

GRINDING BEFORE PLATING

Provide a surface that is as good as or better than you would like to have after plating and grinding.

- **GROUND AND POLISHED SURFACE IS BEST**

- ▶ Maximum radii (Round edges and corners)
 - ▶ No evidence of 'Heat checks' or grinding burn
 - ▶ Eliminate chatter & deep grind lines
 - √ Very important for .010" thick + buildups
 - ▶ Allow for .002" thick minimum when grinding after plating
 - ▶ Heat treat before plating for some materials
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GRINDING AFTER PLATING

- Use a soft to medium grade Aluminum Oxide wheel
 - WET GRINDING: Recommended
 - Use as large amount of coolant as possible
 - Depth of Cut: Do not exceed .0002" feed or .0004" total stock removal in a single pass.
 - ▶ We use .0001/.00015" feed or .0002/.0003" total as a general rule.
 - ▶ The slower the better! (Avoid Overheating)
 - DRY GRINDING: *Not* Recommended
 - If necessary, do not exceed by 1/2 the rules above.
 - No spark - slower the better - avoid heating
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