

Section-4

Q 1

Ans

Grinding wheel specification

S1 A 36 L S V 40

S1 - manufacture's symbol indicating type of abrasive

A - Abrasive (aluminium oxide)

36 - Grain size (medium)

L - Grade (medium)

S - structure (dense)

V - Bond (vitrified)

40 - manufacture symbol (suffix) optional

* Centerless grinding

Centerless grinding is a machining process that uses abrasive cutting to remove material from a workpiece. Centerless grinding differs from centered grinding operation in that no spindle or fixture is used to locate and secure between two rotary grinding wheels, and the speed of their rotation relative to each other determines the rate at which material is removed from the workpiece.