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## Sioux 680 valve grinder manual online pdf

When you use an angle grinder to grind a weld, do you put oil on it? 01-14-2015, 12:35 PM #12 Originally Posted by anoldcrank When you go to the electric grinder to sharpen a drill bit, do you put oil on it? Rex 01-14-2015, 12:22 PM #10 OK. Call Kwik-Way and tell them how stupid they are for selling the stuff! You might want to get after Sunnen as well, they sell honing oil. I know that mechanics commonly use oil in a valve grinder, but that doesn't make it right. I was using a Sioux valve grinder forty years ago. Oil is a lubricant and you want to grind. Runout on the valve face is not generally a problem. 01-14-2015, 03:38 PM #14 Thank you guys for clearing up a mystery for me. The three ball chuck can work very well but it has a lot of moving parts and a lot of potential to get a spec of dust in it and be off. And I've seen some of their work, and it was lousy. I get great results. Rex 01-14-2015, 11:08 AM #7 so you've been doing it wrong all your life because someone taught you wrong. I naturally always used water also. Or, you could say, if runout is below .001, then I am sure the other aspects are what should be looked at. Of course we all will strive to get it down to .001" or less, but even .002" is good enough for most things. The tank is not a problem but has anyone ran into this and what are people using for a replacement pump for these machines 01-13-2015, 08:09 PM #2 I don't know about your application but I have used small 'Little Giant' fountain pumps for coolant pumps before, they are relatively cheap and work well. Heck I'm guilty too. Try again. Stuart 01-13-2015, 08:25 PM #3 Don't use oil I mean, for the grinding stone. Here's the MSDS sheet: It is 94 to 99% something numbered 64741-89-5 Which is something called a light paraffinic. Check the seat runout on some used heads for perspective if you think I'm exaggerating. Grinding fluid is what you use. The results are bad. With top quality new valves there should be nothing to worry about but.... The salesman says to the mechanic, "You never want to use water. So I wondered, where's it coming from to use oil in a valve grinder? That's abrasion. Either soluble oil or some light oil and yes ATF. The Little Giant line has small, inexpensive pumps with pretty low outputs. The 'oil' works alright because it's so thin, it doesn't have too much lubricity. The work looks satisfactory. Whats the difference between mineral oil and paraffin oil? Page 2 01-13-2015, 08:50 AM #1 I bought a sioux 680 valve grinder but there is no oil pump or reservoir for it. None of us had ever read the operator's manual, apparently. 01-15-2015, 09:23 AM #17 Originally Posted by ray thiel Well now that is done can we get back to the pump. The mechanic has been told that this is an 'oil', so when he looks for a substitute, he thinks 'oil' and would probably never think of kerosene, because most people wouldn't. The Kwik Way grinder I got 30 years ago has a sump and pump. I use the grinding oil that Kwik Way sells. 1 Gallon (3.8L) Valve Grinding Oil [000-2112-73] ; Kwik-Way Online Store. A Tradition of Automotive Precision Since 1920 My boss would've shot someone if they filled the sump with water. I notice it has a viscosity of 19 centStokes. Or, a simpler explanation of this whole procedure relating to the chuck: It's not working right, screw with it till it starts working right. Oil interferes with the abrasion. I've seen the work turned out on a valve grinder using oil, and it looks bad. Oh, sure, some hillbillies, rednecks and other sorts of shade tree mechanics use water. I like to add a tablespoon or two of automatic dishwashing detergent to the water. So what I would do is pick a good looking valve, and chuck it up, and touch it to the grinding stone. My dad and his partner always used water in the valve grinder, and got good results. Which is sort of the situation of the OP. 01-14-2015, 08:13 AM #5 Originally Posted by JohnEvans Well I have owned and been around those machines and never saw one using plain water. Roll them to another position. Another name for paraffinic oil is kerosene. I think I can SEE some wave in it at arms length. Oil is for lubrication. Use water. I don't know the composition of your 'oil' but the Little Giant will handle mildly corrosive liquids. But if you want my suggestion, use water, with a little automatic dishwashing soap added. It's more accurate than the parts you are using it for then it's great. But now and then I meet someone insistent on using oil in a valve grinder. When you go to put a valve in it you must adjust the chuck, try this: if you tighten it, with left hand applying some light force to the lever, you can ROLL the balls in the chuck as it tightens. Now I know, it's coming from the valve grinder manufacturers. For occasional activity, there is not much that can be held against a drip cup suspended over the work. Not nearly as good as when water is used, fluid, sulfur cutting fluid, whatever. Why would you want to lubricate a grinding wheel? But if you want to do a good job you need to use this special valve grinding oil. You are grinding. 