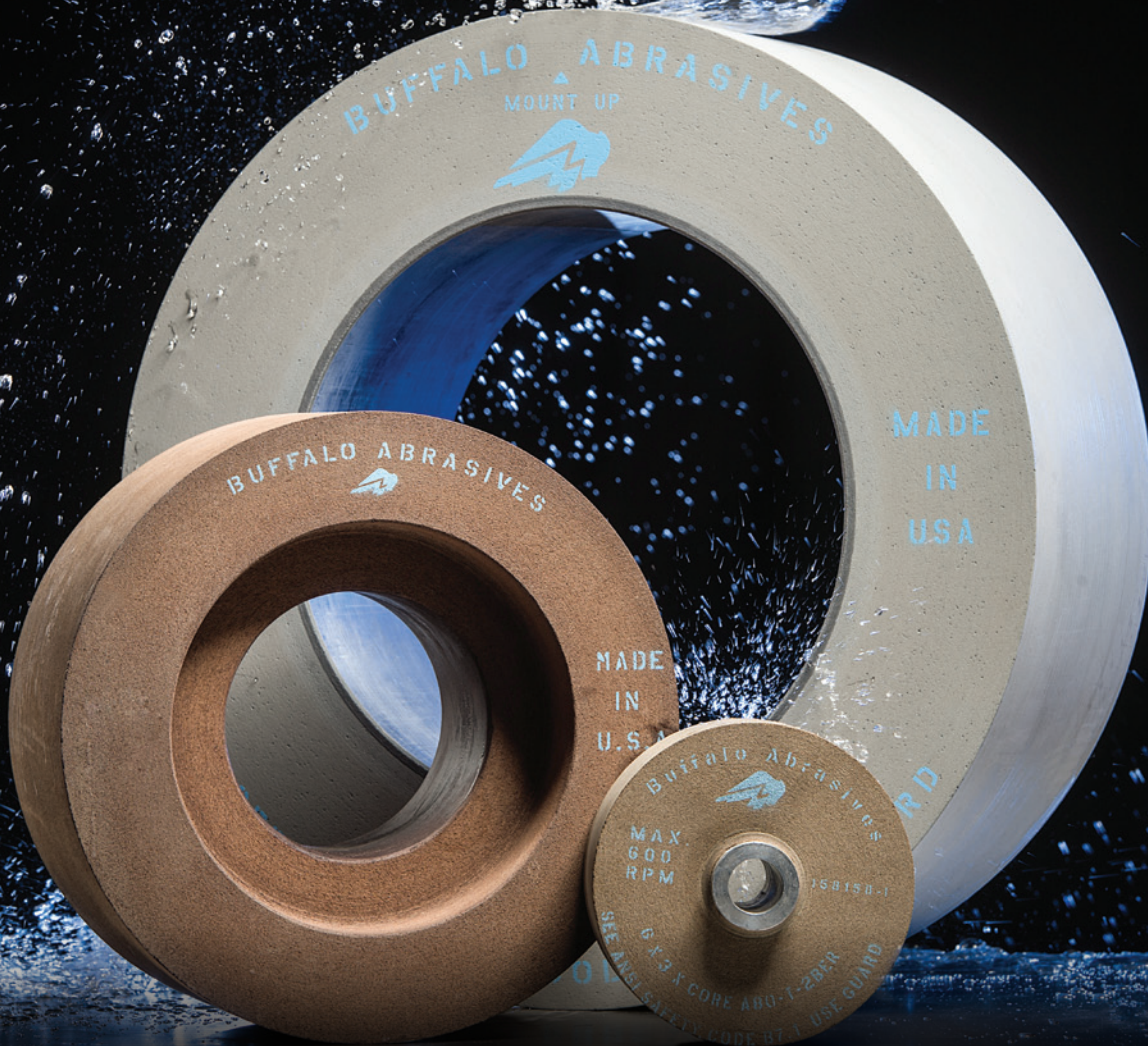




**Buffalo Abrasives**

Experience. Performance. Service.

