

# CENTERLESS GRINDING WHEELS

Whatever finish or stock removal you require Buffalo Abrasives can engineer and manufacture centerless grinding wheels to meet your most exacting needs

- **Diameters thru 24"**
- **Thicknesses through 10" (22" sets)**
- **Selection of phenolic, epoxy or vitrified bonds**
- **High performance abrasive grain blends**
- **Grit sizes through 600**
- **Short dependable manufacturing lead times**
- **Competitive pricing, quick quotations**
- **Applications support available**



We have extensive experience in applications for the following Industries:

- **Bearings**
- **Contract Machining**
- **Medical Accessories**
- **Motor Vehicle Parts**
- **Primary Metals**

This information may be required to optimize wheel performance:

- **Thrufeed, infeed, endfeed**
- **Workpiece material, diameter**
- **Stock removal objective per pass**
- **Finish requirement (Ra)**

## Recommended Set-up for General Purpose Thru-feed Applications

<b>Regulating Wheel</b>	<p>Use a general purpose rubber wheel specification of A804-R-10RX</p> <p>Use a 3 degree angle of inclination and a speed of 90-100 SFPM</p> <p>True with a 1-2 carat single point diamond at 1-2 inches per minute</p>
<b>Work Rest Blade</b>	<p>For work 1/2" diameter and larger, use a blade angle of 20-30 degrees</p> <p>Set work center above wheel centers 1/2 of work diameter (but 5/8" max)</p> <p>Use maximum blade thickness to avoid chatter</p>
<b>Grinding Wheel</b>	<p>Use a general purpose grinding wheel specification of KCA542-M-11B4487</p> <p>Dress with an impregnated diamond dressing tool at 10 inches per minute</p> <p>6-8" wide wheels will remove stock at 1 cubic inch per minute per 10 HP</p> <p>Rough at 1/3 to 1/2 of wheel face width per work revolution, finish at 1/6 to 1/3</p>
<b>Coolant</b>	<p>Use 5 gallons per inch of wheel width per minute and a high velocity nozzle</p> <p>Direct coolant to point of contact between the workpiece and grinding wheel</p>

**Consistency** - Our experienced professionals use proprietary formulations - using the finest raw materials, accurately controlled mixtures and unique bond systems - to produce wheels that deliver consistent performance, wheel after wheel

**Quality** - Fully integrated, in-house facilities, including advanced hydraulic press technology, temperature and humidity controlled mixing and molding, and computer controlled cure cycles, are used to produce the highest quality centerless grinding wheels available today. Our manufacturing is supported with Statistical Process Control, TQM teams and continuous improvement programs.

**Please contact your local Distributor or Sales Engineering for additional information**