

# GRAINLOCK

Description: A cold abrasive cement

Uses: Grainlock CS is a general purpose cement for use with grain sizes 180 to 320 or finer.

Grainlock HD or GB are recommended for the most severe services, essentially for grain sizes 50 to 150.

## **Suggested Directions for use of Grainlock:**

1. Clean face of wheel thoroughly, removing all traces of grease, glue or foreign matter.
2. Stir thoroughly before use.
3. For best results, a sizing coat of Grainlock is recommended. Brush the sizing into the face of the wheel until it is saturated. Air dry for half an hour, then dry at 65°C for one hour. Allow wheel to cool to room temperature before setting up. Sizing penetrates into the face of the wheel, creating a stronger bond for the heads of cement and abrasive which follow.
4. Apply first head of cold cement straight from the containers by brushing thoroughly into the face of the wheel. Roll wheel in the abrasive grain and allow it to air dry sufficiently before adding a second coat of grain. Again allow to air dry, this time for half an hour, before placing it in a drier for the final curing.
5. The recommended times in the drier for curing are: Grainlock CS 16 hours at 65°C, and Grainlock HD and GB 20 hours at 65°C.
6. Before placing the wheel on the spindle, break up the surface by gently tapping the face of the wheel with a round bar. A well-broken face will aid in cutting.

7. Never let set-up wheels wear down to the nap. Always leave a little cushion head when ready for re-setting. This saves time and reduces the amount of product required for a new sizing coat as well as leaving the wheel firm and more durable.
8. Wheels should be thoroughly dried after setting up. Drying can be carried out in air for at least 24 hours or in heated driers. In all cases, free circulation of air is required to give uniform temperature and optimum conditions.