BOLT, 5/16-18x1 1/2 HEX HEAD	4

NOTE:

*20-0007 & 20-0008

2&3 HP/ 3PH

*20-0013 & 20-0014

1-1.5 HP/ 1PH

*1039

2&3 HP/ 1&3 PH

*1039-1

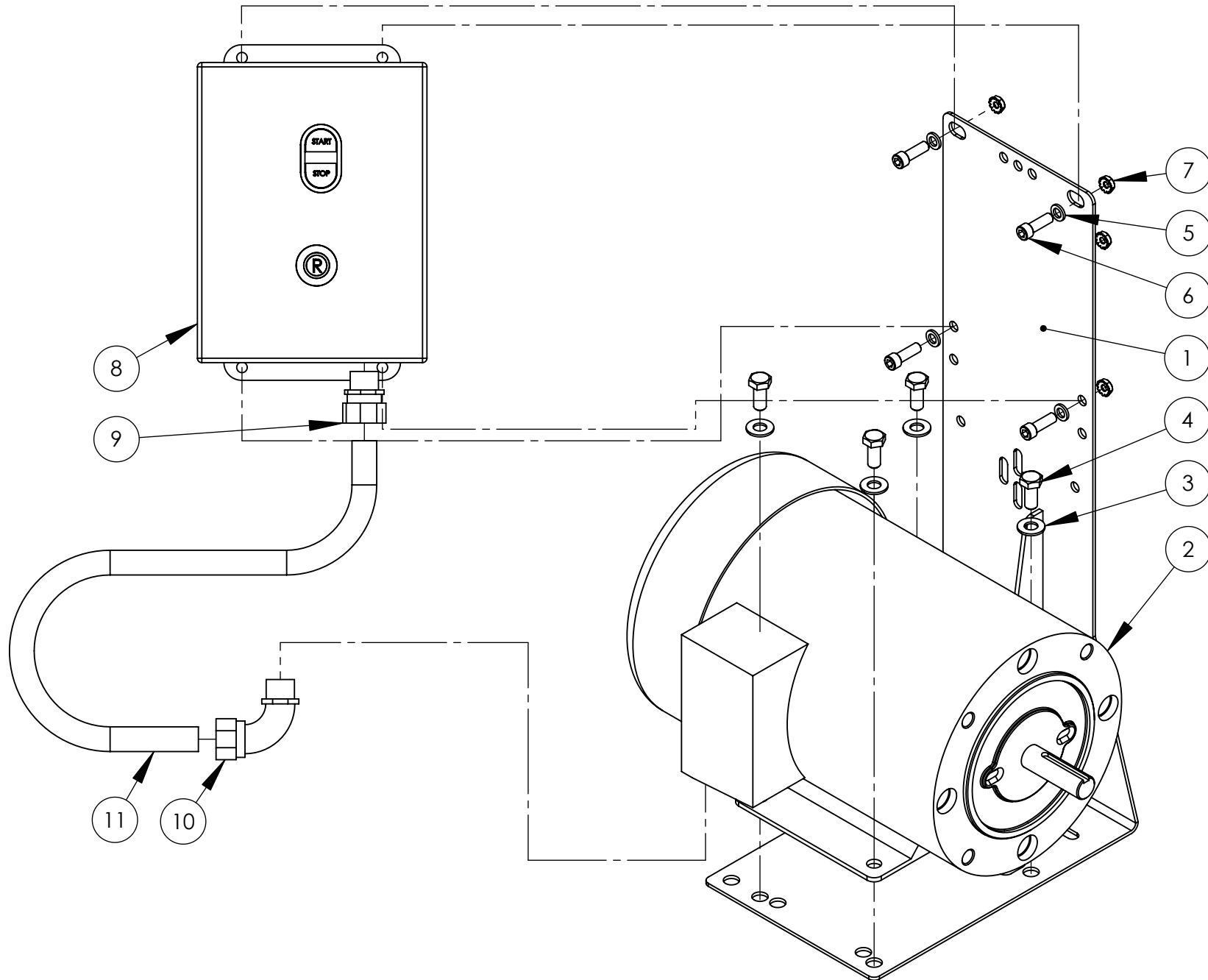
1-1.5 HP/ 1PH

BURR KING

MAG STARTER

PARTS LIST

BURR KING



MAG STARTER			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MB-4C	BRACKET, MOUNTING, STARTER	1
2	MOTOR	CALL FACTORY FOR PART NUMBER	1
3	4	WASHER, 5/16 SAE ZINC PLTD	4
4	37	BOLT, 5/16-18x3/4 HEX HEAD	4
5	5	WASHER, 1/4 AN	4
6	209	SCREW, 1/4-20 X 3/4 ALLEN HEAD	4
7	4-0013	NUT, KEP, 1/4-20	4
8	MS2A3 MS4A3 MS2B3 MS4B3	3/4HP-1HP, 220V 3/4HP-1HP, 440V 1.5HP-3HP, 220V 1.5HP-3HP, 440V	1
9	775	CONNECTOR, 3/8", STR, LIQ. TIGHT	1
10	776	CONNECTOR, 3/8", 90 DEG, LIQ. TIGHT	1
11	020	CONDUIT 3/8" LIQUID TIGHT	1

