

HR8 HONER Instruction Manual

This is what the LORD says:
"Let not the wise man boast of his wisdom
or the strong man boast of his strength
or the rich man boast of his riches,
but let him who boasts boast about this:
that he understands and knows me,
that I am the LORD , who exercises kindness,
justice and righteousness on earth,
for in these I delight," declares the LORD.

Jeremiah 9:23-24

TRU HONE HONER INSTRUCTION MANUAL

INTRODUCTION

This manual has been prepared to familiarize you with the operation and maintenance of your Tru Hone Honer and to provide important safety information. Following these instructions will help assure safe and trouble free operation of your Tru Hone Honer System.

**TRU
HONE[®]**

*...ends the
"Stone Age" of
Knife Sharpening*

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Tru Hone Honer

General Description of Parts & Switches

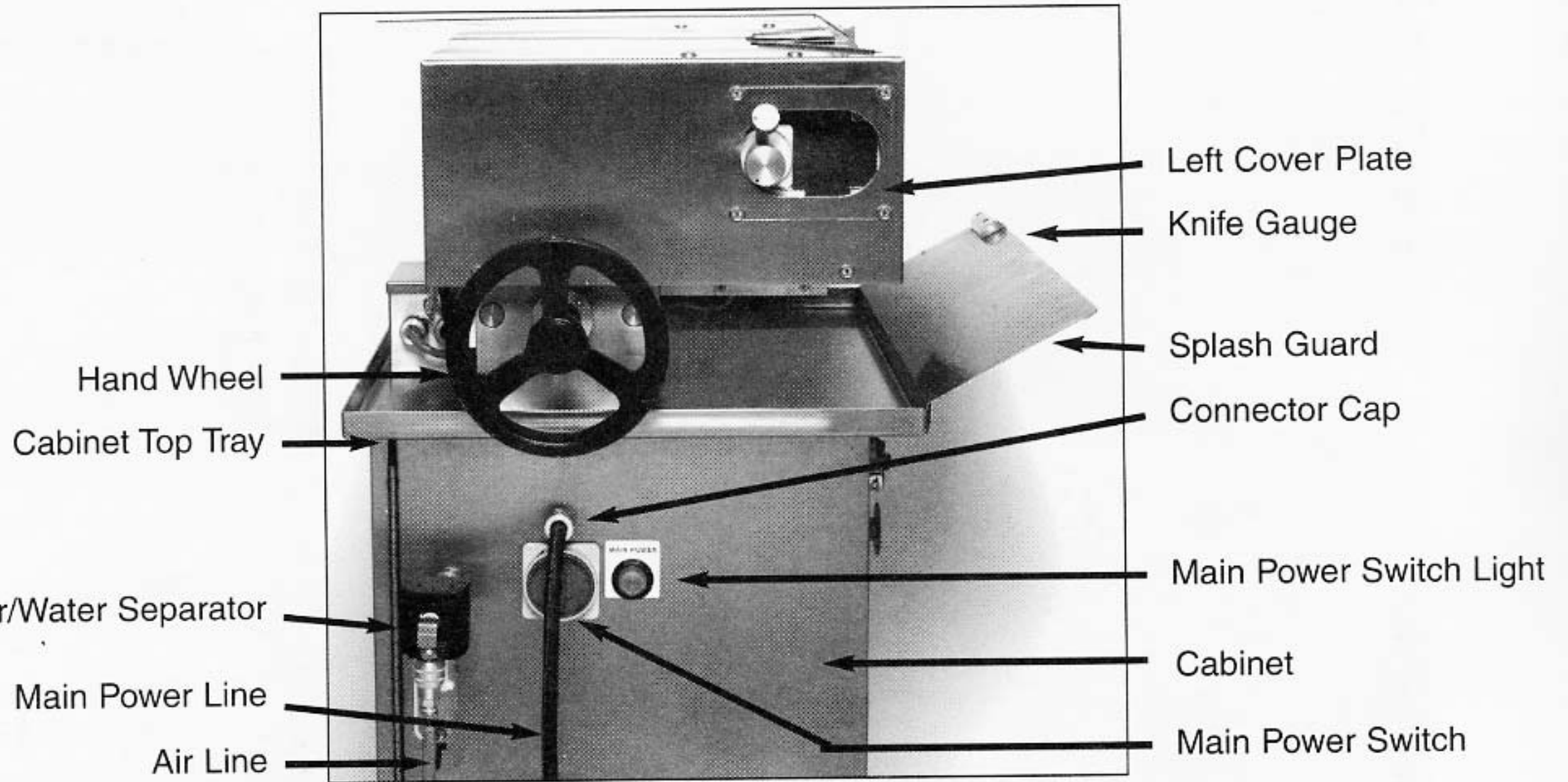


Fig. 1

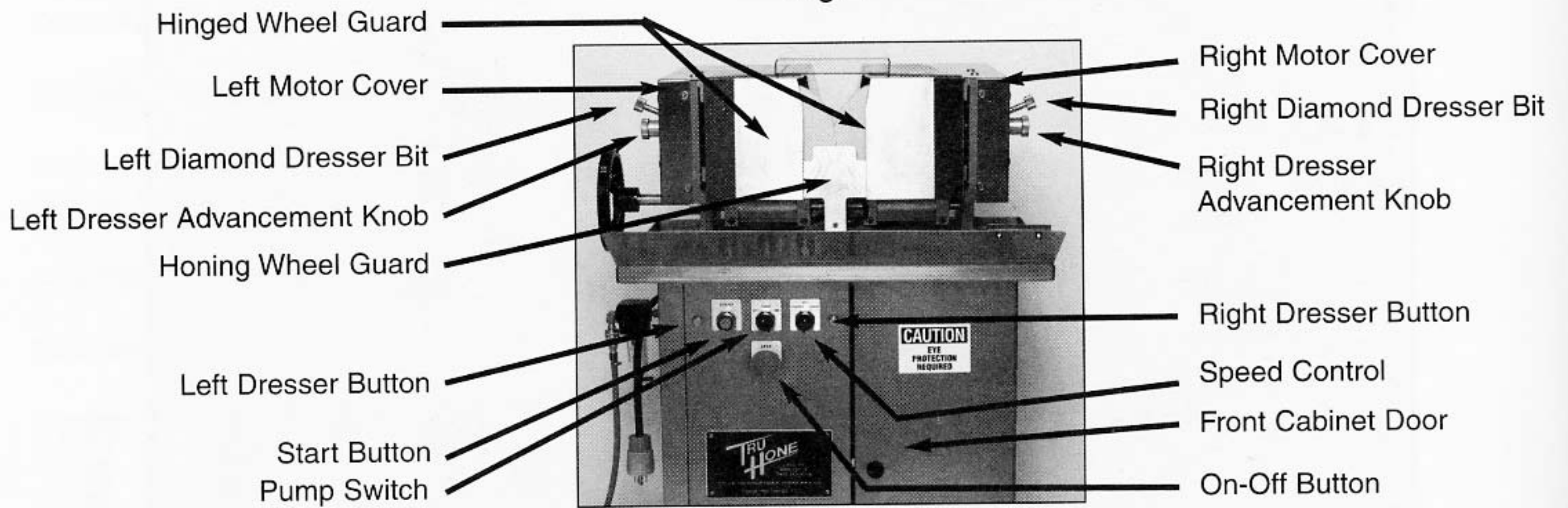


Fig. 2

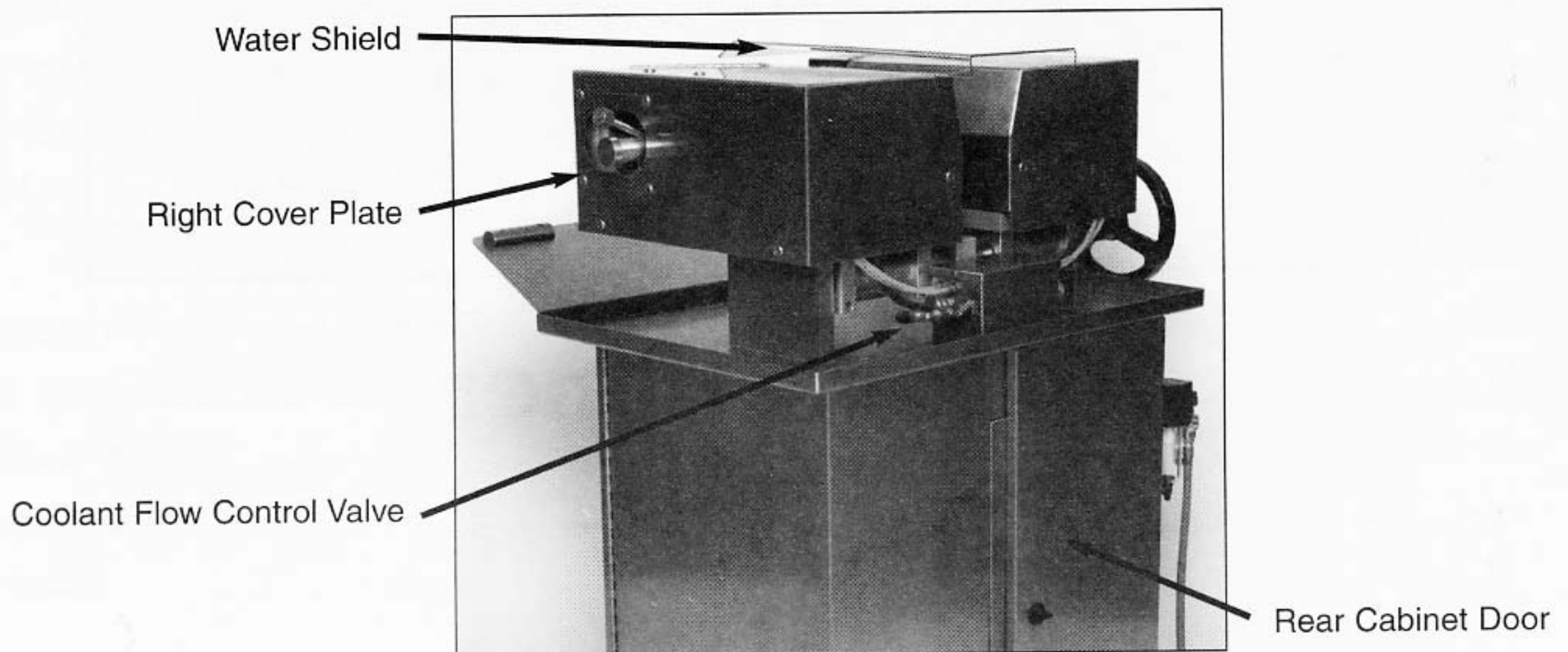


Fig. 3

TRU HONE HONER REQUIREMENTS

ELECTRICAL

Access to 3 Phase Electrical Supply.

Voltage Requirements are 208V to 240V, or 440V to 480V.

Amperage Requirements are 9 AMP with lower voltage or 4.5 AMP with higher voltage.

Wiring Requirements - 4 lead wire SOS-Type supply cable, #14 or #16 gauge.

AIR/HYDRAULICS

Air Pressure of not less than 85 PSI.

Air Volume requirement is minimal.

Quick Disconnect accessibility.

Air Lines are yellow.

Hydraulic Lines are clear.

COOLANT

Coolant System on machine is self-contained recirculated water with USDA approved additive.

Coolant Lines are blue.

SET-UP

ELECTRICAL HOOK-UP

Test the Power Supply Voltage and Phase to be sure it meets the specifications for the Honer. The specifications are listed inside the rear door.

Remove small Junction Box Cover located inside the rear Cabinet to find 4 lead wires leading to Main Power Switch (see fig. 4).

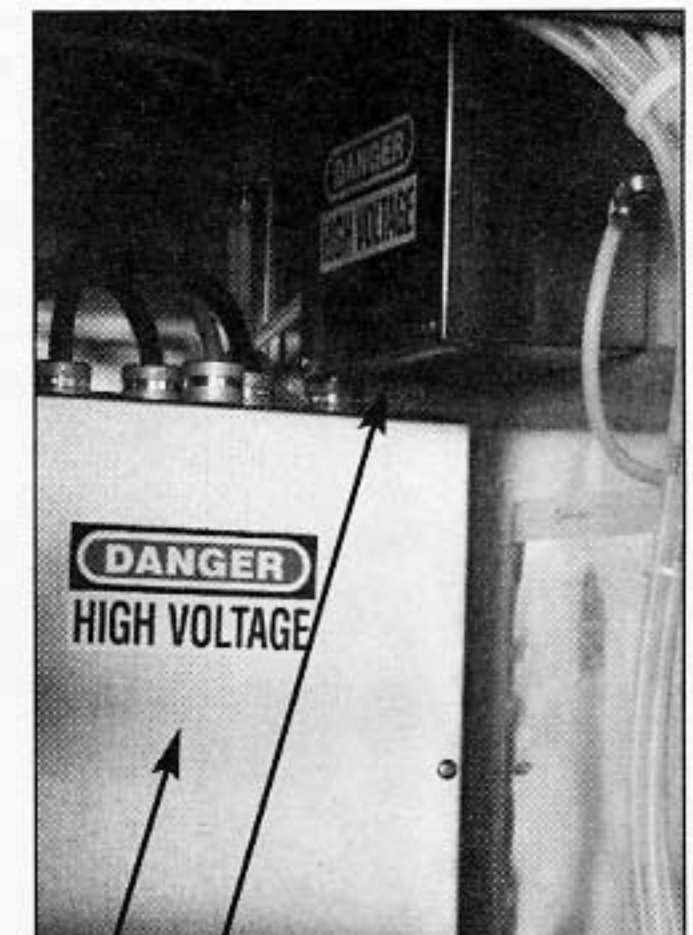
Using a 4 lead wire for power supply cord, strip back cord insulation about 10".

Strip back wire ends approximately 1".

Remove the Cord Connector Cap, Locking Ring & Rubber Seal at left side of Cabinet and slide them onto Power Supply Cord. Insert Cord Wires through Cord Connector into Junction Box and tighten Cord Connector Cap (see fig. 1).

Connect Power Supply Cord wires to Junction Box wires with Wire Nuts and replace Junction Box Cover. Connect other end of Cord to Breaker Box.

This completes wiring hook up subject to checking for PROPER ROTATION OF HONING WHEELS.



Control Box

Junction Box

Fig. 4

HONING WHEEL ROTATION

See fig. 1, 2, and 3 for the location of these Parts and Switches.

Inspect Honing Wheels to be sure they are clear of any obstructions and are not touching each other.

Turn Main Power Switch on, press the Start Button and turn Speed Knob to Sharpen to activate Honing Wheels. Both half sets of Honing Wheels should be turning up in the center. The left Honing Wheels should be turning counterclockwise and the right Honing Wheels should be turning clockwise.

If Honing Wheels are not turning up in the center, turn Speed Knob off, push On-Off Button off, turn Main Power Switch off and disconnect Power at the Breaker Box. Switch two leads in the Honer Junction Box and repeat steps in this section.

AIR/HYDRAULICS HOOK-UP

NOTE: Air is only required to operate the two semi-automatic Diamond Dressing Units that true up the Honing Wheels.

Attach Air/Water Separator provided with machine to Quick Disconnect Nozzle at left side of Honer (see fig. 1).

Attach Air Line to Air/Water Separator.

The Air Regulator inside the rear door should be SET at approximately 85 lbs. and Air Cut-off Valve should be OPEN (see fig. 40).

COOLANT PREPARATION

Remove Coolant Tank located inside the front cabinet (see fig. 42). Set aside the Filter Tray and Pump (see fig. 43). Pour 1 1/2 Cups of Grinding Solution into Coolant Tank and add Water until Coolant Tank is approximately THREE QUARTERS FULL.

Hang Sock Filter from Hook located on the front of the Coolant Down Spout (see fig. 44). Place Pump back into the rear of the Coolant Tank and SET Filter Tray on top of Coolant Tank (see fig. 45).

Slide Coolant Tank back into the front Cabinet (see fig. 42). Make sure the Sock Filter is hanging straight with the bottom inside the Filter Tray. Close front Door.

Honer should be placed in a RELATIVELY LEVEL AREA to insure proper recirculation of coolant into Coolant Tank.

SAFETY

Before using the Honer be sure you are NOT WEARING Rings, Watches, Bracelets and Loose Hanging Necklaces. LONG SLEEVES should be rolled up and HAIR NETS worn for longer hair.

Safety Glasses should be worn at all times while operating Honer.

PREPARING FOR OPERATION

See fig. 1, 2 and 3 for the location of these Parts and Switches.

Slide Stainless Steel Splash Guard onto the front of the Honer Cabinet Top Tray and set the plastic top splash shield in place.

Turn Main Power Switch ON, press the Start Button and turn Speed Knob to Sharpen to activate Honing Wheels. Turn Pump Switch ON.

Turn Hand Wheel COUNTERCLOCKWISE until Honing Wheels are slightly separated. (You can see between them.) (See fig. 5).

CAUTION-Should Hand Wheel become difficult to turn when attempting to bring Honing Wheels together, turning should NOT BE FORCED as damage may result.

Turn Hand Wheel CLOCKWISE until you cannot see between the Honing Wheels. (See fig. 6). Look at the Hand Wheel to see which of the numbers is facing you. Turn Hand Wheel two complete turns CLOCKWISE until the number is back in the same position (See fig 7).

SHARPENING A KNIFE

See fig. 1, 2 and 3 for the location of these Parts and Switches.

Turn Main Power Switch ON, press the Start Button ON and turn Speed Knob to Sharpen to activate Honing Wheels. Turn Pump Switch ON.

Turn Hand Wheel COUNTERCLOCKWISE until Honing Wheels are not overlapped (can see between them)(see fig. 5). Turn Hand Wheel CLOCKWISE until the Honing Wheels begin to overlap (cannot see between them) (see fig. 6). Using one of the numbers on the Hand Wheel as a reference point, turn Hand Wheel two complete turns CLOCKWISE (see fig. 7). The HR8 Honing wheels are now ready to begin sharpening.

Place Knife Blade on Honing wheels as close to the heel as possible (see fig. 8). Holding the Knife level, pull it across the Honing Wheels (see fig. 9). For knives with curved tips or curved blades, raise the Handle to follow the curve as you draw the Blade across the Honing Wheels (see fig. 10).

When the Tip of the Knife Blade is half way across the sharpening surface, start back in with the Knife and at the same time lower the Handle. At the straight part of the blade continue in level with the Knife Blade. The width of the sharpening bevel should be even on both sides of the blade. If it is not, lean the Blade toward the side of the Knife with the narrowest sharpening bevel while sharpening the Knife. Continue sharpening until the Knife is sharp.

