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.

<table>
<thead>
<tr>
<th>Cutting speed (m/s)</th>
<th>Colour code</th>
</tr>
</thead>
<tbody>
<tr>
<td>up to 40 m/s</td>
<td>none</td>
</tr>
<tr>
<td>50 m/s</td>
<td>blue</td>
</tr>
<tr>
<td>63 m/s</td>
<td>yellow</td>
</tr>
<tr>
<td>80 m/s</td>
<td>red</td>
</tr>
<tr>
<td>100 m/s</td>
<td>green</td>
</tr>
<tr>
<td>125 m/s</td>
<td>blue/yellow</td>
</tr>
</tbody>
</table>

**Specifications**

- **Name of manufacturer/distributor**
- **Contact point with spindle**
- **Max. permissible cutting speed \(v_s\)**
- **Batch number**
- **Dimensions**
- **Mounting arrow**
- **Conformity with the standards for safety requirements of bonded grinding wheels**
- **Max. permissible R.P.M. (based on the nominal diameter)**
- **Colour code for permissible cutting speed (see table)**
- **Specification**