

CENTERLESS WHEELS – RESIN



WE MEET YOUR SPECIFIC NEEDS

- Diameters: 12" - 24"
- Thicknesses: 3" - 10" (20" sets)**
- High performance abrasive grain blends
- Grit sizes: 46 - 600
- Thrufeed, infeed, and endfeed applications

PRODUCT TYPES

Resin: for stock removal, long irregular parts and faster thru-feed grinding

Epoxy: for softer grinding action, less chatter, low heat and fine finishes

PRODUCT TYPES

Bar Grinding, Bearing, Contract Machining, Medical Accessories, Motor Vehicle Parts.

RECOMMENDED SET-UP FOR GENERAL PURPOSE THRU-FEED APPLICATIONS*

Regulating Wheel	Use a general purpose rubber wheel specification of A804-R-10RX Use a 3 degree angle of inclination and a speed of 90-100 SFPM True with a 1-2 carat single point diamond at 1-2 inches per minute	
Work Rest Blade	For work 1/2" diameter and larger, use a blade angle of 20-30 degrees Set work center above wheel centers 1/2 of work diameter (but 5/8" max) Use maximum blade thickness to avoid chatter	
Grinding Wheel	General purpose grinding wheel specification Dress with an impregnated diamond dressing tool at 10 inches per minute 6-8" wide wheels will remove stock at 1 cubic inch per minute per 10 HP Rough at 1/3 to 1/2 of wheel face width per work revolution, finish at 1/6 to 1/3	
Coolant	Use 5 gallons per inch of wheel width per minute and a high velocity nozzle Direct coolant to point of contact between the workpiece and grinding wheel	
How to make a wheel act softer/harder	TO MAKE A WHEEL ACT SOFTER <ul style="list-style-type: none"> • Increase work speed/regulating wheel speed • Increase throughput speed/ regulating wheel speed • Increase infeed/Decrease wheel speed • Dress at a faster traverse rate 	TO MAKE A WHEEL ACT HARDER <ul style="list-style-type: none"> • Decrease work speed/regulating wheel speed • Decrease throughput speed/regulating wheel speed • Decrease infeed • Increase wheel speed (observe safe limits– MAX RPM)

*General recommendations only, fill out application data sheet for engineered specification for specific job.

** Wheels thicker than 10" are generally manufactured in two piece sets.