

Technical Notes

Metal Bond Shaping Wheel

The Alpha® Metal Bond Shaping Wheel is designed for the initial shaping process on automatic edge polishing machines and is ideal for the preliminary polishing stage on edge treatments for countertops, tabletops and vanities. It shapes and calibrates straight edges and bullnoses or profiles on machines such as the Park® Pro Edge and Marmo Meccanica (Multiple-head). Easy to use, the Alpha® Metal Bond Shaping Wheel is long lasting and provides high quality performance. It is a heavy-duty wheel developed to remove deep saw marks with ease. Fabricators will love the perfect edges they achieve with the Alpha® Metal Bond Shaping Wheel. Adaptable for use on most automatic edge polishing machines, the Alpha® Metal Bond Shaping Wheel is available in 5/8"-11, M24 or M18 threads. A mechanical stop is recommended to control the depth of cut. Alpha® Metal Bond Shaping Wheels are a must for automatic edge polishing machines.

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Part No.	Size	Maximum RPM	Arbor	Grit
TW55850M	5"	3,500	5/8"-11 Threaded	50
TW52450M	5"	3,500	24mm	50
TW51850M	5"	3,500	18mm-2	50

How to Use

SINGLE HEAD AUTOMATIC POLISHER

1. Consult your operations manual for the proper set-up procedures.
2. Setup the stone on the single-head edge polishing machine.
3. Attach the Alpha® Metal Bond Shaping Wheel onto the spindle of the machine.
4. Set the Hard Stop/Mechanical Stop on the machine for use of the wheel.
5. Adjust the movable Cross-Travel Flags so the Metal Shaping Wheel travels off the stone. The Metal Shaping Wheel should travel two inches off the material on both sides.
6. Adjust the head pressure setting to the desired setting suitable for this wheel.
7. Set traverse speed.
8. Set the mitre step degree.
9. Provide water and proceed with the grinding stage.

MULTI HEAD AUTOMATIC POLISHER

1. Consult your operations manual for the proper set-up procedures.
2. Attach the Alpha® Metal Bond Shaping Wheel onto the spindle of the machine. This wheel is available in thread sizes of 5/8"-11, M18 and M24.
3. Set the Hard Stop/Mechanical Stop on the machine for use the wheel. The Mechanical Stop should be adjusted so the wheel is 1/16" higher than the edge of the stone. (Please note the Metal Shaping wheel should be placed in the head prior to the first resin polishing wheel).
4. Adjust the head pressure setting to the desired setting suitable for this wheel.
5. Set the belt speed.
6. Provide water and proceed with the grinding/calibration stage.

Frequently Asked Questions (FAQs)

What is the recommended Mitre settings using the Metal Bond Shaping Wheel?

This will depend on the thickness of the material and the type of single-head line polisher in your shop. (Consult the machine's operation manual for these settings.)

What materials can the Alpha® Metal Bond Shaping Wheel be used on?

This wheel can be used on granite and Engineered Stone.

On what applications can I use the Alpha® Metal Bond Shaping Wheel?

This particular wheel can be used for creating contour shapes and calibration of flat edges.

What is the recommended RPM for the Alpha® Metal Bond Shaping Wheel?

See chart on page 1.

What is the recommended BAR pressure?

This wheel should always be used with the HARD STOP/MECHANICAL STOP activated. There is no recommended BAR pressure for this particular wheel.

What is the recommended Traverse Speed?

For use on a single-head polisher: 50 ft per minute.

For use on a multiple-head polisher: 1 ft per minute.

Which Alpha® abrasive should follow the Metal Bond Shaping Wheel?

- o 4" Twincur #100 grit
- o 4", 5" and 6" Twincur EB and ES #200 grit
- o 4" and 6" Twincur GB #200 grit.
- o 5" Twincur EG-S and EG-V #80 grit.

Does the Alpha® Metal Bond Shaping Wheel come in SFAT (Snail Lock) style?

No. Alpha® only offers this Shaping Wheel for use on threaded spindles.

What thread sizes are available for the 5" Metal Shaping Wheel?

See chart on page 1.

Helpful Hints

- Consult your operation manual for proper set-up of tooling.
- The Alpha® Metal Bond Shaping Wheel is WET USE ONLY.

Reference

For more product information, visit us on the web at www.alpha-tools.com.