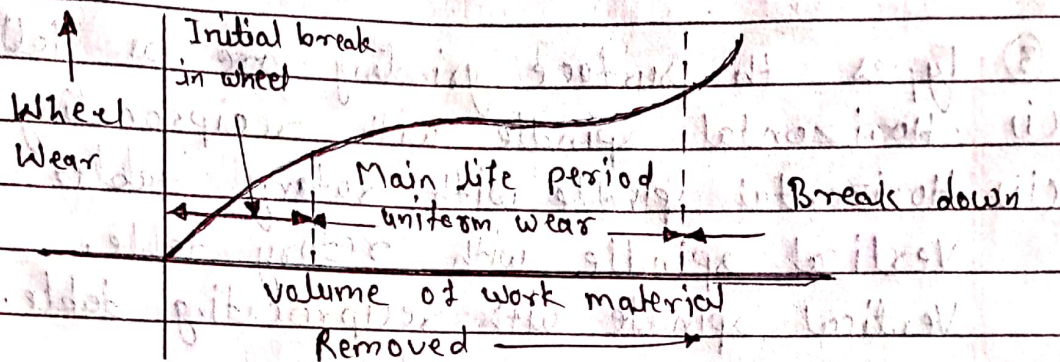


[B] Grinding wheel

(1) Fig show how a grinding wheel wears with more and more grinding (removal of work material).



- ② After the uniform wear period ends, the wheel needs to be reconditioned otherwise wear will be heavy.
- ③ While loading and glazing may not be problem if proper wheel is selected, but wear is natural phenomenon as abrasive grains have finite life.
- ④ During dressing, the dull and used layer of abrasive particles is crushed and fresh surface of abrasive particles is exposed.
- ⑤ The performance of a grinding wheel is characterised by the parameter grinding ratio which is the ratio of volume of work material removed and the volume of wheel worn away.

[E] Centreless Grinding:-

(i) It is the combination of grinding wheel and regulating wheel. Thus centreless grinding does not require centre holes and fixtures for holding the work piece.

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

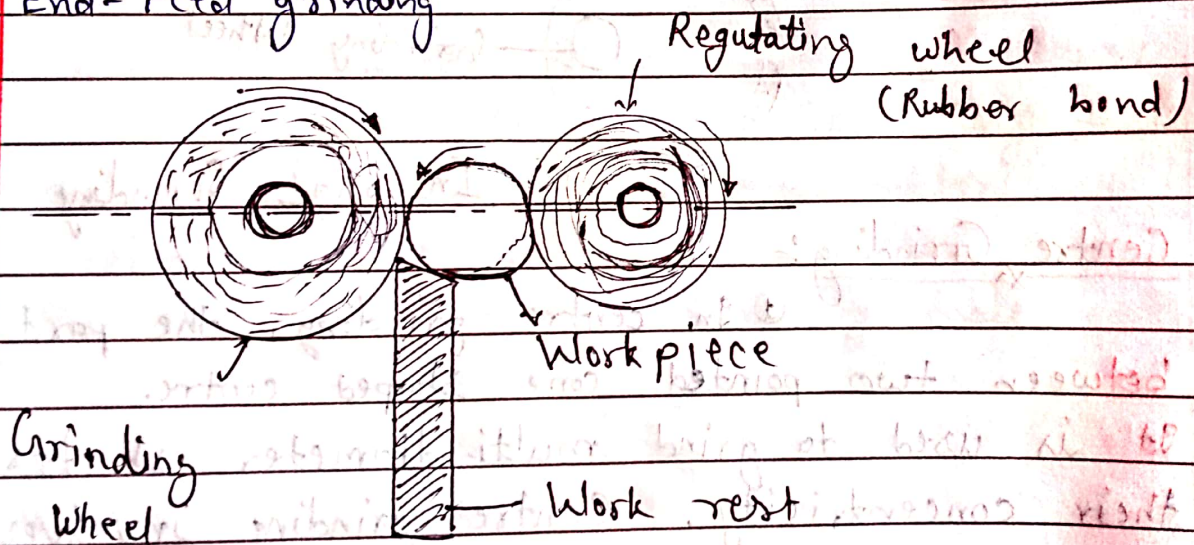
④ Centreless grinding is similar to centred grinding, except that there is no spindle.

(iv) Centreless grinding is of following three types:

① Through feed grinding

② In-feed grinding

③ End-feed grinding



Centreless grinding