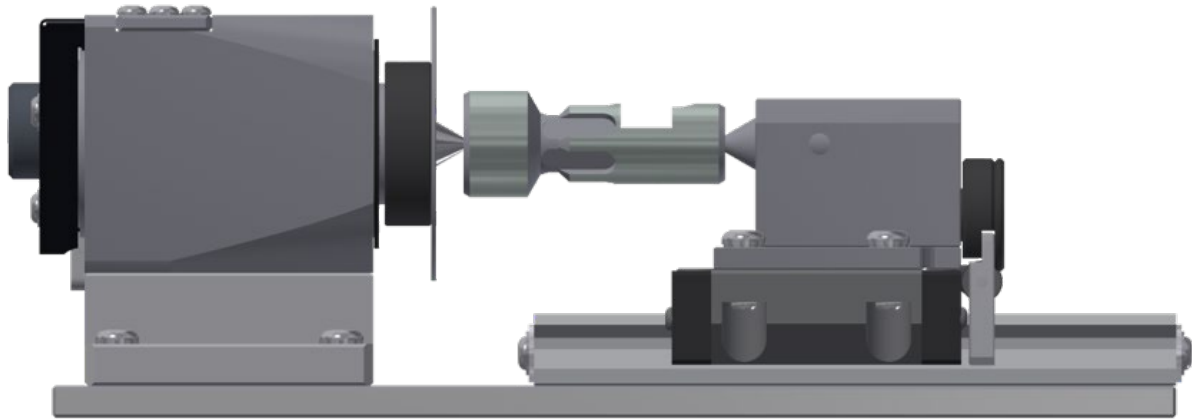




## **Cylindrical grinding – Profile grinding – Plunge grinding on surface grinding machines!**

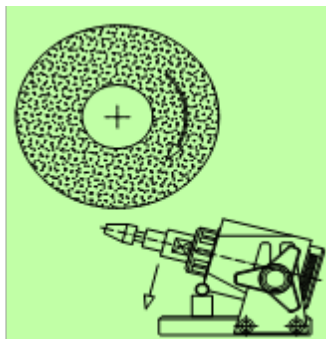


### **Application**

1. Place the RAPID mini on the magnetic table of the surface grinding machine. Align the ground base plate at right angles to the magnetic stop bar and switch on the magnet.
2. Position the workpiece under the center of the grinding wheel.
3. At the control unit with  or  Select the direction of rotation and thus switch on the spindle.
4. Allow the grinding wheel to lightly rub against the workpiece and determine the highest point on the workpiece by moving the machine table.
5. For cylindrical grinding, the drive belt must be tensioned and the locking detent pin must be released. Switch on the motor and allow the workpiece to rotate.
6. When grinding surfaces or pitches:  
Relax the drive belt by loosening the tensioning screws of the motor bracket on the top of the block and moving it in the slotted hole.  
The motor must be at a standstill and the indexing pin must be locked in place.

### **Safety instructions please note:**

- **In the swiveled position, grind only against the gauge block support!**
- **Work only with belt guard.**



### **Service and maintenance:**

- The RAPID mini grinding unit is equipped with sealing rings on the front and rear of the spindle to protect it against splashing water. An additional cover is recommended in case of strong coolant brewing.
- ***Cleanliness and careful treatment will maintain your accuracy.***



## User instructions RAPID mini grinding unit 4.RS05.R

### Grinding with tailstock and rigid center punch:



- Pay attention to heat generation, thin workpieces may bend.
- Heating of the drive motor up to approx. 60° is harmless.
- The tailstock guide rail can be shifted to the right by 30mm if necessary, if slightly longer parts would have to be ground.

### Workpiece change:

- Lock the spindle with the locking pin. Loosen or tighten the workpiece clamping with the E32 wrench for collet nut.
- The spindle holder is prepared to accept E32 collets, Ø range 2-20mm. Optional, collet reductions for ER11, for DECKEL S20x2, driving disc Ø80mm, 3-jaw chuck Ø80mm, magnetic chuck Ø60mm, are available.
- When grinding between centers, the tailstock center can be retracted with spring force (2-finger operation). This enables simple, effortless workpiece changeover.

