

DGP-R3 & DGP-R3-V2 USER MANUAL



DGP
DIAMOND GROUND PRODUCTS

"The Tungsten Electrode Experts"
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Recommended maximum cutting time and grinding time for new electrodes. Failure to follow these recommended times could result in reduced diameter wheel life.

Diameter	Cut Time	Diameter	Grind Time
.040"-1.0 mm	4-7 Secs	.040"-1.0 mm	5-8 Secs
1/16"-1.5 mm	7-10 Secs	1/16"-1.5 mm	11-15 Secs
3/32"-2.3 mm	10-13 Secs	3/32"-2.3 mm	15-20 Secs
1/8"-3.2 mm	13-16 Secs	1/8"-3.2 mm	25-35 Secs
5/32"-4.0 mm	16-19 Secs	5/32"-4.0 mm	30-40 Secs
3/16"-4.8 mm	16-19 Secs	3/16"-4.8 mm	55-65 Secs



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USER MANUAL

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MODELS DGP-R3 & DGP-R3-V2

1. GENERAL DESCRIPTION

The DGP-R3 Tungsten Welding Electrode Grinder is designed specifically for the longitudinal grinding of the conical or tapered points on tungsten welding electrodes from .040" (1.0mm) to 3/16" (4.8mm) in diameter. This model also offers a multi-purpose grinding wheel for other shop uses. The grinder is equipped with a completely enclosed ball bearing motor and a rotor and shaft assembly that is dynamically balance for vibration-free rotation. The motor housing is compact and the unit has ample side clearance on the grinding and aluminum oxid wheels. Wheel guards are secured to the shaft by threaded nuts and safety eyeshields are also included.

DGP-R3 and DGP-R3-V2 Tungsten Electrode Grinders offer precise grinding for your precision welding needs. The DGP-R3 consists of a horizontal axis grinder that can be pedestal mounted, a diamond grinding wheel and assembly on the right side, and a general purpose aluminum oxide wheel for general shop uses on the left side. The DGP-R3-V2 adds a foam-insulated cabinet, vacuum system for dust collection, and a flexible spotlight in addition to the DGP-R3 features. The DGP-R3 can be upgraded later to a DGP-R3-V2.

The diamond grinding wheel on both grinders is on the right side of the machine and the surface rotates toward the electrode which provides consisten and repeatable points from each grind. The grinding surface faces right and right wheel enclosure housing supports the electrode grinding assembly in addition to the Point Flat Dresser Block. The location of the area of contact between the diamond grinding wheel and the tungsten electrode is visible to the operator at all times, which allows for excellent control fo the grinding operation. After repeated use, a groove will eventually be worn into the wheel at the contact point. The contact point should then be adjusted downward slightly to the next unused spot on the diamond grinding wheel. The grinding assembly on the left side also provides excellent visibility and is easy to operate for general grinding use, but is not recommended for tungsten because of the inferior finish it produces. Wheel rotation, viewed from the left end of the grinder, is clockwise.

VACUUM SYSTEM OVERVIEW

The DGP-R3-V2 comes with a tool cabinet and integrated vacuum sytem for the collection of tungsten dust. This feature has become very popular due to notification in the past few years about the danger of inhaling dust from commonly used 2% Thoriated tungsten, which is a known radioactive cancer-causing element. Please contact your local OSHA office if you would like more information about this issue. In addition, we offer free samples of non-radioactive alternative tungsten, which performs better in most applications. Users of the DGP-R3 can later upgrade their systems to add the vacuum system if chosen later.

It is impossible to contain all of the lightweight dust particles that deflect quickly off the wheels from grinding. The vacuum syste offers a way of collecting the majority of the dust that is produced while grinding tungsten electrodes. Each side of the grinder has vacuum holes and hoses to collect dust. To maximize the suction power, use the valves at the back of the grinder moto to direct the suction to the side you are using. If you are using both sides at the same time, leave both sides open. However, if you are only using one side, close the valve on the opposite side and you will increase the suction power to the side you are using.

Replacement vacuum filters are in stock at the factory for immediate shipment.

2. SPECIFICATIONS

Motor: 1/3HP 110/120 Volt, Standard OR 220/240 Volt Optional; 50/60Hz

Wheels: **Right side:**
Nickel Plated Diamond Wheel, 6" diameter
Left side:
Diamond Cutting Wheel, 6" diameter

3. UNPACKING

Check for shipping damage. Diamond Ground Products takes great pride in producing quality equipment. If for some reason you find anything to be defective, please call us at: (805) 498-3837 and we will work with you to solve the problem. The following accessories are shipped with the DGP-R3 and DGP-R3-V2 grinders:

1. Pin Vise used to hold tungsten while grinding
2. Six different Hex Keys, used to make various adjustments, and one Hex Screwdriver, used to secure the tungsten in the cutting apparatus.
3. Collets (four of your choice) - used to guide the tungsten and hold it at the proper angle while grinding.