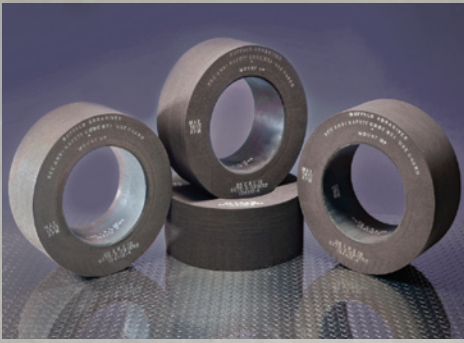


# CENTERLESS GRINDING & FEED REGULATING WHEELS

[BUFFALOABRASIVES.COM](http://BUFFALOABRASIVES.COM) | 888-311-3856



# BUFFALO ABRASIVES

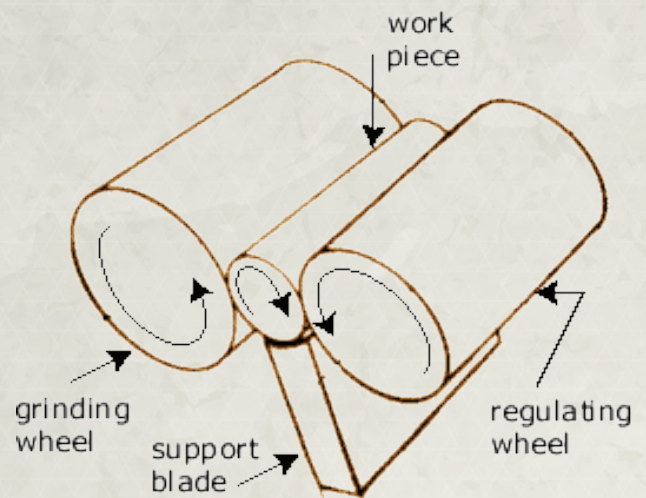


## CENTERLESS GRINDING wheels

### Diameters through 24"

- Thicknesses through 10" (20" sets).
- Selection of phenolic resin, epoxy or vitrified bonds.
- High performance abrasive grain blend.

THRU-FEED APPLICATION   HELPFUL HINTS	
<b>Grinding Wheel</b>	<p>Use Buffalo specification based on application parameters.*</p> <p>For general purpose applications a 6-8" wide wheel will remove stock at 1 cubic inch per minute per 10 HP.</p> <p>Rough at 1/3 to 1/2 of wheel face per work revolution, finish at 1/6 to 1/3.</p>
<b>Regulating Wheel</b>	<p>Use Buffalo specified regulating wheel, rubber bonded—hardness &amp; grit may vary based on application.</p> <p>Use a 3 degree angle of inclination and a speed of 90-100 SFPM.</p>
<b>Dressing</b>	<p>Buffalo Grinding Wheel -use an impregnated diamond dressing tool at 10" per minute.</p> <p>Buffalo Feed Regulation Wheel—use a 1-2 carate single point diamond at 1-2 inches per minute.</p>
<b>Work Rest Blade</b>	<p>Work 1/2" diameter &amp; larger, use a blade angle of 20-30 degrees.</p> <p>Set work center above wheel centers 1/2 of work diameter (5/8" MAX)</p> <p>Use maximum blade thickness to avoid chatter.</p>
<b>Coolant</b>	<p>Use 5 gallons per inch of wheel width per minute and a high velocity nozzle.</p> <p>Coolant point of contact should be directly between workpiece and Grinding Wheel.</p>



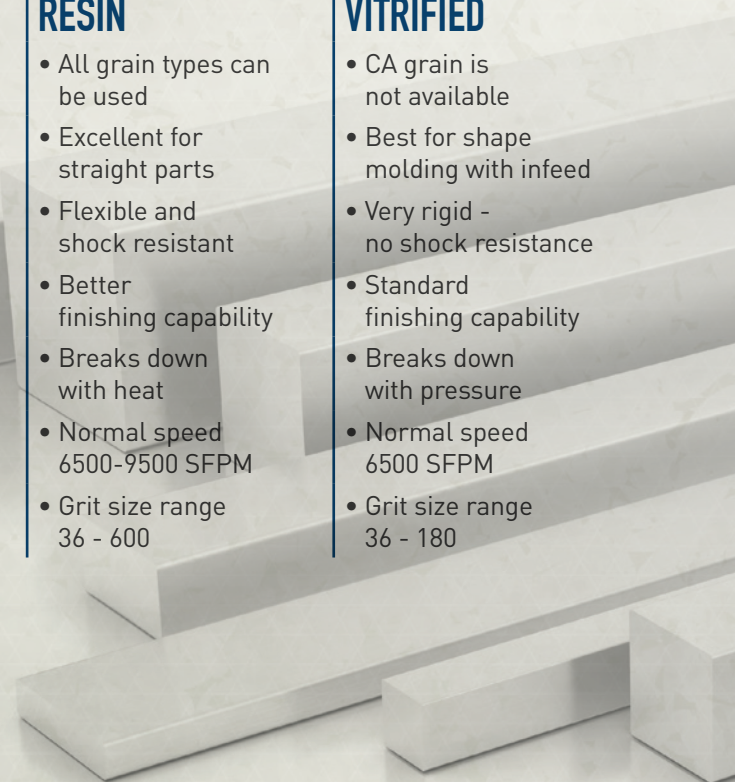
### RESIN

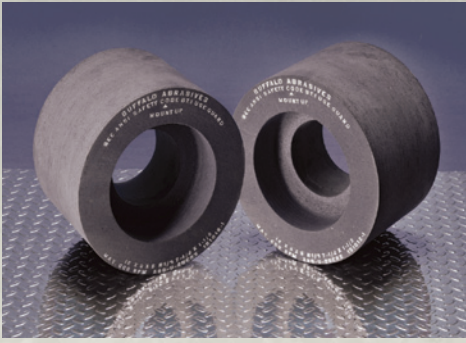
- All grain types can be used
- Excellent for straight parts
- Flexible and shock resistant
- Better finishing capability
- Breaks down with heat
- Normal speed 6500-9500 SFPM
- Grit size range 36 - 600

### VITRIFIED

- CA grain is not available
- Best for shape molding with infeed
- Very rigid - no shock resistance
- Standard finishing capability
- Breaks down with pressure
- Normal speed 6500 SFPM
- Grit size range 36 - 180

\*See quotation guideline on back of brochure





# FEED REGULATING wheels

## Standard Diameters 6" to 14"

- Complete Thicknesses Range including (20" sets).
- Metric Sizes — Full Range.
- Both Rubber and Epoxy Bonds — Customer Engineered.

PROGRAM STANDARDS			
DIAMETER	WIDTHS	HOLE	RECESSES
6	3-4	1-1/2	Specify
8	4	80 mm	Specify
8	6	90 mm	Specify
8	1-2-4	3	Specify
9	1-2-3-4	4	Specify
12	1-2-3-4	5	Specify
12	5-6-7-8-10	5	Specify
14	4-6-8	5	Specify
14	10-12-20*	5-6	Specify

GRADES	APPLICATIONS
A804-R-10RX	General Purpose
A80-R-10RX	Large Diameters
A804-S-8RX	Tight Tolerances
A80-T-2BER	Very Small Diameters

\* 2-10" sections

\*\*Standard Recesses Available - Please specify preferred recess.



Whatever finish or stock removal you require, Buffalo Abrasives can engineer and manufacture centerless grinding wheels to meet your specific needs.

Buffalo Abrasives has extensive experience and Success in the following applications/industries:

- Bearings
- Primary Non-Ferrous Materials
- Contract Thru-Feed Machining



# GRINDING WHEEL QUOTE

## basic information needed

Distributor: \_\_\_\_\_

Salesperson: \_\_\_\_\_

City/State: \_\_\_\_\_

Email: \_\_\_\_\_

### BUFFALO PRODUCT SOLUTION

- |  |   |
|--|---|
| <input type="checkbox"/> ROLL GRINDING                       | <input type="checkbox"/> NEEDLE POINT GRINDING            |
| <input type="checkbox"/> SNAGGING WHEELS                     | <input type="checkbox"/> MARBLE/GRANITE CUP WHEELS        |
| <input type="checkbox"/> FLUTE & THREAD GRINDING             | <input type="checkbox"/> CENTERLESS/REGULATING            |
| <input type="checkbox"/> CUT-OFF WHEELS W/ W/O REINFORCEMENT | <input type="checkbox"/> CYLINDRICAL W/ W/O REINFORCEMENT |
| <input type="checkbox"/> NUT INSERTED DISC – NID             | <input type="checkbox"/> NIAGARA BRAND – STANDARDS        |
|  | <input type="checkbox"/> OTHER                            |

#### Wheel Size

Diameter: \_\_\_\_\_ Width: \_\_\_\_\_ Hole: \_\_\_\_\_

Competitor Name: \_\_\_\_\_

Specification: \_\_\_\_\_

Shape:  T-1 |  T-2 |  T-5 |  T-6 |  T-7 |  T-11 |  T-12 |  T-13 |  T-20 |  T-21 |  T-22 |  T-23 |  T-26  
(check one)

Special face:  A |  B |  C |  D |  E |  F |  G |  H |  I |  J |  L |  N |  Y |  Z RPM: \_\_\_\_\_  
(check one)

Material Being Ground/Hardness: \_\_\_\_\_

Ordering Quantity: \_\_\_\_\_

DISTRIBUTED BY: