

DRESSING AND RESURFACING INSTRUCTIONS

Instructions For Original Dressing and Resurfacing of a Magnetic Chuck.

The bottom of the Chuck should be ground before the chuck is mounted in place, then the top is ground flat and parallel as mounted for use.

1. Place the chuck top down on the surface grinder table and block it to prevent sliding with the Hold Down Clamps bolted to the machine table, snug against the ends of the chuck. Then grind the bottom flat with a wheel that has been made free cutting or "Open" by dressing with a rather rapid and moderately heavy cut taken across the face of the wheel with the diamond. Type of wheel is not critical for grinding either chuck bottom or top, though a wheel with K. O. Lee Designation PV7GM46 for K. O. Lee Surface Grinders using 7" wheels and PV8JM46 for K. O. Lee Surface Grinders using 8" wheels, or equivalent has been found most desirable for exacting requirements.

2. Place chuck top up in final position it is to be mounted on machine table. Clamps should only be tightened sufficiently to keep the chuck from moving on the table.

3. Put Chuck in "on" position.

4. Dress top of chuck to clean up, again using "open" wheel. Width of wheel face doing grinding should be limited to about 1/2" by dressing excess width away with diamond or stone. Use adequate coolant flow or spray mist if machine is not equipped with coolant. Maximum depth of cut of .0003" and traverse feed of 3/8" per stroke are recommended.

5. When the top of the chuck has been cleaned up, take the final pass under the same conditions except that depth of feed should be .00005" to .0001". There should be no effort to "Spark Out" on the top of the chuck after the last pass has been taken. Optimum flatness is best attained by avoiding any polishing or burnishing effect when dressing the top as local hot spots and distortion may result. A "commercial" grind finish is also preferable to a "mirror" finish as it provides the best coefficient of friction for non-slip magnetic holding of critical workpieces.

6. Check results by Five (5) Block Test, in other words, one test block ground at each corner of chuck and one in center with fixed wheel height. Total difference in thickness of block should be within specified limits of the Machine Manufacturer.

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