

# Cut-Off Wheel General Operating Recommendations

**Fixture the work-piece**  
to minimize wheel contact area  
for a faster, cooler cut.

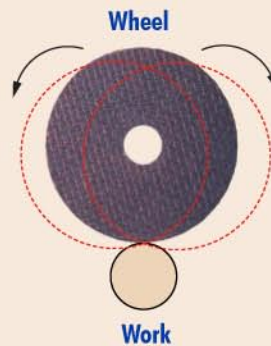


**Incorrect**  
(Wide contact point)



**Correct**  
(Two small contact points)

**Use an oscillating head**  
when cutting thicker cross  
sections (over 3"). This reduces  
arc of contact and permits  
larger sections to be cut with a  
given diameter wheel.



**Counter rotation  
of the work-piece**  
is recommended for  
cutting large cross sections  
(over 8") and when  
cutting tubular stock.



## Operation Guide

<b>Grain</b>	To maximize performance, run at or close to the Maximum Safe Free Speed or RPM. NEVER EXCEED the MSFS or RPM.
<b>Feed Rate</b>	Only the operator can determine if the feed rate is proper for an efficient operation. A good starting point for dry cutting most materials is 2-3 seconds per square inch.

## Application Solutions Guide

There are many variables in using Cut-Off Wheels. If the product you are using does not accomplish the desired results, select a solution from the suggestions below for your specific application or call Weiler's **Application Engineering Hotline at 888-299-2777**.

Problem	Cause	Recommended Solutions
<b>Slow cut rate</b>	• Insufficient power being used	• Increase feed rate; run machine at full power
	• Contact area too large	• Reduce contact area
	• Side run out	• Check for spindle run out
	• Wheel binding	• Provide relief under part
<b>Workpiece burn</b>	• Insufficient feed rate	• Increase feed rate
	• Wheel speed too slow	• Check for wheel slippage
	• Wheel too coarse	• Use finer grit or increase power
<b>Non-square cuts</b>	• Work not properly fixtured	• Support both sides and fixture properly
	• Worn spindle bearings	• Check spindle
<b>Too much burr</b>	• Improper fixturing	• Check part fixturing
	• Grit too coarse	• Use a finer grit

**Safety**  Abrasive users and others in area must wear goggles or face shields over safety glasses. Safety guards must be used. Do not exceed maximum RPM.