

PACER CENTERLESS WHEEL EVALUATION

DATE EVALUATED:	EVALUATION NUMBER:
COMPANY:	EVALUATION LOCATION:
EVALUATION PERSONNEL:	

MACHINE AND COOLANT

MAKE/MODEL:	HP:	
AUTOMATIC OR SPECIAL FEATURES:		
SPINDLE rpm:	WHEEL sfm:	DIAMOND TYPE/SHARP?
COOLANT MFG/SPEC./CONDITION:		
TANK SIZE/FILTERS:	REFRACTOMETER:	
CONCENTRATION:	WHEEL FACE RELIEVED AT FRONT OR BACK:	
SPOUT SHAPE/DIRECTION/VELOCITY:		

FEEDWHEEL AND WORKBLADE

MANUFACTURER:	APPROX. DIA:	SPECIFICATION:
WHEEL ANGLE:	DRESSER ANGLE:	WORK HEIGHT ABOVE CENTER:
DIAMOND SETOVER:	RPM:	GEAR SETTING:
DIAMOND TYPE/SHARP?	WHEEL ALIGNED PARALLEL OR TIGHTER IN FRONT OR BACK?	
WHEEL FACE RELIEVED AT FRONT OR BACK?	BLADE MATERIAL:	
BLADE ANGLE:	TOP LENGTH:	TOP WIDTH:

WORK

MATERIAL:	DIAMETER:	LENGTH:	REMOVAL NEEDED:
FINISH NEEDED:	FINISH AT START:	HARDNESS:	
WALL:	ROUGHING, FINISHING (OR BOTH) PASS:		
THRU OR INFEEED:	TOLERANCE (+/-) OF DIA:		
OTHER TOLERANCE:	END PRODUCT:		

PERFORMANCE

WHEEL SIZE:	WHEEL SPECIFICATION:
REMOVAL PER PASS:	THRUFEED SPEED:
COMPENSATION TREQ. AND AMOUNT PER COMP.	
REDRESS FREQUENCY:	AMPERANCE TOTAL AND AT IDLE:
FINISH (RA) AND APPEARANCE:	
TOTAL: BARS, LENGTH AND COMPENSATION:	
Cu" PER MIN REMOVAL RATE, G RATIO:	
$\text{Cu" per min removal rate} = 3.14 \times \text{work dia} \times \text{removal per pass} / 2 \times \text{thru-feed ft. per min} \times 12" \text{ per ft.}$ $\text{G ratio is Grinding wheel ratio (cu" work removed / cu" wheel used)}$ $\text{G ratio} = (3.14 \times \text{work dia} \times \text{removal per pass} / 2 \times \text{total feet} \times 12 \text{ per ft.}) / (3.14 \times 9 \text{ approx. wheel dia} \times \text{total compensation} \times \text{wheel width})$	

COMMENTS: