

Centerless Training Course



**CENTERLESS
REBUILDERS, INC.**

**Classes are offered
at various times
throughout the year.
For more information,
contact Michelle at
michellek@gmail.com
or call (800) 249 8103**

Centerless Grinding Principals & Practices



Increase your Productivity...

To enhance the centerless grinding operations used in manufacturing. CRI has developed a 3-day training program for engineers and operators. The training consists of a theoretical session coupled with hands-on sessions. The theoretical session will be in a classroom setting. For the hands-on session, CRI will make centerless grinders available.

Topics Covered:

- Basic principles of the centerless grinding process
- Roundness generation and parameters
- Workpiece configuration and roundness
- Centerless grinding machine errors and effect on roundness
- Measuring technology for geometry
- Force, vibration, and chatter
- Regulating wheel profile for infeed and thrufeed grinding
- Grinding wheel profile
- Design of tooling: cams, workrest blades
- Thermals and set-up stability
- Infeed grinding of stepped work pieces
- Thrufeed grinding of rollers, pins, and short shafts
- Thrufeed bar grinding
- Thrufeed grinding of under square work- pieces (bearing races, valve seats, etc.)
- Application of correct regulating wheels
- Centerless grinding process design
- Advance CBN technology

Hands-on Session

- Preventative Maintenance
 - Slide and dresser gib adjustments
 - Reg spindle bearing adjustment
 - Zero recalibration of grinder
- Setting height above center
- Setting feed angle and regulating wheel truing angle
- Truing grinding and regulating wheels
- Setting grinding gap in thrufeed grind
- Adjusting the swivel plate for taper
- Setting guides in thrufeed grinding
- Setting Grind and set-up correction

You will Receive:

- Centerless Grinding Technology and Practice Handbook.
- Access to online service to assist in calculating setup parameters for your operation.
- Lunch provided by CRI
- Discounted hotel rate (contact Michelle at CRI for more Information)

Classroom Training Location:

Fairfield Inn & Suites
45800 Marketplace Blvd
Chesterfield, MI 48051

Hands-on Training Location:

57877 Main Street,
New Haven, MI 48048

Registration:

Please E-mail Michelle at
michellek@centerless.net
Please provide:

- Company name and address
- Participants name and email address

Cancellation Policy:

Full refunds for cancellations received in writing via email at least 3 days before the event. Cancellations within 3 days of event or no-shows are not eligible for a refund



The duration of the training program is three days. One day for classroom and one-and-half days for hands-on. Class size limited to 18 students.

