

## NUT INSERTED DISC MOUNTING & DRILLING INFORMATION

### MOUNTING

Before mounting a Nut Inserted Disc it should be tapped lightly with a mallet near the outer edge. A clear sound indicates that the disc is all right. Inspect all inserts for foreign material. Studs should be checked for straightness, soundness and battered threads. The back of the abrasive disc should be clean and flat. The steel disc wheels must be clean, flat, free from grinding swarf and burrs. When mounting abrasives on steel disc wheels, start all of the screws, then center the abrasives on the steel disc wheels. (Locating holes eliminates the necessity of centering.) Tighten all screws in each bolt circle together, starting with the inside row. Inserts should be tightened with from five (5) to ten (10) foot-pounds of torque. A standard allen wrench should be used to tighten the screws snugly. Do not use long pipes or hammers these wrenches will distort the metal around the holes in the steel disc wheel.

### DRILLING

The American Standards Association has approved hole spacing for the mounting of abrasive discs on disc grinding machines. This is designated as "A.N.S.I. Drilling" and, with a few exceptions, is the standard used.

DRILLING - CYLINDER TYPE DISCS

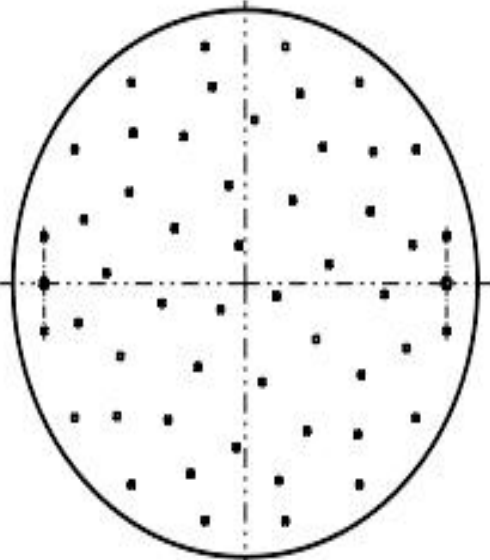
Disc Diameter	A.N.S.I. Drilling				
10"	6 on 8"	3 on 4-1/2"			
12"	6 on 10-1/2"	3 on 4-3/4"			
14"	8 on 12"	4 on 7"			
15" & 16"	10 on 12-3/4"	5 on 7-1/2"			
18"	10 on 14-3/4"	5 on 11"	5 on 8"	3 on 4"	
20"	12 on 17"	6 on 12"	6 on 8"	3 on 4-1/4"	
22" & 23"	12 on 20"	6 on 18"	6 on 14"	6 on 8"	3 on 5-1/4"
24"	12 on 22"	6 on 18"	6 on 13"	6 on 8"	
26"	14 on 22-1/2"	7 on 16-3/4"	7 on 15"	3 on 4-1/4"	
30"	16 on 26-1/2"	12 on 22"	12 on 18"	8 on 11"	3 on 4-1/4"

DISC DIAMETER	DRILLING
10"	6 on 9"
11"	6 on 10"
12"	8 on 11"
14"	8 on 12"
16"	8 on 14"
18"	8 on 16"
20"	12 on 18"
22"	12 on 20"
24"	16 on 22"
26"	16 on 24"
28"	16 on 26"
30"	16 on 28"

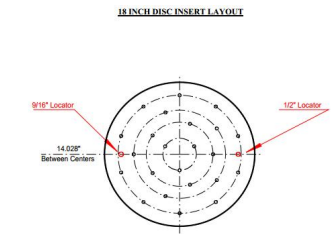


### LOCATING HOLE

Locating holes (sometimes called dowel pin holes) usually consist of a 1/2" locator and a 9/16" locator in the center of a chord drawn between two inserts on the outer bolt circle. They are placed diametrically opposite each other.

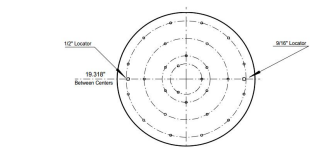


Positioning the locating holes on a chordal line will give an uneven dimension between centers of the two locaters, i.e. 25.9906" for the 30" standard. When recording a locating hole measurement, report the size of the two holes and how they line up with adjacent inserts.



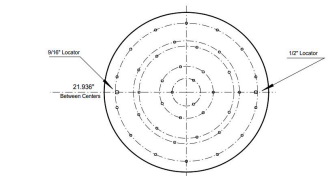
ID	Outer Row	Next Row	Next Row	Next Row
0 - 2	10 on 14-3/4	5 on 11	5 on 8	3 on 4
+2 - 6	10 on 14-3/4	5 on 11	5 on 8	
+6 - 9	10 on 14-3/4	5 on 11		
+9	10 on 14-3/4			

21 INCH DISC INSERT LAYOUT



ID	Outer Row	Next Row	Next Row	Next Row	Next Row
0 - 3	12 on 20	6 on 18	6 on 14	6 on 8	3 on 5-1/4
+3 - 6	12 on 20	6 on 18	6 on 14		
+6 - 12	12 on 20	6 on 18	6 on 14		
+12 - 16	12 on 20	6 on 18			
+16	12 on 20				

26 INCH DISC INSERT LAYOUT



ID	Outer Row	Next Row	Next Row	Next Row	Next Row
0 - 2	14 on 22-1/2	7 on 16-3/4	7 on 15	7 on 8-1/2	3 on 4-1/2
+2 - 6	14 on 22-1/2	7 on 16-3/4	7 on 15	7 on 8-1/2	
+6 - 13	14 on 22-1/2	7 on 16-3/4	7 on 15		
14	14 on 22-1/2	7 on 16-3/4			
+14	14 on 22-1/2				