

PACER ROLL WHEEL EVALUATION

DATE EVALUATED:	EVALUATION NUMBER:
COMPANY:	EVALUATION LOCATION:

EVALUATION PERSONNEL:

MACHINE AND COOLANT

MAKE/MODEL:	HP:	MINIMUM WHEEL RPM AVAIL.:
ONE OR TWO WHEEL MACHINE:	IF TWO, WERE BOTH USED:	CARRIAGE LOOSE, SNUG OR LOCKED:
WHEEL BALANCED BEFORE USING:		IMPREG. OR SINGLE PORT DIAMOND/SHARP?
INFED AUTOMATIC ACROSS ROLL, AT ENDS OF ROLL ONLY, OR MANUAL:		
CONDITION OF SPINDLE, BELTS, ECT. THAT CAN CAUSE CHATTER:		GRINDING BELOW CENTER:
OTHER SETTINGS AND CONDITIONS:		
COOLANT MFG., SPEC., CONDITION:		TYPE FILTERS USED:
% CONCENTRATION:	REFRACTOMTER:	FLOW INTO NIP, ONTO ROLL OR WHEEL:

ROLL

MATERIAL:	DIAMETER:	FACE LENGTH:	CROWN:
HARDNESS:	HOLES OR SLOTS:	METHOD OF SUPPORTING JOURNALS:	
FINISH AND APPEARANCE NEEDED:	PROFILE NEEDED:	REMOVAL NEEDED:	
ROUGHING, FINISHING OR BOTH:	SAG OR RUN OUT:	TYPE (USE) OR ROLL:	

PERFORMANCE FACTORS	COMPARISON WHEEL	EVALUATION WHEEL
WHEEL MANUFACTURER:		
WHEEL SIZE (DIA X WIDTH X HOLE):		
WHEEL SPECIFICATION:		
WHEEL SPEED (RPM, SETTING):		
ROLL SPEED (SFM, SETTING):		
TRAVERSE SPEED (IN/REV, MIN/PASS, SETTING):		
INFED SPEED (MIN/THOU, SETTING)		
AMPERAGE TOTAL AND AT IDLE:		
CHATTER OCCURANCE, IF ANY:		
PROFILE RESULTS (END TO END):		
FINISH (RA) AND APPEARANCE:		
REMOVED (TIMED), HOURS, THOU/HOUR		
Cu" PER HR REMOVAL RATE, "G" RATIO:		

Cu" per min removal rate = $3.14 \times \text{start roll dia} \times \text{removed} / (2 \times \text{face}) / \text{hours}$ G ratio is Grinding wheel wear (cu" work removed / cu" wheel used)
 G ratio = $(3.14 \times \text{start wheel dia} \times \text{radius used} \times \text{width}) \leftarrow \text{Measure before + after from flange to od to get radius used}$

COMMENTS: