



Back Lapping Machine

Do not wear loose fitting clothing,
jewelry, neck ties or long hair



Sharp objects may cause injury



Wear hearing protection



Wear eye protection

**This machine is intended for backlapping
reel mower blades & bedknives ONLY!**

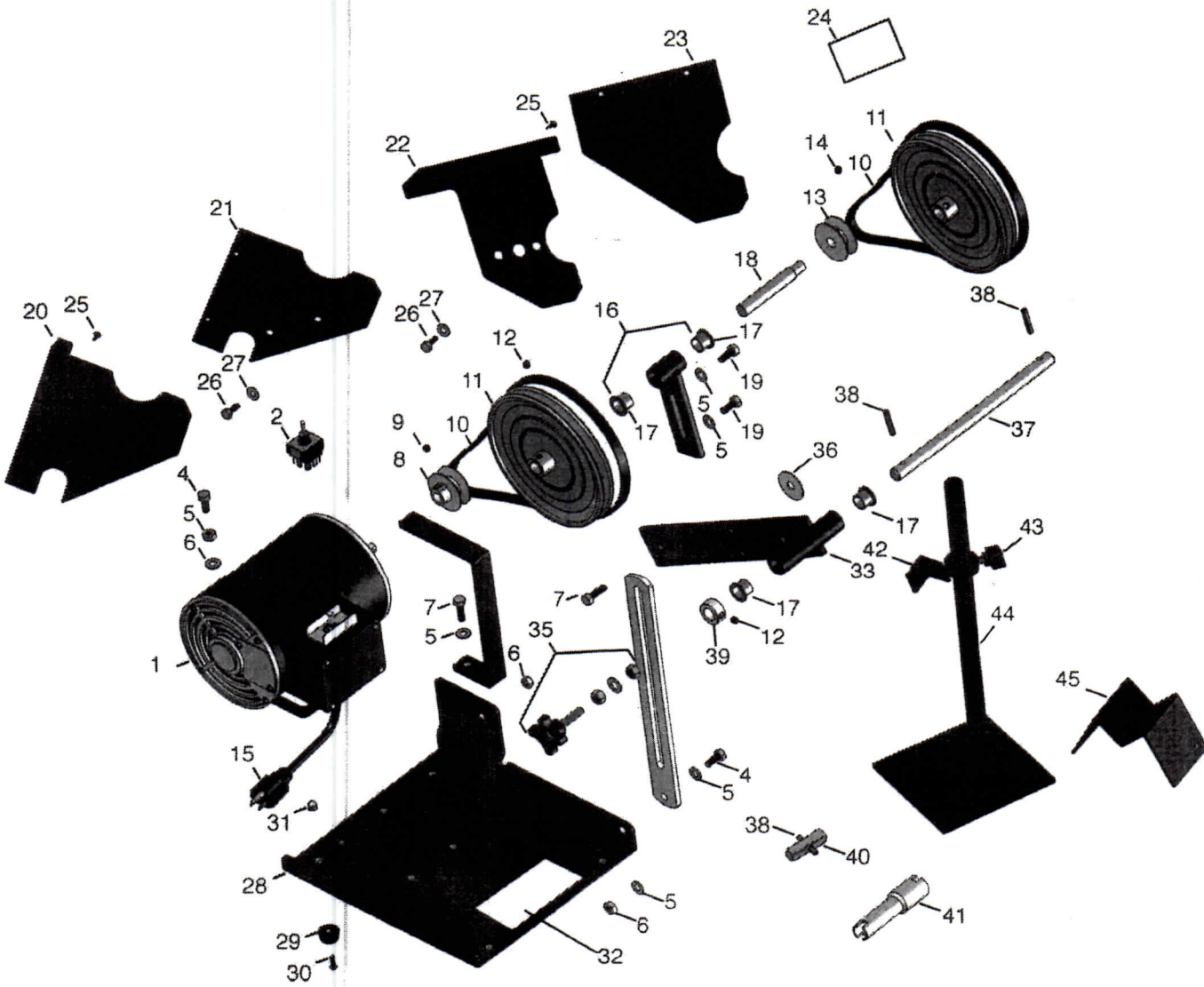
**Any other use may cause personal injury
and void the warranty.**

