

Template: adapt to your own procedure and risk assessment

Abrasive wheel change on a fixed grinder

When: mounting a new wheel on a bench or pedestal grinder. Only people who have been trained and appointed to mount abrasive wheels should do this.

BEFORE YOU START

The replacement wheel, the correct flanges and blotters, the right spanner, and eye protection.

STEPS

- 1 ☐ **Isolate the grinder** and lock it off.
- 2 ☐ **Check the wheel's markings.** Its maximum operating speed must be the same as or higher than the spindle speed on the machine's plate, and its size and bore must match the machine.
- 3 ☐ **Check the expiry date** if the wheel is resin-bonded and has one marked.
- 4 ☐ **Inspect the wheel** for chips, cracks and damage. For a vitrified wheel, do a ring test: hold it by the bore and tap it lightly with a non-metallic tool. A clear ring is good; a dull sound means it must not be used.
- 5 ☐ **Check the flanges.** Clean, flat, undamaged and matching in diameter.
- 6 ☐ **Mount the wheel** with the blotters in place. It should slide onto the spindle without forcing. Never enlarge the bore.
- 7 ☐ **Tighten the nut** only enough to hold the wheel firmly, following the manufacturer's instructions.
- 8 ☐ **Refit and adjust the guards.** Set the work rest as close to the wheel as practicable and set the tongue guard to the manufacturer's setting.
- 9 ☐ **Run it up.** Remove your lock, stand to one side and run the wheel at full speed for at least a minute with everyone clear of the line of the wheel.
- 10 ☐ **Sign off** and record the wheel change.

Stop and report if the wheel's speed rating is lower than the spindle speed, the ring test sounds dull, or a guard is missing or damaged.

TOOLBOX TALK

- Why do we stand to one side when a new wheel is first run up?
- Who on this site is appointed to change wheels?

- What happens if the work rest gap is too wide?

Further reading: HSE HSG17, Safety in the use of abrasive wheels. PUWER 1998.

ADAPTED AND APPROVED FOR THIS SITE

Site and equipment

Procedure or RAMS reference

Approved by (competent person)

Date and review date
