

AN IMPROPER USE MIGHT CAUSE SERVER DAMAGE

Read the following as Grinding is a secure operation when following these basic rules

1. HANDLING

Handle all grinding wheels (even the hard and reinforced ones) very carefully. If a grinding wheel is suspected of having been damaged or bumped contact the manufacturer.

2. STORAGE

- When receiving the shipment carefully check the packaging and all grinding wheels in order to make sure they have not been damaged in transit.
- Store the grinding wheels carefully and rationally.
- Make sure to maintain stock rotation. That's essential for organic products (vitrified, rubber or shellac bonds) which must not be used after expiration date - when mentioned - or after the shelf life period recommended by the manufacturer .
- Do not subject grinding wheels to humidity or sudden temperature change.

3. CHOICE AND MOUNTING

- Use the right grinding wheel for the job
- Visually inspect the grinding wheel and if it's a vitrified one ring test it to check for cracks. If in doubt refer to manufacturer. Never use a cracked grinding wheel or one that may have been dropped or damaged. Make sure the machine speed never exceeds established safe operating speed marked on wheel.
- Do not force an abrasive grinding wheel onto machine or alter size of the mounting hole. Don't use an abrasive grinding wheel that fits the arbor too loosely.
- Check mounting flanges for equal size, relieved as required and correct diameter. Do not use mounting flanges on which bearing surface is not clean, flat, smooth.
- Only a trained person should mount a grinding wheel.
- Observe mounting angular orientation if indicated.
- Always interpose new cardboard gaskets (loose or glued ones) of adequate diameter between every side of the grinding wheel and flanges. Make sure they are in optimal condition and check for curls.
- Tighten mounting nut and bolt adequately to ensure a secure dragging. Nuts excessively tightened can damage flanges and wheel.
- Avoid using refrigerants with a Ph level higher than 9 and/or a temperature higher than 3 54- 0 °a1 C with organic-bonded wheels used with water. If the Ph level and/or the temperature are too high the wear resistance of the wheel can decrease.
- Always use adequate safety guards. See FEPA safety code at point 7.2.
- Before grinding adjust safety guards and other protections if present.
- Wear safety glasses or equal eye protection.
- Always wear your own protective gear adequate to the job.

4. USE OF GRINDING WHEEL

- When starting up a grinder always stand safely to one side and run wheel for one minute at operating speed before grinding. Check for people in front of the machine.
- Always position and keep the grinding support at a maximal distance of 2 mm from the grinding wheel or on the axis passing through the center of the wheel.
- Switch on exhaust fan before grinding.
- The contact between the wheel and the workpiece should be soft and regular. Do not apply too much pressure or slow down the grinding wheel.
- Avoid thermal shocks and excessive overheating of the wheel.
- A soft lateral push can be applied to hallow grinding wheels, grinding cup wheels and dish wheels.

This short summary of basic rules cannot cover every case, especially regarding special applications. To know more about this matter or to find an answer to any question you may have refer to the FEPA European Safety Code or to supplier.



**Diarex® Pro Series™
Silicon Carbide
Grinding Wheels**

Stock No.	Grit
960000	24
960002	36
960004	46
960006	60
960008	80
960010	120
960016	220
960024	400



**Diarex® Pro Series™
Tapered Silicon
Carbide Grinding
Wheels**

Stock No.	Grit
960035	24
960036	36
960037	46
960038	60
960039	80
960041	120
960043	180
960044	240



**Diarex® Pro Series™
Grinding Wheels**

Stock No.	Grit
960060	24
960062	46
960064	60
960066	120
960068	220