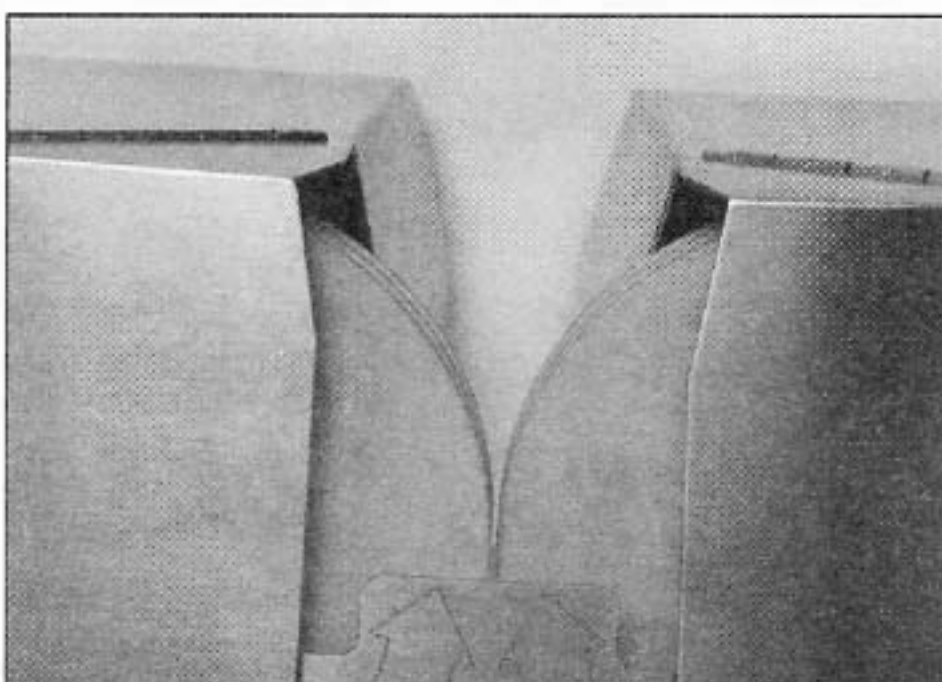


Fig. 5

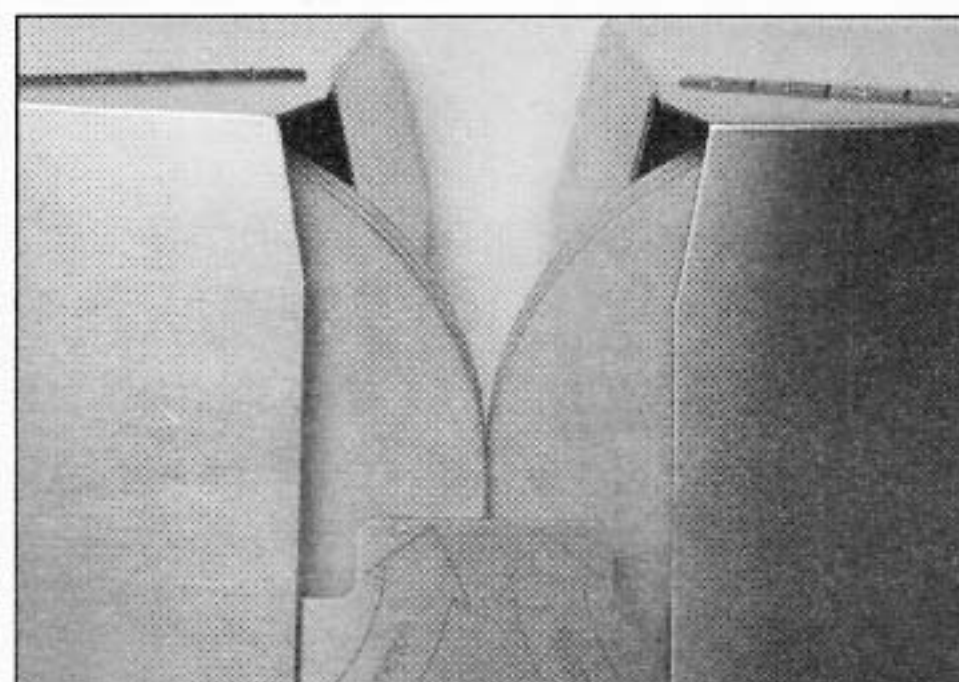


Fig. 6

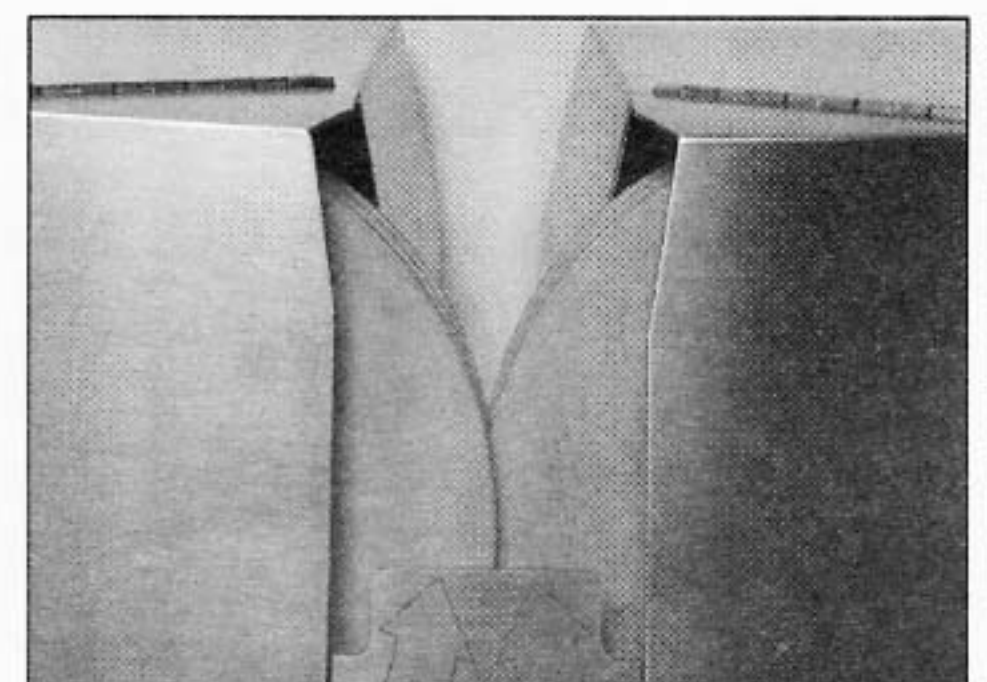


Fig. 7

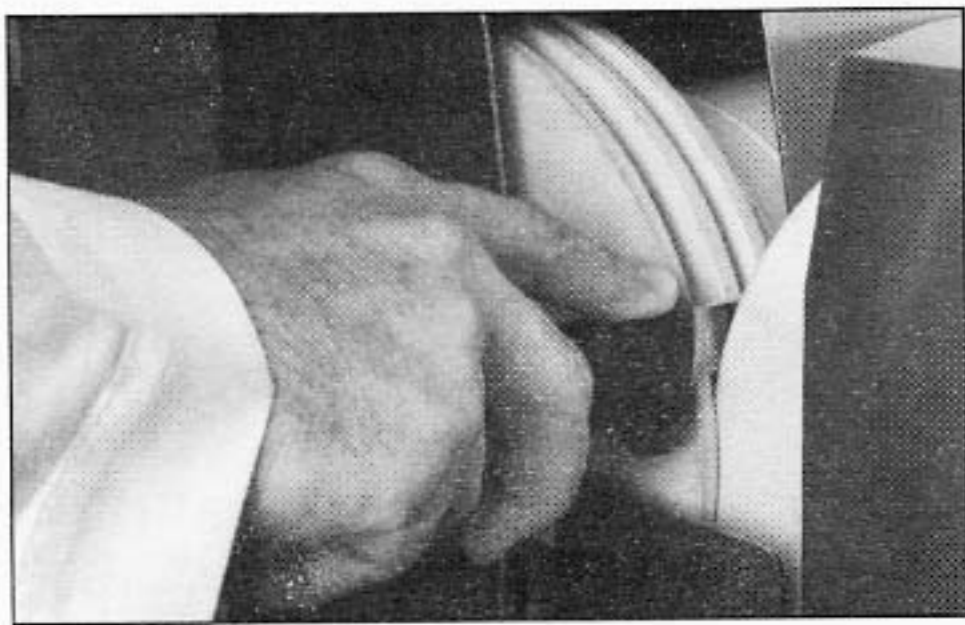


Fig. 8

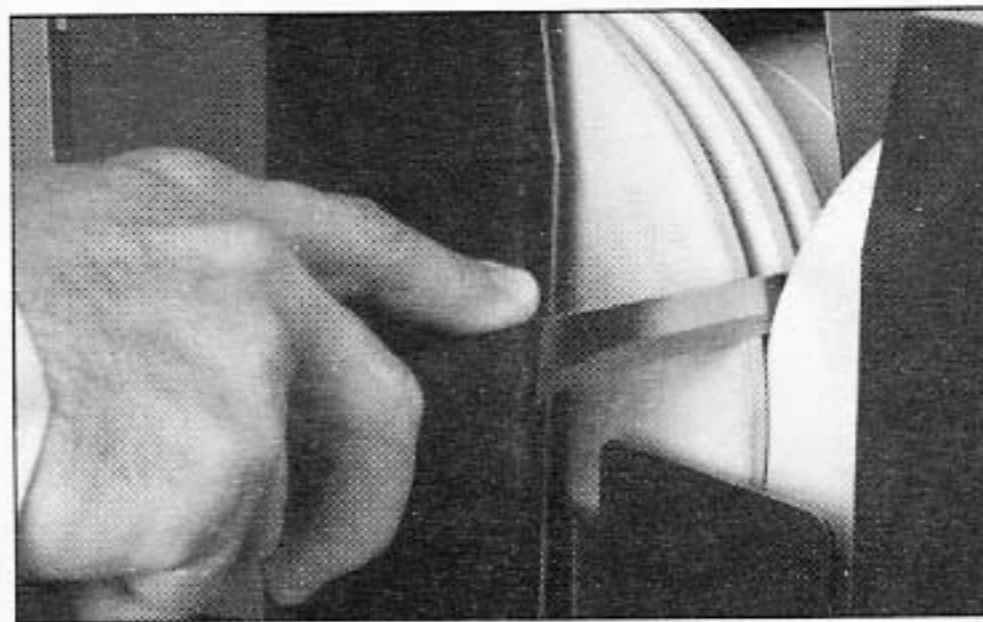


Fig. 9

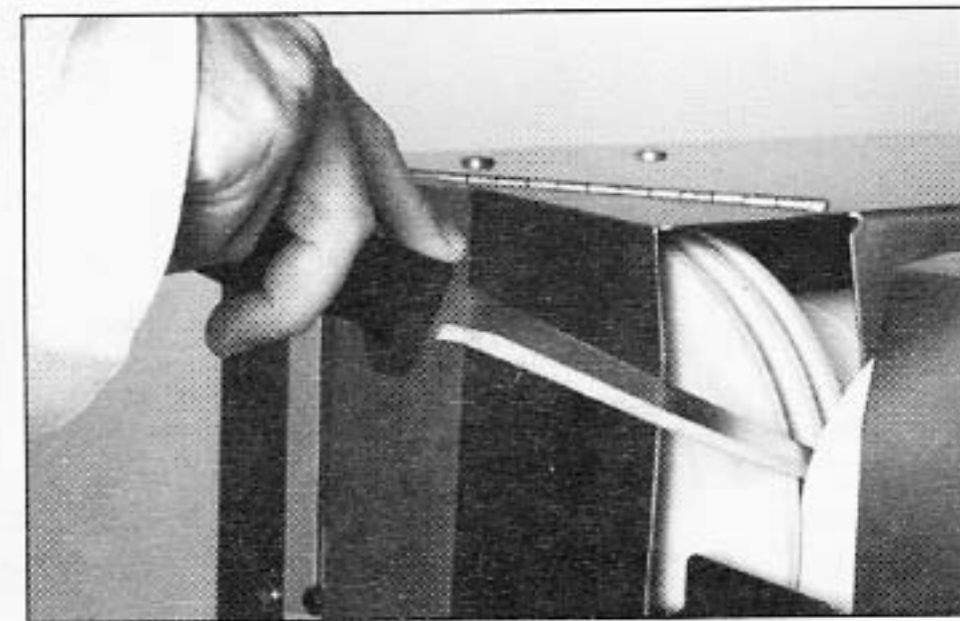


Fig. 10

DRESSING HONING WHEELS

1. Before dressing the Honing Wheels, visually inspect the end of each Diamond Dresser Bit to be sure it is clear of the Honing Hheels and in good condition (see fig. 11). If the Dresser Ram Assembly is turned in too far clockwise and the end of the Diamond Dresser Bit does not clear the Honing Wheels (see fig. 12), turn the Dresser Advancement Knob **COUNTERCLOCKWISE** (see fig. 13) until the end of the Diamond Dresser Bit is clear of honing wheels (see fig. 11).

2. If the machine is not on, turn Main Power Switch **ON**, press Start Button **ON**, turn Speed Knob to **DRESS** which activates the Motors and turn Pump Switch **ON**.

Chamfering may be necessary before dressing if the edges of the Honing Wheels are not rounded. See section on Chamfering Honing Wheels.

3. Press and hold in either the Left or Right Dresser Button (see fig.14). This cycles the Dresser Assembly to the front. **CAUTION: DO NOT Dress Honing Wheels in this direction.**

4. Continue holding in the Dresser Button until you turn the Dresser Advancement Knob 1 click **CLOCKWISE** (see fig. 15). This moves the Diamond Dresser Bit into position for dressing the Honing Wheels one time.

5. Release the Dresser Button. Diamond Dresser Bit dresses the Honing Wheels as it returns to the **IDLE** position. If the Diamond Dresser Bit does not dress (does not touch) all three Honing Wheels or does not sound smooth (chatters), return to step 3. To keep both half sets of Honing Wheels even with each other, it is important to dress each half set of Honing Wheels the same number of clicks on the Dresser Advancement Knob.

6. On the last dressing pass, the Diamond Dresser Bit should sound like it is making a smooth cut across all three Honing Wheels. To dress the other half set of Honing Wheels, press the other Dresser Button and repeat steps 3 through 5.

7. After both half sets of Honing Wheels have been dressed, the Dots on the Dresser Advancement Knobs should be at the same position.

8. Turn Hand Wheel **COUNTERCLOCKWISE** until Honing Wheels are not overlapped (can see between them)(see fig. 5). Turn Hand Wheel **CLOCKWISE** until the Honing Wheels begin to overlap (cannot see between them) (see fig. 6). Using one of the numbers on the Hand Wheel as a reference point, turn Hand Wheel two complete turns **CLOCKWISE** (see fig. 7). Turn Speed Knob to the sharpen position. The HR8 Honing Wheels are now ready to begin sharpening.

