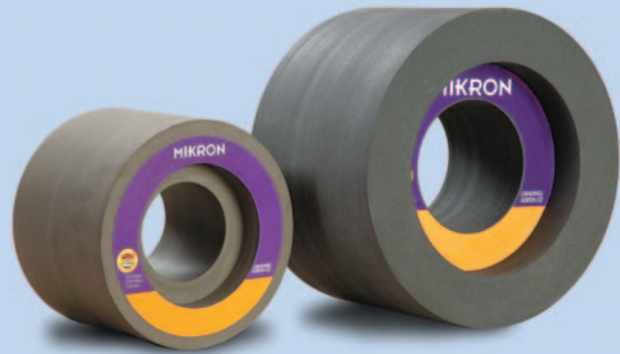


# REGULATING WHEELS

**NORTON  
ADVANTAGE**

*Grindwell Norton offers a superior range of regulating feed wheels to match its MIKRON - Super Edge, Super Grinding - Centreless range. Regulating wheels are available in both, the more popular rubber bonded variety as well as in resinoid bond.*



**BONDED ABRASIVES**

## TYPICAL APPLICATIONS

- ▶ Used in centreless grinding as a control and feed wheel

Industry	Steel	Bearing	Auto OEM	Auto Ancillaries	Cutting Tool	General Engg
Usage	●	●	●	●	●	●
	● Primary Use		● Secondary Use			

## GOOD REGULATING WHEELS

### FEATURES

- ▶ Better resiliency
- ▶ Better gripping power

### BENEFITS

- ▶ Better surface finish
- ▶ Reduces chatter tendency
- ▶ Greater shock absorption, better roundness
- ▶ Less slippage
- ▶ Dimensional accuracy
- ▶ Less rejection

## TROUBLESHOOTING GUIDE

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Poor surface finish or quality of grind	- Wheel too hard	- Use softer grade
Wheel is hard and glazing	- Lower speed of control wheel	- Increase the speed of control wheel
Faster wheel wear & poor finish	- High speed of control wheel	- Reduce the speed of control wheel
Job is not round (oval, lobed, etc.) and burn marks	- Lower speed of control wheel	- Increase the speed of control wheel

## STOCK AVAILABILITY TABLE

### Regulating Wheels

Size Dia x Thk x Bore	Std. Pkg.	Specification	Stock Item
230 x 50 x 76.2	2	A80RREU	RR10
230 x 100 x 76.2	1	A80RREP	RR3R
300 x 150 x 127	1	A80RREU	RR4
230 x 150 x 76.2	1	A80RREU	RR5
300 x 200 x 127	1	A80RREU	RR6

## TechTips

- ▶ The tilt given to the regulating wheel directly affects the feed rate of the work piece and hence is important with respect to the finish obtained and the productivity of the process.
- ▶ Please set a proper offset of dressing tool to ensure line contact between regulating wheel and job in through-feed grinding.