

Handfeed



American Made Since 1942

- **Rugged Construction**

- **Long Life Accuracy**

- **Flo-Clean Lubrication**

- **Hand Scraped Ways**



- Optional Variable Speed Spindle allows infinite adjustment from 500 to 6,000 RPM.
- Rugged construction. Long life accuracy. One-piece cast column, heavily ribbed for rigidity. All castings are 30,000 psi graphitic iron to resist deflection under load.
- Hand scraped cast iron ways standard. Tool steel or optional Turcite ways.
- Stainless steel screws throughout, including wheel guard hardware and threads.
- There are over 45,000 Harig Grinders still in service!
- Temperature compensating spindle housing and removable 3" Diameter cartridge-type 2 HP spindle with preloaded Class 7 duplex bearings.
- Automatic lubrication standard. Continuously floods ways, bearings and lead screws.
- Choice of table drive. Harig® 612 and 618 Hand Feed Surface Grinders can be ordered with rack and pinion or cable drive.
- Hardened and ground screws, ensure long life and consistent accuracy.
- Telescoping guarded elevating screw. Centered between ways for smooth operation.
- Table and carriage castings cover ways even when table is fully extended
- Laser-Accurate Slip-Rings
- Financing and leasing readily available.

1 Year
Warranty on
Parts and
Labor!



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Harig 618 Handfeed Precision Surface Grinder

02-08

HARIG® 618 Hand Feed Surface Grinders

6 x 18 in. platen

Long life accuracy

Harig® Hand Feed Machine Specifications

618

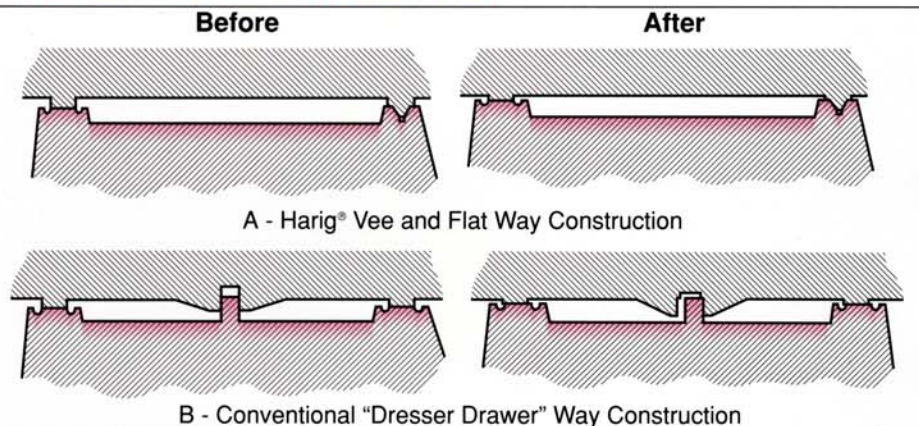
Longitudinal travel	20 in. (508 mm)
Cross feed travel	6-3/4 in. (171 mm)
Vertical working height (under 7" wheel)	11-3/4 in. (298 mm)
Platen work area	6 x 18 in. (152 x 457 mm)
Grinding wheel furnished	7 x 1/2 x 1-1/4 in. I.D. (178 x 13 x 32 mm)
Grinding wheel maximum capacity	8 x 1-1/4 x 1-1/4 in. I.D. (203 x 32 x 32 mm)
Elevating handwheel grad.	0.0001 in. (0.0025 mm)
Cross feed handwheel grad.	0.001 in. (0.02 mm)
Spindle motor	2 HP (1.38 kW)
Spindle speed	3450 RPM
Floor area cabinet	40 x 31 in. (1016 x 787 mm)
Floor area operating space	69 x 45 in. (1753 x 1143 mm)
Net weight of machine	1250 lbs. (567 kg)
Weight, domestic crated	1325 lbs. (601 kg)
Weight, export boxed	1600 lbs. (726 kg)
Export box dimensions	76 x 55 x 45 in. (1.9 x 1.4 x 1.1 m)

Note: Specifications subject to change without notice.

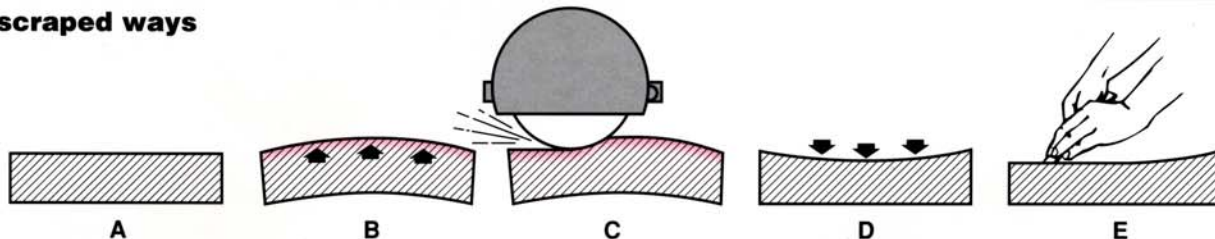
Harig® Features that prolong accurate machine life:

Vee and flat ways

Wear-compensating vee and flat ways maintain a perfect fit for the life of your grinder for both cross and longitudinal travel. This is extremely important in shoulder and slot grinding. Diagram (A) illustrates how vee and flat way design compensates for wear and maintains perfect fit. Conventional ways shown in (B) illustrate how side clearance increases with wear permitting the table to "yaw" under side pressure.



Hand scraped ways



(A) Harig hand scrapes cross, longitudinal and column ways for absolute flatness. (B) Grinding ways

cause heat expansion which bows the way surface toward the wheel. (C) The crest of this bow is ground off. (D)

When the casting cools, there is a slight depression. (E) Hand scraping brings ways back to absolute flatness.

HARIG®

Harig Products, Inc. • 1875 Big Timber Road • Elgin, IL 60123 • (847) 695-1000 • Fax: (847) 695-1043

Safety Notice: Harig Products, Inc. provides protective devices for the safe use of this equipment. Operation of this equipment may cause injury if the protective devices are removed. A comprehensive safety manual is provided with all machines offered by Harig Products, Inc. and recommended safe operating procedures must be adhered to.