**All operators must be thoroughly trained
BEFORE operating this equipment.**

Back Lapping Machine Parts

No.	Part No.	Description	Req. Qty.	Item No.	Part No.	Description	Req. Qty.
1	TLT9358	Motor, Backlapper, 1/2 H.P., 1725/1450 RPM, 115/230/110/220 Volts, 60/50 Hertz, 1 PH, Split Phase, Reversible 1.0 S.F. DP, Incl: 6FT. 115V/60HZ Cord & Plug Assy, Conduit Box w/3 Position Toggle Switch for Reversing	1	30	TLT300104	Button Hd Cap Screw 10-31x5/8" R&R	4
				31	TLT300101	Nut, Acorn, 10-32	4
				32	TLT300109	Warning Decal	1
				33	TLT3659542	Support Arm & Bushing Assy	1
				34	TLT30015	Adjusting Arm	1
				35	TLT9314	Adjusting Handle w/Hardware R&R	1
2	TLT300103	Switch	1	36	TLT3689106	Flat Washer 13/32x1 1/2	1
3	TLT3649237	Handle	1	37	TLT3659054	Drive Shaft	1
4	TLT400184	Screw 5/16-18x3/4 Hex	3	38	TLT9331	Roll Pin, 1/4x1 1/4	3
5	TLT453009	Flat Washer, 5/16 SAE	8	39	TLT150328	Retaining Collar 5/8"	1
6	TLT32153-3	Locknut, 5/16-18 Esna Zinc	6	40	TLT3009	Socket, Drive Assy	1
7	TLT300102	HX HD 5/16-18x1" GR5 R&R Sheave,	1	41	TLT3008	Drive Coupling, Fits Neary	1
8	TLT9342	2"x1/2" w/Hub	1	42	TLT33008	Adjustable Support Jack	2
9	TLT300105	Set screw 5/16-18x5/16"	1	43	TLT80169	Knob, Support Stand	2
10	TLT9328	Belt Backlapping Machine	2	44	TLT3659553	Support Stand	2
11	TLT3708440	Sheave, 7"	2	45	TLT3659020	Roller Support	2
12	TLT300106	Set Screw, 5/16-18x1/4"	3				1
13	TLT3659039	Belt Sheave, 2"x1/2" Bore	1				
14	TLT3659039-1	Set Screw, 1/4-20x1/4"	1	47	TLTBLB	Backlapping Brush	1
15	TLT80235	6 1/2 Cord w/Molded Plug	1	48	PHL50	50 grit Lapping Compound	
16	TLT3659546	Shaft Housing & Bushing Assy R&R	1	48	PHL80	80 grit Lapping Compound	
17	TLT3-1506	Bushing	4	48	PHL100	100 grit Lapping Compound	
18	TLT3659047	Reduction Shaft	1	48	PHL120	120 grit Lapping Compound	
19	TLTC-10023	Bolt, HX HD 5/16-18x1/2	2	48	PHL180	180 grit Lapping Compound	
20	TLT30002	Guard, Back Sheave	1	48	PHL220	220 grit Lapping Compound	
21	TLT30003	Cover, Back Sheave	1				
22	TLT30012	Guard, Front Sheave	1				
23	TLT30006	Cover, Front Sheave	1				
24	TLT300108	Caution Decal	1				
25	TLT300107	Screw, Sheet Metal 3/8" SL Hx Hd R&R	4				
26	TLT400104	Bolt, 1/4-20x1/2" Hex Hd	2				
27	TLT3256-22	Flat Washer, 1/4 Yellow	4				
28	TLT3659010	Base Lapping Machine	1				
29	TLT3709767	Rubber Support	4				

Back Lapping Machine Parts



Safety Instructions

- 1. DO NOT OPERATE WITHOUT GUARDS.**
- 2. DO NOT OPERATE THE BACK LAPPER UNDER THE INFLUENCE OF DRUGS, ALCOHOL OR MEDICATION.**
- 3. KEEP WORK AREA SAFE & CLEAN.** Do not operate back lapper in damp or wet locations.
- 4. ALWAYS WEAR SAFETY GLASSES.**
- 5. KEEP ALL VISITORS AWAY.**
- 6. REMOVE HAND TOOLS AND OTHER ATTACHMENTS BEFORE OPERATION.**
- 7. DO NOT FORCE BACK LAPPER.** Only use this back lapper for the purpose in which it is intended.
- 8. USE ONLY RECOMMENDED ACCESSORIES.** Use of accessories not shown in this manual may cause personal injury.
- 9. ALWAYS WEAR PROPER APPAREL.** Loose clothing, gloves, neck ties, or long hair may get caught in equipment.
- 10. KEEP AREA CHILD PROOF.** Do not allow children to play on or around equipment.
- 11. SECURE YOUR EQUIPMENT.** Make sure the back lapper and cutting unit will not move before operation.
- 12. DO NOT OVER REACH.** Keep proper balance and footing at all times.
- 13. REDUCE RISK OF UNINTENTIONAL STARTING.** Make sure back lapper switch is OFF before plugging in.
- 14. CHECK DAMAGED PARTS.** Any damaged guards or other parts should be replaced immediately.
- 15. NEVER LEAVE BACK LAPPER RUNNING UNATTENDED.** Do not leave back lapper until motion has come to a complete stop.
- 16. DISCONNECT POWER BEFORE SERVICING.**
- 17. ALWAYS UNPLUG WHEN NOT IN USE.**
- 18. MAINTAIN BACK LAPPER PROPERLY.** Follow maintenance instructions for proper preventative daily maintenance.
- 19. READ THIS MANUAL CAREFULLY.** Learn all applications, limitations and safety hazards before operation.
- 20. KEEP ALL DECALS CLEAN AND LEGIBLE.** Replace any damaged decals immediately.

