

## FETTLING WHEELS

Fettling wheels with specially formulated bond systems are ideally suited for heavy duty grinding applications such as removing unwanted metal on castings, removing flaws and cracks, gates, risers and parting lines. The robust nature of these grinding applications requires the grinding wheel to be designed, manufactured and tested in accordance with European standard E.N.12413 (safety requirements for bonded abrasives). As an added safety precaution steel reinforcing rings are moulded into the wheel in the manufacturing process.

Choosing the right abrasive grit is key to the optimum performance of stock removal and surface finish and delivery of the lowest unit grinding cost. Most ferrous materials are ground with wheels made with brown aluminium oxide grain but increasingly zirconium alumina grit is added to achieve increased production rates. Cast iron and non ferrous materials require wheels manufactured from silicon carbide grit. The grit size range for most foundry grinding is 12grit through to 24grit mainly 12g and 14g for larger castings, 14g and 16g for medium castings and 16g, 20g and 24g for smaller castings.

Fettling wheels are formulated to be very hard to cope with the robust and unforgiving nature of the job in hand. It should be noted that unless the machine is of the multi-speed type, the peripheral speed of the wheel will decrease as it wears down, thereby altering the grinding action. The grain depth of cut increases and the wheel acts softer. The coarser the grit, in conjunction with an open structure, the more rapid will be the rate of stock removal.

Cup wheels for portable machines, Cones & plugs together with Cutting Off wheels are also available offering you a single source supply.



Phoenix Naylor's Abrasives Ltd.  
Bridge Way, Broombank Rd  
Chesterfield Trading Estate,  
Chesterfield, S41 9QJ

Phone: (0) 161 320 9580

Fax: (0) 161 335 9074

Email: [info@phoenixabrasives.co.uk](mailto:info@phoenixabrasives.co.uk)

[www.phoenixabrasives.co.uk](http://www.phoenixabrasives.co.uk)

ISO 9001-2015