4. WARRANTY

The DGP-R3 & DGP-R3-V2 come with a one-year warranty on parts and labor, excluding wheels that are a consumable part that naturally wears over time. This warranty excludes abuse to the machine, dropping of the unit or improper handling by the operator.

5. SAFETY AND OPERATING GUIDELINES

Before any work is done, read the caution below carefully. Working safely prevents accidents.

- When not in use, turn the grinder off for safety purposes and to decrease wear on the machine.
- Wear proper apparel. Do not wear loose clothing, including gloves, neckties, rings, bracelets, or other jewelry, which may get caught in moving parts of the machine.
- Wear protective hair covering to contain long hair.
- Wear safety glasses and a facemask.
- Never operate power tools when tired, intoxicated, or when taking medication that may cause drowsiness.
- Work area should have sufficient lighting.
- A proper electrical outlet should be available for the tools. A three-prong plug should be plugged directly into a three-pronged outlet. Extension cord should be the correct gauge.
- Keep visitors at a safe distance from the work area.
- Always unplug grinder prior to inspection.
- Read this manual thoroughly for specific adjustments and operating procedures.
- Do not perform “make-shift” repairs. Any part that is damaged should be promptly replaced.
- Only use the grinder for its intended purpose. Do not use it for a job it was not designed for.
- Make sure that the grinder is off before plugging it in.
- Do not apply extreme force on the tungsten while grinding. This may cause your grinder to jam or cause premature grinding wheel wear.
- Never leave the grinder unattended. Turn the grinder off first and do not leave it until it comes to a complete stop.
- Know your grinder; learn its operation, applications, and specific limitations.
- Always unplug grinder prior to inspection.
- Grinding parts other than tungsten will severely decrease wheel and equipment life.
- Unplug the grinder when changing accessories, such as collets, wheel, or other replacement parts.
- Avoid accidental start-up. Make sure that the grinder is in the off position before plugging it in.
- Do not force the grinder. It will work most efficiently at the rate for which it was designed. Consult the “Recommended Minimum Cutting and Grinding Time for New Electrodes” sticker on the grinder to determine optimum rate of speed.
- Use recommended accessories. Use of improper accessories may cause risk of injury of persons or accelerated wear on the grinder.
- Handle the tungsten and grinder correctly. Consult grinder operation procedures in this manual and handle tungsten with pin vise whenever possible to protect hands from possible injury.
- Feed tungsten into grinding wheel against the direction of rotation of the wheel.
- Turn the wheel off if it jams. A wheel jams when it digs too deeply into the tungsten (the motor force keeps it stuck in the tungsten).
- Never stand or lean on the grinder. Serious injury could occur if the grinder is tipped or if the cutting tool is unintentionally contacted.
- Keep hands away from moving parts and cutting surfaces.

6. MAINTENANCE

- Always unplug grinder before inspection.
- Keep the grinder clean for safest operation.
- Remove adjusting keys and wrenches. Form a habit of checking that keys and adjusting wrenches are removed before the grinder is turned on.
- Keep all safety guards in place and in good working order.
- Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended functions.
- Check for damaged parts and alignment of moving parts, binding of moving parts, breakage of mounting parts and any other condition that may affect the grinder operation. Consult DGP factory for replacement parts at: (805) 498-3837
- Do not use power tools in dangerous environments, such as damp or wet locations. Do not expose power tools to rain.
- Work area should be properly lighted.
- The proper electrical outlet should be available for the tool. For 110V, a three prong plug should be plugged directly into a three prong outlet and/or extension cord.
- Keep visitors a safe distance from work area and keep children out of work place. Use padlocks or master switches to prevent any unintentional use of power tools.

TROUBLESHOOTING CHART

SYMPTOMS	POSSIBLE CAUSE(S)	CORRECTIVE ACTION
Grinder won't start	1. Blown line or tripped circuit breaker	1. If fuse is blown, replace with fuse of proper size. If breaker is tripped, reset it.
	2. Low line voltage	2. If voltage is less than rated, check size of wiring from main switch on property. If OK, contact power company.
	3. Material wedged between wheel and guard	3. Remove material wedged between wheel and guard.
Excessive vibration	1. improper mounting of grinder or accessories	1. Remount
	2. Improper wheel mounting	2. Remove both wheels then remount wheels, but rotate one wheel 1/4 turn with respect to its previous position. The other wheel would retain its original position.
Grooved wheel	1. Electrode pushed with excessive force	1. Use recommended grinding times table.
	2. On steep angled tungsten, collet touching wheel	2. Use short collets available from Diamond Ground Products.
Motor is overheating	1. Motor not turning freely (without power)	1. Clean around wheels & shaft. Then replace bearings.