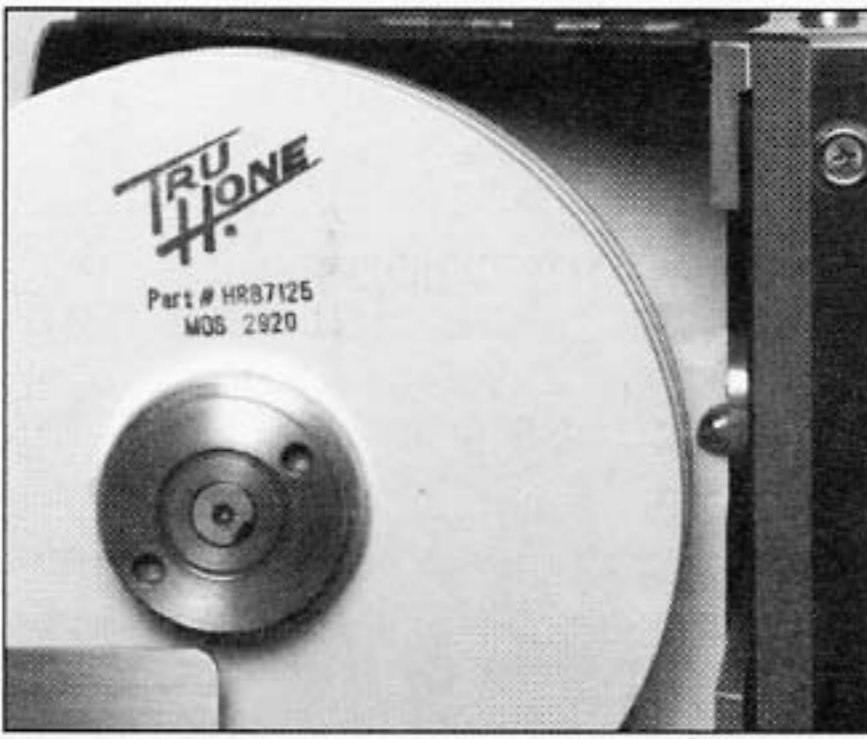


Fig. 11

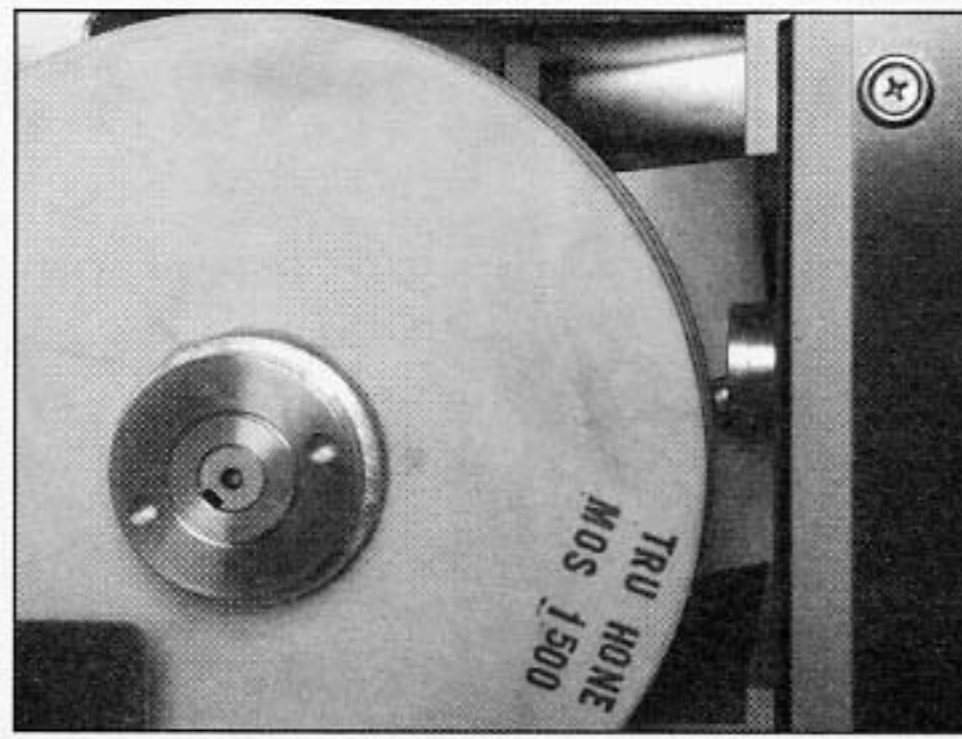


Fig. 12

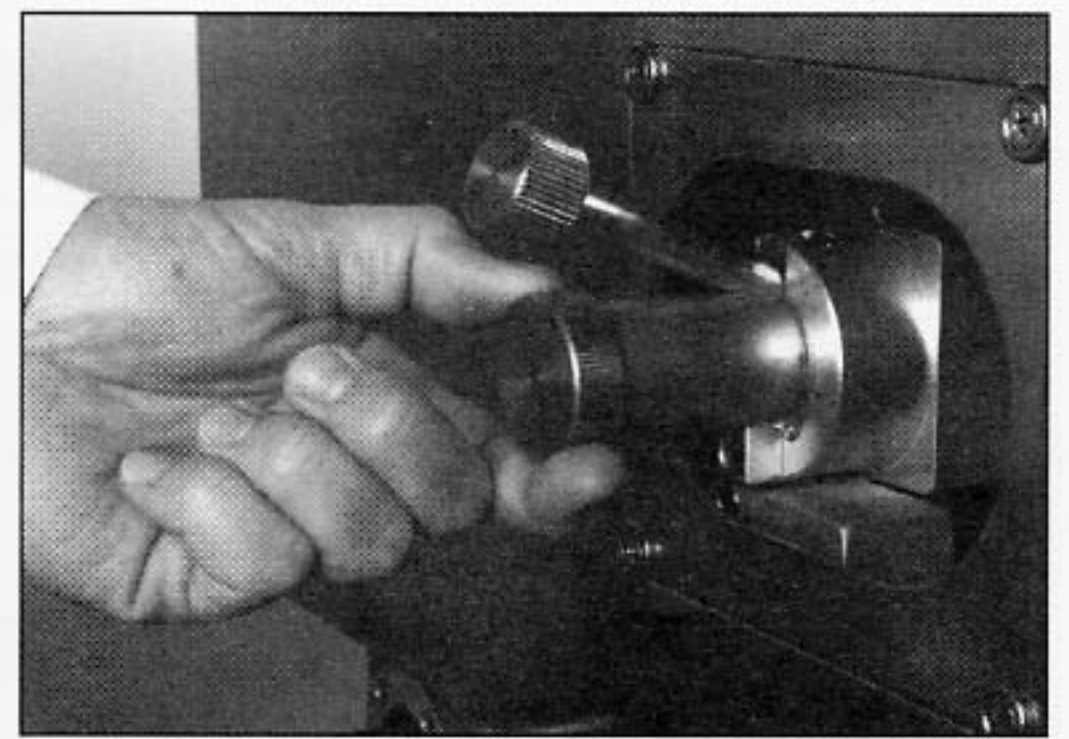


Fig. 13

9. Dress Honing Wheels often enough so that it takes only one or two clicks per Dresser Advancement Knob to dress the Honing Wheels.

10. Periodically inspect the size of the Honing Wheels to see that they are the same size. See section on Sizing Honing Wheels.

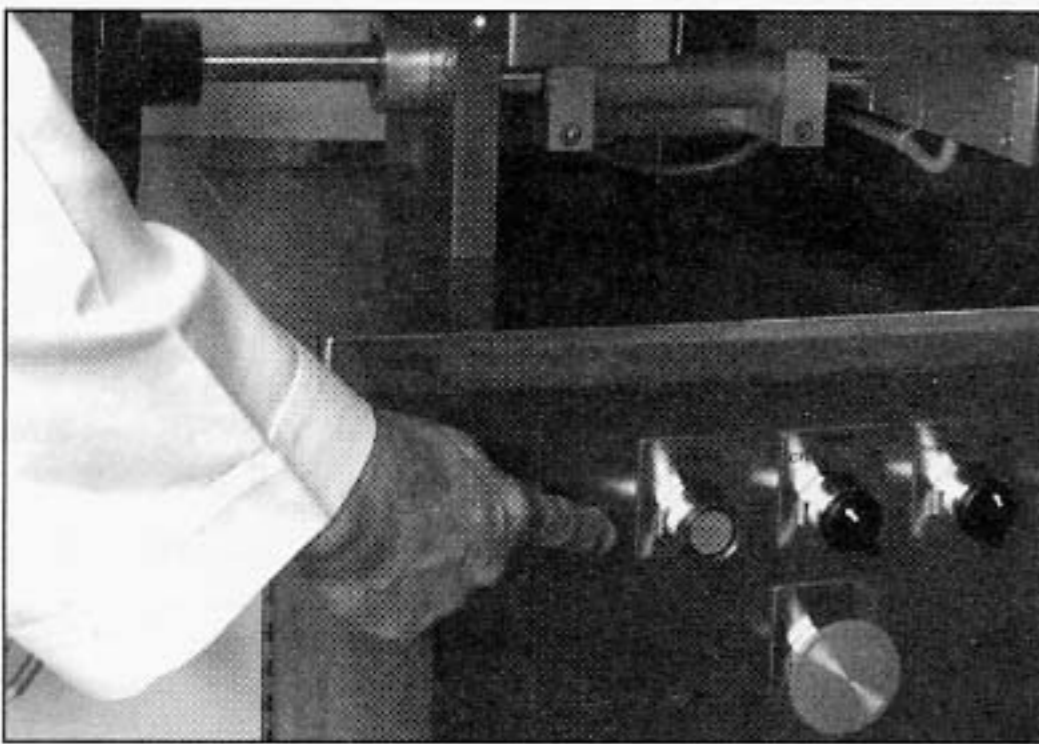


Fig. 14

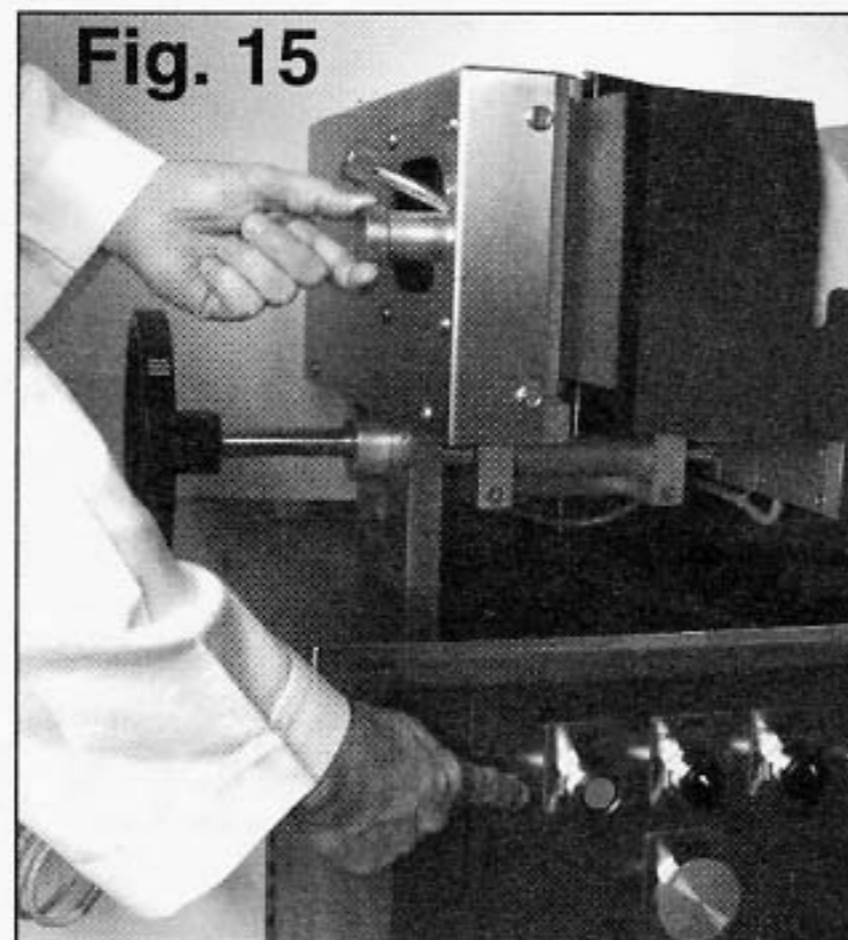


Fig. 15

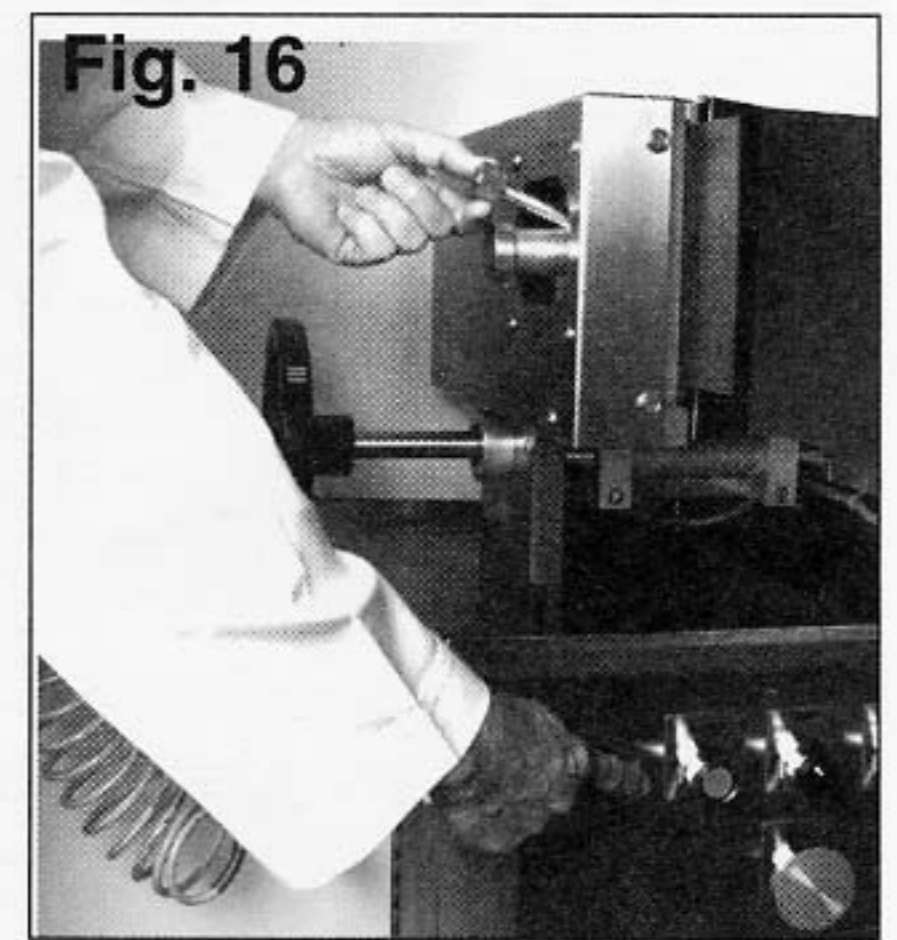


Fig. 16

ROTATING DIAMOND DRESSER BITS

About once a week Diamond Dresser Bits need to be TURNED to keep a sharp edge of the diamond next to the Honing Wheels.

Turn Main Power Switch ON, press the Start Button and turn Speed Knob to Dress (see fig. 1&2).

Press and HOLD IN the Left Dresser Button (see fig. 14). This cycles the Dresser Assembly to the front (forward position).

Continue HOLDING IN the Left Dresser Button until you TURN the Diamond Dresser Bit approximately 1/4 turn CLOCKWISE (see fig. 16).

Release the Dresser Button and repeat the previous steps for the Right Diamond Dresser Bit.

After both Diamond Dresser Bits have been rotated, the dots should be at the SAME POSITION.

CHAMFERING HONING WHEELS

Periodically, chamfering is necessary to keep the edges of the Honing Wheels from chipping.

Turn Main Power Switch ON, press the Start Button and turn Speed Switch to Dress position (see fig. 1 & 2).

Holding the Dressing Stick at approximately 45 degrees (see fig. 17), press the side of the Dressing Stick against the front edge of the left front Honing Wheel. Lightly roll the dressing stick back and forth until chamfering is complete.

Next, using the same procedures, chamfer the back edge of the first Honing Wheel and the front edge of the second Honing Wheel at the same time (see fig. 18). Repeat these steps until all of the Honing Wheels on both half sets have been chamfered.

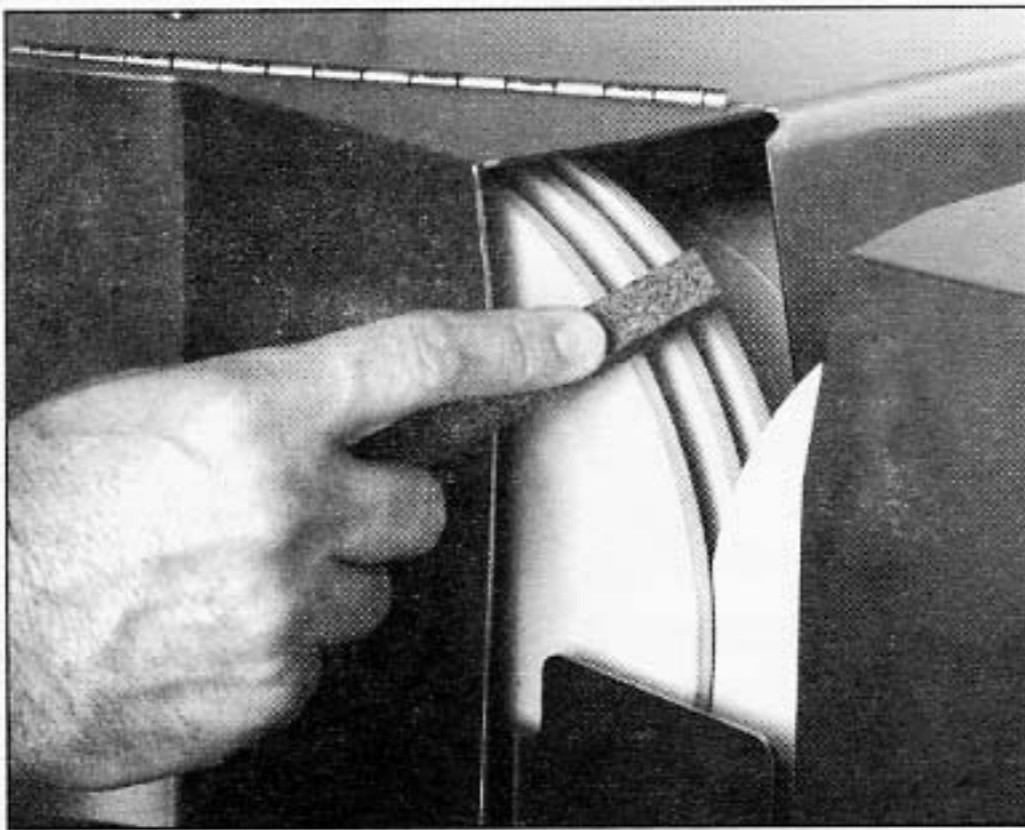


Fig. 17

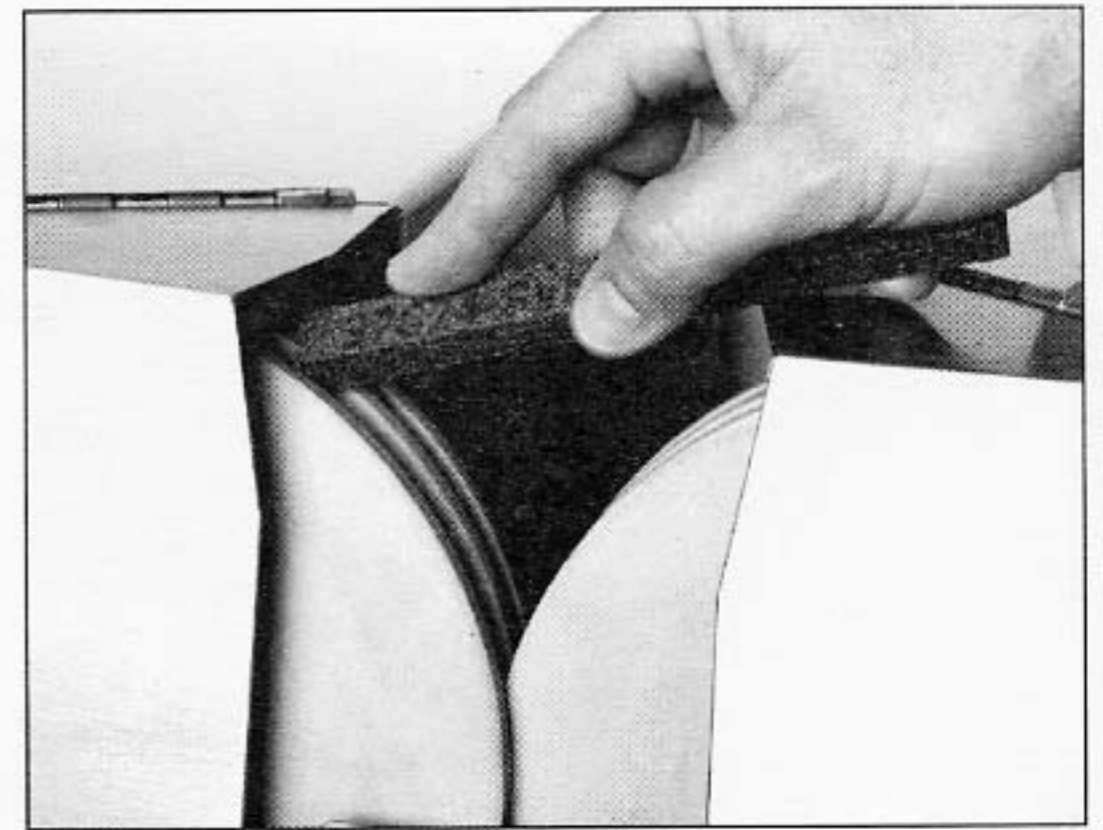


Fig. 18

SIZING HONING WHEELS/WHEEL GAUGE

Both half sets of Honing Wheels need to be the same size in order to get the same angle on both sides of the knife edge.

After both half sets of Honing Wheels have been chamfered and dressed (see sections on Chamfering and Dressing Honing Wheels), they should be measured with the Wheel Gauge to make sure they are the same size (see fig. 19). If one of the half sets of Honing Wheels is larger than the other, dress it until it is the same size as the smaller half set of Honing Wheels and until the dots on the Dresser Advancement Knobs are in the same position.