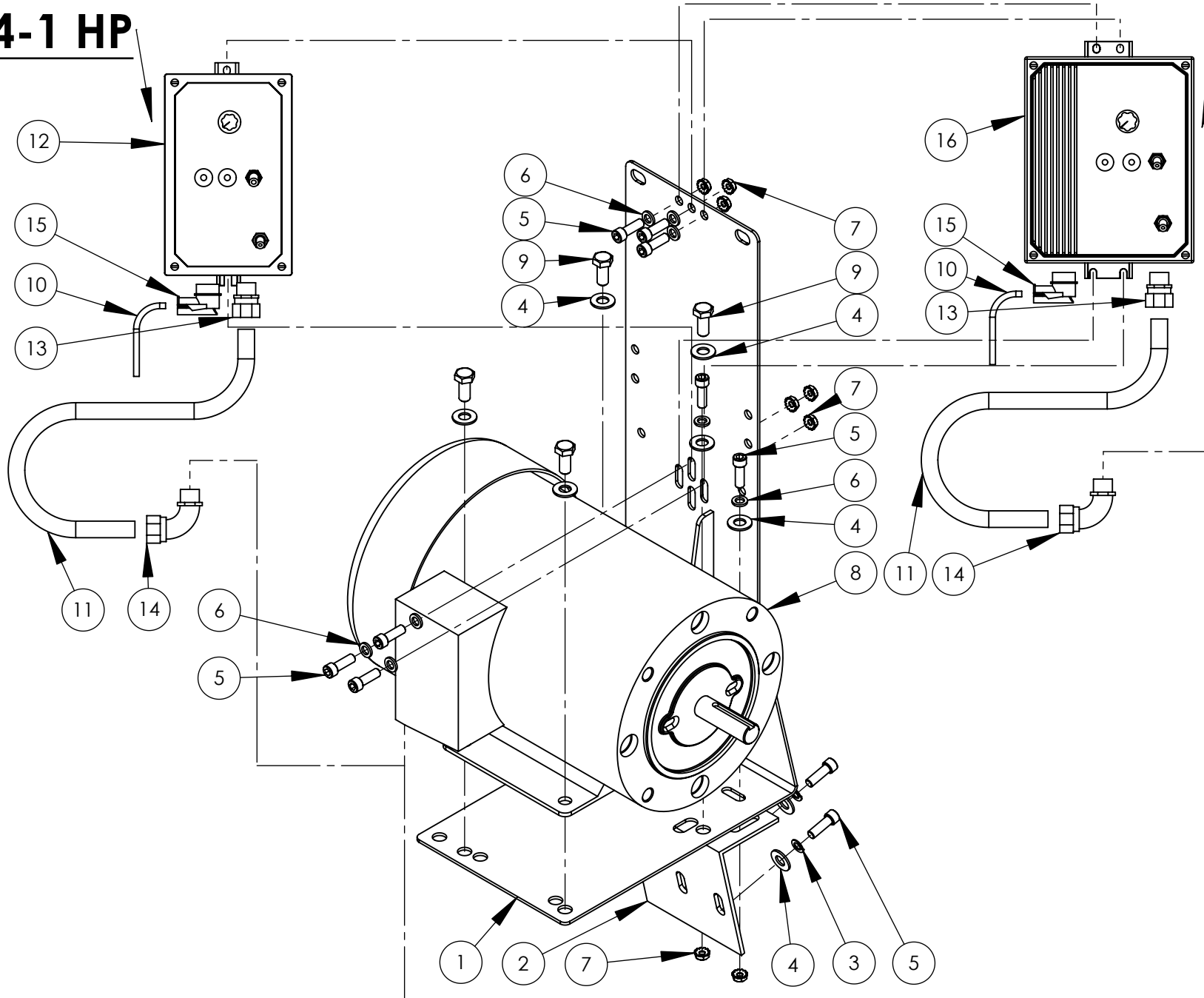
VARI SPEED

SINGLE PHASE

BURR KING

3/4-1 HP

1.5-3 HP



VARI SPEED			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MB-4C	BRACKET, MOUNTING, STARTER	1
2	941-3	BRACE, MB4 SUPPORT	1
3	5-0032	WASHER, 1/4, LOCK, SPLIT, PLTD	2
4	4	WASHER, 5/16 SAE ZINC PLTD	8
5	209	SCREW, 1/4-20 X 3/4 ALLEN HEAD	10
6	5	WASHER, 1/4 AN	8
7	4-0013	NUT, KEP, 1/4-20	8
8	100B-1725C 150B-1725C	1 HP MOTOR 1.5 HP MOTOR	1
9	37	BOLT, 5/16-18x3/4 HEX HEAD	4
10	015-1 017	120V CORD 220V CORD	1
11	020	CONDUIT 3/8" LIQUIDTIGHT	1
12	864-1	CONT. 115/220V 0.75-1HP	1
13	775	CONNECTOR, 3/8" STR, LIQ. TIGHT	1
14	776	CONNECTOR, 3/8", 90 DEG, LIQ. TIGHT	1
15	643	RELIEF, STRAIN 3/8" 90 DEG	1
16	862-3	CONT. 115/220V 1.5-3HP	1

