



*Woodworking machinery at its best!*

## **CBN GRINDING WHEEL INSTRUCTIONS**

### **A little background information.**

CBN is an abbreviation for Cubic Boron Nitride. It is an abrasive material. Cubic boron nitride is the second-hardest known material after diamond, making it useful in a wide variety of industrial applications.

**Recommended Speed:** Optimum speed for 6" (150mm) diameter wheel is 1700 to 3000 rpm.

**Bore Size:** The bore is 32mm diameter. To use on a bench grinder with a 1/2" diameter shaft an adaptor is required. Adaptors are very tight fitting metal bushings with a shoulder to greatly reduce runout. They are mounted between the wheel and the motor.

**Application:** CBN wheels can be used on a bench grinder or on a woodworking lathe.

CBN wheels are suitable for all woodworking tools made of **High Speed Steel (HSS)**.

The wheel consists of a metal body which is coated in a plating process with a layer of CBN grain. Plated wheels never change size or shape therefore eliminating time-consuming re-profiling.

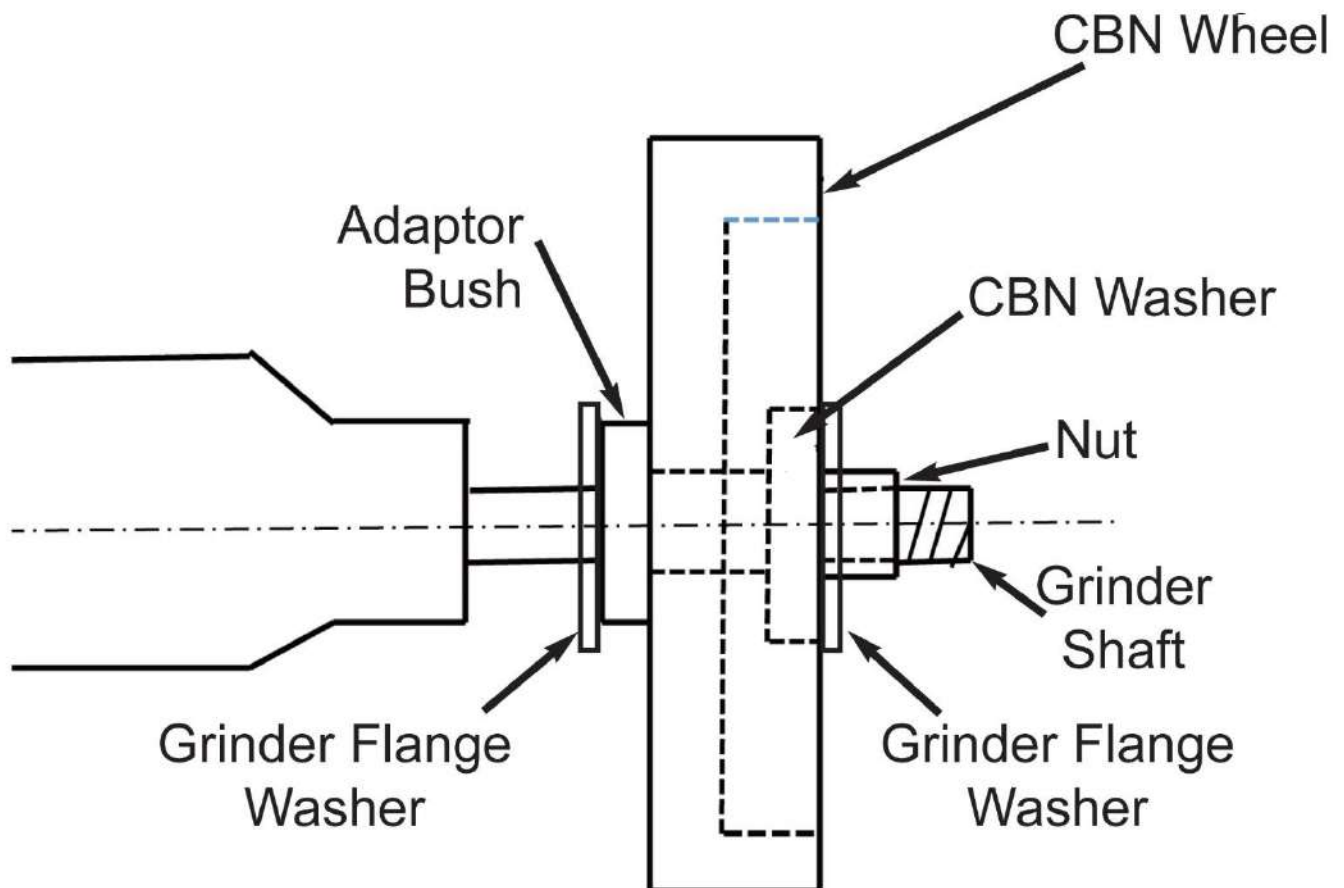
**Important:** If you are used to using an aluminum oxide wheel, be aware that CBN wheels do not require much force, just a little backup pressure for the weight of the tool. Too much pressure can generate excessive heat and may harm the wheel. CBN grinding grains are as hard as diamond grains and will do the work for you without any effort and in a very short time.

**Maintenance:** None. The CBN wheel never needs truing or dressing.

**Fitting Instructions :** The diagram below shows the correct assembly of the CBN wheel onto a Bench Grinder, The wheel can be mounted on either the right or left side of the bench grinder. If fitting on the left, assemble in a mirror image of this drawing.

The recessed side of the wheel faces outward.

The flat side of the wheel is manufactured at 90 degrees to the coated periphery. If using a bore adaptor bush, it should fit against this side.



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