

Simplex 350 Back Lapper

SIP™
Simplex Ideal Peerless



Thank you for selecting the Simplex 350 Lapping Machine. We believe it is the finest industrial grade lapping machine for reel mowers available. Made with heavy gauge steel and cast iron, glass filled nylon gears and a large 1/2 horsepower motor, the Simplex 350 will provide years of efficient, trouble free service.

Safety Guidelines

The following is a list of general safety guidelines. Please read and understand these guidelines before proceeding. As is the case with most machinery, failure to operate it in a safe manner may result in injury. Please be careful.

1. Keep all guards in place and functioning properly.
2. Do not wear any loose clothing or jewelry which may get caught in the machinery. Secure long hair in a cap or net.
3. Keep your work area clean and organized.
4. Never leave grinder running while unattended.
5. Motor must come to a complete stop before reversing.

Operation

The Simplex 350 is factory and shipped complete with roller rests and jack stands. To use, plug into a grounded 115 volt outlet.

Lapping consists of revolving the reel backwards while applying lapping compound evenly to the blades with a brush. This compound causes each reel blade to lap itself in with the bed knife resulting in a perfect match of reel and bed knife.

Lapping is a satisfactory method of sharpening when the reel and bed knife blades are slightly rounded and do not cleanly cut the grass. Lapping is also used to create a land or flat after manually relief grinding the reel. Lapping should not be used to recondition reels with excessive rounding of the blades, bad nicks, or uneven bed knife wear.

Adjust the bed knife so that there is slight clearance all the way across. This will allow the lapping compound to get between the blades and may cause the bed knife to spring slightly while being lapped-in. If necessary, adjust the bed knife a second or third time after lapping has progressed as required.

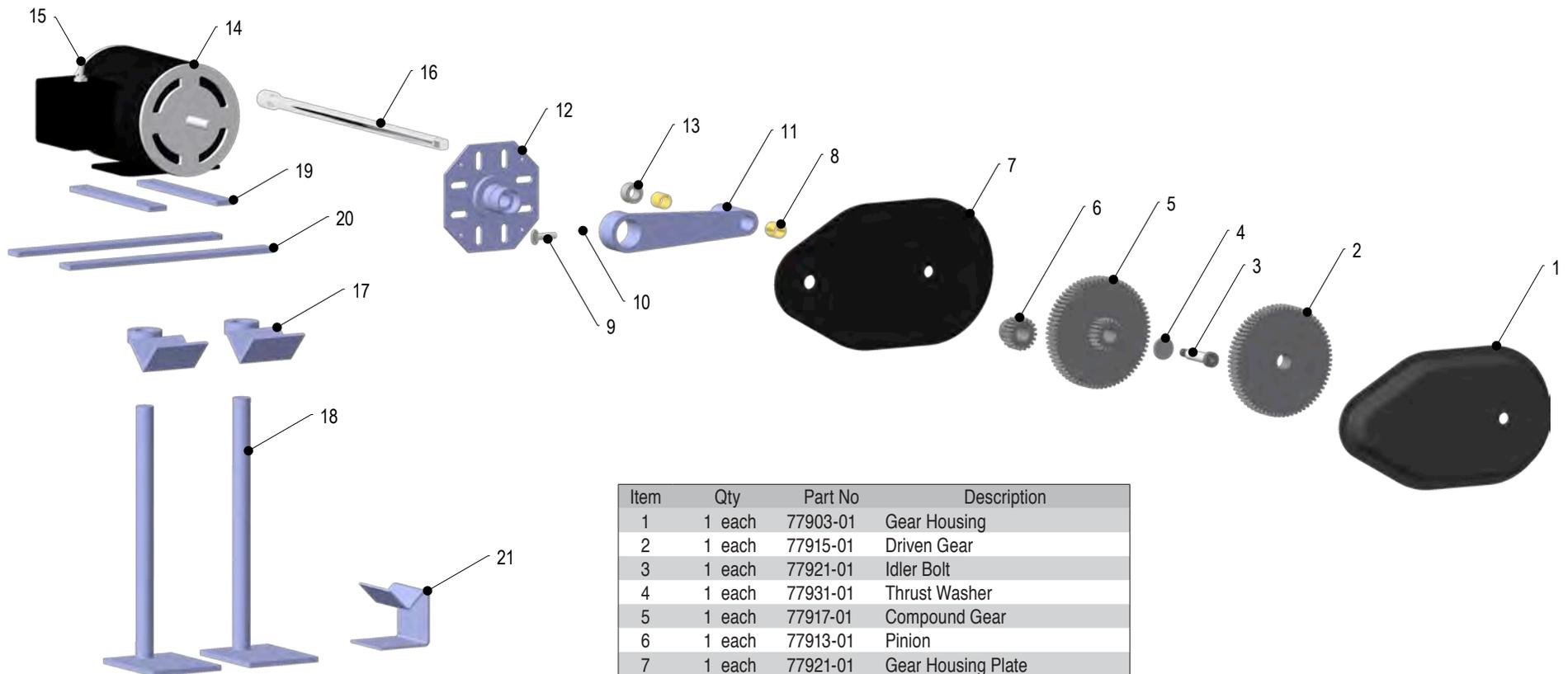
Support the mower off the floor using the roller rests and jack stands. Place the jack stands at the front of the mower and raise the support jacks so they just support the deck plate or spacing bar of the mower. Tip the mower using the support jacks as pivots and place the roller rest under the rear roller. The mower should be in position with the wheel off the ground and so the lapping compound will continue to run down between the blades

If necessary, remove which ever wheel is most convenient. Remove the pinion cover and pinion gear. On hand mowers, reverse the pawl so that the flat edge will be in a position to catch the driving coupler and revolve the reel backwards.

Place the lapping machine in position, loosen the thumb screw which locks the pivoting radius arm and adjust the height of the drive shaft.

Place the drive coupler (not supplied) on to the drive shaft and the mower. Turn on the lapping machine so that it turns the reel backwards. If it is not turning backwards, turn the lapping machine off, wait until it comes to a complete stop, then turn it on in the reverse direction. Continue to lap as necessary.

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Item	Qty	Part No	Description
1	1 each	77903-01	Gear Housing
2	1 each	77915-01	Driven Gear
3	1 each	77921-01	Idler Bolt
4	1 each	77931-01	Thrust Washer
5	1 each	77917-01	Compound Gear
6	1 each	77913-01	Pinion
7	1 each	77921-01	Gear Housing Plate
8	2 each	77919-03	Bushing
9	1 each	12705-20	Thumb Screw
10	1 each	77927-01	Ball Bearing
11	1 each	77909-01	Radius Arm
12	1 each	77911-01	Radius Arm Mount
13	3 each	77923-01	Collar
14	1 each	77901-01	Motor with Cord and Switch
15	1 each	75072-01	Reversing Switch
16	1 each	77309-00	Shaft
17	2 each	73034-01	Jack Support
18	2 each	74199-01	Jack Stand
19	2 each	77925--01	Motor Base
20	2 each	77925--02	Cross Leg
21	2 each	76191-01	Roller Rest