EMPLOYEE TRAINING RECORD

TRAINING TITLE Wheel Mounting of Portable Grinders

KEY TEACHING POINTS

STRAIGHT WHEELS

- Inspect and conduct "Ring Test" before mounting a wheel.
- Check flanges for distortion or abrasion. When flanges are distorted or warped contact area is reduced.
- Flanges must not be reversed.
- Use paper blotters to cushion flange pressure.
- Do not use flat washers, or other filler materials in place of flanges.
- The fixed or loose flanges should have same diameter and have undercut relief. The minimum flange size is 1/3 the wheel diameter.

CUP WHEELS

- Flat Flange - no relief provides proper support for steel bushing and heel.
- Use a flat unrelieved flange with a threaded hole mounting. This prevents strain on the bond that anchors the bushing to the wheel cup.

CONE AND PLUG WHEELS

- The common cause of breakage is that the spindle threads are either too short or too long for the tapped hole in the wheel.

DEPRESSED CENTER WHEELS

- Replace worn or bent reusable adapters. A damaged adapter will not mount properly.
- Do not reuse "throw-away" adapters.
- Ensure grinder spindle shoulder runs true. The adapter must tighten against this shoulder. Use spacers provided with adapters if the spindle is too long.
- The wheel will wobble if the shoulder is not square with the spindle, or if the adapter does not tighten against the shoulder. This can result in wheel breakage.

TEST

QUESTION	ANSWERS	
	TRUE	FALSE
1 On straight wheels, inspect them and conduct a ring test before mounting.		
2 Spindle length is a factor in breakage of cone and plug wheels.		
3 A flat unrelieved flange with a threaded hole mounting prevents strain on the bond that anchors the busing to the wheel cup.		
4 Do not reuse "throw away" adapters.		
5 Wheel wobble can result in wheel breakage.		

EMPLOYEE'S NAME	EMPLOYEE'S SIGNATURE	DATE
INSTRUCTOR'S NAME	INSTRUCTOR'S SIGNATURE	DATE

1. True 2. True 3. True 4. True 5. True