**Check whether the voltage set on the fuse link matches your mains voltage!**



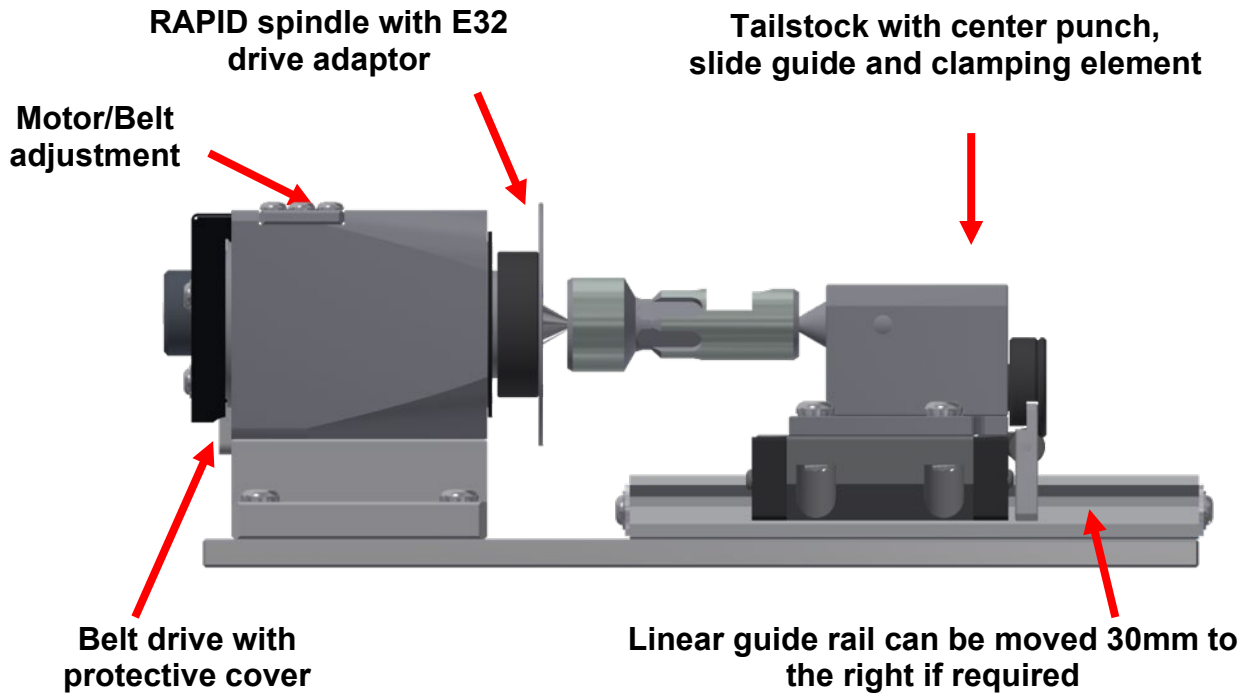
1. Connect power cable and 5-pin connection cable
2. The OFF key lights up
3. For spindle rotation, select the desired direction of rotation to the right  or left 
4. The active key lights up.
5. Use the potentiometer to increase or reduce the speed.
6. With OFF you stop the spindle rotation

### Technical data: RAPID 4.RS05.R (1069556A)

Support surface ca.	350x100mm	Weight ca.	13kg
Height (horizontal) ca.	110mm	Index-dividing head	15° (± 1min)
Height (vertical) ca.	175mm	Center height ca.	45mm
Tool holding fixture	E32 (für Spannzangen Ø 2-20mm)	Spindle runout	0,002mm
Drive	E-Motor, stepless adjustable, 0-300min <sup>-1</sup> Right / left rotation switchable	Power connection	115-230V, 50-60Hz, 70W

