Mounting Type 1, 5 & 7 Wheels

1. Visually inspect the grinding wheel for cracks or any damage. Subject the wheel to the ring test or return to the manufacturer if there is any doubt regarding the soundness of the wheel.

2. Compare the speed marked on the wheel with the machine spindle speed. If the maximum RPM marked on the wheel is lower than the spindle speed *DO NOT* mount the wheel.

3. Inspect the machine spindle and flanges for any damage or wear. Make certain that the flange screws are not too long for the tapped holes in the wheel sleeve. Thoroughly clean spindle and flanges of all worn blotter material and any dirt or foreign material.

4. Never force a wheel onto a spindle. *DO NOT* use oil or grease on the spindle as this can cause wheel breakage. If a lubricant is required, use a silicone spray on the spindle to ease mounting.

5. Always use new blotters on collet and flange surfaces when mounting a wheel.

6. Make sure the mount up arrow is at the top of the wheel. In the case of a multiple wheel set make sure the match lines stenciled on the grinding face are aligned.

7. Tighten the bolts on the flange by hand to make sure the flange is properly seated.

8. Tighten all the bolts in an alternating pattern to 15 ft-lbs. Repeat this tightening sequence this time increasing the torque to 20 ft-lbs. min. or to the machine builder's recommendations. Higher horsepower machines or Centerless grinders require greater torque then recommended above. Use 30-35 ft-lbs. for up to a 12" wide Centerless wheel and 45-50 ft-lbs min. for wheels wider than 12". *Use more than 20 ft-lbs. only when approved by the machine builder.*

9. Re-torque the flange bolts to specification after eight hours of operation. Check every eight hours thereafter until the torque remains constant.

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TECHNICAL REPORT