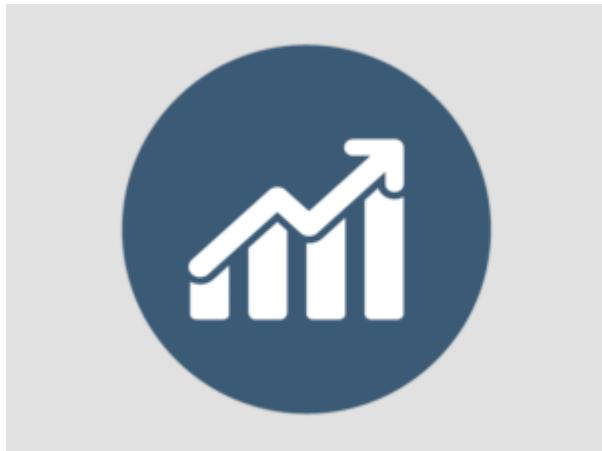
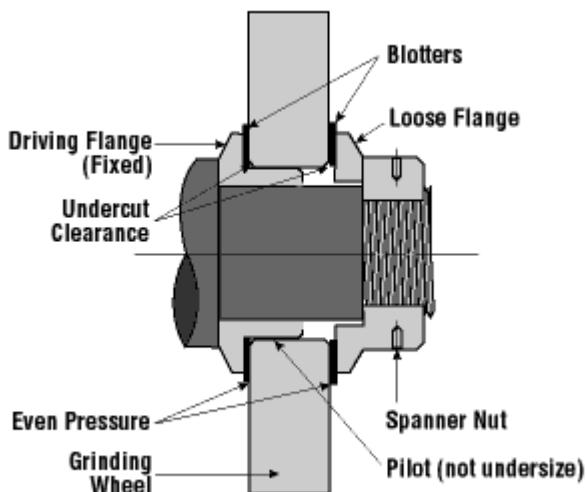


Bench and Pedestal Wheel Mounting – Fact Sheets



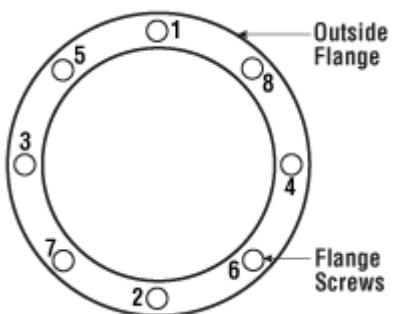
HOW SHOULD YOU MOUNT AN ABRASIVE WHEEL?

- Follow the manufacturer's recommendations when handling, grinding, maintaining and storing abrasive wheels.



- Ensure you have the correct type and size wheel for the machine by checking the markings on both. Consider the material to be used by the machine, the finish quality, and the contact area of the wheel with the work item.
- Ensure that the machine spindle speed is not greater than the speed marked on the wheel.
- Examine the wheel for cracks or chips (visual inspection) to ensure the wheel is in safe condition and perform the "ring test." Replace the wheel, if faulty.
- Do not force a wheel onto the machine spindle or change the size of the mounting hole.
- Maintain even pressure from both flanges against the sides of the wheel. Check flanges with a straight edge. Worn or warped flanges must not be used.
- Maintain a clearance (undercut relief) of at least 3 mm (1/8 in.) to prevent pressure on the wheel near the hole.

- Check the surface of the abrasive wheel and flanges to ensure that no particles are present.
- Use paper blotters between a wheel and flanges to take up slight wheel surface roughness.
- Ensure mounting pilot(s) is rounded with length about 2/3 width of the wheel.
- Extend the threaded section well inside the loose flange.
- Tighten grinding wheels just enough to prevent them from slipping. Over tightening the spindle nuts or clamping screws can damage the wheel and grinder parts. With multiple screw mounting flanges, tighten the bolts uniformly. Start by barely tightening a screw, “snug-up” opposite screw and, in a crisscross manner, continue until all mounting screws are uniformly tight.
- Examine the wheel for cracks or chips and perform the “ring test.” Replace the wheel, if faulty.



- Place the threads of the central spindle in the direction that allows the nut to tighten because of the force of the work being done.
- Ensure all safety guards are in place.
- Wear appropriate personal protective equipment (e.g. safety eye glasses with side shields/full face shield, dust mask, cotton gloves and hearing protectors).
- Do not wear loose clothing, dangling jewellery and make sure that loose hair is tied properly.
- Ensure work area and floor are clean.
- Before turning on the power, the operator should turn the wheel by hand to check for appropriate wheel clearance.
- Warn all persons to stay clear of the area where the wheel is used.
- Stand to one side and test the wheel. Start and run the wheel for at least 1 minute. If any undue vibration occurs, switch off immediately and make adjustments. Never adjust moving machinery.

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