

Grinding Wheel Specification :-

- The type of grit material.
- The grit size.
- The bond strength of the wheel, commonly known as wheel hardness.
- The str. of wheel denoting the porosity.
- The type of bond material.
- Other than these parameters the wheel manufacturer may add their own identification code prefixing or suffixing the standard code.

A grinding wheel is specified by the following parameters :-

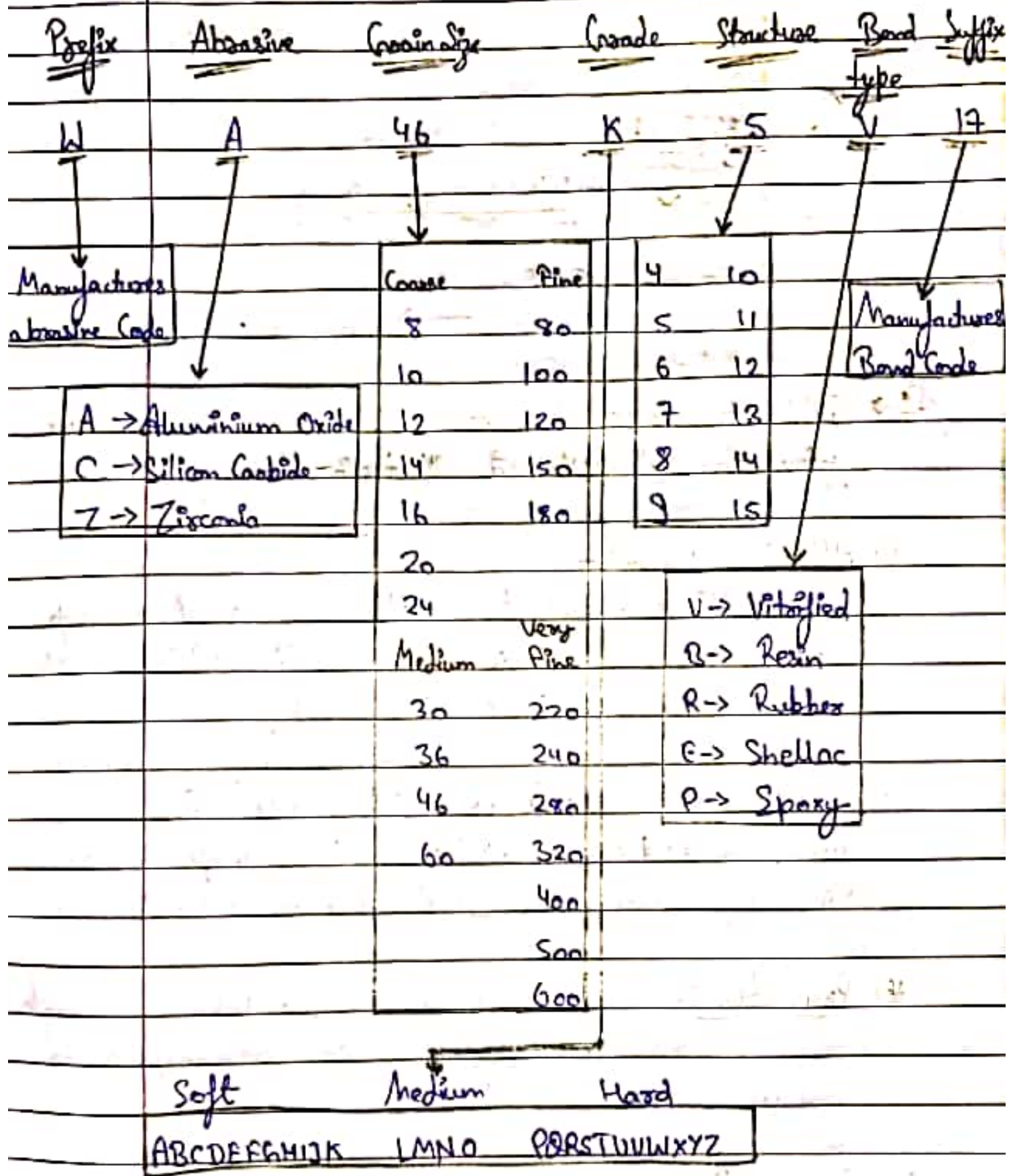
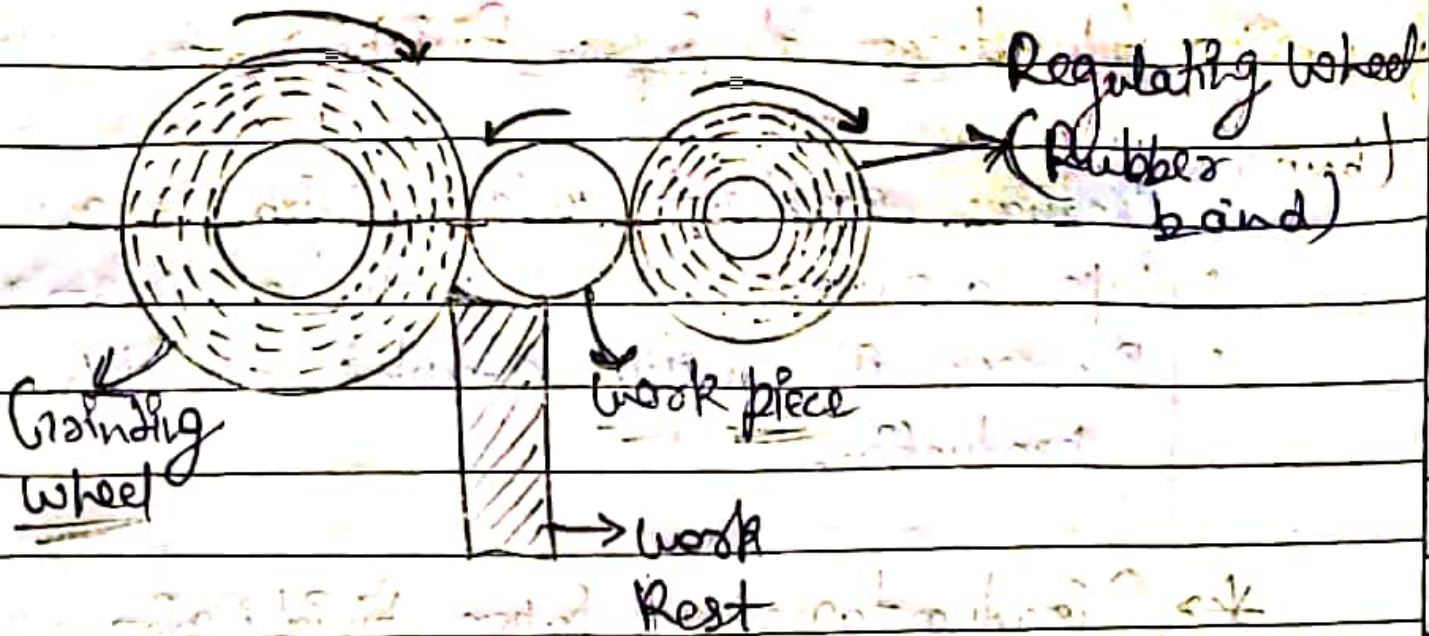


fig :- Standard marking system for grinding wheels.

Centreless Grinding - It is the combination of grinding wheel & regulating wheel. Thus centreless grinding does not require centre holes & fixtures for holding the workpiece.

Centreless grinding is popular as a high speed, low cost operation.

Centreless grinding is similar to centred grinding except that there is no spindle.



figs - Centerless Grinding

* Types of Centerless grinding :-

- (a) Through feed grinding.
- (b) In-feed grinding.
- (c) End-feed grinding.