

Depressed Centre Grinding Wheels

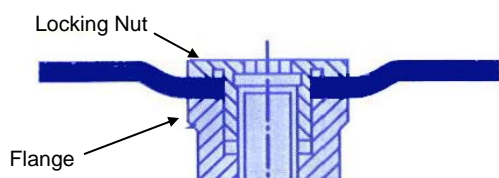
Safety Information

Type 27 and 28 Depressed Centre (or Raised Hub) wheels, because of their shape and usage require specially designed adaptors.

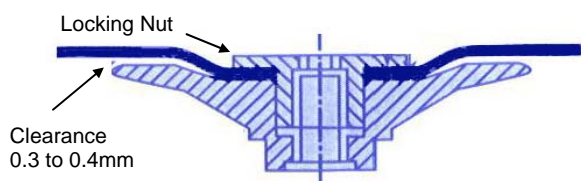
Type 27 and Type 28 wheels shall be used only with a **safety guard located between the wheel and operator during use**. Flanges must meet the requirements of the Australian / New Zealand Standard 1788.1 for Type 27 and Type 28 wheels where the locking nut may be less than the normal minimum one third of the diameter of the wheel to prevent interference when offside grinding.

The flange assembly serves to drive the wheels by clamping force against the depressed portion of the back flange. The variance in flange diameters and the use of side pressure on the wheel during the grinding operation requires that only reinforced organic bonded wheels made to meet Australian Standard AS17788.1-1987 / New Zealand Standard 5246.1 may be used on this type of machine.

Correct Flange Assembly

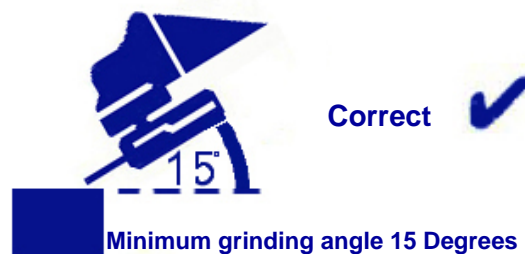


Correct mounting for type 27/28 wheels less than 180mm diameter



Correct mounting for type 27/28 wheels equal to or greater than 180mm diameter

Correct Grinding Angle



DO NOT USE FLAT !

Basic Grinding Procedures

- Do not "bump " the wheel when starting to grind or while grinding.
- Do not use excessive pressure! Allow the wheel to do the work.
- Ensure that you select the correct wheel grade for the workpiece being ground. (For example do not use *Metal* grinding wheels on masonry products.)
- At the completion of grinding allow the wheel to free run to a stop. i.e. do not do not force on the workpiece to stop it.
- When not in use store the machine and the wheel in a dry area where they will not be bumped or knocked.

Safe Grinding Practices

- R.P.M. of the machine must never exceed R.P.M. indicated on the wheel.
- **Do not use without Machine Guard !!!**
- Always wear eye protection.
- Always wear hearing protection and appropriate protective clothing.
- Use in accordance with Australian / NZ Standard AS1788.2-1987.