

Wheel mounting – peripheral cutting speed

Wheel mounting

An **ATLANTIC** grinding wheel ready for despatch conforms to DIN EN 12413.

The heavy point of the grinding wheel is marked with an arrow; this imbalance is technically unavoidable in the manufacturing process.

As a result of a play between the grinding wheel bore and spindle, the wheel 'hangs' causing eccentricity and additional imbalance.





It is therefore important to ensure that the arrows point downwards when mounting.

Both these imbalances can be minimized by wheel dressing if mounted correctly.

Before the grinding wheel is dismounted or stopped, it is important to allow the coolant to be centrifugally spun out of the wheel.

Cutting speeds

The maximum cutting speed of **ATLANTIC** grinding wheels is indicated in the adjoining table, and should never be exceeded.

Cutting speed		Colour code
up to 40 m/s		none
50 m/s		blue 
63 m/s		yellow 
80 m/s		red 
100 m/s		green 
125 m/s		blue/yellow 