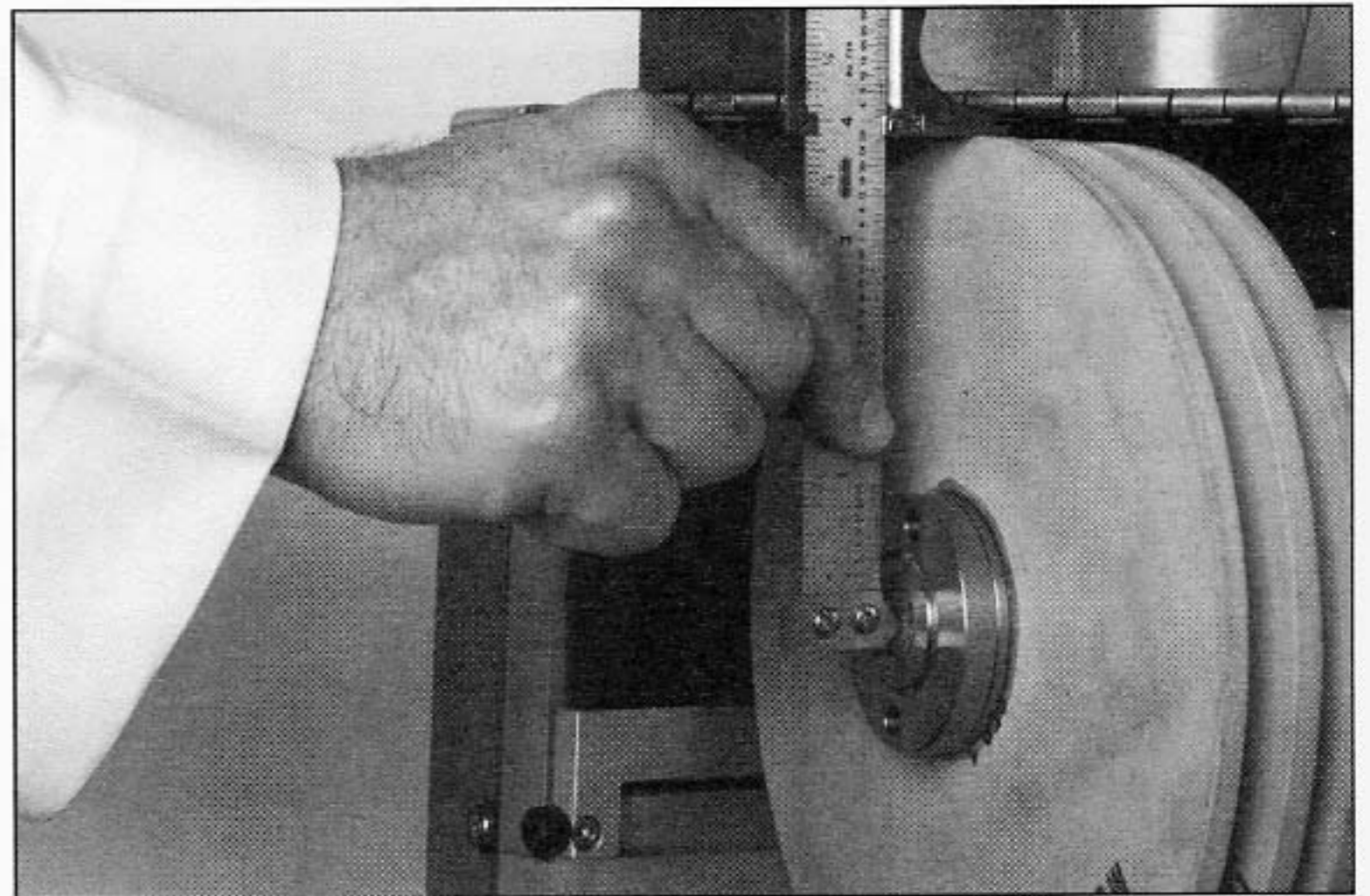


Fig. 19

REPLACING HONING WHEELS

Turn OFF all Switches (see fig. 1 & 2). Speed Switch, Pump Switch, Stop Button and Main Power Switch.

Remove the clear, Top Splash Shield.

Turn Hand Wheel COUNTERCLOCKWISE until Honing Wheels are at maximum separation. Turn up hinged Wheel Guards and using a 5/32" Hex Key Wrench remove Honing Wheel Guard (see fig. 20).

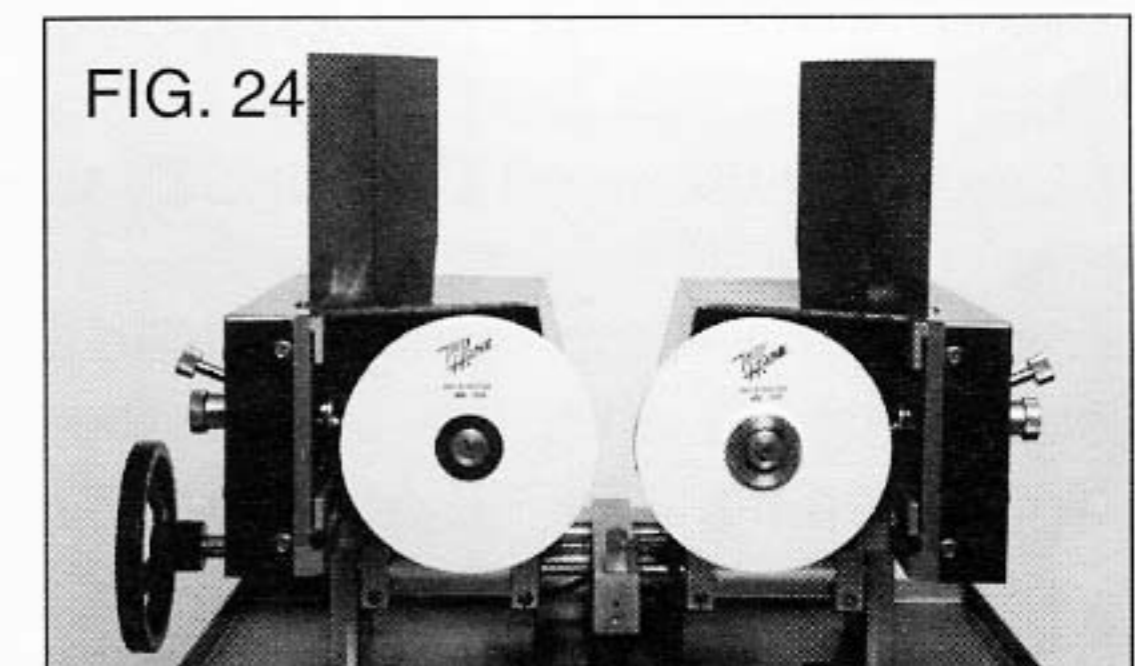
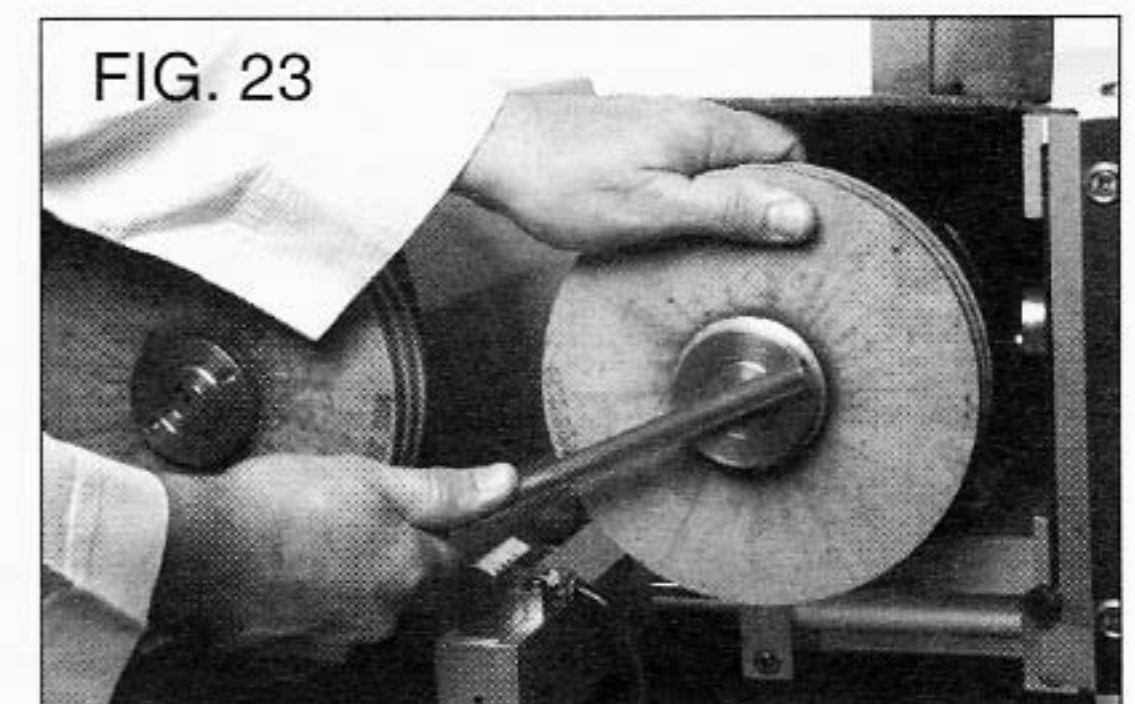
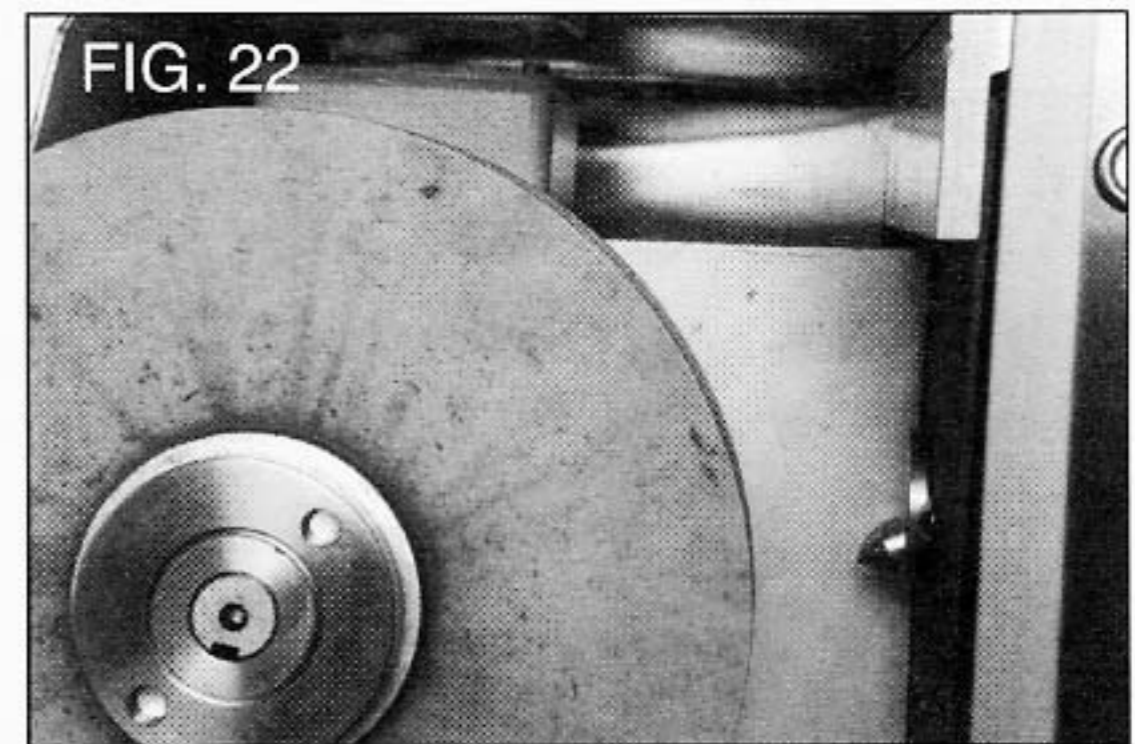
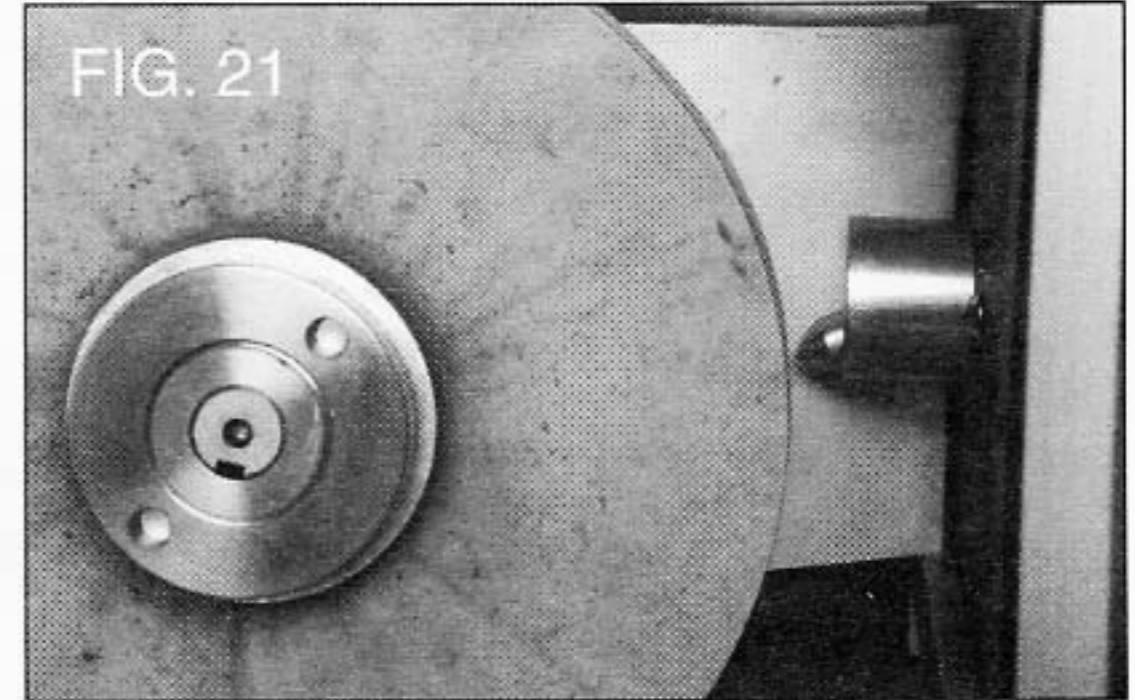
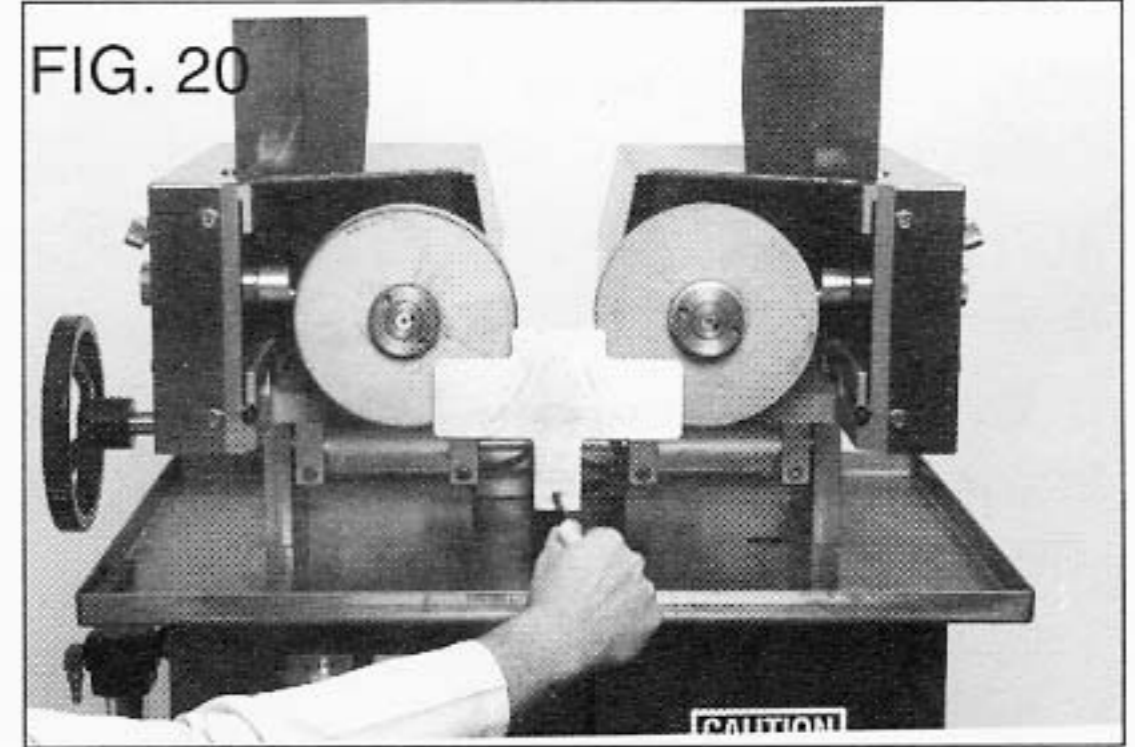
CAUTION: Both Dresser Ram Assemblies ARE EXTENDED IN and need to be TURNED BACK (see fig. 21). Turn back both Dresser Advancement Knobs COUNTERCLOCKWISE until the end of each Dresser Ram Assembly is approximately 1/8" from being flush with the Slide Shield (see fig. 22).

Hold one half set of Honing Wheels and using the Key Wrench remove the washer nut that holds the Honing Wheels onto the Honing Wheel Adapter Hub (see fig. 23). Note: The right hub is Left Threaded. Remove old half set of Honing Wheels. Repeat the same procedures for removing the other half set of Honing Wheels. Clean the Honing Wheel Adaptor Hubs of any honing dust.

Turn one half set of new Honing Wheels opposite to the other half set of new Honing Wheels (see fig. 24) and slide onto hubs. Brass Shims located behind the Honing Wheels may be moved from one hub to the other for proper wheel alignment. Return the Washer Nut to each hub and tighten with Wheel Wrench. If wheels rub, repeat the previous steps.

Reposition and secure the Honing Wheel Guard. Lower the hinged Wheel Guards and return the clear top splash shield to the top of the machine.

New wheels need to be Chamfered and Dressed before being used. Please refer to the Chamfering and Dressing sections.



After both half sets of Honing Wheels have been chamfered and dressed they should be measured with the Wheel Gauge to make sure they are the same size (see fig. 19). If one half set of Honing Wheels is larger, dress it until it is the same size as the smaller half set of Honing Wheels and until the dots on the Dresser Advancement Knobs are in the same position.

Turn Hand Wheel COUNTERCLOCKWISE until Honing Wheels are not overlapped (can see between them)(see fig. 5). Turn Hand Wheel CLOCKWISE until the Honing Wheels start to overlap (cannot see between them)(see fig. 6). Using one of the numbers on the Hand Wheel as a reference point, turn the Hand Wheel two complete turns CLOCKWISE (see fig. 7).

The HR8 honing wheels are now ready to begin sharpening.

REPLACING A DIAMOND DRESSER BIT

Turn OFF all Power Switches.

