

## CHAPTER II

### Typical Operations

The operations shown in this chapter are representative of the various types of work performed on these machines. While no attempt has been made to describe each job in detail, the main features of set-up and operation are outlined as a guide to good grinding practice.

Operations shown utilize available additional equipment as well as equipment furnished with machine. Operations within the capacity of the No. 510 machine can be performed with ease and efficiency.

Fig. 7. Set-up for side wheel grinding, at right, shows the flexibility of the wheel guard.

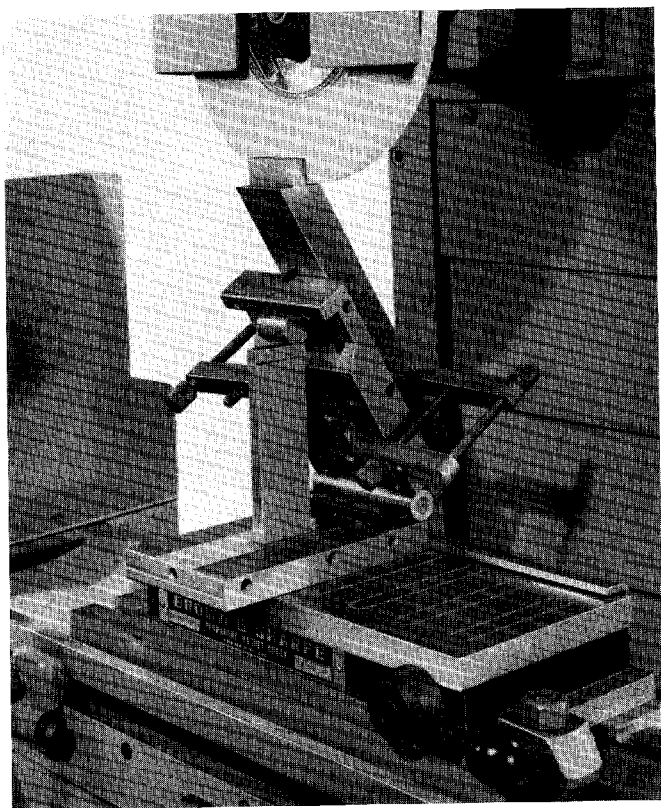
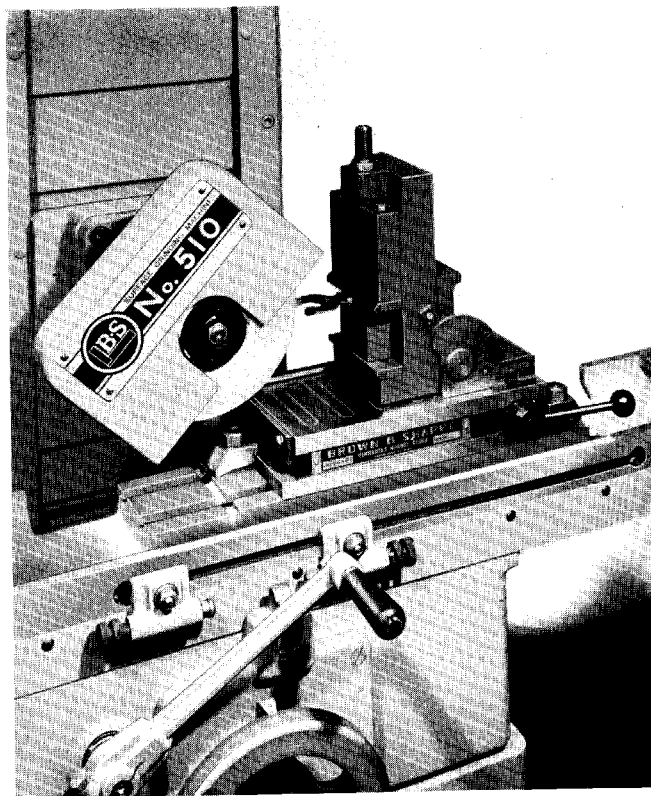


Fig. 8. Illustration at left shows the vertical capacity of machine. With the table sliding in fixed bed ways, conditions are ideal for this operation.

