

How to Order Sopko Precision, Hardened, and Ground Wheel Adapters.



America's Largest Manufacturer of Precision Grinding Wheel Adapters.

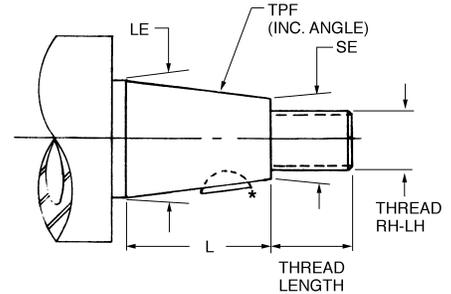
STEP 1

DETERMINE THE TAPER OF THE SPINDLE THE ADAPTER WILL BE USED ON.

The following formula can be used to determine the spindle taper per foot (TPF):

Measure the large end of the spindle taper (LE).
 Measure the small end of the spindle taper (SE).
 Measure the length of the spindle taper (L).
 Calculate taper per foot (TPF).

$$\frac{LE - SE}{L} \times 12" = TPF$$



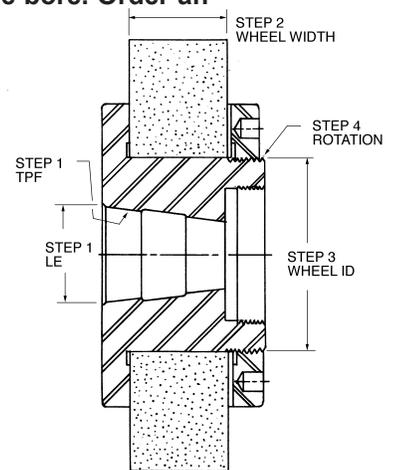
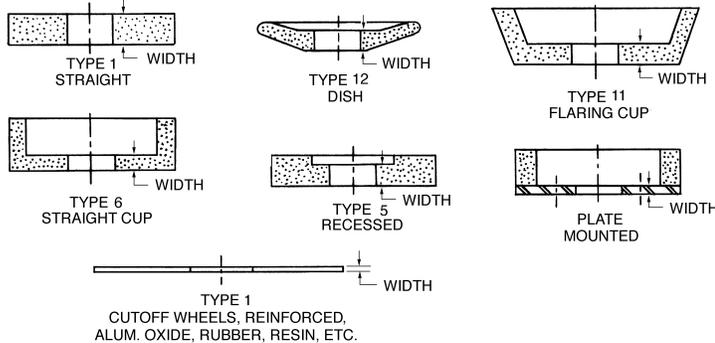
* Is there a keyway in the taper? Specify the width of the keyway.

As a general rule, 3.000" TPF adapters fit surface grinders and cylindrical grinders, and 4.500" TPF adapters fit tool and cutter grinders.

STEP 2

DETERMINE THE WIDTH OF THE GRINDING WHEEL TO BE "LOCKED."

When ordering adapters it's important to understand the meaning of the term "wheel width to be locked." The term refers to the width of the grinding wheel at the bore and should not be confused with the overall width of the wheel. First determine the type of wheel to be used, then measure the width of the wheel at the bore. Order an adapter to lock the measured wheel width.



Grinding wheel size is stated as OD X width X ID (7" X 1/2" X 1-1/4").

STEP 3

DETERMINE THE INSIDE DIAMETER OF THE GRINDING WHEEL.

The common wheel bore sizes are 1-1/4", 2", 3", 5", and 8".

Special wheel ID adapters and metric ID wheel adapters are available.

STEP 4

DETERMINE WHEEL ROTATION (VIEWED FROM WHEEL END).

If the grinding wheel is being clamped with a nut, select an adapter with right hand (RH) threads if the spindle is rotating counter clockwise (CCW), and left hand threads (LH) if the spindle is rotating clockwise (CW). The only exception to this rule is cup wheel mounting where RH threads are used for CW spindle rotation and LH threads are used for CCW rotation because the nut is on the reverse side.

This page is intended to be photocopied and used to compile important data. Use the drawings to note your specific dimensions as accurately as possible; then phone or fax us with the information.