MOUNTING THE DGP-R3

The DGP-R3 stand alone grinder (without vacuum system and cabinet) should be mounted to a solid horizontal surface (mounting hardware is not provided).

If mounted to a metal cabinet or pedestal, align the mounting holes with the corresponding holes in the cabinet or pedestal. Insert a 1/4"-20 X 1 1/4" hex head bolt with flat washer beneath the head of the grinder. From the bottom of the cabinet or pedestal, place a 1/4" flat washer and 1/4"-20 hex nut onto the bolt extension. Tighten only until the space between the grinder base and the cabinet or pedestal is 1/8". Using a second nut on each bolt, tighten against the first to prevent loosening by vibration.

If mounted to a wooden bench top, use 1/4" wood screws that are 1-1/4" long with flat washer beneath the heads. Tighten screws until the space between the grinder base and the bench is 1/8".

ELECTRODE GRINDING ASSEMBLY

THE BASICS

The Electrode Grinding Assembly is attached to the right wheel housing (refer to Figure 1 for the general arrangement of the assembly). It provides the means to support an electrode in a fixed position relative to the diamond-grinding surface through an electrode guide collet that matches the electrode diameter. The electrode is brought into gentle contact with the diamond-grinding surface and at the same time is rotated slowly in one direction between the operator's thumb and forefinger. As an alternative, pin vises are also provided to hold the tungsten during rotation. Note: all positioning and adjustment should be made before turning on the grinder. Operation Instructions

Please refer to Figure 1 below for the optimum location of the electrode point contact area with respect to the grinding surface. In the position shown, the motion of the diamond grinding wheel surface is parallel to the centerline of the electrode to accomplish longitudinal grinding of the electrode point. When grinding very steep angles, such as 10°, be careful that the electrode guide collet does not make contact with the diamond grinding wheel. This can contaminate the wheel and reduce the life of the wheel significantly. For these types of angles, you may need to consult the factory to obtain optional short collets that are available for these applications.

Refer to Figure 2 below for use with the following operation instructions:

1. If the tungsten you are using is already flat at the end, like new tungsten straight out of the box, proceed to Step 4.
2. Locate the Point Flat Dresser Block (DGP-R512) attached at the 6 o'clock position of the right side wheel cover. Find the hole that matches the diameter of your tungsten and turn on the grinder. Slowly push the tip against the wheel until the point is removed. Once again, be patient and do not gouge the wheel. A burr can form if too much pressure is exerted on the tungsten.
3. Select the electrode guide collet with the hole diameter closest to the tungsten electrode diameter and position it in the electrode guide collet tube. Notice that the collet has been beveled on a 15° angle at the front or exit of the collet. With this surface parallel to the grinding wheel surface, tighten the set screw to hold it in place. The back, or entrance, end of this collet has been milled down to its center line to make it easy to insert the electrode for grinding.
4. Adjust the angular position of the electrode grinder assembly to the desired included angle of grind for the electrode point using the angle adjustment handle (Handle A).

ELECTRODE GRINDING ASSEMBLY (CONTINUED)

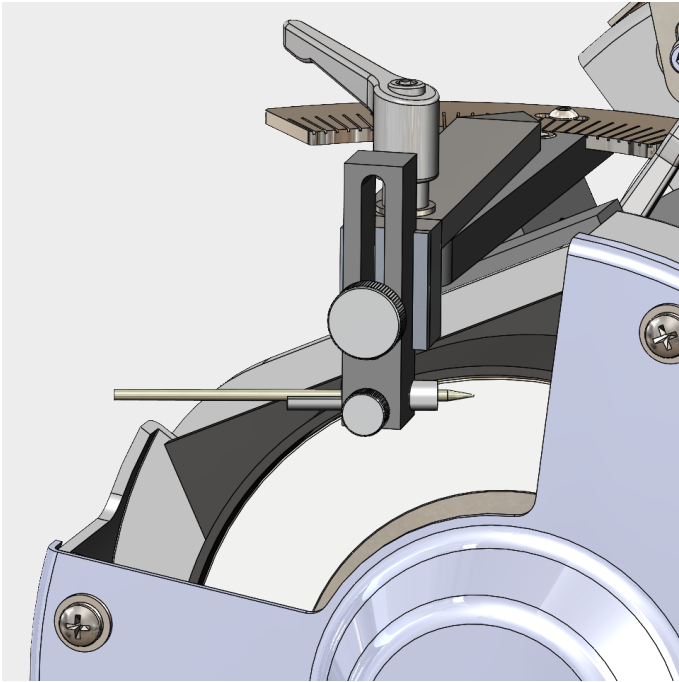


Figure 1: Optimal location of electrode point contact area

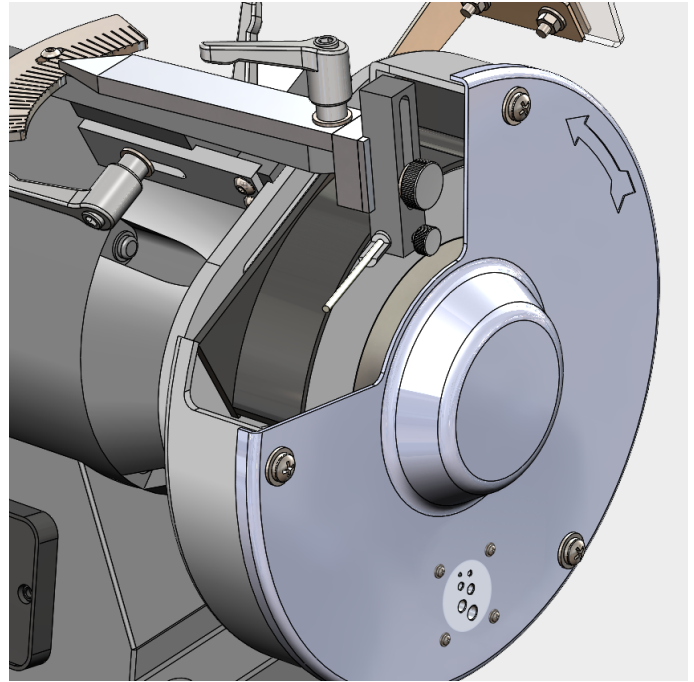


Figure 2: Electrode grinding assembly

RECOMMENDED GRINDING TIMES

Electrode Diameter		Grinding Time
.040"	1.0mm	5-9 sec
1/16"	1.6mm	11-15 sec
3/32"	2.4mm	15-20 sec
1/8"	3.2mm	25-35 sec
5/32"	4.0mm	30-40 sec
3/16"	4.8mm	55-65 sec

Table 1: Recommended grinding times for each diameter

ELECTRODE CUTTING ASSEMBLY

THE BASICS

The left side of the DGP-R3 is an Electrode Cutting Assembly which includes a Diamond Cutting Wheel and cutting apparatus consisting of a measuring ruler on a cut-off arm, a cut-off fork, and an adjustable indexer for cutting the electrodes to various lengths quickly and accurately. Holes are provided for several different diameters electrodes in the cut-off fork. The cutting assembly rotates from a level position up towards and past the edge of the cutting wheel to accomplish the cut. Please refer to Figures 3 and 4 on Page 8 in conjunction with the following instructions.

OPERATION INSTRUCTIONS

1. Locate the Adjustable Stop (A), which is the polished chrome bar protruding from the micrometer and through the black Fixed Stop Block (B) on the Measuring Ruler (C). Make sure it is positioned across from the appropriate hole diameter in the Cut-Off Fork (D) which corresponds to the electrode diameter you intend to cut. To adjust it, loosen the two steel screws (E) under the Cut-Off Fork (D) and slide the ruler fixture until the stop will line up with the electrode you will be pushing through the Cut-Off Fork. Then tighten the screws (E).
2. The exciting feature of the micrometer is the ability to change between different lengths quickly and accurately. Dial out the adjustable stop by turning the gripped, larger micrometer cylinder until it stops at the required length. The scale on the fixed bar on the micrometer is numbered in increments of .100" and the scale on the moving dial bar is in increments of .001".
3. With your length chosen and the power off, insert the electrode tip first, into and through (right to left) the appropriate sized hole on the Cut-Off Fork (D) until tip gently touches the Adjustable Stop (A).
4. Tighten the associated setscrew (F) on the Cut-Off Fork (D) with the provided hex screwdriver to hold the electrode securely. Then turn on the power.
5. Pivot the cutting assembly up and towards the diamond cutting wheel and gently push the electrode shaft into the cutting wheel. For larger electrode sizes, please be especially patient.
6. 6. Return the cutting assembly to the level position before removing the electrode.

