

Bonded Abrasive troubleshooting guide

Symptom	Problem	Solution
Wheel not cutting	Wheel glazing (shiny look)	Use a softer grade wheel. Use a coarser grain wheel. Use a more powerful tool and always grind in a rocking motion. Remaining in the same spot too long will cause the material to overheat and glaze the wheel. Apply more pressure on the operation but without reducing the tool's RPM. Reduce pressure if the tool's RPM slows down. Use a higher grinding angle. Use the wheel on a sharp work piece to unglaze.
Low removal rate	Wheel too hard / glazing	Use a softer grade wheel. Use a more powerful tool. Apply more pressure on the operation but without reducing the tool's RPM.
	Low performance wheel	Use a higher performance wheel made with harder and sharper grains.
Excessive wheel wear	Wheel too soft	Use a harder grade wheel. Use a better designed wheel.
Wheel loading (material sticks to wheel)	Perhaps cutting non-ferrous materials	Use coarser grain wheel. Use a softer grade wheel or one specifically designed for the material (such as for non-ferrous metals).
Uneven wear	Too low angle	Dress wheel and use a steeper angle.
	Uneven wheel thickness	Use a balanced wheel.
	Wheel too thin	Use a thicker wheel or one made for grinding operations.
Wheel edge not holding	Wheel too coarse	Use a finer grain wheel.
	Wheel too thin	Use a thicker wheel.
	Wrong wheel	Use a wheel made for grinding applications or better designed.
	Wheel too soft	Use a harder wheel grade.
	Improper working angle	Use proper angle, shallow angle cause breakage. See label info for proper angle
	Improper use	Face grinding causes breakouts - stop operation.
Edge burning / fraying	Wheel too hard	Use a softer grade wheel.
	Machine too weak	Use a more powerful tool. Check extension cords as light gauge cords will add ampere to the tool, thus reducing the power.
	Operation on the same spot	Use a slow rocking motion to dissipate heat.
Burning of work piece	Wheel too hard	Use a softer grade wheel or specifically designed for the material.
	Insufficient pressure	Increase pressure on work piece to increase material removal. Use a slow rocking motion to dissipate heat. Use a more powerful tool.
Wheel vibrates	Unbalanced wheels	Use a balanced wheel.
	Uneven flanges	Use new straight flanges as both need to be of the same diameter.
	Improper mounting / clamping	Mount wheel sitting flat and centered in clamping flanges.
	Work piece not secured	Work on a safely clamped work piece and as close to the clamp as possible.
Wheel breakage	Wheel speed too high Improper mounting / clamping Wheel jams on work piece Excessive wheel pressure on work Too much side pressure Wheel damaged in handling	Stop all operations. Investigate wheel breakage and correct the cause. If impossible, communicate problem to manufacturer.