

MACHINE TOOLS

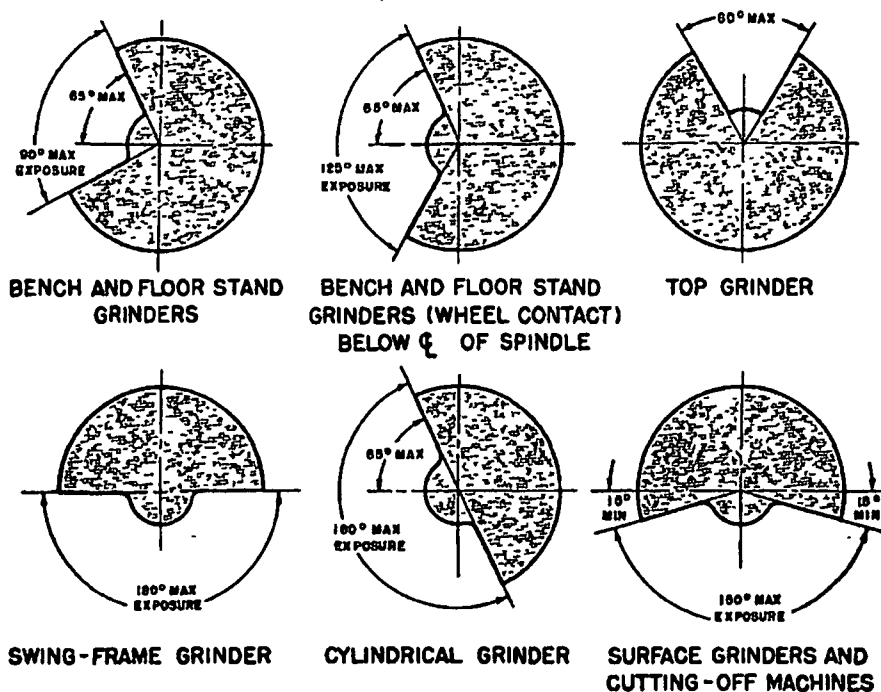


Fig 24-20 Maximum exposure angles for various grinding applications



Fig 24-21. Speed testing of grinding wheels is done in totally enclosed variable speed machines

Safe speeds

The various types of abrasive wheels and disks should be operated at speeds not exceeding those recommended by the manufacturer. In particular, unmarked wheels of unusual shape, such as deep cups with thin walls or backs, or with long drums, should be operated according to the manufacturer's recommendations.

All wheels should be tested by the manufacturer (Fig 24-21) at specific testing speeds shown in Table 24-L. Wheels which need not be tested include those less than 6 in in diameter, diamond wheels, mounted wheels, and other special types. A letter of certification should accompany each speed-tested wheel and the maximum operating speed should be clearly marked on the wheel.

Before a wheel is mounted, the machine spindle should be checked for the correct