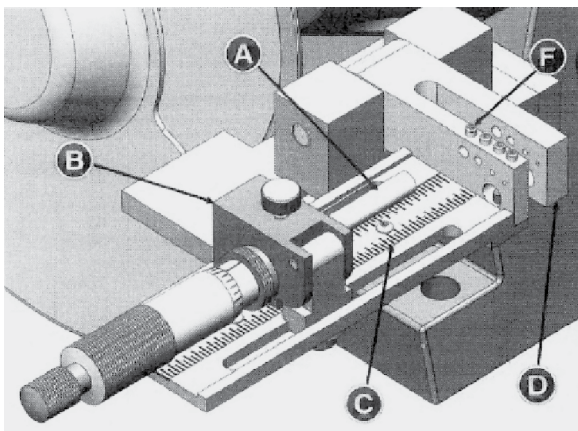


Figure 1: Electrode Cutting Assembly
Viewed from the left

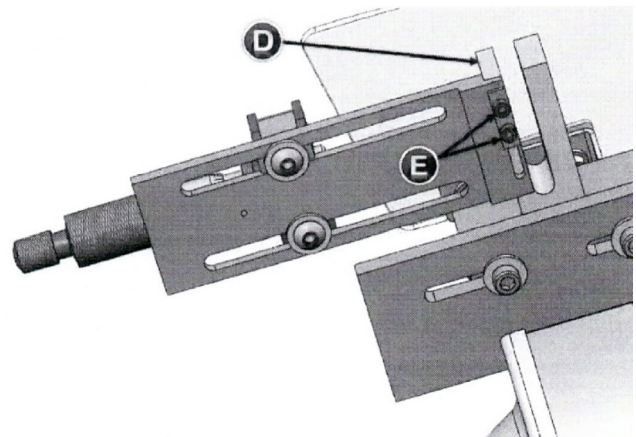
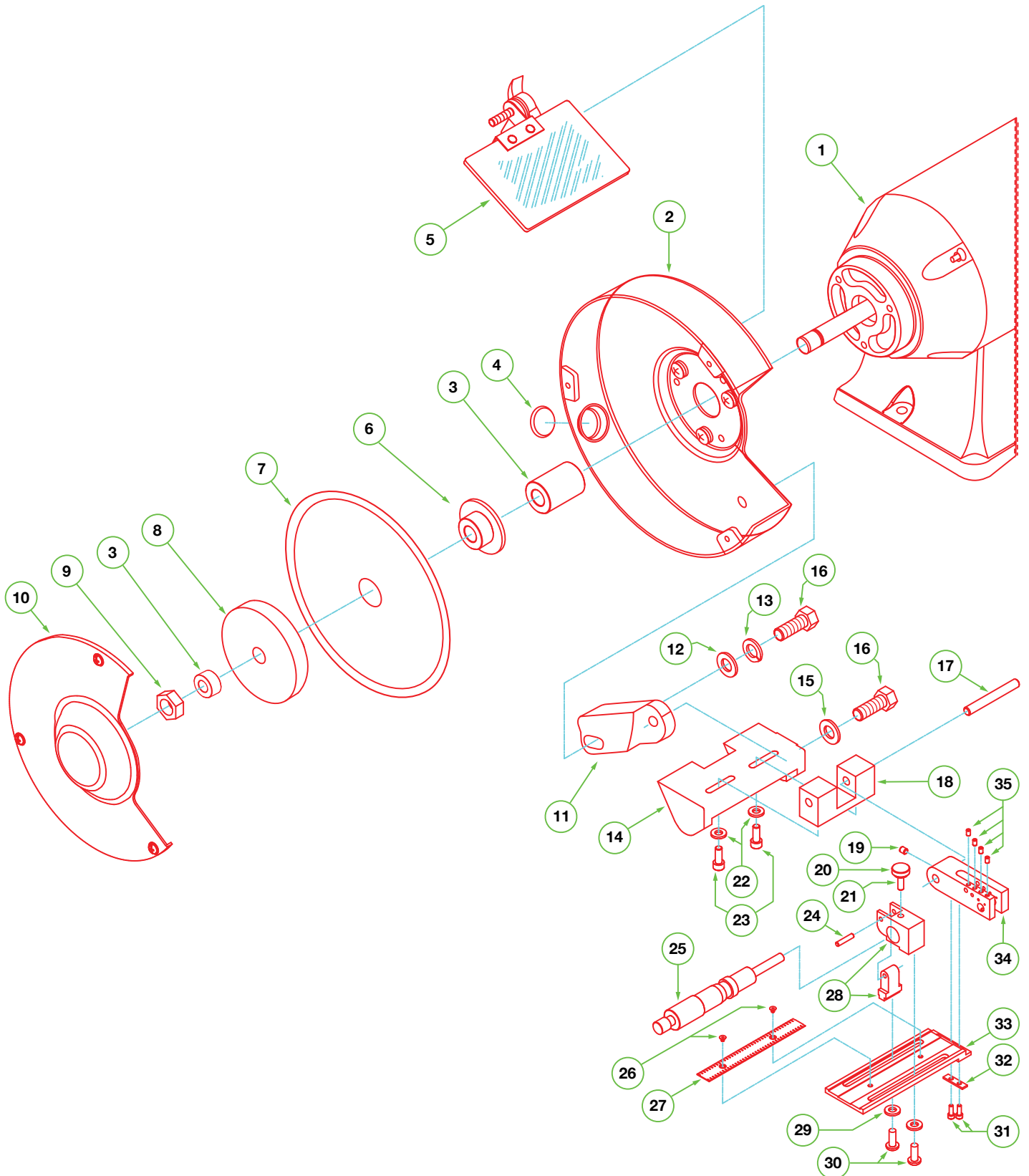


