

GRINDING WHEEL STORAGE

WHEEL SAFETY: The following safety information is based in part on material contained in the ANSI B7.1 Safety Requirements for the "Use, Care and Protection of Abrasive Wheels". It is recommended that all personnel involved with grinding wheels become familiar with ANSI B7.1.

PROPER USE OF GRINDING WHEELS

Given the correct wheel, in accordance with approved procedure, safe operation depends largely on the treatment to which the wheel is subject during use.

DO:

- Ensure that guards and work rests are properly adjusted and secure before starting machine.
- Always use safety guard covering at least one-half the grinding wheel.
- Allow a newly mounted wheel to run at operating speed with guard in place at least one minute before starting to dress or grind.
- Always wear protective glasses or some type of eye protection when grinding.
- Always dress or make grinding contact gently.
- Re-dress the wheel when necessary.
- Turn off the coolant before stopping the wheel to avoid creating an out of balance condition.

DO NOT:

- Ever exceed the maximum operating speed established for the wheel.
- Start the machine until the guard is in place.
- Stand directly in front of the wheel when the machine is started.
- Jam the work into the wheel, nor use excessive pressure or infeed.
- Force grinding so that the motor slows noticeably or the work gets hot.
- Grind on the side of the wheel (see ANSI B7.1 for exception).
- Allow stationary wheels to rest in fluids.
- Apply pressure to wheels to stop them.
- Continuously use glazed wheels without dressing.
- Use wheels for purposes other than those for which they are designed.

RECEIPT

- On receipt, grinding wheels should be examined to see if they show any signs of damage, such as chips, cracks or discoloration. Damaged wheels must not be used.

HANDLING

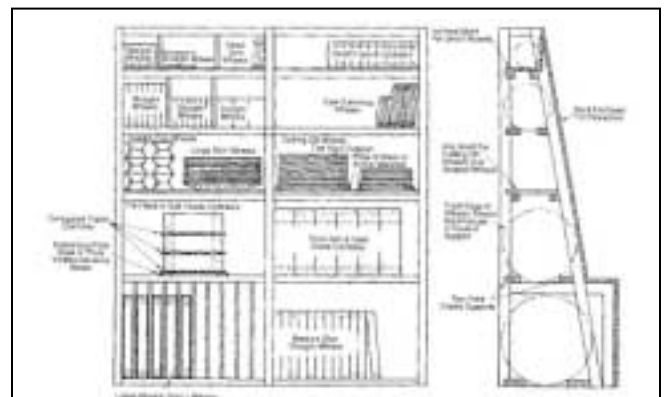
- All grinding wheels can be damaged by any mishandling that result in the wheel being subjected to any shock loading. This can occur due to the product being inadvertently dropped, knocked over or banged against any other object. This is equally true if the wheel is secured on a pallet which has been dropped heavily from a fork lift truck.
- Any grinding wheel subjected to such mishandling should be carefully examined for signs of damage such as chips, cracks or discoloration. If in doubt - do not use.

WHEEL HANDLING

- Only a trained person should mount a grinding wheel.
- A wheel should only be mounted on the machine for which it was intended.
- All grinding wheels should be closely inspected before mounting to ensure that they have not been damaged while in storage or transit.
- The ring test should be carried out only in a place where the tone of the ring can be easily heard.
- The speed of the spindle on which the wheel is mounted should not, under any circumstances, exceed the maximum speed specified for the wheel.
- Bushings should not project beyond the side of the wheel and the wheel blotter when used. The wheel should fit freely, but not loosely, on the spindle.
- Wheels, blotters and flanges should be free from foreign matter.

STORAGE

- Do not subject wheels to humidity, water or other liquids, freezing temperatures or sudden temperature change.
- Small wheels up to 4" diameter, together with cones, plugs, mounted points and wheels may be stored in suitable bins, drawers or boxes.
- Type 2 cylinder wheels, type 6 straight cup wheels, type 12 dish wheels and type 13 saucer wheels should normally be stacked on flat sides with cushioning material between them.
- Thick rim and hard grade cylinder and straight cup wheels may be stored on the periphery.
- Soft grade, straight cup wheels, and all type 11 taper cup wheels, should be stored base to base and rim to rim to prevent chipping of edges and cracking of walls.
- Thin plain wheels, such as cutting off wheels or saw sharpening wheels should be stacked on a flat surface of steel, or similar rigid material.
- Other plain or shaped wheels of appreciable thickness are best supported on their periphery in racks. The racks should provide cushioned, two point, cradle support to prevent the wheels from rolling.



STORAGE DIAGRAM

This drawing illustrates a rack design which is suitable for handling a wide variety of abrasive wheels.