Disconnect Air Line or SHUT OFF the Air Cut-Off Valve located inside the rear door (see fig. 41).

On the Dresser Assembly for which the Diamond Dresser Bit is being changed, turn BACK Dresser Advancement Knob FOUR (4) OR MORE FULL TURNS counterclockwise.

NOTE: The new Diamond Dresser Bit will extend FARTHER IN because of the new condition of the Diamond. Therefore it is important to turn BACK the Dresser Ram Assembly BEFORE changing the Diamond Dresser Bit.

At the side of the cover, remove 4 Phillips Flat Head Screws (see fig. 25) and the small Stainless Cover Plate to access the desired Dresser Assembly (see fig. 26).

With 3/16" Hex Key Wrench remove the Socket Head Cap Screw located just below the Dresser Ram Assembly (see fig. 27). Pull out the Dresser Ram Assembly (see fig. 28).

Wipe clean the Dresser Ram Assembly and the inside of the Dresser Saddle which holds the Dresser Ram Assembly.

Using a 1/16" Hex Key Wrench loosen the Spring Plunger Screw that holds the Diamond Dresser Bit (see fig. 29) enough to slide out the used Diamond Dresser Bit (see fig. 30).

Remove the Knob from the used Diamond Dresser Bit Shaft and tighten it onto the end of the new Diamond Dresser Bit Shaft (see fig. 31).

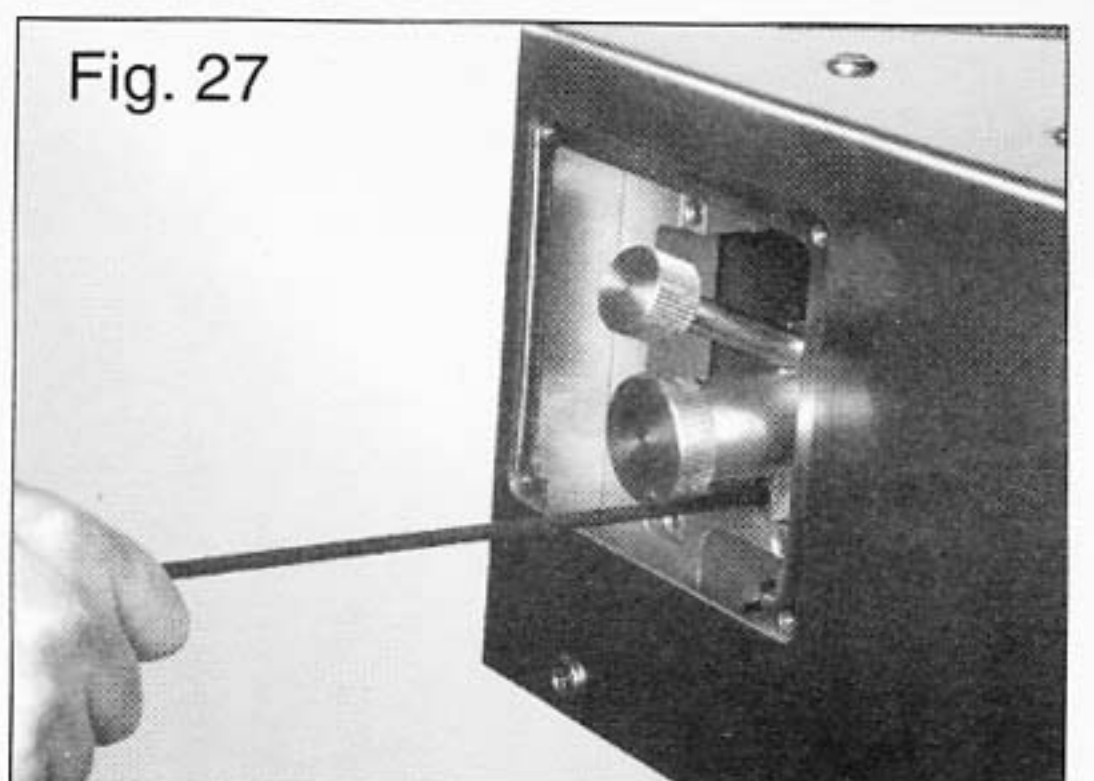
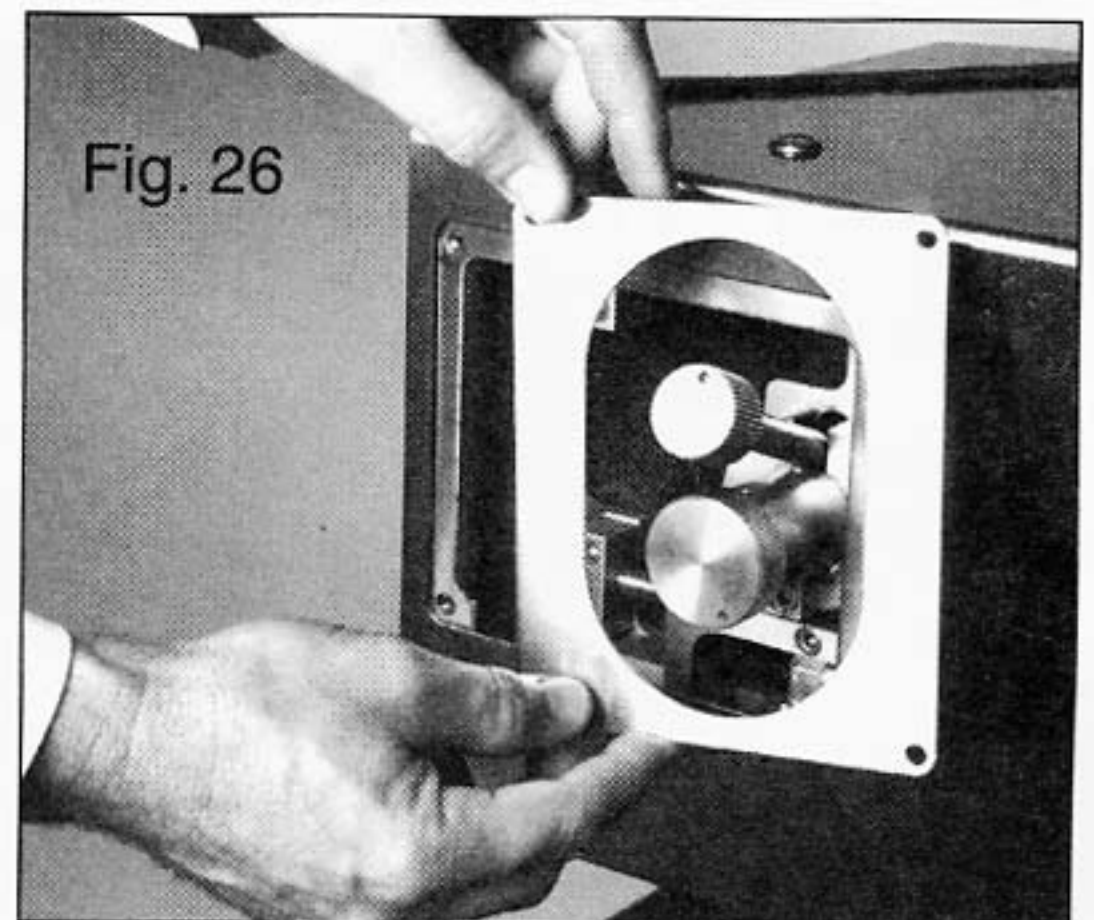
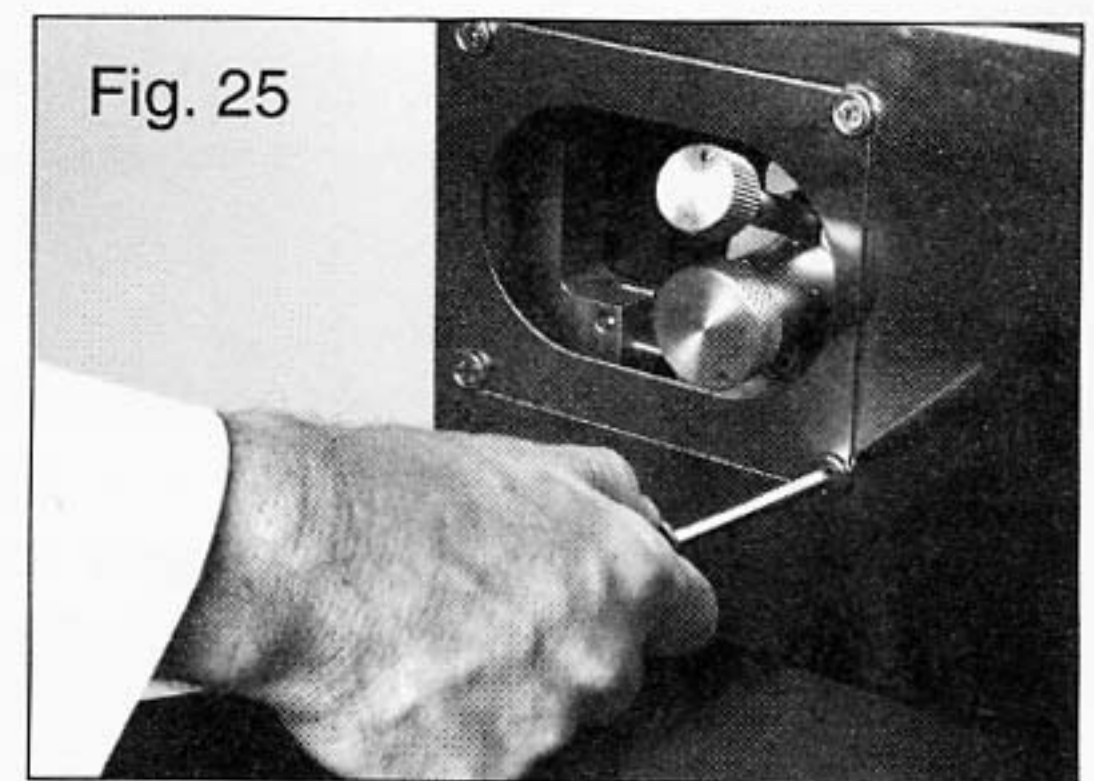
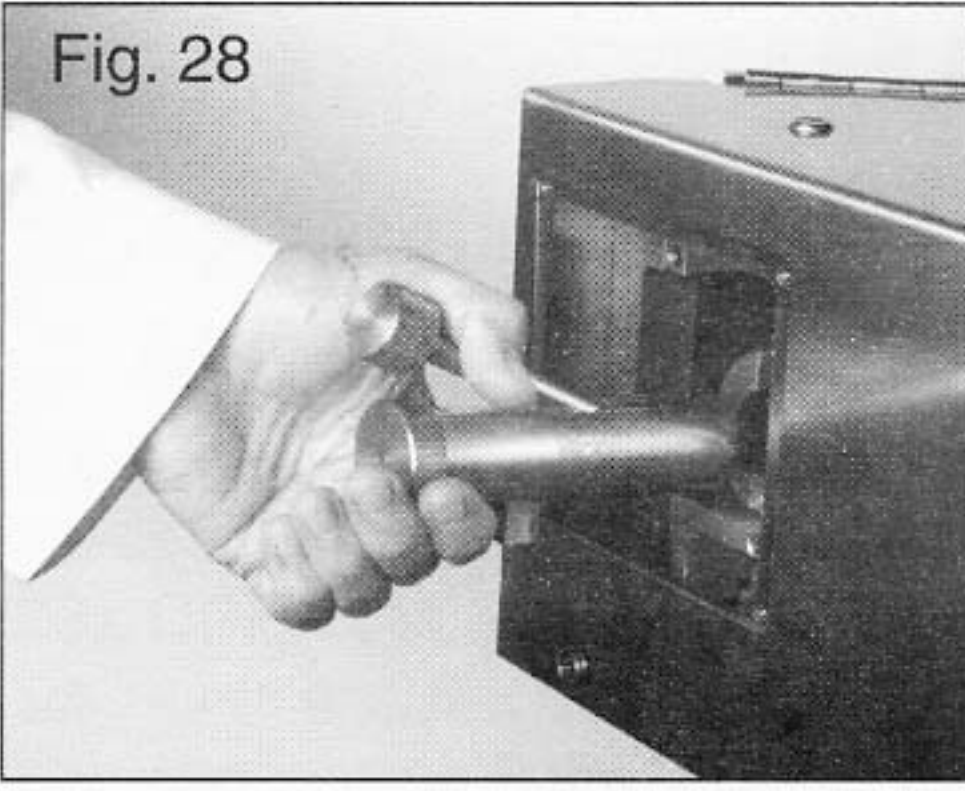


Fig. 28



Clean the Diamond Dresser Bit hole in the Dresser Ram Assembly. Fill the groove that is cut into the Diamond Dresser Bit Shaft with grease and grease the Shaft.

Slide the Diamond Dresser Bit into the Dresser Ram Assembly until the groove is past the Spring Plunger (see fig. 32). Tighten the Spring Plunger Screw until it resists movement of the Diamond Dresser Bit Shaft. Pull the Diamond Dresser Bit Shaft back until the Spring Plunger drops into the groove. Continue tightening the Spring Plunger Screw until it is tight and then loosen it 1/4 of a turn.

Slide the Dresser Ram Assembly back into the Dresser Saddle and tighten with the Socket Head Cap Screw. NOTE: Be sure that the Dresser Ram Knob is setting straight on the end of the Ram. If it is not, PUSH UP on the Dresser Ram Key Nut before tightening Socket Head Cap Screw.

Reposition Cover Plate and fasten with 4 Phillips Flat Head Screws..

OPEN Air Cut-Off Valve and RESTART Honer.

Turn Dresser Advancement Knob CLOCKWISE one click at a time while cycling Diamond Dresser Bit across running Honing Wheels. As soon as new Diamond Dresser Bit dresses Honing Wheels, line up Dresser Advancement Knob Dots by dressing either the left or right Honing Wheel.

Fig. 29

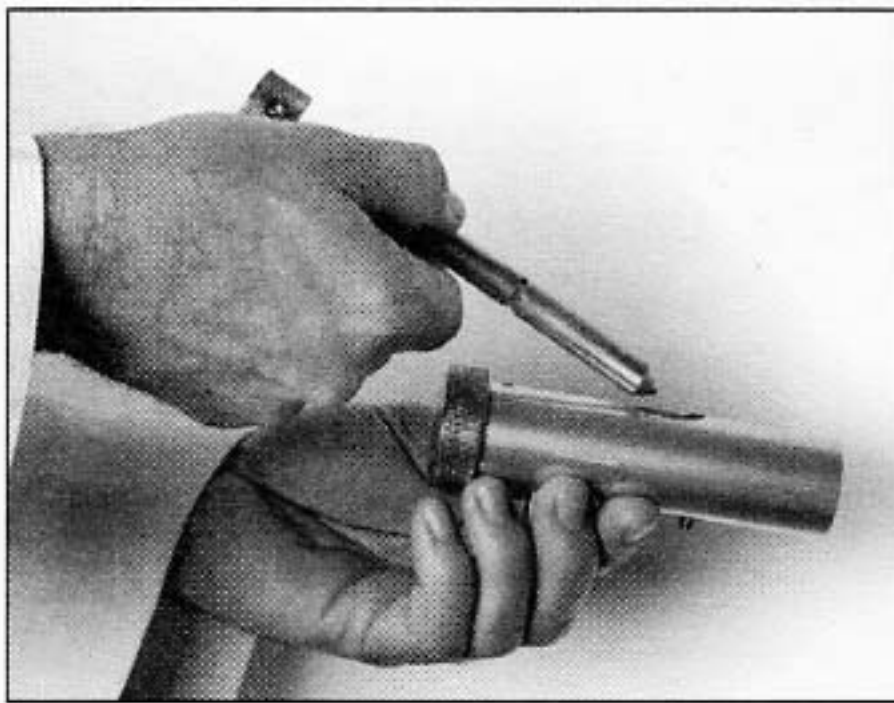
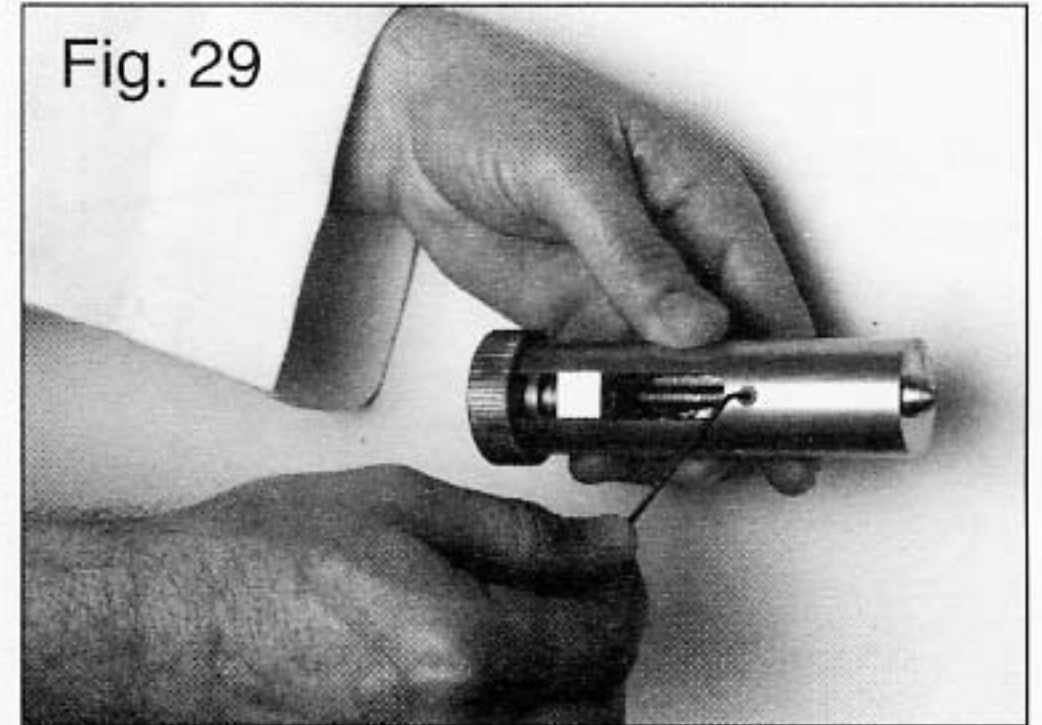


Fig. 30

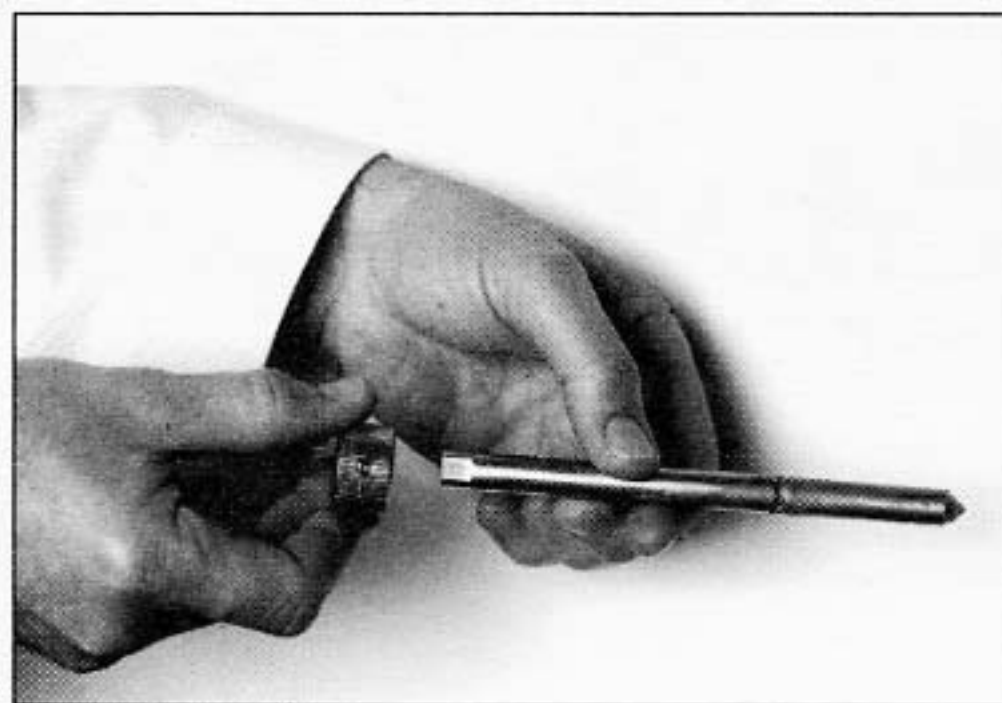


Fig. 31



Fig. 32

HYDRAULIC DRESSING SYSTEM MAINTENANCE

The Mineral Oil Reservoirs for the Dressing System Hydraulics are located inside the rear door (see fig. 33). The Mineral Oil Levels should be checked weekly. The Hydraulic Lines are clear in color.

