

For better grinding check these common causes of trouble



Poor Finish:

1. Dull or cracked diamond
2. Loose diamond or diamond holder
3. Diamond overhangs too far
4. Poor grade of diamond
5. Wheel out of balance or roundness
6. Oil on portions of wheel
7. Dull grinding wheel
8. Incorrect wheel grade
9. Sharp corners on wheel
10. Improper speeds and feeds
11. Excessive stock removal
12. Headstock belts slipping
13. Unmatched belts on wheelhead
14. Dirty, incorrect or insufficient coolant
15. Insufficient coolant when dressing
16. Dirty workpieces
17. Centers too long or loose
18. Loose wheel or wheel mount
19. Loose sheave on grinding wheel spindle
20. Vibration from outside source

Sizing Troubles:

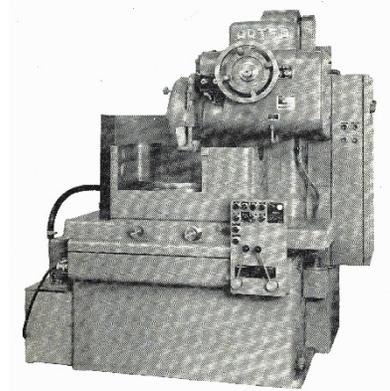
1. Loose or incorrect taper on centers
2. Insufficient tarry
3. Insufficient coolant when grinding
4. Improper wheel
5. Bad centers in workpiece
6. Incorrect lubricant or hydraulic oil
7. Inconsistent operating cycle

Out of Roundness:

1. Loose or incorrect taper on centers
2. Workpiece not properly supported
3. Too much footstock tension on slender work
4. Not enough tension on footstock
5. Headstock or footstock not clamped properly
6. Condition of workpiece center holed
7. Lack of lubrication on centers
8. Overheating due to lack of coolant
9. Stock removal too rapid
10. Insufficient tarry
11. Out of balance workpiece

Taper:

1. Loose or incorrect taper on centers
2. Loose footstock spindle
3. Footstock or headstock not clamped tightly
4. Machine out of level
5. Condition of center holes in workpiece
6. Too much-too little tarry at one end
7. Over travel of wheel at end of work
8. Dirt under swivel table
9. Insufficient coolant when dressing wheel



FRONT VIEW MODEL "E" HYDRAULIC
ROTARY SURFACE GRINDER



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