

LESSON PLAN

Roll Grinding in a Paper Mill

- I. GRINDING WHEELOLOGY
- II. ROLL GRINDING VARIABLES
 - A. Spindle Speed
 - B. Infeed
 - C. Traverse Speed
 - D. Roll Speed
 - E. Coolant
 - F. Wheel Diameter
 - G. Temperature
 - H. Swingrest Adjustment
 - I. Roll Roundness
 - J. Roll Profile
- III. GRINDING WHEELS
 - A. Basic Components
 - B. Selection
 - C. Dressing
 - D. Balancing
 - E. Storage
 - F. Spin-Out
- IV. ROLL GRINDING GENERAL
 - A. Roll Speeds
 - B. Wheel Speeds
 - C. Swingrest Procedure
- V. MAINTENANCE
 - A. Lubrication
 - B. Belt Tension
 - C. Safety

- VI. COOLANTS
 - A. Water
 - B. Soda Ash
 - C. Water Soluble Oils
 - D. pH
 - E. Application
- VII. SURFACE FINISH
 - A. Measurement
 - B. Equipment
- VIII. ROLLS
 - A. Measurement & Tolerances
 - B. Diameter
 - C. Profile
 - D. Crowning
 - E. Dubbing
- IX. NEWSLETTERS
 - A. Swingrest Adjust Procedure
 - B. Auto Profile Caliper
 - C. Maintenance
 - D. Roll Setup
 - E. Stock Removal
- X. ROLL GRINDER
 - A. Inspect
 - B. Adjust
 - C. Grind