

# MODEL 75 FRONT FACER

**SIP**  
SIMPLEX IDEAL PEERLESS

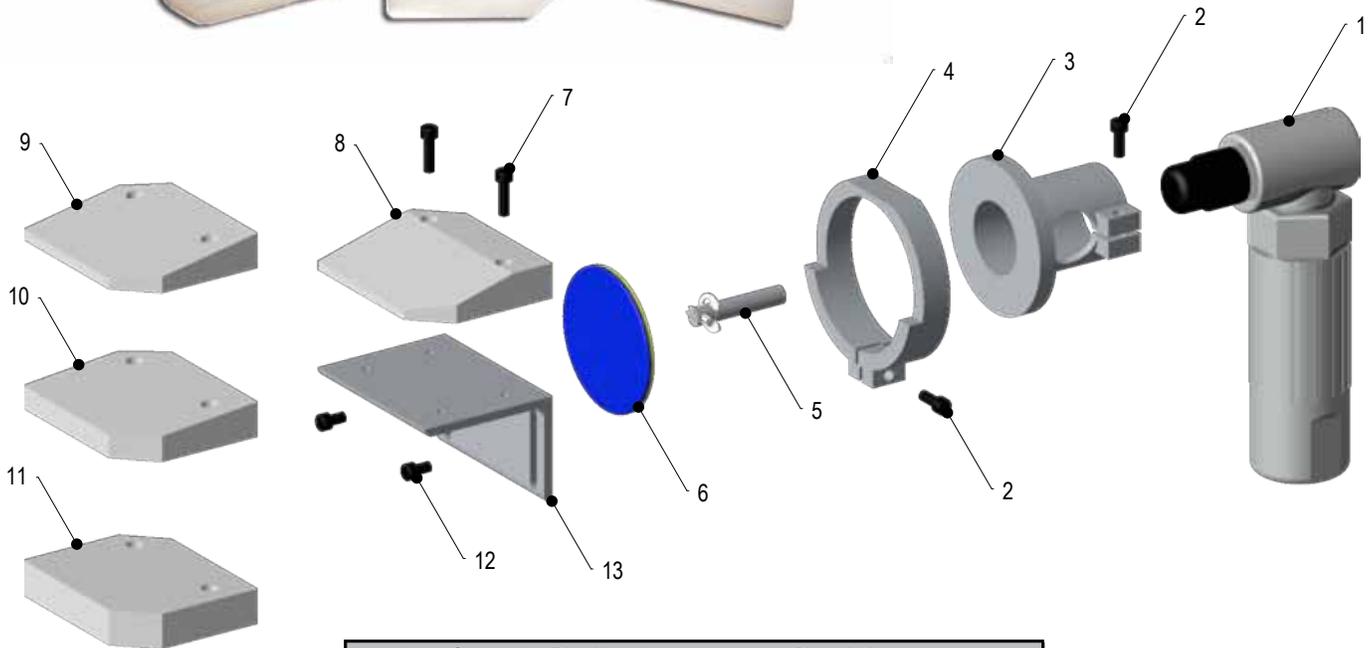


Contents include:

- 1) Front facer with disc and pad
- 3) Angle Pads
- 2) Wrenches
- 5) Replacement discs
- 2) Instruction Sheets

Reorder number for discs  
(10 per package)

- 77813-10 .....40 grit
- 77813-14 .....80 grit
- 77813-15 .....120 grit



Item	Qty	Part No	Description
1	1 each	77811-01	Ingersoll Rand 90° Grinder
2	2 each	12401-05	6-32 x 5/8 Socket Head Cap Screw
3	1 each	77801-01	Tube Body
4	1 each	77803-01	Guide Ring
5	1 each	77809-01	Front Facer Arbor
6	2 each	77813-01	2" QDC Alumina Zirconia Discs
6	2 each	77813-04	2" QDC Alumina Zirconia Discs 80 Grit
6	2 each	77813-05	2" QDC Alumina Zirconia Discs 120 Grit
7	2 each	12401-04	6-32 x1/2 Socket Head Cap Screw
8	1 each	77807-15	Plastic Angle Plate 15 Degree.
9	1 each	77807-10	Plastic Angle Plate 10 Degree.
10	1 each	77807-05	Plastic Angle Plate 5 Degree.
11	1 each	77807-00	Plastic Angle Plate 0 Degree.
12	2 each	12401-02	#6-32 x 1/4 Socket Head Bolt
13	1 each	77805-01	Angle Mount

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## Grinding with the front facer



Place the nylon pad on the bottom of the bed knife just in from the end and hold the grinding disc away from the bed knife edge.



Pull the trigger of the front facer and push it against the bed knife.



Pull the front facer back to the beginning of the bed knife then push it to the end of the bed knife. Repeat as necessary.

## Setting the relief angle



The front facer comes with four angle pads; 0°, 5°, 10° and 15°, which can be mounted to give either a positive or negative relief angle. Refer to your mowers manual to determine which pad to use.



Remove the two socket head screws which secure the nylon pad and replace with the selected pad.

## Adjusting the front facer



You can adjust the height of the guide by loosening the two socket head screws and sliding the guide up or down. If the front facer bogs down, you should adjust the fence up so that less of the disc surface contacts the bed knife. You can also check your air pressure or use shorter air lines.

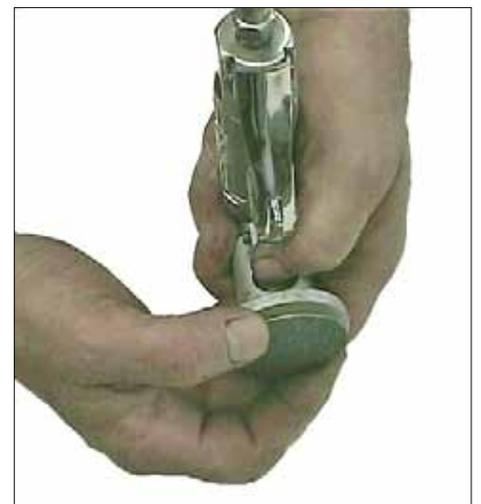
## Replacing the disc



Loosen the clamp screw.



Remove the guide assembly. You may need to loosen one of the guide adjusting screws for the clamp to loosen.



Put your thumb in the hole of the facer and hold it against one of the flats. Untwist the disc and pull it off. Reverse the procedure for mounting the new disc.