

## CORRECT STORAGE OF RESIN BONDED GRINDING WHEELS

**Please store in dry and well-ventilated premises without major temperature changes** (temperatures between 10° and 30° C and max. 70% relative humidity).

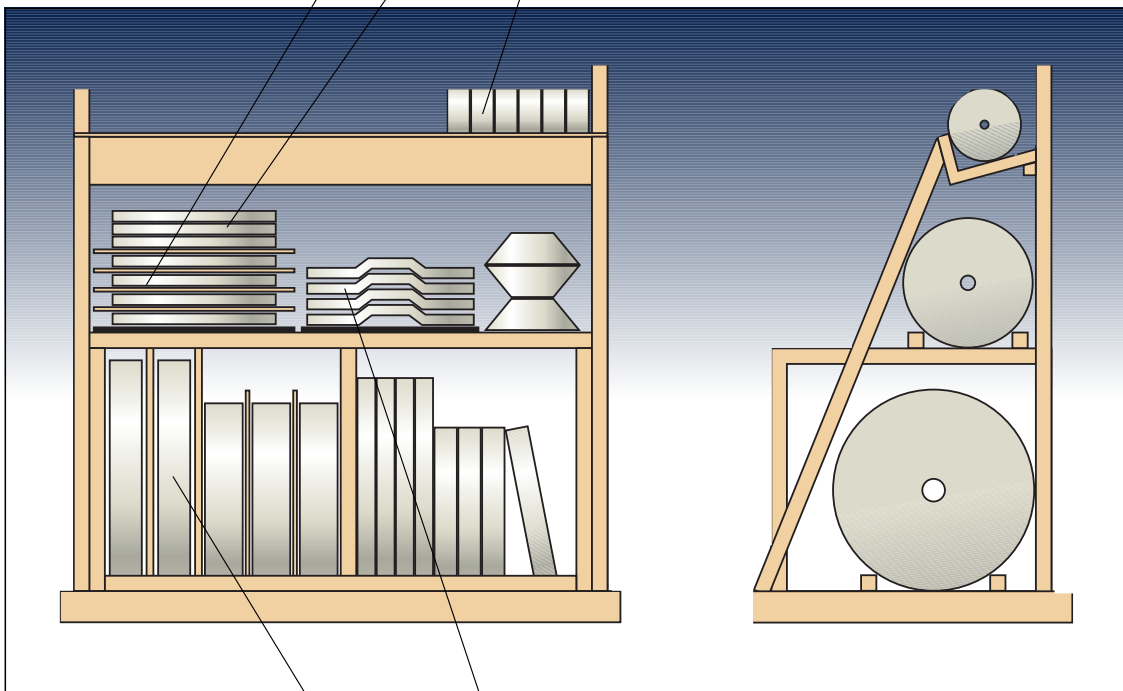
This will help preserve the physical properties of reinforced resin bonded grinding wheels for up to three years, up to two years for non-reinforced ones. The storage premises should be as close to the place of use as possible in order to avoid mechanical damage to the wheels during transport, as well as moisture condensation while in transit on colder days.

**Please use appropriate stands, shelves, drawers and boxes for storing various types of grinding wheels.**

Store wide thin-section grinding wheels in a horizontal position on a flat surface or on a steel base.

Place thinner resin bonded cutting-off wheels on a flat surface in order to prevent bending.

Store small grinding wheels on upper shelves or in their original packaging.



Store depressed-centre concave grinding wheels one on top of the other or in their original packaging, up to a stack height of 120 cm.

Store grinding wheels and thick-section grinding rings of larger dimensions vertically on lower shelves, but transport them horizontally.



## CORRECT HANDLING

1. **DO** always follow instructions for correct storage.
2. **DO** always visually inspect grinding wheels before mounting for possible damage during transport and eliminate damaged ones.
3. **DO** always use a safety guard, which should cover nearly one half of the grinding wheel.
4. **DO** always use non-reinforced cutting-off wheels on fixed stationary machines.
5. **DO** always switch off the power at the supply and/or unplug the machine before changing the wheel.
6. **DO** always use the tools supplied by the machine manufacturer to change the wheel.
7. **DO** always ensure that the spindle speed of the machine is no higher than the operating speed marked on the wheel.
8. **DO** always use the correct wheel mounting flanges for grinding wheels and check that they are undamaged, clean and free of burrs.
9. **DO** always use blotters between the mounting flanges and the wheel sides for soft mounting of flat cutting-off wheels.
10. **DO** always allow newly mounted wheels to run at operating speed with the guard in place for at least one minute before cutting or grinding.
11. **DO** always wear protective gear: safety clothing, dust masks, eye protection (glasses or shield), gloves and ear protection.
12. **DO** have machine speeds checked regularly, especially after maintenance or repair.
13. **DO** always check the tension of the driving belt, where fitted, on a regular basis: belts must be kept tight in order to ensure optimum power transmission.
14. **DO** always secure the workpiece firmly before beginning cutting or grinding.
15. **DO** store portable machines appropriately when not being used, to avoid accidental physical damage to the wheel.
16. **DO** always use portable machines in a comfortable position, where the body is well balanced and the machine is well supported.
17. **DO** grind at the prescribed angle to the item with depressed-centre grinding wheels on an angle grinding machine.
18. **DO** always keep the work space around cutting and grinding operations clear. It is very dangerous if an operator slips or falls during cutting or grinding operations.

## INCORRECT HANDLING

1. **DON'T** store wheels in a damp atmosphere or in extreme temperatures.
2. **DON'T** use non-reinforced cutting-off wheels on portable machines.
3. **DON'T** handle wheels roughly.
4. **DON'T** mount a damaged wheel.
5. **DON'T** EVER exceed the maximum operating speed marked on the wheel.
6. **DON'T** force a wheel onto a machine spindle.
7. **DON'T** use mounting flanges which are incorrect, damaged, dirty or worn out.
8. **DON'T** tighten the mounting nut or locking flange excessively. This can distort the flanges.
9. **DON'T** use blotters for soft mounting of depressed-centre concave wheels.
10. **DON'T** use a machine which is not in good mechanical condition.
11. **DON'T** use a machine without a wheel guard.
12. **DON'T** use wheels without proper ventilation or dust protection equipment.
13. **DON'T** apply side pressure to cutting-off wheels.
14. **DON'T** stop the wheel after use by applying pressure to the wheel edge or side. Always switch the machine off and allow the wheel to stop revolving.
15. **DON'T** allow the wheel to be trapped or pinched in the cut.
16. **DON'T** apply excessive pressure onto the wheel so that the driving motor slows down.
17. **DON'T** grind on the side of cutting-off wheels .
18. **DON'T** drop portable machines or lower to the floor by the cable or air hose. A wheel can be easily cracked by the weight of the machine if it is put down hard. This is a common cause of wheel breakage.
19. **DON'T** grind with a depressed-centre concave grinding wheel at an angle lower than the pre scribed angle.
20. **DON'T** use a machine in a position where you do not have full control of the machine and you are not well balanced.