

Date Evaluated

# PACER - Roll Wheel Evaluation

Evaluation #

Company

City

State

Personnel involved

Country

## Machine and Coolant:

Make, model  HP  Minimum wheel rpm avail.

One or two wheel machine  If two, were both used  Carriage loose, snug or locked

Wheel balanced before using  Impreg. or single point diamond, sharp?

Infeed automatic across roll, at ends of roll only, or manual

Condition of spindle, belts, etc. that can cause chatter  Grinding below center

Other settings and conditions

Coolant mfg., spec., condition  Type filters used

% Concentration  Refractometer  Flow into nip, onto roll or wheel

## Roll:

Material  Diameter  Face length  Crown

Hardness  Holes or slots  Method of supporting journals

Finish and appearance needed  Profile needed  Removal needed

Roughing, finishing or both  Sag or run-out  Type (use) of roll

Performance Factors:	Comparison Wheel	Evaluation Wheel
Wheel manufacturer	<input type="text"/>	<input type="text"/>
Wheel size (dia x width x hole)	<input type="text"/>	<input type="text"/>
Wheel specification	<input type="text"/>	<input type="text"/>
Wheel speed (rpm, setting)	<input type="text"/>	<input type="text"/>
Roll speed (sfm, rpm, setting)	<input type="text"/>	<input type="text"/>
Traverse speed (in/rev, min/pass, setting)	<input type="text"/>	<input type="text"/>
Infeed speed (min/thou, setting)	<input type="text"/>	<input type="text"/>
Amperage total and at idle	<input type="text"/>	<input type="text"/>
Chatter occurrence, if any	<input type="text"/>	<input type="text"/>
Profile results (end to end)	<input type="text"/>	<input type="text"/>
Finish (Ra) and appearance	<input type="text"/>	<input type="text"/>
Removed (total), wheel radius used (lost)	<input type="text"/>	<input type="text"/>
Removed (timed), hours, thou/hour	<input type="text"/>	<input type="text"/>
<b>Cu" per hr removal rate, "G" ratio</b>	<input type="text"/>	<input type="text"/>

Cu" per hr removal rate = (3.14 x start roll dia x removed,timed/2 x face) / hours

G ratio is Grinding wheel wear (cu" work removed / cu" wheel used)

G ratio = (3.14 x start roll dia x removed,total/2 x face) / (3.14 x start wheel dia x radius used x width) <--- Measure before + after from flange to od to get radius used

## Comments: