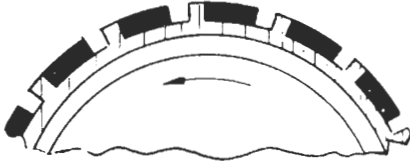


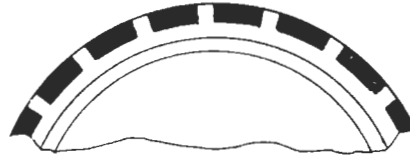
# CONTACT WHEELS FOR ROLL GRINDING

The proper contact wheel is an important factor in any grinding application. For assistance in determining which wheel is best suited for your application, we offer the following illustrations with description. If you are in doubt about your selection, we will be glad to make a recommendation if you supply information regarding the type of material being ground, amount of stock to be removed, finish requirements, etc.



**TYPE "SAR"**

Serrated Aluminum Wheel with Rubber fill. Roughing wheel only for aggressive grinding applications. This wheel is directional and can only be run in one direction.



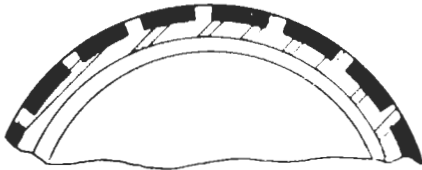
**TYPE "PAR"**

Plain Aluminum Wheel with Rubber fill. This has been found to be best for producing very close tolerances. It should be noted that the lathe must be in excellent condition. Otherwise, use Type PDDR.



**TYPE "SDDR"**

Serrated Dual Density Rubber. This wheel will produce tolerances nearly equal to type "PAR" but a better finish is achieved. This wheel is directional and can only be run in one direction.



**TYPE "PDDR"**

Plain Dual Density Rubber. This wheel is used where a good finish is needed with moderate stock removal and close tolerance. This is the most commonly used wheel.



**TYPE "PR"**

Plain Rubber. A smooth face wheel, 70 to 90 durometer (specify) for applications requiring the use of diamond or structured abrasive belts. This wheel can also be serrated (TYPE "SR") for general purpose grinding.



**TYPE "PA"**

Plain Aluminum Face. For grinding soft rubber rolls.

## DRESSING THE CONTACT WHEEL

IT IS IMPORTANT that all wheels be "dressed" to the roll before grinding. This assures squareness of the contact wheel to the roll. Each time the grinder is removed, it is best to re-dress the wheel.

TO DRESS, place the grinder on the lathe and look for the best area of the roll. Be sure the grinder is as square as possible. Clean the roll so pressure sensitive abrasive can be placed on the roll. This should go at least 3/4 way around the roll and be 50 to 80 grit. Start the grinder and move the contact wheel in until it makes contact with the abrasive. Move the grinder back-and-forth completely across the abrasive both ways. This must be repeated until the entire surface of the contact wheel has been dressed. Don't plunge cut.

**Wear eye protection — Keep hands clear when using grinding equipment.**

## RECOVERING USED WHEELS

Type "SAR" AND "PAR" wheels have aluminum lands which, when worn down, can't be replaced. They can be made into Type SDDR, PDDR, and PR wheels at some savings. The SDDR, PDDR and PR type wheels can be recovered at considerable savings. It is strongly recommended that a spare contact wheel be ordered with the grinder. Delivery on replacement wheels may require 6 to 8 weeks.



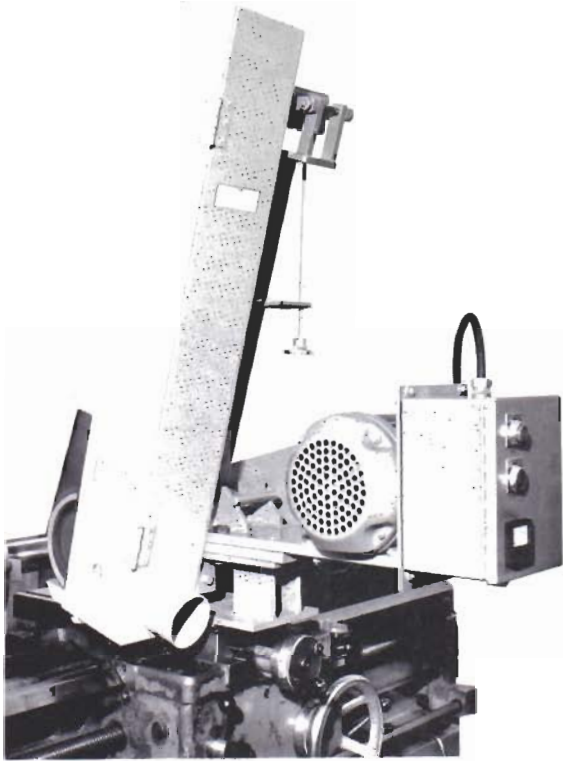
GRINDING & POLISHING MACHINERY CORPORATION **MACHINERY**

2801 TOBEY DRIVE / INDIANAPOLIS, IN 46219-1481

PHONE (317) 898-0750

FAX (317) 899-1627

Printed in U.S.A.



## MOUNTING INFORMATION

A schematic on the lower portion of this page illustrates two common types of lathe compound tool holders and the cross slide of a lathe. The size of the lathe on which the grinder is to be used frequently determines whether it is best to mount on the compound side or the cross slide.

On large lathes, mounting on the compound slide may prove satisfactory, but on smaller lathes, it is better to remove the compound and mount directly on the cross slide.

The schematic shows which dimensions are needed in order to provide an adaptor that will fit the lathe.

NOTE: Size of tailstock housing determines minimum diameter of roll for grinding.

FOR THE BEST PLACEMENT OF THE GRINDER — PLEASE SPECIFY THE MINIMUM AND MAXIMUM SIZE OF ROLL

