

GRINDING THE MOUNTING SURFACE OF RECTANGULAR CHUCKS

- A. Place the chuck, face down, on the sliding table of the surface grinder and indicate the surface of the chuck length wise and cross wise. Shim as necessary to level the surface to be ground.
- B. Block each end of the chuck to prevent from moving while being ground. **DO NOT HOLD IN PLACE BY ENERGIZING THE CHUCK.**
- C. Using a general purpose medium hardness 36-40 grit type grinding wheel. Wet grind using any non-nitrate or inhibited-nitrate coolant.
- D. Depth of cut can vary dependant on machine size and wheel type, consult machine manual or grinding wheel manufacturer.
- E. Crossfeed-half wheel width per pass dependant on machine and wheel size, consult machine manual.
- F. Table speed about 75 feet per minute dependant on machine and wheel size, consult machine manual.
- G. Grind and clean bottom of chuck. **DO NOT DRY GRIND THE CHUCK.**

After the base surface has been ground flat, remove the chuck, clean and dry the mounting area of the table. Be sure to clean thoroughly freeing from all burrs before mounting in normal upright position.

NOTE: Each time the chuck is ground the wheel should be trued. There should be no effort to "spark out" on the top of the chuck after the last pass has been taken. A "commercial" grind finish will provide the best coefficient of friction for non-slip magnetic holding of work pieces on the chuck.

A loaded wheel, whether caused by heavy cuts, improper dressing, or wrong type of wheel can creat heat build-up sufficient to wrap the center of the chuck up into the wheel and seriously affect chuck flatness.

For prompt service call toll free 1-800-W-MAGNET



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