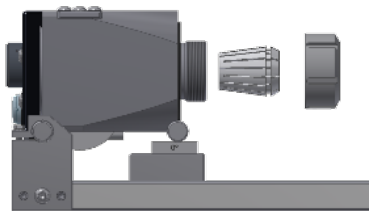
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## Basic components

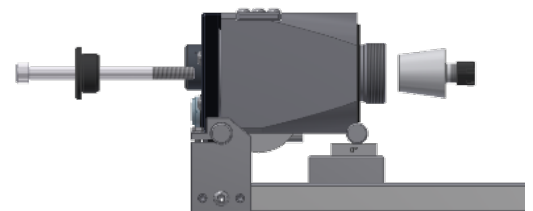


**RAPID the "Swiss knife"  
for your surface grinding machine!**

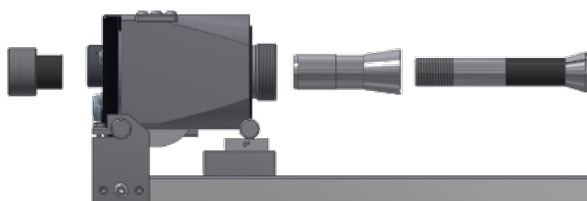
**Many clamping options = rational help in prototyping!**



For E32 collets: 2-20mm (Standard)  
RAPID 4.RS03.F, 1069042A,  
For workpiece-Ø up to 80mm



Adapter E32 for ER11 collets 1-7mm,  
1053704A  
Example: Grinding possible from Ø 0.3mm



Adapter for DECKEL S20x2- collets 3-16mm,  
1047548A,  
Example: for existing DECKEL-collets

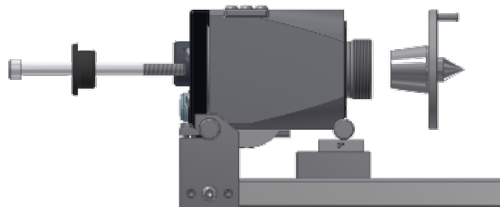
## Simple clamping allows fast use



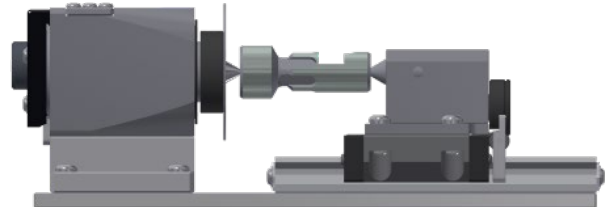
Adapter for 3-jaw chuck Ø 80mm,  
 1007358A  
 3-jaw chuck = 1011397A



Adapter for magnet chuck Ø 80mm,  
 1065448A  
 magnet chuck = 1047644A

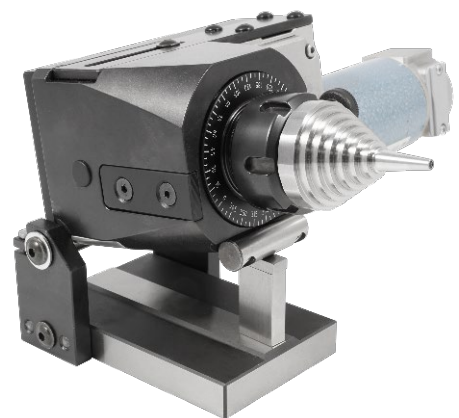


Driving disc Ø80mm, with E32  
 1068675A



Führungsschiene nach rechts versetzbar,  
 um z.B. die Spitzenweite zu vergrößern.

**For grinding any taper up to 45°,  
 or also for swiveling up to 90°,  
 we recommend to use a separate Rapid mini (type 3.RS03.F,  
 1069042A)  
 (control unit and accessories are identical).**



**MPM wishes you much success  
 and pleasure with the grinding unit RAPID mini!**