



SWSI

Southern Welding Systems International LLC

Welding | Industrial | Safety

International Wholesale Distribution

Contact us for Pricing:

Phone: 281-485-9772 | Fax: 281-485-4386

Email: Sales@swsintl.com | Website: www.swsintl.com

Address: 3908 1st Street Pearland, Texas 77581

Troubleshooting

	TROUBLE	CAUSE	SOLUTION	
Snagging Wheels	Poor stock removal rate	Insufficient pressure applied Wheel too coarse or hard	Increase pressure to use all power available Use finer grit and/or softer grade wheel	
	Grinding costs too high (or wheel costs too high)	Wheel acting too soft Insufficient power to support pressure	Use coarser and/or harder grade wheel Buy larger grinder	
	Wheel loading or glazing	Grade too hard Grit too coarse	Try softer grade Try finer grit	
	Wheels "dusty"	Wheels too soft	Try harder grade	
	Wheel doesn't hold corner	Wheel too coarse Wheel too soft	Use finer grit Use harder grade	
	Burning of work piece	Not enough pressure Wheel too hard Wheel face loaded	Increase amount of pressure or reduce contact area Use softer grade and/or coarser grit wheel Dress to open wheel face	
	Finish rough	Wheel too coarse	Try finer grit size	
	Wheel slows or stalls	Pressure too high Belt slippage Wheel too hard	Reduce pressure or reduce contact area Adjust and retighten belts Use softer grade wheel	
Cut-Off Wheels	Poor cutting rate	Insufficient power being used Wheel too hard Contact area too large Wheel too coarse Wheel out of side truth	Increase feed or pressure to pull full power Use softer wheel or thinner wheel Reduce contact area to minimum Use finer grit wheel Check spindle and wheel side run-out	
	Poor quality cut	Non square cuts Work piece burn Wheel too coarse Wheel too hard	See Non-square cuts below See Work piece burn below Use finer grit wheel Spasmodic wheel breakdown Use softer wheel	
	Non-square cuts	Work not clamped properly Misaligned spindle bearings Poor coolant distribution Wheel too hard	Check clamp and clean to remove swarf Check for bearing truth and alignment Ensure equal volume of coolant to each wheel side Use softer acting wheel – softer grade/finer grit	
	Work piece burn	Insufficient feed rate Poor coolant flow Wheel too coarse Wheel too hard Wheel running out Wheel speed too slow	Work machine to maximum power available Increase volume and direct at cutting point Use finer grit wheel or pull more power Use softer grade wheel Check spindle and clock wheel side truth Ensure no wheel slippage and maximum speed being used	
	Poor finish	Too much burr Wheel too coarse	Use finer grit or softer wheel Use finer grit	
	Portable Grinding	Poor stock removal rate	Insufficient pressure applied Wheel too coarse or hard	Increase pressure to use all power available Use finer grit and/or softer grade wheel
		Grinding costs too high (or wheel costs too high)	Wheel acting too soft Insufficient power to support pressure	Use finer grit and/or harder grade wheel Buy larger grinder
Wheel loading or glazing		Grade too hard Grit too fine	Try softer grade Try coarser grit	
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Finish rough		Wheel too coarse	Try finer grit size	