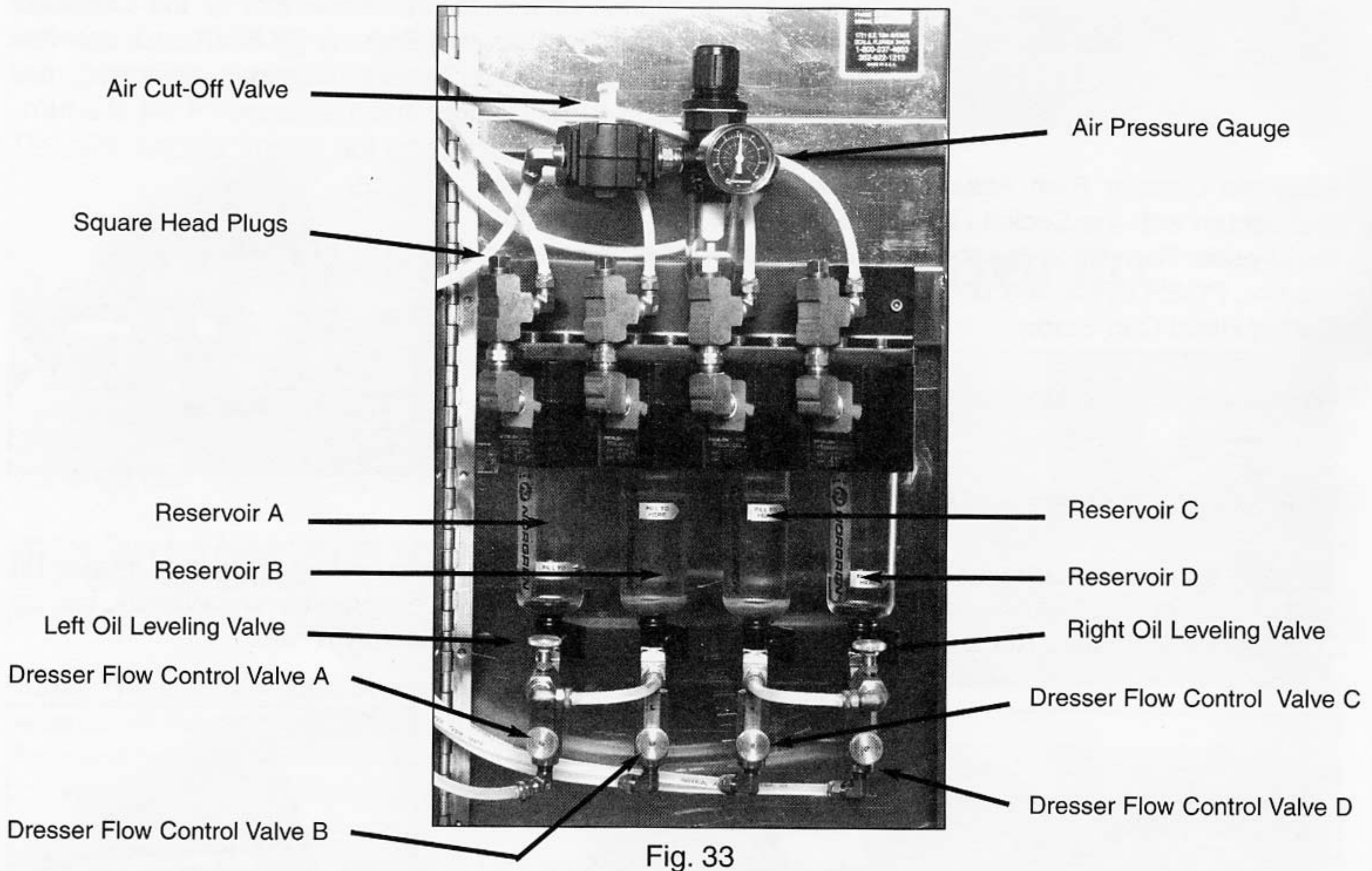
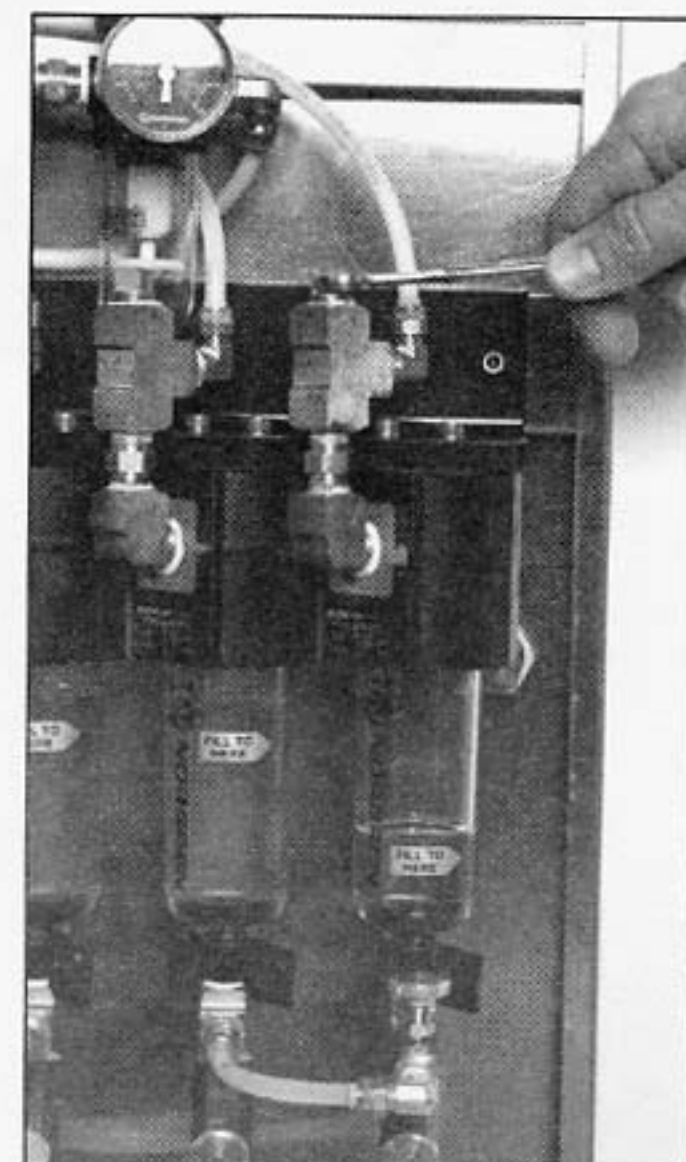


Fig. 33

ADDING OIL

If any of the Oil Levels are below the full line, *****DISCONNECT the Air Line***** from the Honer or SHUT OFF the Air Cut-off Valve (see fig. 33). Remove the Square Head Plug on top of the appropriate Reservoir (see fig. 34) and fill to the full mark with clear Mineral Oil. DO NOT OVER FILL OIL LEVELS. Replace Square Head Plugs that were removed for filling.

Fig. 34



ADJUSTING OIL LEVELS

Use the following steps when no oil is needed, but the levels are incorrect.

A & B RESERVOIRS

If the Mineral Oil Level in Reservoir (A) is above the full line and the Oil Level in Reservoir (B) is below the full line (see fig. 35), turn Air ON and Loosen Locking Nut just below Left Oil Leveling Valve Knob (see fig. 33). OPEN the Left Oil Leveling Valve Knob COUNTERCLOCKWISE. The Oil Level in Reservoir (A) will decrease and the Oil Level in Reservoir (B) will increase. When the Oil Level in Reservoir (B) reaches the full line, turn the Left Oil Leveling Valve Knob CLOCKWISE TO STOP the flow of oil. Retighten Locking Nut on this Valve.

If the Mineral Oil Level in Reservoir (B) is above the full line and the Oil Level in Reservoir (A) is below the full line (see fig. 36), turn Air ON, turn Main Power Switch ON, press the Start Button and turn the Speed Knob to Dress (see fig. 1 & 2). ***This next step may require TWO PEOPLE to perform.*** PUSH IN AND HOLD the Left Dresser Button just to the left of the Start Button. Loosen Locking Nut just below Left Oil Leveling Valve Knob. Open the Left Oil Leveling Valve Knob COUNTERCLOCKWISE. Oil will flow from Reservoir (B) to Reservoir (A). When the oil level in Reservoir (A) is approximately 1" above the full line, turn the Left Oil Leveling Valve Knob CLOCKWISE TO STOP the flow of oil. Release the Left Dresser Button. Check Oil Levels. Repeat these steps if necessary. Retighten Locking Nut on this Valve.



Fig. 35

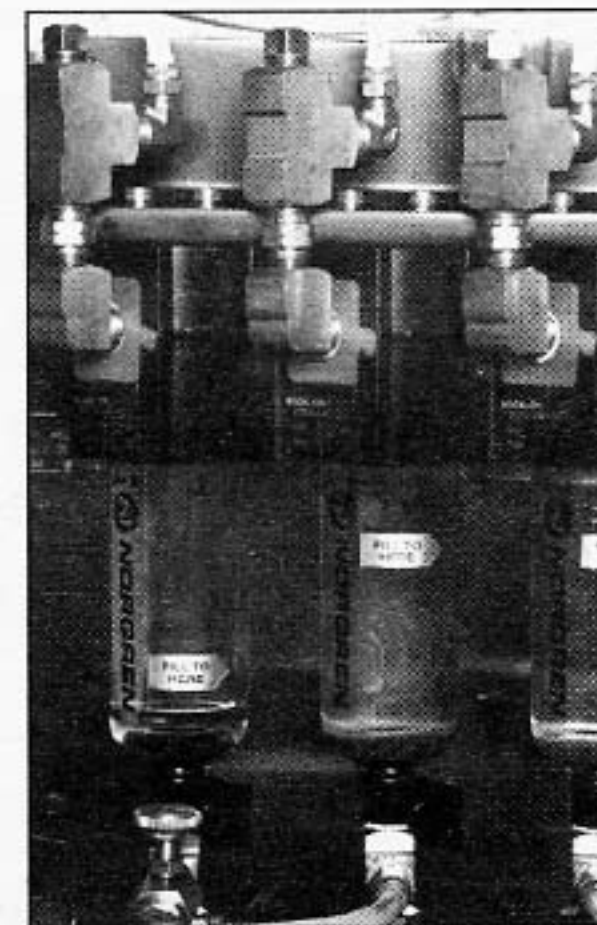


Fig. 36

C & D RESERVOIRS

If the Mineral Oil Level in Reservoir (D) is above the full line and the Oil Level in Reservoir (C) is below the full line (see fig. 37), turn Air ON and Loosen Locking Nut just below Right Oil Leveling Valve Knob (see fig. 33). OPEN the Right Oil Leveling Valve Knob COUNTERCLOCKWISE. The Oil Level in Reservoir (D) will decrease and the Oil Level in Reservoir (C) will increase. When the Oil Level in Reservoir (C) reaches the full line, turn the Right Oil Leveling Valve Knob CLOCKWISE TO STOP the flow of oil. Retighten Locking Nut on this Valve.

If the Mineral Oil Level in Reservoir (C) is above the full line and the Oil Level in Reservoir (D) is below the full line (see fig. 38), turn Air ON, turn Main Power Switch ON, press the Start Button and turn Speed Knob to Dress (see fig. 1 & 2). ***This next step may require TWO PEOPLE to perform.*** PUSH IN AND HOLD the Right Dresser Button just to the right of the Speed Knob. Loosen Locking Nut just below Right Oil Leveling Valve Knob. Open the Right Oil Leveling Valve Knob COUNTERCLOCKWISE. Oil will flow from Reservoir (C) to Reservoir (D). When the oil level in Reservoir (D) is approximately 1" above the full line, turn the Right Oil Leveling Valve Knob CLOCKWISE TO STOP the flow of oil. Release the Right Dresser Button. Check oil levels. Repeat these steps if necessary. Retighten Locking Nut on this Valve.

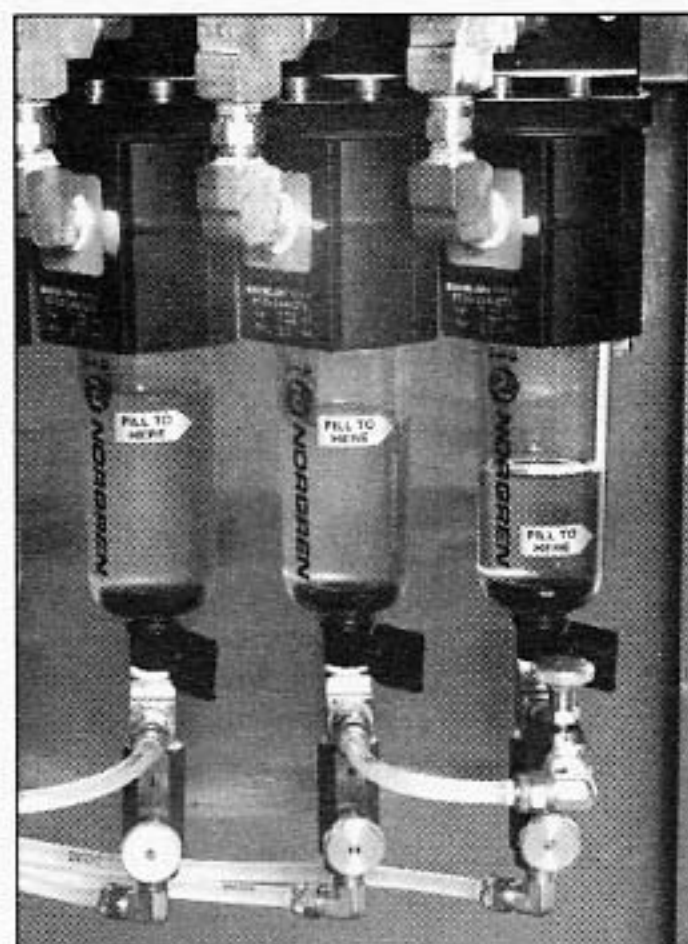


Fig. 37

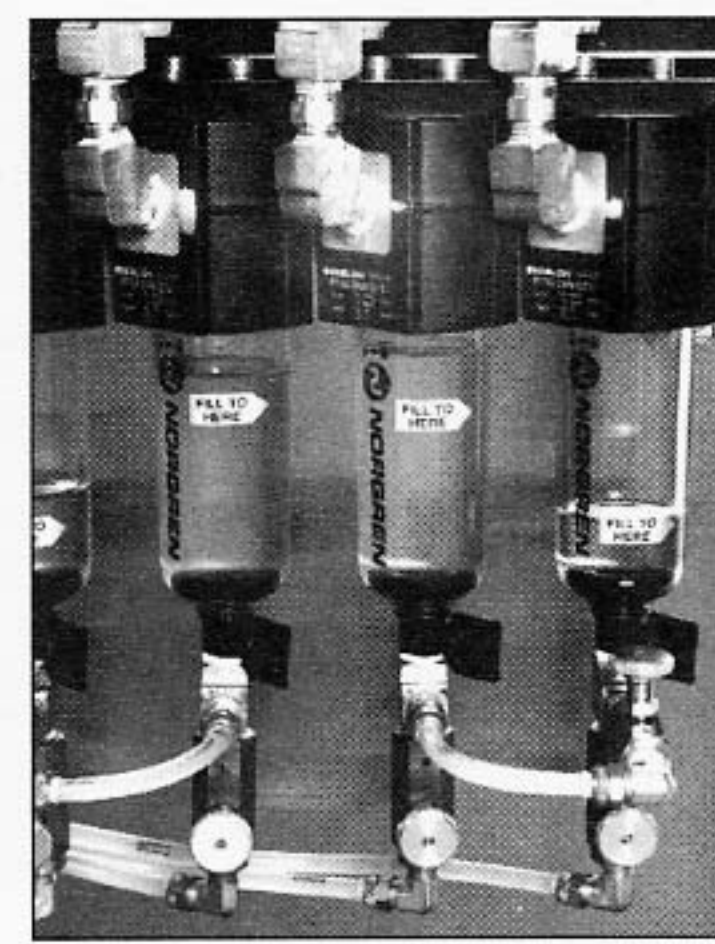


Fig. 38

ADJUSTING DRESSING CYCLES

The Dressing Cycle is the time it takes for a Dresser Assembly to move to the Forward Position or return to the IDLE Position. The Dressing Cycles are preset at 12 seconds but may be slower in cooler environments and faster in warmer environments. Adjust the Dressing Cycles according to the environment in which the Honer is being operated.

LEFT DRESSING CYCLE

To adjust the Left Forward Dressing Cycle, turn Air ON, turn Main Power Switch ON, press Start Button and turn Speed Knob to Dress (see fig. 1 & 2). Push in and Hold the Left Dresser Button located just to the left of the Start Button. The Time for the Left Dresser Assembly to move to the Forward Position should be approximately 12 seconds. If the Forward Dressing Cycle is too slow or too fast, adjust with Dresser Flow Control Valve A (see fig. 33). Loosen the 3/8" Locking Nut behind the Valve Knob and turn Valve Knob **CLOCKWISE TO SLOW** down the Dressing Cycle or **COUNTERCLOCKWISE TO SPEED** it up. When the Dressing Cycle has been adjusted to 12 seconds, retighten the Locking Nut.