Figure 2: Electrode cutting assembly
Viewed from the right

**Consult Illustrated Parts Lists on the following pages and
See Page 13 for optional Accessories and Consumables Parts List**

DGP-R3 PRECISION TUNGSTEN GRINDER

LEFT SIDE



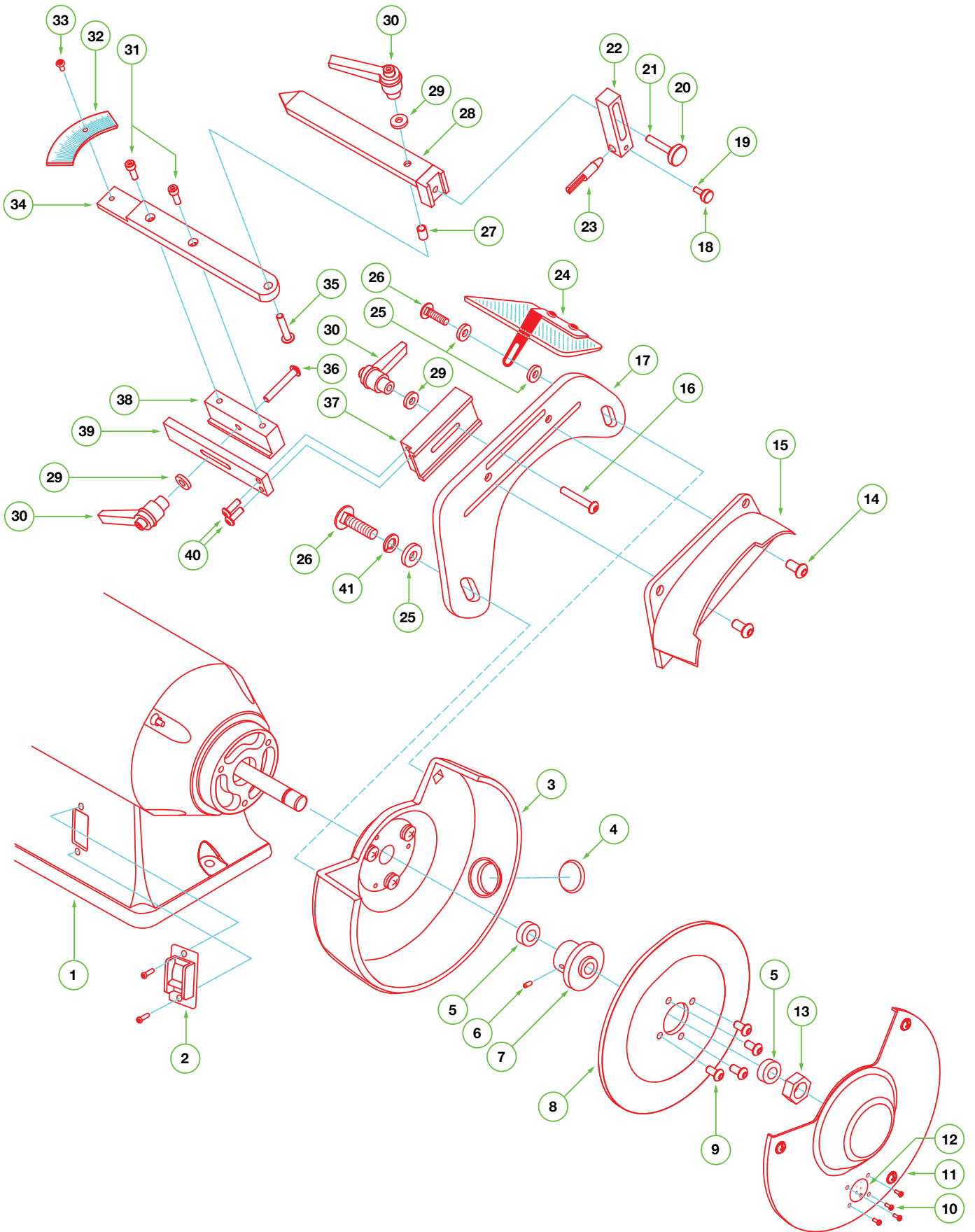
DGP-R3 PRECISION TUNGSTEN GRINDER

LEFT SIDE - PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	DGP-R500	Bench Grinder-Motor-6"; 1/3HP 120/240 Volt	1
2	DGP-R502	Inside Wheel Guard w/Screws (left side)	1
3	DGP-R504	Cut-off Wheel Spacer and Washer	1
4	DGP-PG1489	Push-in Plug 1 1/4" ID x 1 3/8" for Vacuum Port	1
5	DGP-R545	Eyeshield — Plexiglass w/Hardware (left side)	1
6	DGP-F167-A	Hub — Inner	1
7	DGP-P735	Diamond Cutting Wheel, 6"	1
8	DGP-F175-A	Hub - Outer	1
9	DGP-F233	Nut — Hex 1/2" - 12 LH Thread	1
10	DGP-R510	Outside Wheel Cover w/Screws (left side)	1
11	DGP-R511	Support Arm	1
12	DGP-P725	Washer Flat 3/8"	1
13	DGP-P724	Washer - Splitlock SS #3/8	1
14	DGP-F035-A	Base — Electrode Cut Off	1
