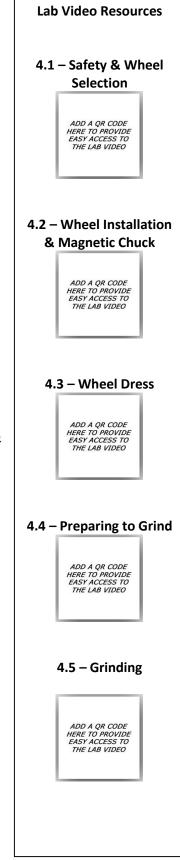
Process Sheet CAM 1109 Lab 4 - Surface Grinding

Safety and Procedure

- 1) Use safety glasses when entering shop
- 2) Review all safety measures discussed in classroom
- 3) No long sleeves. No jewelry. No hoodies. No shorts. No open shoes, etc.
- 4) Remove wheel if on grinder & do ring test & check for blotters on both sides
- 5) Turn on exhaust system & install wheel with left hand nut
- 6) Move table to right & lock & clean chuck with brush, then wipe with hand
- 7) No rags on grinder ... DANGEROUS!!!!!!!!
- 8) Dressing Wheel make sure table is locked
- 9) Place diamond on chuck slightly left of center of wheel & turn on magnet
- 10) If your diamond is on an angle, have it pointing left & left of center of wheel
- 11) Turn on wheel & turn downfeed wheel until it just touches wheel & clean up wheel
- 12) Take 3-4 cuts of .003 & 1 more of .001
- 13) Move crossfeed away from wheel & then move table to right & lock
- 14) Remove diamond & clean up chuck as you did to **prepare** for dressing
- 15) Place part on chuck, turn on magnet, and touch off lightly & go across entire piece to clean up 1 side
- 16) Remove part, cleanup table again & stone ground side & lay down on chuck
- 17) Turn on magnet & go across entire surface of part
- 18) Make sure you are off part & feed down .001 & make another cut
- 19) Continue same until part is to print dimensions
- 20) You may need to dress wheel again if finish looks poor

FINISH IS CONTROLLED BY PROPER WHEEL DRESS, SLOW CROSS FEEDS & FAST TABLE SPEEDS. NO MORE THAN ¼ TURN ON CROSS FEED WHEEL.



NO PRINT IS INCLUDED IN THIS LAB PROJECT SINCE THE STUDENT WILL BE SURFACE GRINDING ONE OF THE WIDGETS FROM THE PREVIOUS LABS.





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