To adjust the Left Return Dressing Cycle, turn Air ON, turn Main Power Switch ON, press Start Button and turn Speed Knob to Dress (see fig. 1 & 2). Push in and Hold the Left Dresser Button located just to the left of the Start Button. This cycles the Left Dresser Assembly to the Forward position. Release the Left Dresser Button. The Time for the Left Dresser Assembly to return to the Idle position should be approximately 12 seconds. If the Dressing Cycle is too slow or too fast, adjust with Dresser Flow Control Valve B (see fig. 33). Loosen the 3/8" Locking Nut behind the Valve Knob and turn the Valve Knob **CLOCKWISE TO SLOW** down the Dressing Cycle or **COUNTERCLOCKWISE TO SPEED** it up. When the Dressing Cycle has been adjusted to 12 seconds, retighten the Locking Nut.

RIGHT DRESSING CYCLE

To adjust the Right Forward Dressing Cycle, turn Air ON, turn Main Power Switch ON, press Start Button and turn Speed Knob to Dress (see fig. 1 & 2). Push in and Hold the Right Dresser Button located just to the right of the Speed Knob. The time for the Right Dresser Assembly to move to the Forward Position should be approximately 12 seconds. If the Forward Dressing Cycle is too slow or too fast, adjust with Dresser Flow Control Valve D (see fig. 33). Loosen the 3/8" Locking Nut behind the Valve Knob and turn Valve Knob **CLOCKWISE TO SLOW** down the Dressing Cycle or **COUNTERCLOCKWISE TO SPEED** it up. When the Dressing Cycle has been adjusted to 12 seconds, retighten the Locking Nut.

To adjust the Right Return Dressing Cycle, turn Air ON, turn Main Power Switch ON, press Start Button and turn Speed Knob to Dress (see fig. 1 & 2). Push in and Hold the Right Dresser Button located just to the right of the Speed Knob. This cycles the Right Dresser Assembly to the Forward position. Release the Right Dresser Button. The time for the Right Dresser Assembly to return to the Idle position should be approximately 12 seconds. If the Dressing Cycle is too slow or too fast, adjust with the Dresser Flow Control Valve C (see fig. 33). Loosen the 3/8" Locking Nut behind the Valve Knob and turn the Valve Knob **CLOCKWISE TO SLOW** down the Dressing Cycle or **COUNTERCLOCKWISE TO SPEED** it up. When the Dressing Cycle has been adjusted to 12 seconds, retighten the Locking Nut.

AIR/WATER SEPARATOR

The Air/Water Separator located on the left side of the Honer next to the Main Power Switch (see fig. 1) removes water in the Air Line that will contaminate the Hydraulic System. An Air/Water Separator should always be used on the Air Line. When water accumulates in the Air/Water Separator it must be manually released by turning the valve at the bottom of the Air/Water Separator (see fig. 39).

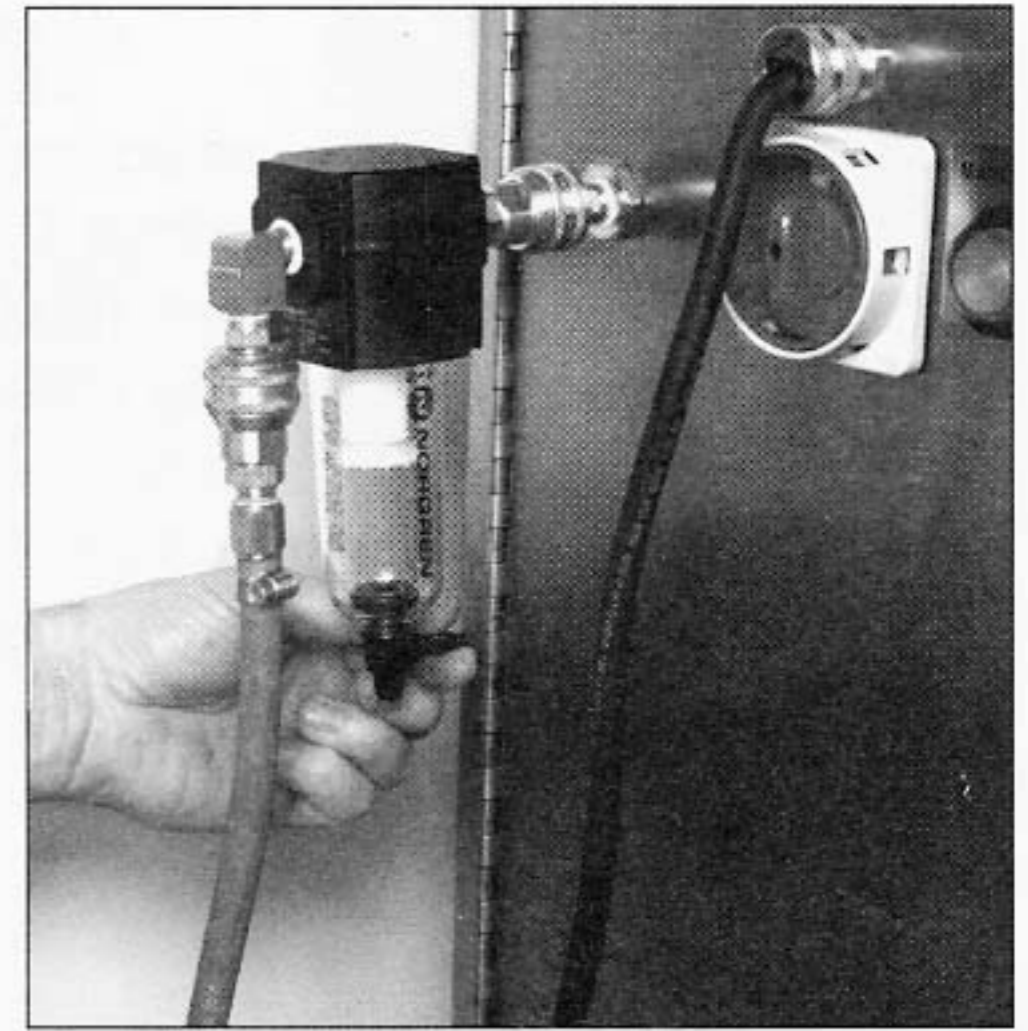


Fig. 39

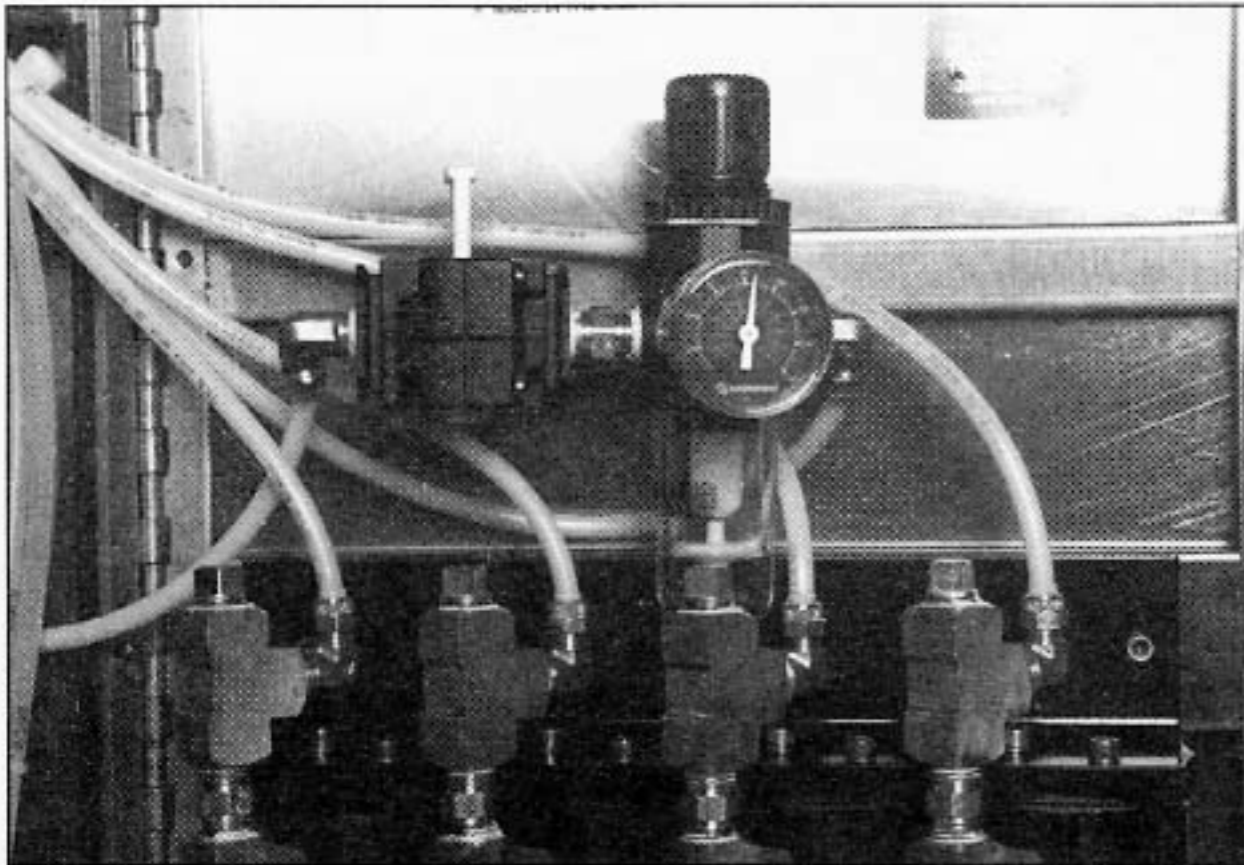


Fig. 40

AIR PRESSURE GAUGE

The Air Pressure Gauge located inside the rear door is preset at approximately 85 lbs (see fig. 40). If adjustment is required read directions on the very top of the Pressure Gauge on how to release the Locked Position and adjust Air Pressure. After adjustment has been made return to Locked Position.

AIR CUT-OFF VALVE

The Air Cut-Off Valve located inside the rear door must be OPEN (Lever Up & Air Gauge reading approximately 85 lbs.) in order to operate the Hydraulic Dressing System (see fig. 40).

The Air Cut-Off Valve must be CLOSED (Lever Down & Air Gauge reading ZERO) whenever adding Mineral Oil to Hydraulic Dressing System or disconnecting any Hydraulic Lines (see fig. 41).

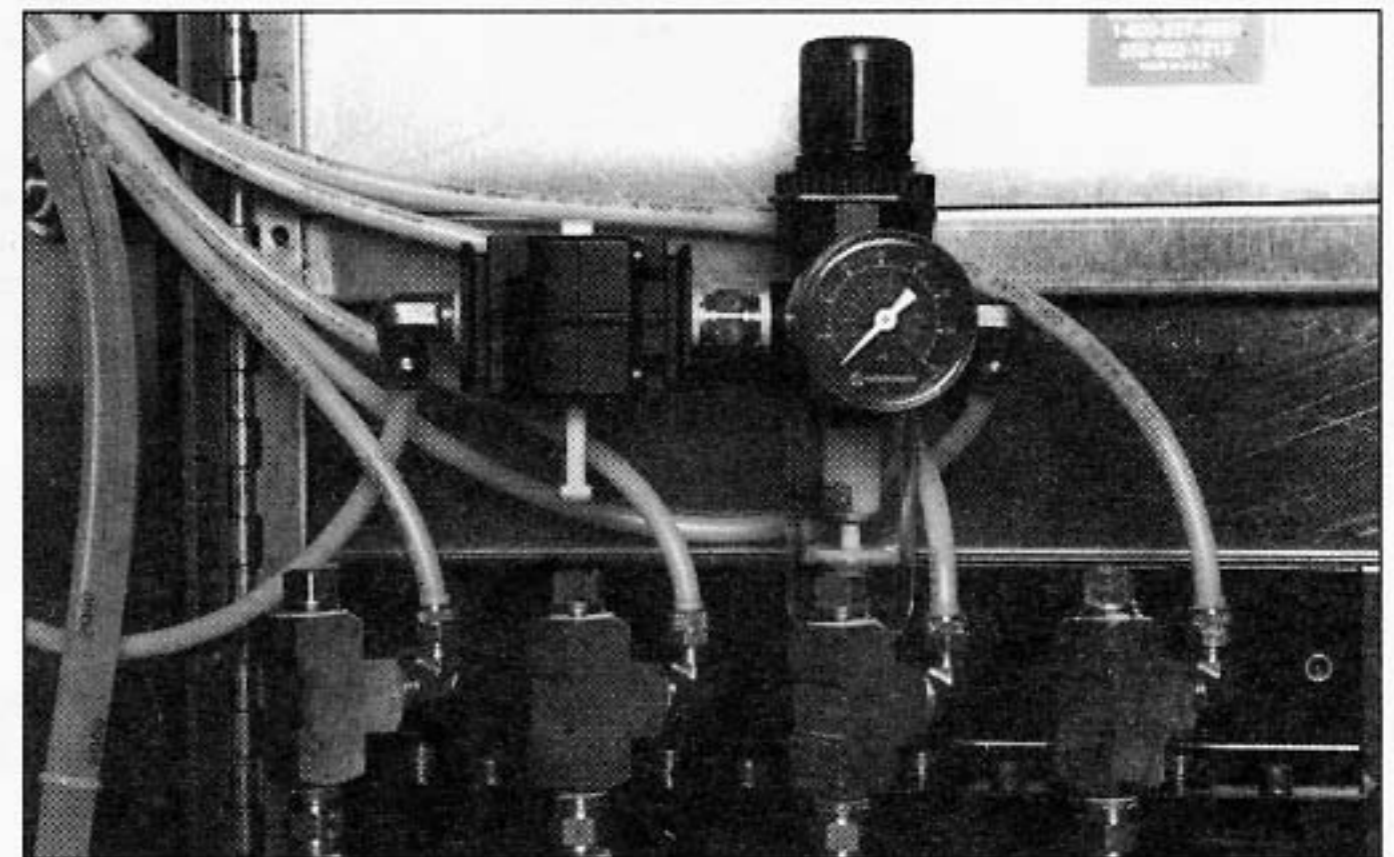


Fig. 41

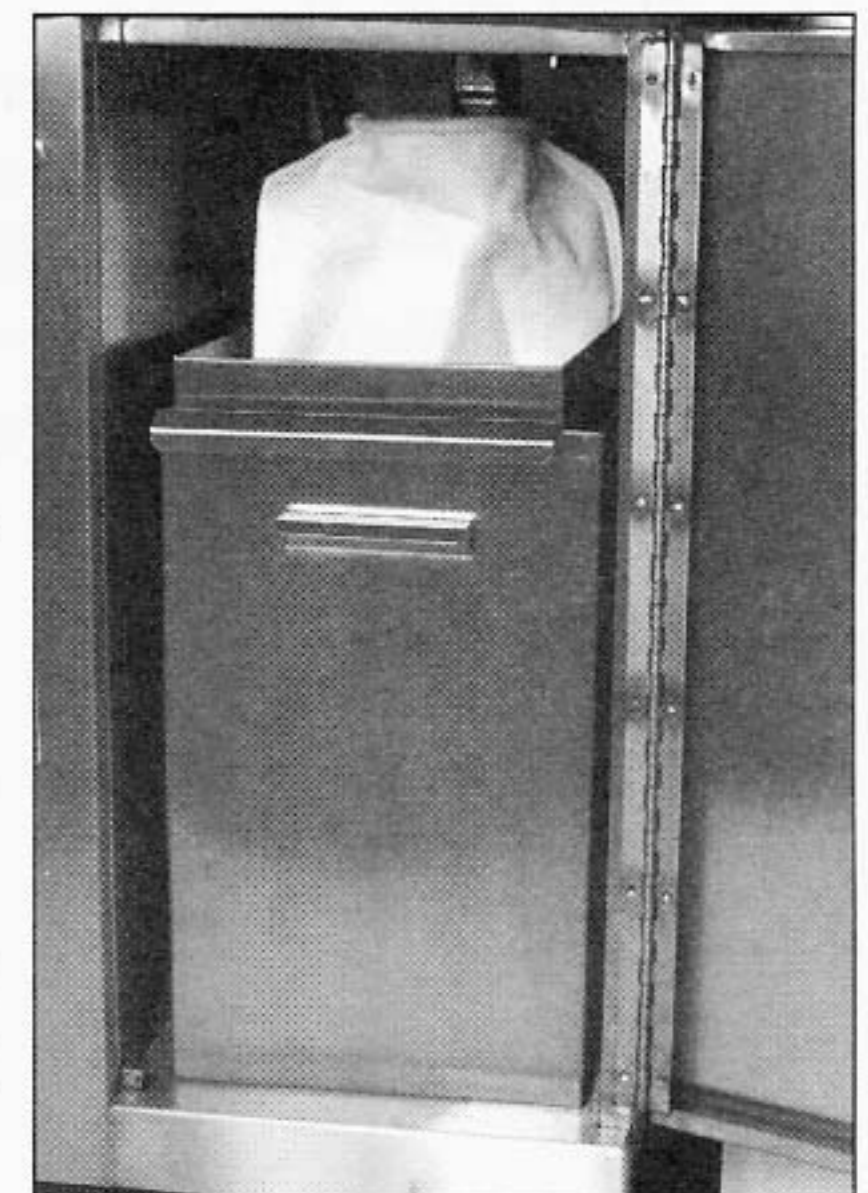
COOLANT TANK & FILTERS

The Coolant Tank and Filters located inside the front cabinet (see fig. 42) should be checked weekly to be sure Coolant is clean and at the proper level and Filters are clean.

Fig. 42

ADDING COOLANT

If the Coolant is clean but the Level is down, add Grinding Solution and Water (1/4 Cup Grinding Solution:1 Gallon Water) until the Coolant Tank is approximately THREE QUARTERS FULL.



CHANGING COOLANT

Remove Coolant Tank located inside the front cabinet. Set aside the Filter Tray and Pump (see fig. 43). Pour out old Coolant and rinse Coolant Tank. Pour 1 1/2 Cups of Grinding Solution into Coolant Tank and add Water until Coolant Tank is approximately THREE QUARTERS FULL. Rinse or change Tray and Sock Filters. Return Tray Filter to Filter Tray. Hang Sock Filter from Hook located on the front of the Coolant Return Spout (see fig. 44). Place Pump back into the rear of the Coolant Tank and SET Filter Tray on top of the Coolant Tank (see fig. 45). Slide Coolant Tank into right front cabinet (see fig. 42). Make sure the Sock Filter is hanging straight with the bottom inside the Filter Tray. Close front Door.



