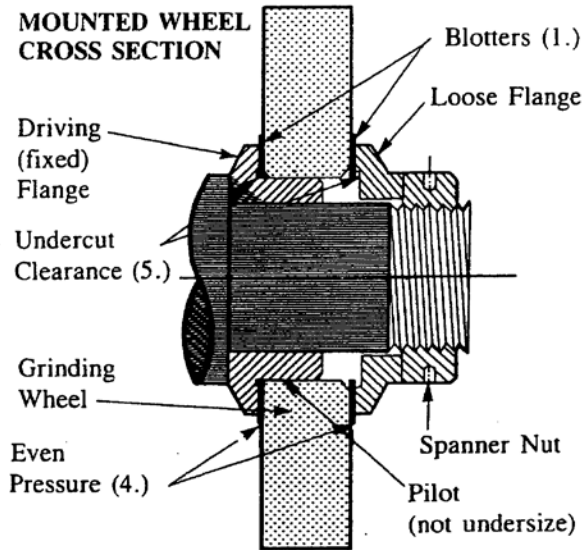


SAFE WORK PRACTICES BENCH & PEDESTAL WHEEL MOUNTING

**This information does not take precedence over OH&S. All employees should be familiar with the Saskatchewan Employment Act and the OH&S Regulations.*

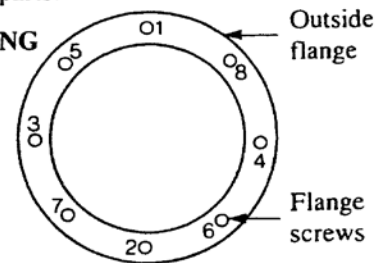
Grinding machine wheel use and maintenance should conform to manufacturer's recommendations.



1. Ensure you have the correct type and size wheel for the machine by checking the markings on both. The machine spindle speed must not be greater than the speed marked on the wheel.
2. Examine the wheel for cracks or chips. Replace a faulty wheel.
3. Do not force a wheel onto the machine spindle or change the size of the mounting hole.
4. Maintain even pressure from both flanges against the sides of the wheel. Check flanges with a straight edge. Worn or warped flanges must not be used.
5. Maintain a clearance (undercut relief) of at least 3 mm (1/8 in) to prevent pressure on the wheel near the hole.
6. Check the surface of the abrasive wheel and flanges to ensure that no particles are present.

7. Use paper blotters between wheel and flanges to take up slight wheel surface roughness.
8. Ensure mounting pilot(s) is rounded with length about 2/3 width of the wheel.
9. Extend the threaded section well inside of the loose flange.
10. Tighten grinding wheels just enough to prevent them from slipping. Overtightening the spindle nuts or clamping screws can damage the wheel and grinder parts.

TIGHTENING ORDER



With multiple screw mounting flanges tighten the bolts uniformly. Start by barely tightening a screw, 'snug-up' opposite screw and in a criss-cross manner, continue until all mounting screws are uniformly tight. Use a torque wrench to apply not more than 20 to 27 joules (15 to 20 foot-pounds).

11. Place the threads of the central spindle in a direction that allows the nut to tighten because of the force of the work being done.
12. Replace all guards.
13. Warn all persons in the area of the wheel to stand clear.
14. Stand to one side and test the wheel. Start up and run the wheel for at least 1 minute. If any undue vibration occurs, switch off immediately and make adjustments.