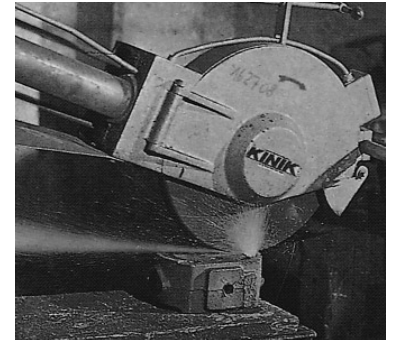
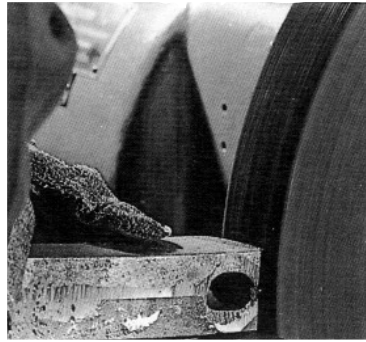


Foundry snagging is to get rid of the unwanted metal after casting, such as gates, risers, flashing, stubs, fins and parting lines. Since the tolerance is usually not critical, coarse and durable wheels are used. Foundry snagging wheels are widely used in the automotive, ship building and steel fabrication industries, and in general maintenance or repair shops, as well as in foundries, forging shops, and steel mills.

Benchstand, pedestal, floorstand and swing frame grinders are the machines used in foundry snagging.



Recommendations: For floorstand, swing frame and pedestal grinding machines.

Material	Max. speed Application	Vitrified (V):2000 m/min (33m/s)			Resinoid (B): 3000 m/min (50m/s)		
		Standard	Fast removal	Economic	Standard	Fast removal	Economic
Non-Ferrous Metal		C36-MV	C24-NV	C24-PV	C20-PB	C16-PB	AC20-PB
Ductile Iron		C24-QV	C20-PV	C24-RV	AC24-QB	ZC20-QB	AC24-QB
Iron Forgings		A30-PV	A24-PV	A30-QV	A24-PB	WA24-PB	A24-QB
Mild Steel		A24-QV	A24-PV	A36-QV	A24-QB	A20-PB	A20-RB
Gray Iron		C20-QV	C20-PV	C24-RV	AC20-PB	ZC16-QB	AC20-QB
Malleable Iron		A30-QV	A30-PV	A36-QV	A24-QB	A16-PB	A24-RB
Steel Castings		A24-QV	A24-PV	A36-QV	A20-PB	AC20-PB	A20-RB
Steel (hard types)		38A46-MV	38A36-MV	A36-PV	WA30-PB	WA24-PB	A30-PB
Stainless Steel		A24-PV	WA24-NV	A24-QV	WA24-PB	WA24-NB	WA24-QB
Welds		A30-PV	A24-PV	A30-QV	A24-QB	A24-PB	A24-RB

Note:

- AZ and ZC abrasives achieve higher stock removal rates in foundry snagging.
- Select harder grade and finer grit to grind small workpieces.
- 3600m/min(60m/s) & 4800m/min (80m/s) high speed wheels are available on request.
- Please specify the operating speed of wheels in your order.

Standard sizes & max. rpm.

D	T	H	Max. rpm.		D	T	H	Max. rpm.	
			Vitrified	Resinoid				Vitrified	Resinoid
2" (50mm)	3/8". 1/2"	3/8". 1/2"	12,732	19,099	10" (255mm)	1". 1-1/4". 1-1/2"	1". 1-1/4". 1-1/2"	2,497	3,745
2-1/2" (65mm)	3/8". 1/2"	3/8". 1/2"	9,794	14,691	12" (305mm)	1". 1-1/4". 1-1/2"	1". 1-1/4". 1-1/2"	2,087	3,131
3" (75mm)	3/8". 1/2"	3/8". 1/2"	8,488	12,732	14" (355mm)	1". 1-1/4". 1-1/2"	1-1/4". 1-1/2". 2"	1,793	2,690
4" (100mm)	1/2". 3/4". 1"	1/2". 3/4". 1"	6,366	9,549	16" (405mm)	1-1/4". 1-1/2". 2"	1-1/4". 1-1/2". 2"	1,572	2,358
5" (125mm)	1/2". 3/4". 1"	1/2". 3/4". 1"	5,093	7,639	18" (455mm)	1-1/4". 1-1/2". 2"	1-1/4". 1-1/2". 2"	1,399	2,099
6" (150mm)	1/2". 3/4". 1"	1/2". 3/4". 1"	4,244	6,366	20" (510mm)	2". 2-1/2". 3"	2". 6"	1,248	1,872
7" (180mm)	1/2". 3/4". 1"	5/8". 3/4". 1"	3,600	5,305	24" (610mm)	2". 2-1/2". 3"	6". 8". 12"	1,044	1,565
8" (205mm)	1/2". 3/4". 1"	5/8". 3/4". 1"	3,600	4,658	30" (760mm)	2". 2-1/2". 3"	6". 8". 12"	838	1,256

Note: 1. Additional size & specifications are available on request.

2. Please select resinoid wheels for portable & swing frame grinders for safety.

Fault Finding and Correction Guide

Problem	Possible Causes	Suggested Correction
1. Burning of workpiece	Not enough pressure. Wheel too hard. Wheel glazed.	Increase pressure or contact area. Use softer grade and/or coarser grit. Dress the wheel.
2. Wheel slows down	Pressure too high. Belt slippage. Wheel too hard.	Reduce pressure or contact area. Adjust and retighten belts. Use softer grade and/or coarser grit.
3. Wheel corners breaking down	Grit too coarse. Worn spindle bearings. Wheel too soft.	Select wheel with finer grit. Check spindle run-out and its bearings. Use harder grade of wheels.