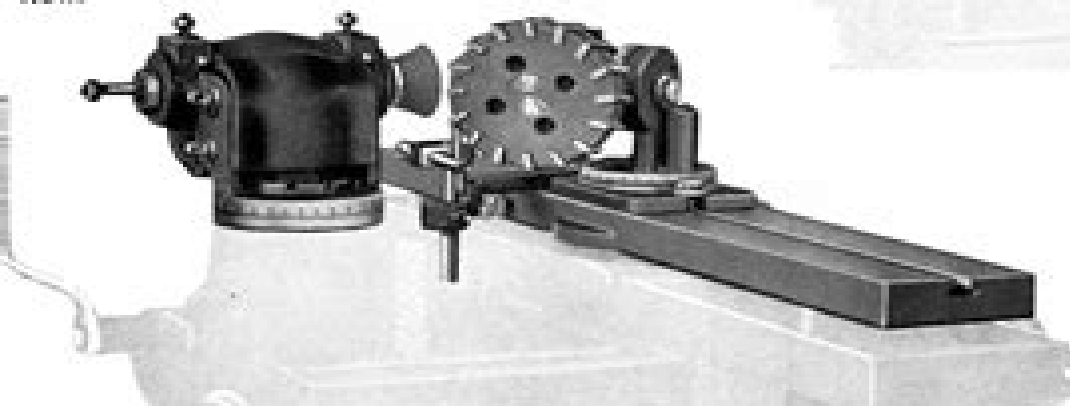
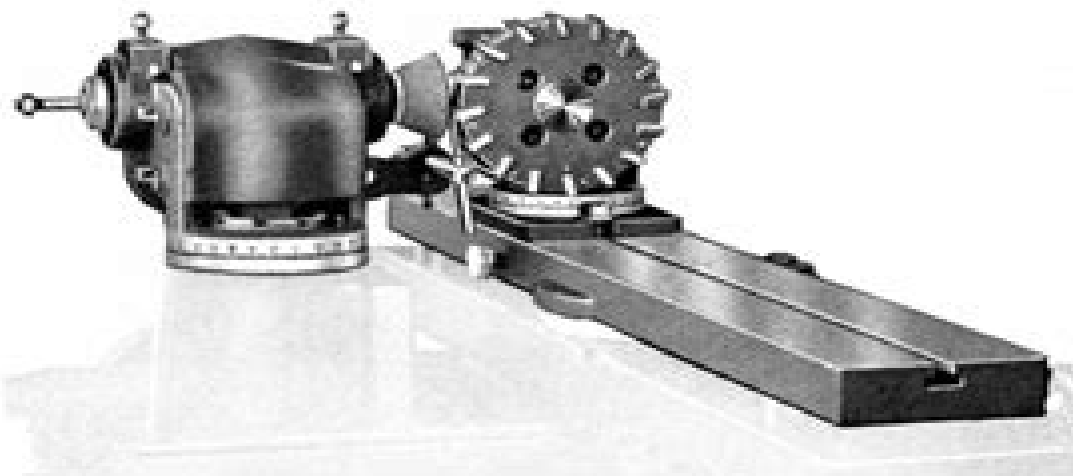


FACE MILL GRINDING

It will be observed that in grinding face mills on the Grand Rapids No. 3 and No. 4 Universal Grinders, they are rigidly mounted in a taper bearing in the universal headstock. This headstock is bolted solidly to the table, giving a mounting of the cutter that eliminates all tendency to chatter such as would be present if the face mill were mounted on a taper shank, which in turn was supported only by a V bearing and clamp with the resultant three-point line contact bearing. In grinding the face, the swivel block is tilted to the required angle to provide the desired clearance, the degree of angular setting being read on the graduated swivel block.

In grinding the periphery, the universal headstock bearing is set at a right angle to the wheel spindle, as illustrated, and the clearance is provided by setting the spring tooth rest so as to either raise the tooth being ground above center or lower it below center, depending on whether the cutter be left hand or right hand. Where the diameter of the cutter is too great to allow swinging over the table, as illustrated, the cutter is mounted the same as for grinding the face and then the table is swivelled 90° to provide the same relation between the cutter and the wheel as shown in this view.



For grinding the corner angles the universal headstock is swivelled on its base to the required angle and the clearance is provided by a combination of the two clearance settings described above for straight face and periphery settings.

The best milling practice calls for an approximately round corner which is provided by first grinding the corner at 45 degrees and then grinding both the corners thus formed at about 22½ degrees as read from the face and periphery respectively.

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D Keegan



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