

Trouble Shooting Guide

STL-SG-001 STYLE -SB

118 X 40.50 X 200
(4.64"x1.59"x7.87")
110/90 X 45 X 200
(4.33"x3.54"x1.11"x7.87")
100/85 X 38 X 200
(3.93"x3.34"x1.49"x7.87")
117/88 X 45 X 200
(4.60"x3.46"x1.77"x7.87")

STL-SG-002

100 X 65-57 X 60-33
(3.93"x2.55"-2.24"x2.36"-1.29")

STL-SG-011

60/65 X 20 X 65
(2.36"/2.55"x0.78"x2.55")
84/80 X 24 X 120
(3.30"/3.14"x0.94"x4.72")
19.5 X 80 X 70
(0.76"x3.14"x2.75")
150 X 80/71 X 25
(5.90"x3.14/2.79"x0.98")

STL-SG-004

98 X 105 X 52
(3.85"x4.13"x2.04")

STL-SG-005

74.61/61.91 X 90.48 X 50.8
(2.93"/2.43"x3.56"x2")

STL-SG-006

225 X 80 X 20
(0.98"x3.14"x0.78")

STL-SG-007

125 X 60/25 X 15
(4.92"x2.36"/0.98"x0.59")
64.3/38 X 20 X 60
(2.53"/1.49"x0.78"x2.36")

STL-SG-008

222.25/155.58 X 76.2 X 304.8
(8.75"/6.12"x3"x12")

STL-SG-009

173.03 X 38.1 X 127
(6.81"x1.5"x5")

STL-SG-003 STYLE -SC

103.19/84.14 X 38.1 X 152.4
(4.06"/3.31"x1.5"x6")
203.2 X 84.14/103.19 X 38.10
(8"x3.31"/4.06"x1.5")
185 X 62/56 X 20
(7.28"x2.44/2.20"x0.87")
87/103.5 X 38 X 200
(3.42"/3.54"x1.49"x7.87")

STL-SG-010

334 X 19.4 X 32
(13.1"x0.76"x1.25")

STL-SG-016 STYLE -SE

90 X 50.45 X 16
(3.54"x1.96"-1.77"x0.62")
125/85 X 35 X 140
(4.92"/3.34"x1.37"x5.51")
68/57 X 30 X 130
(2.67"/2.24"x1.37"x5.11")
100 X 45/50 X 16
(3.93"x1.77"/1.96"x0.62")

STL-SG-012 STYLE -STG

31 X 127
(1.22"x5")

STL-SG-013 STYLE -BL

170.06 X 45 X 46
(6.69"x1.77"x1.81")

STL-SG-014

6-1/2" / 4-1/2" X 2-1/4" X 9"

STL-SG-015 STYLE -SC

305 X 222/130 X 95
(2.54"x8.75"/5.11"x3.74")
107.16 X 44.45 X 254
(4.21"x1.75"x10")

STL-SG-017 STYLE -SO

92.08/68.27 X 24.05 X 142.08
(3.62"/2.68"x0.94"x5.59")

STL-SG-018

120/80 X 44.5 X 200
(4.72"/3.14"x0.17"x7.87")

STL-SG-019 STYLE -CD

285.75 X 57.15 X 152.4
(11.25"x2.25"x6")
285.75 X 57.15 X 203.2
(11.25"x2.25"x8")
11-1/4"x3"x8"

STL-SG-020 STYLE -SO

103/94 X 38 X 180
(4.05"/3.70"x1.49"x7.08")
57/65 X 25 X 105
(2.24"/2.55"x0.98"x4.13")
100/85 X 40 X 150
(3.93"/3.34"x1.57"x5.90")
152.4 X 84.14/103.19 X 38.10
(6"x3.31"/4.06"x1.5")
103-94 X 38 X 180
(4.09"x1.49"x7.08")

STL-SG-021 STYLE -AA

10-15/16" X 2-9/16" X 6"
11-5/16" X 2-9/16" X 6"
10-15/16" X 2-11/64" X 6"

STL-SG-022 STYLE -SA

117.48 X 73.025 X 247.65
(4.62"x2.87"x9.75")
1.332" X 3.50" X 7-3/4"
152.4 X 152.4 X 100
(6"x6"x3.93")

STL-SG-023 STYLE -NO

127 X 38.1 X 200
(5"x1.5"x7.87")
66.04/55 X 30.54 X 100
(2.6/2.16"x1.20"x3.93")

Segment Acting Too hard/Burning/Low Stock Removal

- 1) Increase rate of automatic downfeed
- 2) Decrease table rotation speed
- 3) Dress more frequently
- 4) Reduce area of table load (If more than one piece is being ground, or step grind)
- 5) Check coolant for maximum flow
- 6) Use softer segment specification

Segment Acting Too Soft/Changing Segments Too Frequently

- 1) Decrease rate of automatic downfeed
- 2) Increase table rotation speed
- 3) Check for abnormal machine vibration caused by improper mounting of segments or excessive build-up of sludge on inside of segment holder
- 4) Use harder segment specification

Poor Surface Finish

- 1) Decrease table speed
- 2) Slow finish downfeed rate and spark out
- 3) If grinding dry, try grinding wet
- 4) Check coolant for maximum flow
- 5) Check coolant for excessive contamination
- 6) Use finer grit segment

Recommendations For Reducing Grinding Costs Per Piece

- 1) Select abrasives type best suitable to material being ground
- 2) Use coarse grit size such as 24 or 30 grit whenever possible – use sparkout to obtain required finish
- 3) Select the hardest grade that will not burn the workpiece or cause machine power over load
- 4) Select softer grade for general purpose applications or to grind a wide variety of materials
- 5) Select the highest maximum downfeed that will not burn the workpiece, prematurely break down the segment, or cause machine power overload