15	DGP-P725	Washer — Flat 3/8"	1
16	DGP-P310	Screw - Bolt Hex Socket Head 3/8" - 1/16 x 1"	2
17	DGP-F205	Pivot Shaft	1
18	DGP-F190	Pivot Block	1
19	DGP-PG1386	Screw-SHSS #8-32 x 1/4 Cup PT	1
20	DGP-P440	Knob Black Plastic#6	1
21	DGP-PG1320	BHSCS BLK #6 - 32 x 3/8"	1
22	DGP-P723	Washer - Flat #10 x 7/16 OD x .05 THK SST	2
23	DGP-P630	Screw - SHCS SS #10-32 x 3/16 Cut PT	2
24	DGP-PG1854	Dowel Pin STL 1/8" x 5/8" L	1
25	DGP-P495	Micrometer Head .01-1" 001 GRAD	1
26	DGP-P610	Screw - FHCS SS #2 - 56 x 3/16"	2
27	DGP-P520 DGP-P530	Rule, Steel-Flex 16R 1/2" x 6" - (Standard) Rule, S.S. Flex Metric - (Optional)	1
28	DGP-F045-B	Block Assembly Set (DGP-F045-A & DGP-F045-B Indexer)	1
29	DGP-P723	Washer - Flat 10 x 7/16 OD x .05 THK SST	4
30	DGP-PG1442	Screw - SHCS SS #10 -32 x 1/2" Cut Point - BLK	2
31	DGP-P642	Screw - SHCSS SS #4 - 40 x 5/16"	2
32	DGP-P606	Nut Bar	1
33	DGP-F130-5	Micrometer / Ruler Support	1
34	DGP-F143-A	Cut-Off Fork	1
35	DGP-P640	Screw - Set #4-40 x 3/16 SST	5

DGP-R3 PRECISION TUNGSTEN GRINDER

RIGHT SIDE



DGP-R3 PRECISION TUNGSTEN GRINDER

RIGHT SIDE - PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	DGP-R500	Bench Grinder - Motor 6" 1/3HP 120/240 Volt	1
2	DGP-R501	On-Off Switch	1
3	DGP-R506	Right Wheel Inside Cover w/Screws	1
4	DGP-PG1489	Push-in Plug 1 1/4" ID x 3/8" for Vacuum Port	1
5	DGP-R505	Arbor Spacer w/Washer for Grinding Wheel	1
6	DGP-PG1439	Screw — SHSS 1/4" - 20 x 3/8" Cup PT BLK; Arbor Set Screw	1
7	DGP-R507	Arbor for Grinding Wheel	1
8	DGP-PG1425	Wheel — Diamond - 300 Grit (STANDARD)	1
	DGP-PG1426	Wheel — Diamond - 600 Grit (OPTIONAL)	1
9	DGP-PG1442	Screw — BHSCS #10-32 x 1/2" BLK; Screws for Wheel	4
10	DGP-PG1349	Screw — BHSCS #6-32 x 1/4" BLK; Screws for Flattening Block	4
11	DGP-R509	Right Wheel Outside Cover w/Screws	1
12	DGP-R512	Block - Flattening	1
13	DGP-F231	Nut — 1/2" 12 Hex-RH Thread	1
14	DGP-P542	Screw — BHSCS #8-32 x 1/2" BLK	2
15	DGP-R516	Inside Dust Shield	1
16	DGP-P672	Screw — SHC #10-32 x 5/8" BLK	1
17	DGP-R519	Support Bracket	1
18	DGP-P440	Knob Cap #6 Black Plastic	1
19	DGP-PG1320	Screw — BHSCS #6-32 x 3/8" BLK	1
20	DGP-P460	Knob Cap #10 Black Plastic	1
21	DGP-PG1363	Screw — SHCS #10-32 x 1" BLK	1
22	DGP-F260	Z axis Clamp Block	1
23	DGP-F049	Collet — .020" (0.5mm)	Choice of 4
	DGP-F060	Collet — .040" (1.0mm)	
	DGP-F070	Collet — 1/16" (1.6mm)	
	DGP-F080	Collet — 3/32" (2.4mm)	
	DGP-F090	Collet — 1/8" (3.2mm)	
	DGP-F100	Collet — 5/32" (4.0mm) ID 1/4" OD	
DGP-F110	Collet — 3/16" (4.8mm)		
24	DGP-R544	Eye Shield — Plexiglass w/Hardware (right side)	1
25	DGP-P725	Washer — Flat 3/8"	3
26	DGP-P310	Bolt HEX head SS #3/8-16 x 1"	2
27	DGP-F200	Pivot Bushing	1
28	DGP-F007-A	Angle Pointer	1
29	DGP-P730	Washer — Flat #10 x 1/2" OD x 3/32"	3
30	DGP-P410	Handle — Adjustable Threaded Hole - BLK	3
31	DGP-P571	Screw — BHC #8-32 x 1/2" BLK	2
32	DGP-F025-A	Angle Scale - RT Hand	1
33	DGP-P541	Screw — BHSCS #6-32 x 3/8" BLK	1
34	DGP-F225-A	Scale Support Bar	1
35	DGP-P661	Screw — BHSCS #10-32 x 1" BLK	2
36	DGP-P660	Screw — BHSCS #10-32 x 1 1/4" BLK	2
37	DGP-F255-A	Y axis Clamp Block	1
38	DGP-R538	X axis Clamp Block	1
39	DGP-R539	X axis Guide Bar	1
40	DGP-P542	Screw — BHSCS #8-32 x 1/2" BLK	2
41	DGP-P724	Washer — Splitlock SS #3/8	1

ACCESSORIES AND CONSUMABLES PARTS LIST

DESCRIPTION		PART NO.
300 Grit Grinding Wheel - For grinding .040" to 3/32" (1.0mm to 2.4mm)		DGP-PG1425
600 Grit Grinding Wheel - For grinding 3/32" to 3/16" (2.4mm to 4.8mm)		DGP-PG1426
Diamond Grinding Wheel		DGP-P735
Vacuum Filters (Cartridge type for vacuum units only)		DGP-M968
Upgrade to Vacuum System (Includes cabinet, vacuum system, and flexible spotlight)		DGP-UPG
Cabinet Only (no vacuum or flexible spotlight)		DGP-P685
Flexible Spotlight (No Bulb)		DGP-P490
Replacement Bulb for Flexible Spotlight		DGP-P480
Replacement Grinder Switch	For 110/220	DGP-R501
Tip/Flat Gauge - Imperial (For measuring the diameter of the tip/flat)		DGP-F145
Tip/Flat Gauge - Metric		DGP-F147
Replacement Collets	.040" (1.0mm)	DGP-F060
	1/16" (1.6mm)	DGP-F070
	3/32" (2.4mm)	DGP-F080
	1/8" (3.2mm)	DGP-F090
	5/32" (4.0mm)	DGP-F100
	3/16" (4.8mm)	DGP-F110
Pin Vises	Small .040" - 1/16" (1.0mm - 1.6mm)	DGP-P513
	Medium 1/16" - 1/8" (1.6mm - 3.2mm)	DGP-P514
	Large 1/8" - 3/16" (3.2mm - 4.8mm)	DGP-P515



To order your replacement parts, or if we may assist you, please contact us:

2651 Lavery Court • Newbury Park, CA 91320
P: 805.498.3837 • F: 805.498.9347 • sales@diamondground.com
DIAMONDGROUND.COM