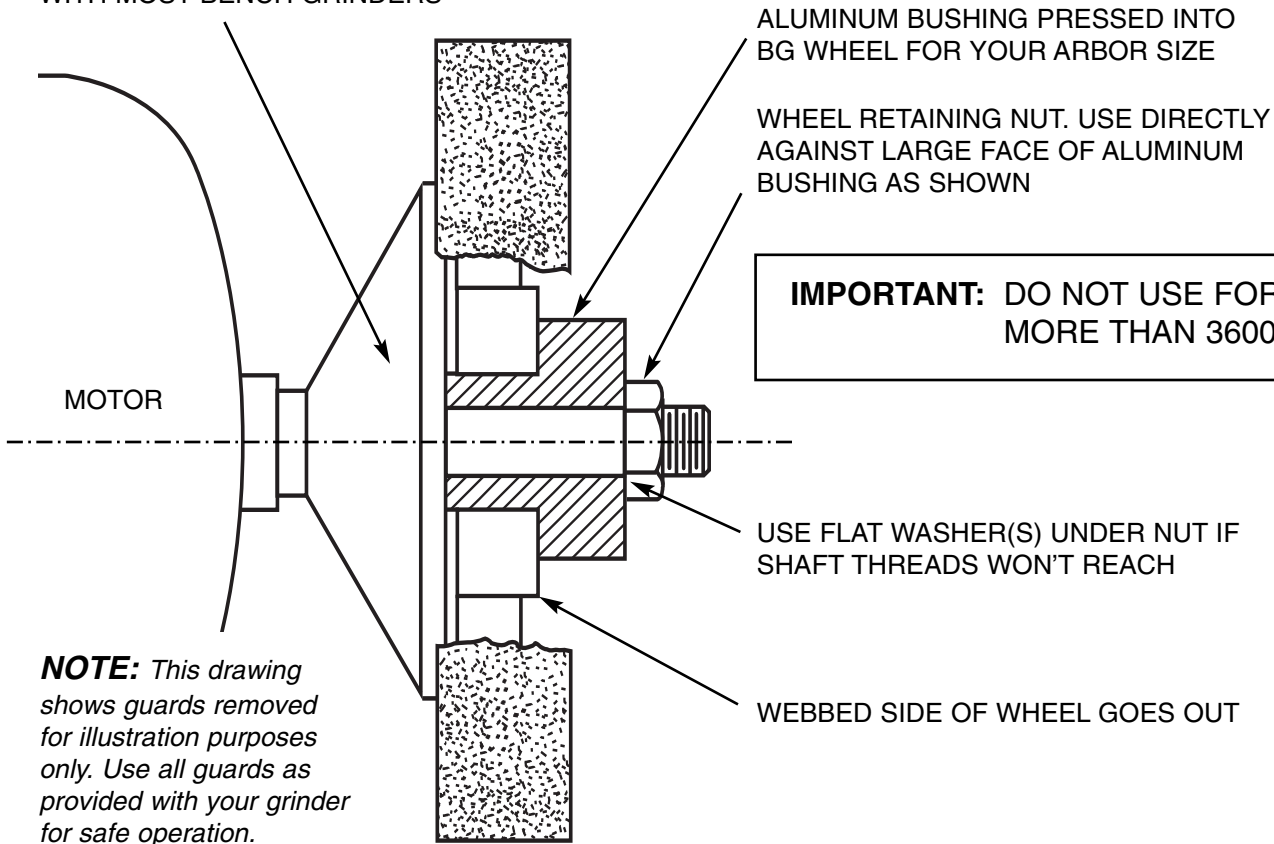


Installation and Use of **Accu-Finish®** BG Diamond Wheel

LARGE FLANGE WASHER COMMON WITH MOST BENCH GRINDERS



NOTE: This drawing shows guards removed for illustration purposes only. Use all guards as provided with your grinder for safe operation.

IMPORTANT: DO NOT USE FOR MORE THAN 3600 RPM

1. Accu-Finish BG Wheels are designed for use on bench and pedestal grinders up to a **maximum of 3600 RPM**. Refer to the above drawing for proper installation. Note the use of a large flange washer (standard equipment with most grinders) on one side only. The ribbed side of the wheel should face the outside of the grinder as shown.

2. Use these wheels for grinding carbide tools, ceramics, glass, stone and other hard materials. It is always faster and better to relieve the steel shanks of brazed carbide tools with a belt sander or aluminum oxide wheel before grinding on BG diamond Wheels. Occasional steel grinding should not damage the wheel. However, extended steel use may load the wheels especially the fine grits. If this happens, the wheel can usually be cleared by grinding plan carbide (such as a carbide insert).

3. These Diamond Wheels are designed mainly for grinding on the 1" wide face. The outside corners have a radius that will cut for a limited time, so save them for grinding small chipbreakers, etc. Moderate cutting pressures are fine. It is not necessary to limit yourself to light hand pressures while grinding. Wet grinding using a water base coolant or mist is recommended if your grinder is equipped for this. Dry grinding is common and produces acceptable results. However, avoid quenching hot carbide tools in water. Let them air cool to prevent thermal cracking.

4. Since most bench grinders shafts don't run perfectly true, your BG Diamond Wheel will wear more in one spot (the high run-out point). To compensate for this, periodically loosen the nut and rotate the wheel approximately 90° relative to the shaft, then retighten. This moves the "high spot" around the wheel for better life. Also, switching the wheel to the other side of your grinder helps due to reversed cutting. Because these wheels are electroplated diamond, do NOT attempt to true them by dressing as you would a vitrified or resin bond wheel. As your wheel wears, it will give a finer finish and cut slower. After a point you will want a new wheel. *Hint - save your old wheel for finishing and use the new one to rough!*

5. Please observe all safety rules as you should with any grinding wheel. **WEAR SAFETY GLASSES.** Always follow the instructions from the grinder manufacturer. Avoid inserting a tool or object into the side of a rotating wheel, this could cause damage or injury.

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