01-15-2015, 09:07 AM #16 Well now that is done can we get back to the pump. Welcome to the forum Ray. The answer is kerosene, or light paraffinic oil, so, save your money, use water. I just need an oil pump for my old grinder. Overtightening the chuck makes it WORSE, so don't do that, just use light pressure. It does a lousy job. I bet your thinking if I started with a tweaked valve it would be impossible, but not really. Desired angle, good finish, and actually making a true "circle" or more correctly "cone shape" At the same time this machine was popular so were centerless grinders, but guess what, with the centerless design if the valve stem is not a perfect circle then the face won't be either. Your supposed to tip and chamfer the tip, making the chamfer at least .020 wide so it does not cut into the taper, before facing the valve, but I'm sure this gets overlooked sometimes. 12-07-2015, 02:01 PM #19 If you search around you will usually see that any type of coolant/oil pump is real expensive or has a ferocious GPM rating, or is the size of a Mack truck. I doubt if the coolant makes any difference. 01-14-2015, 11:10 AM #8 Originally Posted by anoldcrank I was using a Sioux valve grinder forty years ago. LOL So, I think it's a good machine. Why in the fuck are you busting my chops?? Usually, once or twice and it would get off whatever spec of dust was in there, or get the balls sitting right or who knows what, and after that I could reface a few heads worth of valves and they'd all be under .001" runout. The only reason they sell this stuff is because of people that think you are supposed to use oil to grind. Gee 40 years ago I was using one of those machines refacing valves and was using some form of oil, come to think about it I was doing it right at 50 years ago at my first job in the automotive after market !! John 01-14-2015, 12:19 PM #9 Originally Posted by anoldcrank so you've been doing it wrong all your life because someone taught you wrong. Do you put oil on anything else to grind it, besides a valve? If it seemed to have a lot of runout I'd loosen the chuck and ROLL it again as I tightened. But then the mechanic runs out of this special 'oil' and tries a substitute. 01-14-2015, 10:54 AM #6 40 years ago I was using a Kwik-Way valve grinder and the sump of that machine was filled with grinding oil. It works against you. This is where the problems begin. So, now to answer the OP's original question :What is a substitute for "valve grinding oil"? The 12s a piece valves we are all running, how good you think those stem are to begin with? If it hits the same spot every time you know it's straight. Yes, water works well on the valve, but it's not worth a damn for the machine. Don't use oil. 01-13-2015, 08:50 AM #1 I bought a sioux 680 valve grinder but there is no oil pump or reservoir for it. What were you doing forty years ago? Never use water." And then the salesman delivers kerosene and calls it 'special valve grinding oil', and the mechanic pays a premium price, I am sure. I was thinking about the little giant myself but has anyone tries anything else besides that. It's for the machine to prevent corrosion. There is a difference between lube oils and cutting oils :-). Don't use lube oil for cutting operations! 12-07-2015, 01:29 PM #18 Has anyone burned their valve grinding machine down yet using anoldcrank's Kerosene? The mechanic has been confused because the more correct terminology would be 'grinding fluid'. So I look that up on the table here: And see that 19 cSt is a little thicker than WATER, but not as thick as olive oil. ChemDplus - 64741-89-5 - Distillates (petroleum), solvent-refined light paraffinic - Searchable synonyms, formulas, resource links, and other chemical information. 01-13-2015, 10:44 PM #4 Well I have owned and been around those machines and never saw one using plain water. 01-14-2015, 04:06 PM #15 The oil isn't for the valve or stone for that matter. 'An adjustable valve to control delivery rate, drop...drop...drop.....') The "oil" thing was a curious exchange. And this is probably what I've been seeing. The tapered part where the TIP goes can be a wear item, clean it out and look closely and see how bad it is in there, you might need a new one if it has a lot of use. 01-14-2015, 12:22 PM #11 Thread grinders run oil too. Stuart 12-07-2015, 06:24 PM #20 The Sioux grinder I had 40 years ago was a dry grinder, no place for any coolant at all. I have always wondered why some mechanics insist on oil for a valve grinder. I've seen people use auto transmission fluid. When you go to the electric grinder to sharpen a drill bit, do you put oil on it? If it is working ok, leave it alone. Various things are tried, such as motor oil, auto trans. All of those machines used transgrind synthetic OIL. Grinding threading oils have an extremely high temp flash point. He's a funny tight wad and accident looking for a place to happen. 40+ years ago my Mom told me; "Never get in an argument with an idiot." Rex 01-14-2015, 01:03 PM #13 Fresh out of highschool, I worked in a grinding shop, running a rollomatic 5 axis CNC grinder. I found this Goodson product: GOODSON : Cylinder Head Supplies : Valve Grinding Oil I figure, they are all about the same. On the one I ran it worked best biting the valve as the lever was straight up or a little less, but that may vary from one to another. If the wheel is not dressed properly you will not get a good job. Plain water and you will soon have a rusty lump. I worked for a man, and somehow the discussion came up, and he said, you never want to use oil in a valve grinder.



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