NOTE

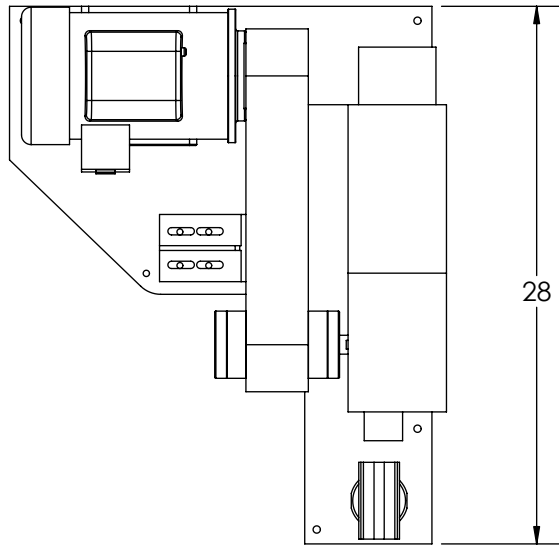
FOR 3 PHASE CONTROLLER CALL FACTORY.

CE CERTIFICATION PART NUMBERS**ADD TO CONTROLLER**

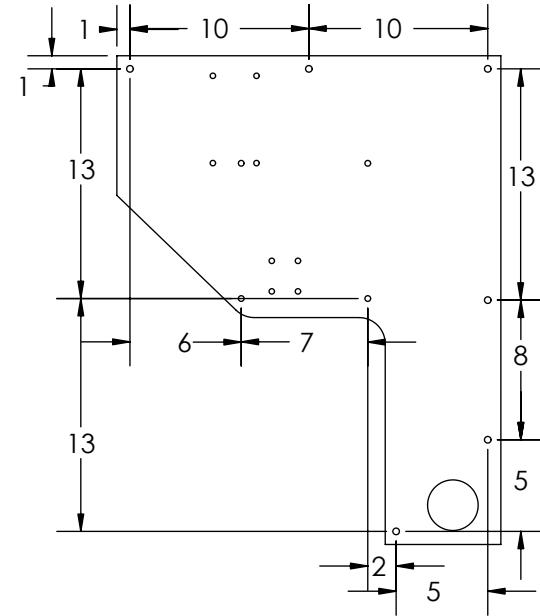
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
12	9974-6	LINE FILTER	1
16	9974-5	LINE FILTER	1
CHANGE PART			
15	3356	RELIEF, STRAIN	1
10	CE CORD	NO PLUG- CUSTOMER INSTALLED PLUG	1

MODEL 1050 WIRE WHEEL TUBE FINISHER

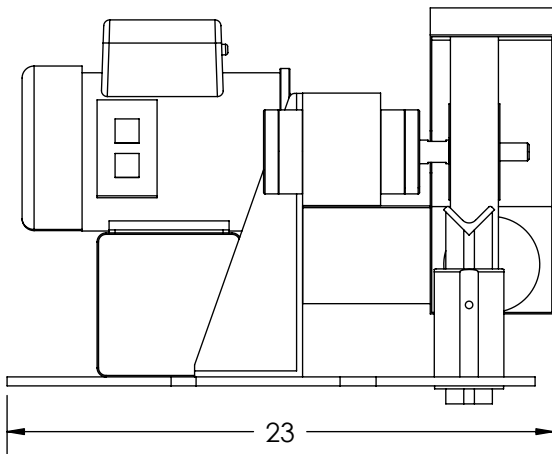
BURR KING



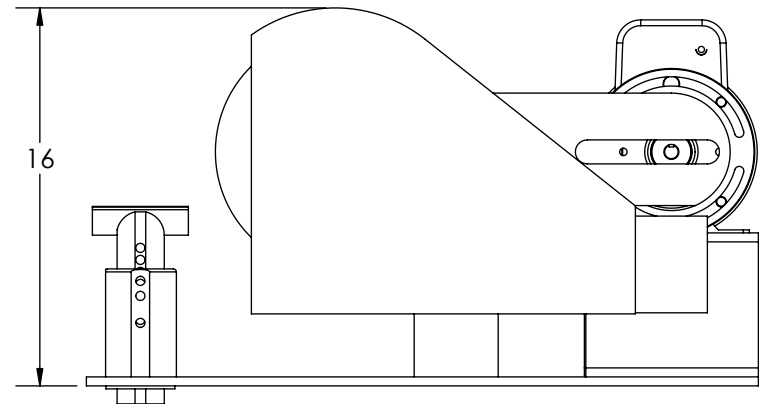
TOP VIEW



MOUNTING PATTERN



FRONT VIEW



RIGHT SIDE VIEW