



INTRODUCING A NEW RESIN WHEEL

WAM

FOR CENTERLESS GRINDING

Three abrasive grains combine for grinding performance unavailable with one or two grains:
W (White aluminum oxide) + **A** (Aluminum oxide, regular brown) + **M** (Monocrystalline aluminum oxide)

Pacer introduces a wheel for better long-bar performance. It has made brown AIO wheels for many years and white + brown in recent years. It lately focused on the unique properties of monocrystalline and developed wheels having all three grains: white, brown and mono. User test results with a TwinGrip set were very good.

White AIO is friable and sharp for cool cutting although it wears faster. Combining white and brown improves performance by allowing somewhat more removal and speed with less heat.

Brown AIO has long been the backbone of grinding wheels due to toughness and long life although it can tend to glaze and require redressing. Work may become hot, limiting removal and speed.

Monocrystalline AIO is newer - tougher than brown, harder than white. It has numerous, razor-sharp cutting edges that last long. The refined, premium grain is seldom used in this country in large wheels.

A cool cutting, low wearing wheel protects tolerances, roundness and finish. It grinds easier, with less energy. High volume grinding of 1045 CS 24' bars showed that **WAM** wheels remove more per pass at faster thrufeed and give better finishes. Even at the higher rates, bars emerged cool. Wear was less than normal. Improving grinding productivity is difficult but better wheels can make it happen. Pacer's new 3-grain wheels can decrease costs and increase quality.



The following jobs were done with a Pacer three-wheel combination set:

(1st) 24 x 8 x 12 WAM54M9NT2 (2nd) 24 x 6 x 12 WAM80L9NT2 (3rd) 24 x 6 x 12 A180E5RB Cork

Diameter	Length	Removal	Speed	Comp.	Roundness	Finish	Comments
1-1/2"	24'	.009"	10'/min	.0004"/bar	.0001"	18 Ra	no spirals, grit marks, chatter or redressing - smooth, quiet grinding
2"	24'	.008"	6.75'/min	.0004"/bar	.0001"	14-16 Ra	

Pacer specializes in manufacturing centerless grinding wheels. Over the decades it has developed excellent resin-bond roughing wheels and cork-filled, rubber-bond finishing wheels. The **New Technology (NT2)** resin bond is unique to Pacer. Due to its strength, less is needed which provides more porosity for coolant + chips and softer, smoother grinding. Pacer cork wheels are widely used for ground & polished bars and many other applications. Combination sets of resin and cork sections eliminate second passes or improve single passes.

Tests to date have been on long-bar but **WAM** is expected to perform well on other types of centerless work.



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