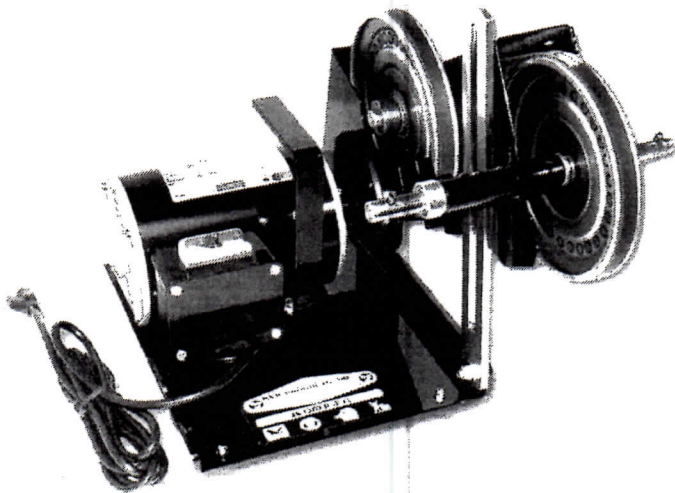
Operating Instructions

Cutting Unit Preparation

1. For ground driven cutting units, disengage the drive pinion gear. See the owner's manual for your particular mower.
2. Support the cutting unit in stands to prevent movement during sharpening. Raise the two stand brackets to support the front roller or cross bar high enough to easily see and reach the bed knife and reel contact point.
3. Place the front roller or cross bar into the support stand brackets. Place the stands as wide as possible.
4. If necessary, place the rear roller in the small stabilizer to prevent movement.
5. Adjust the reel to bed knife tension so the reel can slowly spin freely by hand.

Connecting the Back Lapper to the Cutting Unit

1. Adjust the height of the back lapper by loosening the adjusting-handle to align the drive shafts of the back lapper and the cutting unit.
2. Use the coupler, socket or any other provided adapter to connect the cutting unit to the back lapper. Most mower manufacturers supply a hex drive for this connection.
3. If necessary, adjust the back lapper height and alignment once connected, making sure the cutting unit and back lapper are square for smooth operation.



Sharpening the Cutting Unit

1. Choose the appropriate lapping compound.



2. Plug the back lapper into the properly grounded electrical outlet.

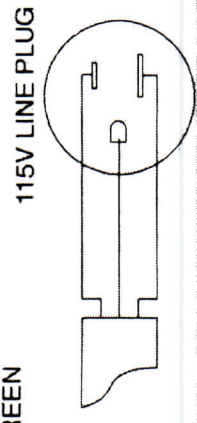
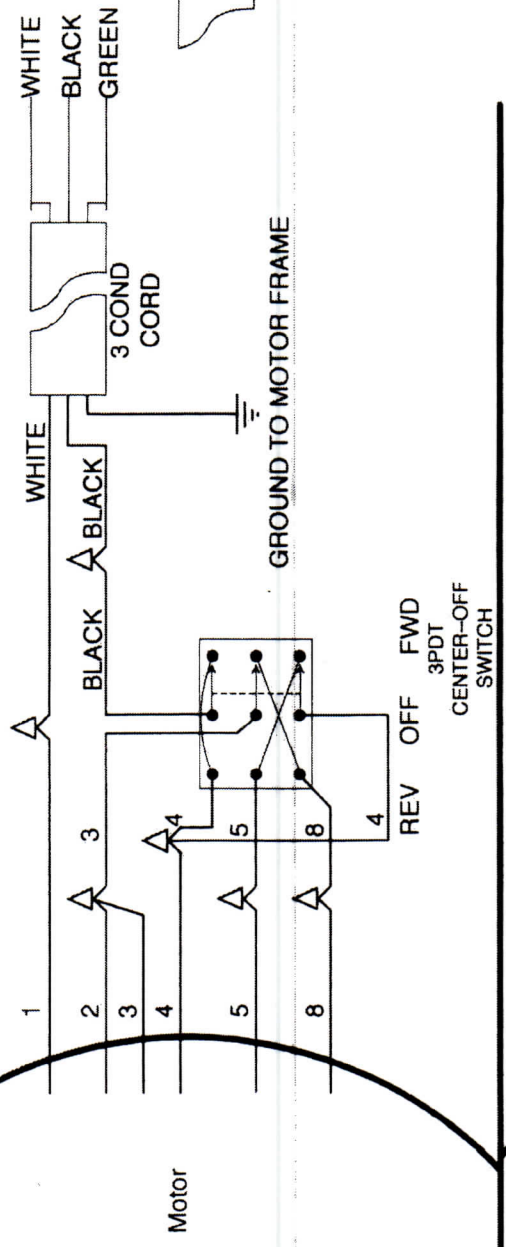
Caution: Do not modify the plug provided. If the plug goes not fit in your outlet, have a qualified electrician install the proper electrical outlet.

3. Turn on the back lapper. The toggle switch is labeled FOR and REV. This does not necessarily indicate which direction the reel will turn depending on which how you are connected to the cutting unit. For sharpening, the reel should turn in reverse from its normal cutting rotation.
4. Using the Back Lapping brush, apply the lapping compound to the spinning reel blades. Once the reel spins free, slightly tighten the reel to bedknife adjustment and apply more lapping compound. Continue this process until the reel and bedknife edges are square and sharp.
Note: When adjusting the reel to bedknife tension, make sure the reel and bedknife edges are square to each other.
5. Turn off the back lapper and disconnect the back lapper from the cutting unit.
6. Check the sharpness of the cutting unit in the center and on each end. The cutting unit should cut a strip of paper about 1" wide in each location.
7. Clean off all lapping compound from the cutting unit using a water hose or pressure washer. **DO NOT SPRAY THE BACK LAPPER!**

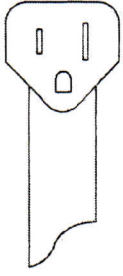
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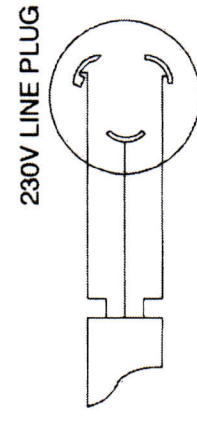
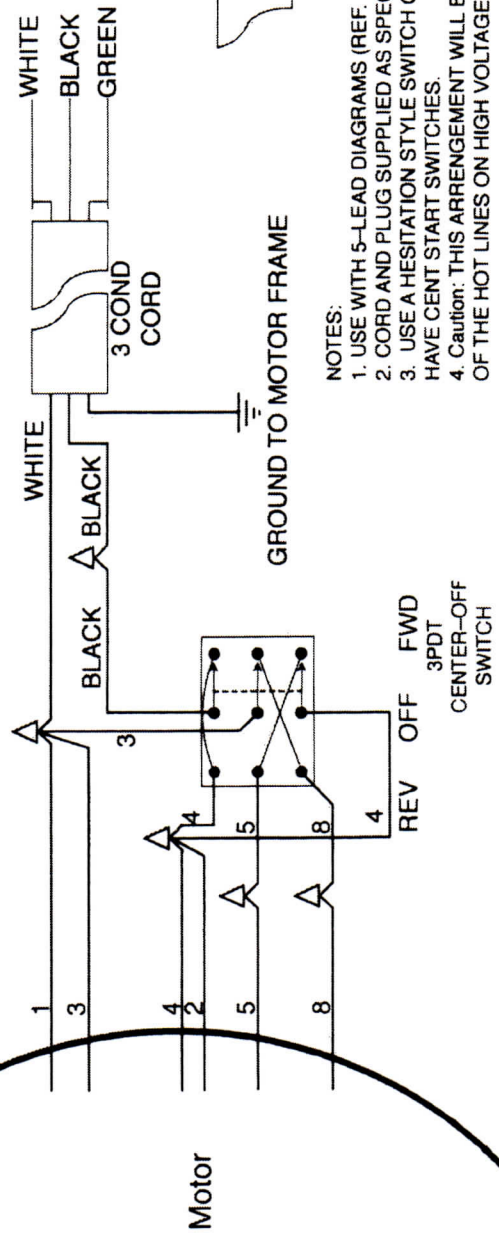
HIGH VOLT CONNECTION



MOLDED 115V PLUG



LOW VOLT CONNECTION



NOTES:

1. USE WITH 5-LEAD DIAGRAMS (REF. CD0008).
2. CORD AND PLUG SUPPLIED AS SPECIFIED.
3. USE A HESITATION STYLE SWITCH ON MOTORS THAT HAVE CENT START SWITCHES.
4. Caution: THIS ARRANGEMENT WILL BREAK ONLY ONE OF THE HOT LINES ON HIGH VOLTAGE CONNECTION.

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BALDOR ELECTRIC Co.

1PH, DV, (CD0001), 3PDT REV SW W/CENTER OFF

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