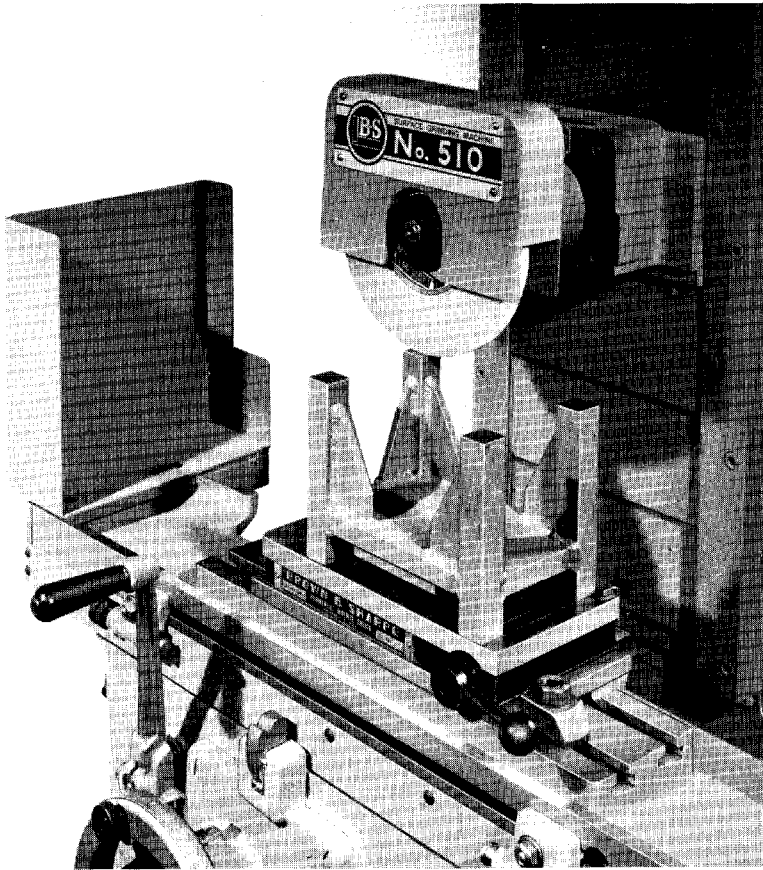
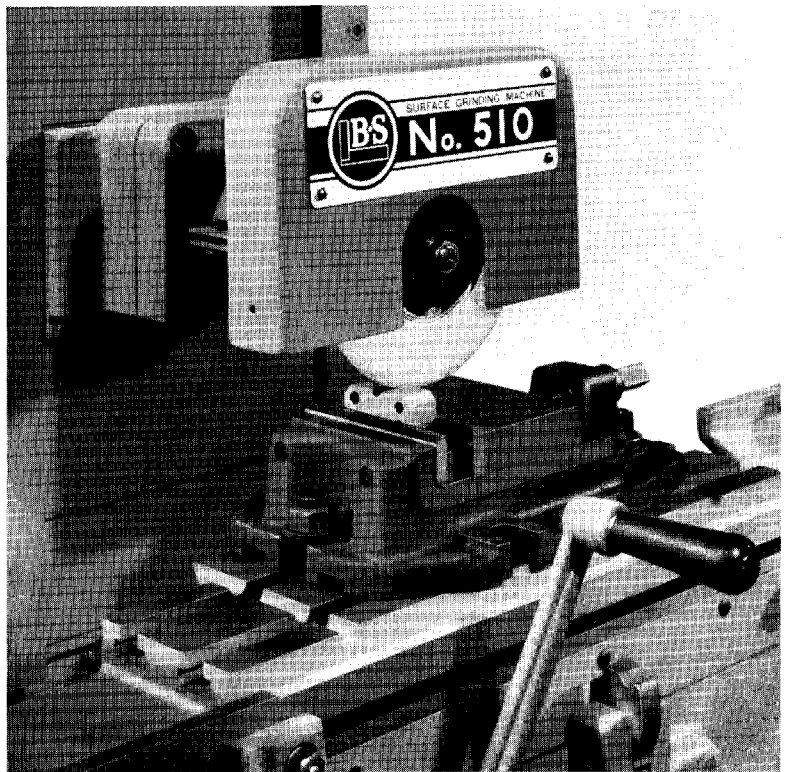


Fig. 9. Finishing four jig legs to uniform height. In grinding narrow, widely separated surfaces as shown, time is saved by grinding one surface at a time. All four surfaces are ground each time before the wheel is lowered for the next cut.

Fig. 10. The table sliding in fixed bedways is advantageous for short, fast strokes.



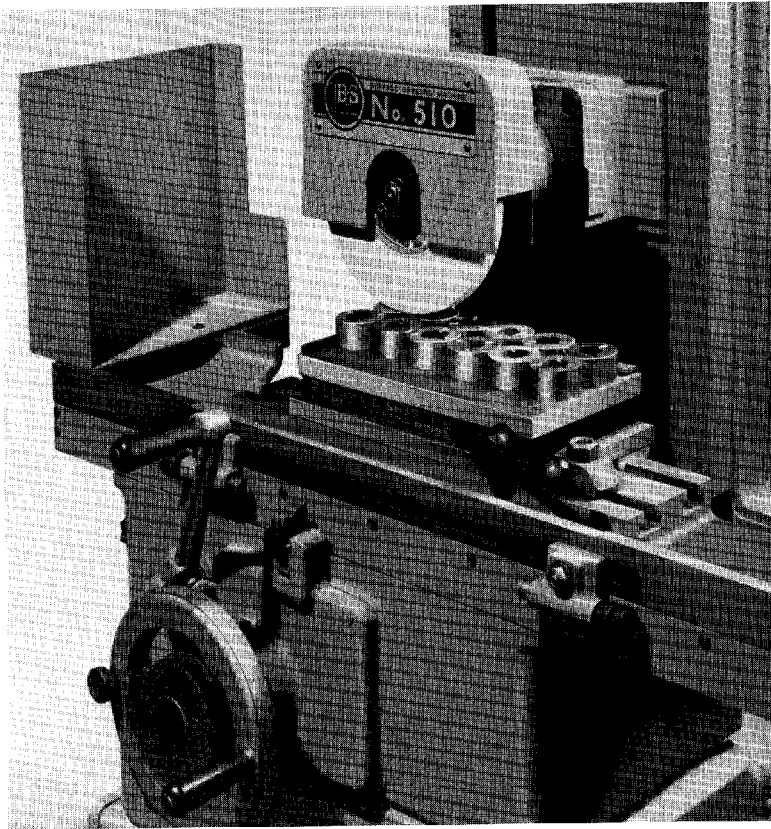


Fig. 11. A representative production job-grinding the surfaces of twelve pieces with one loading of the permanent magnet-type chuck.

Fig. 12. Movable wheel slide upright contributes immeasurably to accurate slot grinding.

