

**Diamond Coated Grippers For A Longer Gripping Life.**  
**Lower Cost**                      **GT Specialties**                      **Better Gripper**

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## Reconditioning aluminum gripper bar

Our Company has 37 years of experience in manufacturing grippers with a Diamond coated gripping surface. This page shows how we repaired a PFA Ryobi aluminum gripper bars. Since we cannot diamond coat directly onto aluminum parts. We are going to show you a procedure for gluing diamond covers that we can make to the size needed.



Glue with Cyanoacrylate 3M glue (GUL) or you can use J-B Weld Epoxy.

Pre-fold one side of copper foil down 90° from-diamond surface. Pre-folding will help in the alignment onto the pads.



Inspecting each gripping pad surface for low spots, the pads are then cleaned before bonding an aluminum epoxy to build-up the pad surface.



After the aluminum epoxy is dried, the bar is set-up onto a milling machine to machine all pads flat and in line to each other.



We cut each diamond cover from the copper strip, cutting the sides flush to the diamond coating and leaving about one eighth of inch of copper for the front and back side of pads.



A picture of a Ryobi PFA gripper bar that was reconditioned with a 80/100 grit diamonds. The gripper fingers have the diamond coating bonded on to them and the bar pads have diamond covers glued.

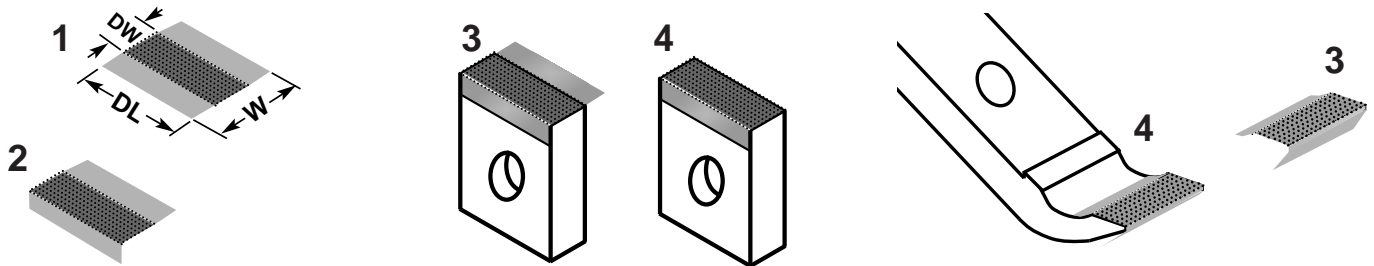


## HOW TO GLUE DIAMOND COVERS

Diamond Covers are applied to the tops of worn gripper pads to improve the gripping texture.

### INSTRUCTIONS

- (1) Wipe off the back side of copper strips with alcohol to remove any oil film before cutting each Diamond Coated surface. Cut each diamond surface from strip with scissors. (*Illustration 1*)
- (2) Clean gripper pads with a wire brush and alcohol. To insure a perfect, secure bond, grippers should be free of all ink and oil.
- (3) Pre-fold one side of copper foil down 90° from diamond surface. (*Illustration 2*) Pre-folding will help in the alignment onto the pads. (*Illustration 3*)
- (4) Apply 2 to 3 drops of adhesive (Cyanoacrylate 3M glue (GUL)) onto top surface of clean gripper pad. You can use J-B Weld Epoxy. Place Diamond Cover over gripper pad and hold down firmly with a wood paddle. Fold remaining copper foil down the other side of the pad. (*Illustration 4*)



P/N	DW		DL		W		Price
P003	1/4"	(6.3 mm)	3/8"	(9.5 mm)	1/2"	(12.7 mm)	\$5.00
P004	1/4"	(6.3 mm)	7/16"	(11.1 mm)	1/2"	(12.7 mm)	5.00
P005	1/4"	(6.3 mm)	1/2"	(12.7 mm)	1/2"	(12.7 mm)	5.00
P007	1/4"	(6.3 mm)	5/8"	(15.8 mm)	1/2"	(12.7 mm)	5.22
P008	1/4"	(6.3 mm)	3/4"	(19 mm)	1/2"	(12.7 mm)	5.22
P010	1/4"	(6.3 mm)	1.0"	(25.4 mm)	1/2"	(12.7 mm)	6.05
F024	5/16"	(8.mm)	1/2"	(12.7 mm)	9/16"	(14.mm)	5.00
F026	5/16"	(8.mm)	3/4"	(19.mm)	9/16"	(14.mm)	5.88
F027	5/16"	(8.mm)	1.0"	(25.4 mm)	9/16"	(14.mm)	6.10