Fig. 43

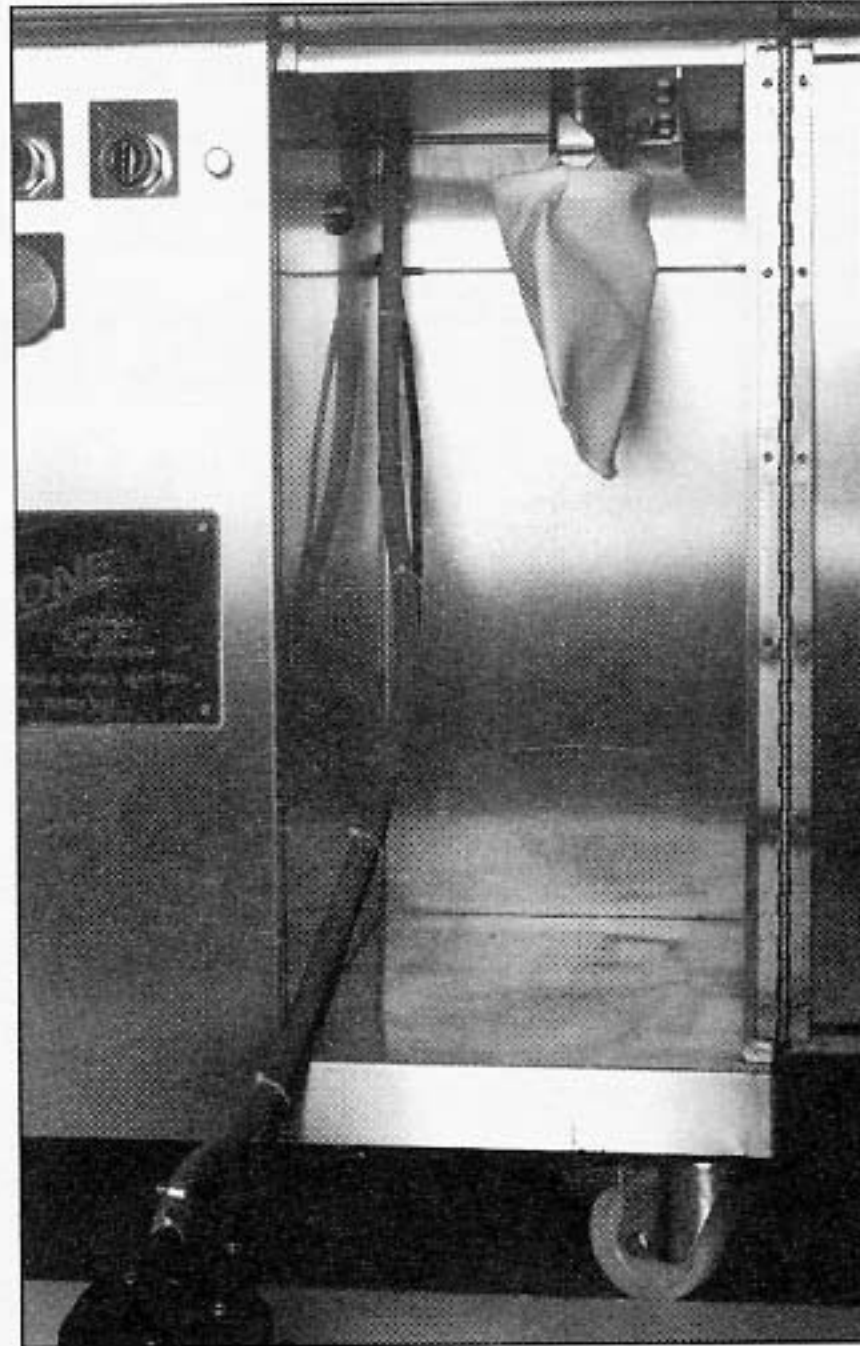


Fig. 44

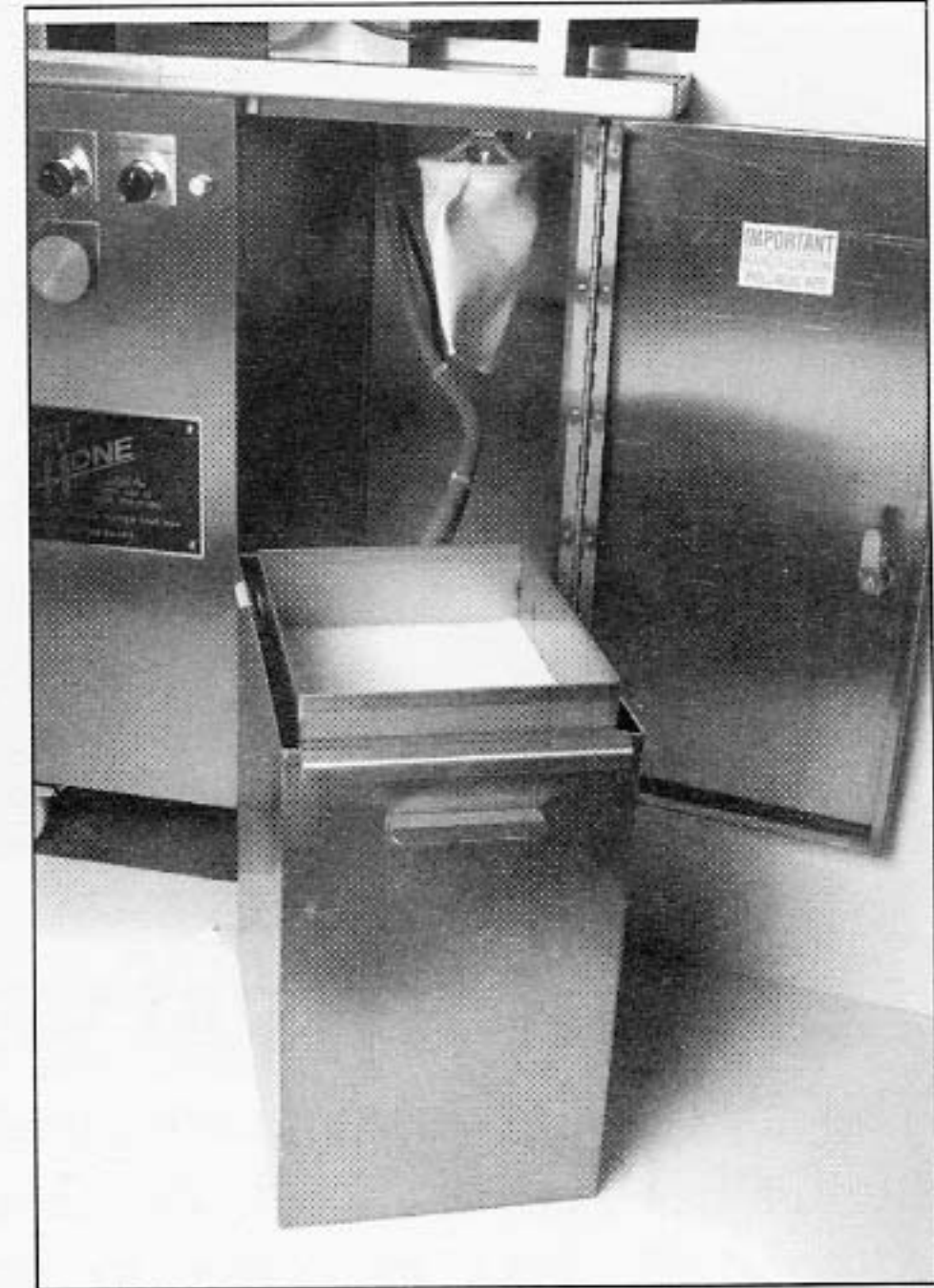
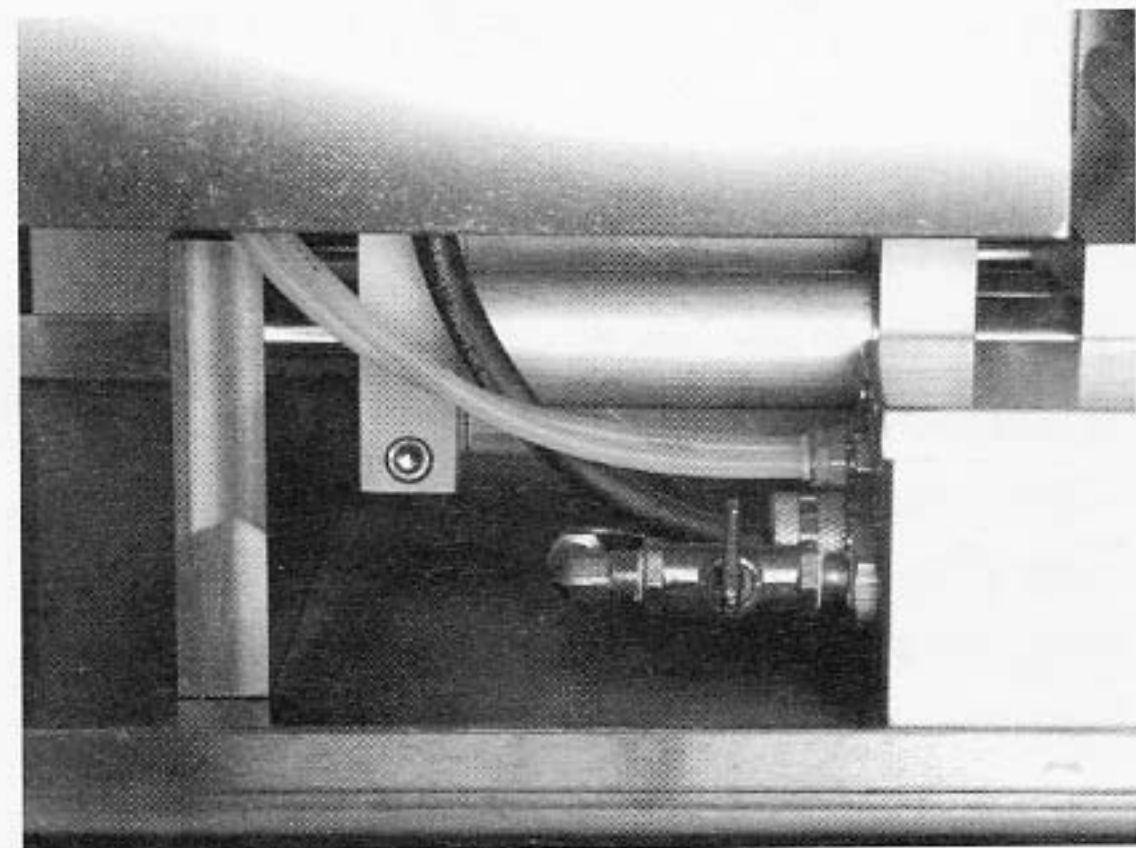


Fig. 45

COOLANT FLOW CONTROL VALVE

The Coolant Flow Control Valve (see fig. 46) controls the flow of coolant to the Coolant Fountain. The Coolant Flow Control Valve is closed in the six or twelve o'clock positions. Use the between positions to Increase or Decrease the coolant flow. The Coolant Flow Control Valve should be OPEN ENOUGH to allow the desired flow of coolant to the Honing Wheels.

Fig. 46



110 VOLT OUTLET BOX FOR PUMP

The 110 volt Outlet Box is located inside the rear Cabinet just to the left of the Control Box (see fig. 47). The Top Outlet is for the Pump and is activated by the Pump Switch. The Lower Outlet is a Standard 110V Outlet and is activated by the Main Power Switch.

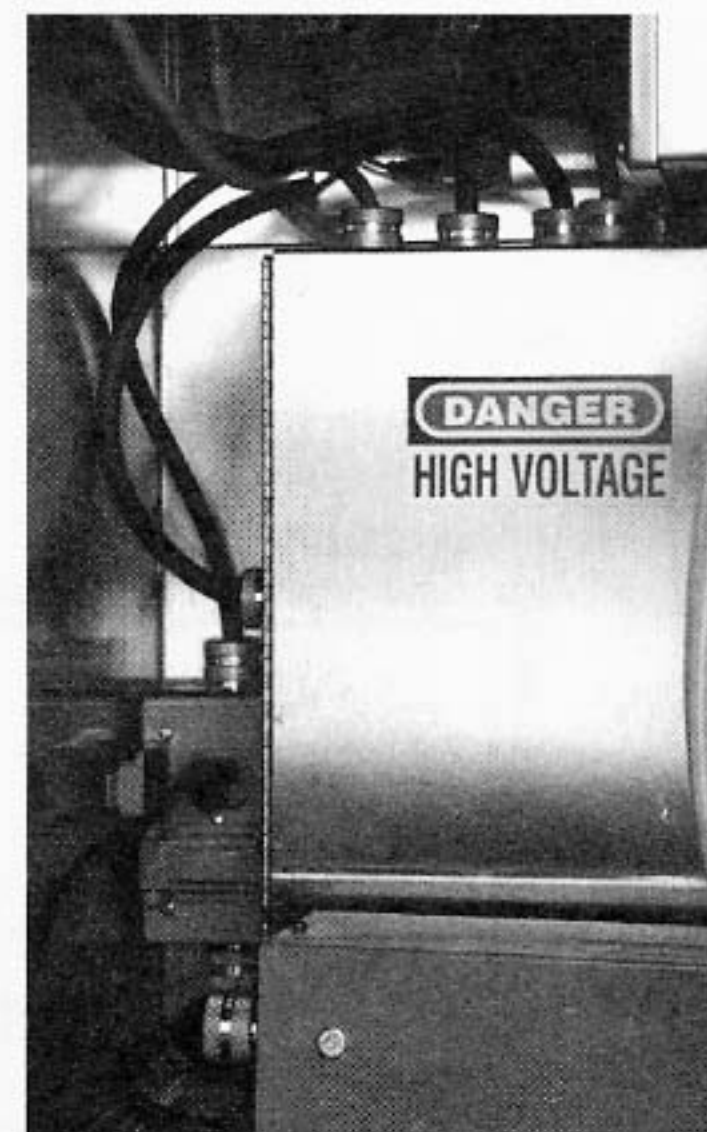


Fig. 47

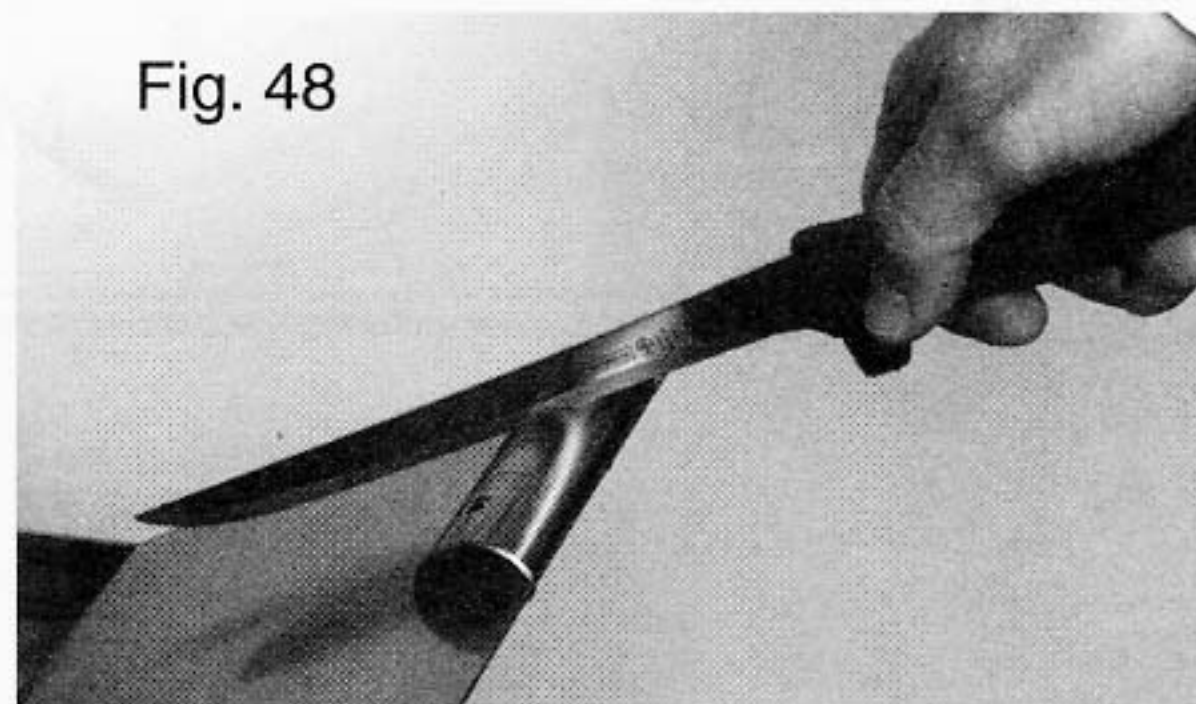
CONTROL BOX

Reset Buttons are located inside the rear cabinet in the Main Control Box (see fig. 47). They are Red Square Buttons. In the event there is a Loss of Power to the Motors, push Reset Buttons to regain motor power. Inside the Control Box, two bus type fuses are located for protection of the transformer. If an overload is placed on the transformer these fuses will blow. The transformer also supplies 110V power for switches in the Control Box. Replace fuses when necessary.

KNIFE GAUGE

The Knife Gauge measures the thickness of the taper of a Knife Blade (see fig. 48). Before sharpening a knife on the Honer, draw the edge of the Blade through the desired slot on the Knife Gauge (either .023" or .020"). (The .016" slot is a "NO GO". If knife edge drops freely into this slot the taper of the edge is too thin.) A properly tapered Blade should fit into the .023" or .020" Slot but NOT TOUCH THE BOTTOM

Fig. 48



of the Slot. If the Blade Edge touches the bottom of the Slot, the Blade has been tapered too thin. If the Blade DOES NOT FIT into the Slot, it needs more tapering on the Hollow Grinder.

CLEANING

When sharpening is completed for the day, it is recommended that the Honer be wiped down.

Turn Pump Switch OFF, turn Speed Knob to OFF, push Stop Button OFF and turn Main Power Switch OFF (see fig. 1 & 2). Set the top Water Shield aside and using paper towels wipe down the sharpening area of the Honer. Clean the top Water Shield and set it back in place.

After most of the Coolant has drained back into the Coolant Tank, use paper towels to wipe up the grindings from the Cabinet Top Tray.

Monthly or Quarterly a more thorough cleaning is necessary.

Turn Honer OFF and disconnect Air Line or SHUT OFF the Air Cut-Off Valve. Remove the small Plates that protect the Dresser Assemblies.

Take off the Main left and right Stainless Steel Motor Covers.

Clean as necessary.

Do not store up for yourselves treasures on earth, where moth and rust destroy, and where thieves break in and steal. But store up for yourselves treasures in heaven, where moth and rust do not destroy, and where thieves do not break in and steal. For where your treasure is, there your heart will be also.

Matthew 6:19-21



*...ends the
"Stone Age" of
Knife Sharpening*

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