

# CBN Flywheel Grinding Wheels Instructions

## GOODSON

**Tools and Supplies for Engine Builders**

156 Galewski Drive • P.O. Box 847 • Winona, MN 55987-0847  
Toll-Free 1-800-533-8010 • Local 507-452-1830 • [www.goodson.com](http://www.goodson.com)

# ECBN-200, 225, 250, 300, 4 & 6

**Please read instructions before using.**

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## Instructions

1. Thoroughly clean the machine and install clean water with new change of coolant. **MUST BE USED WITH CLEAN GRINDING COOLANT.**
2. Do not dress your wheel with the dresser attachment on your machine. When the wheel starts to load up and make noise, try a heavier cut of .010" or .015". If the wheel still makes a screaming noise (or loaded sound), take the dressing stick that came with the wheel, or better yet an old flywheel stone and hold it to the face (cutting edge) of the wheel, while it is turning, for a few seconds, which will unload the wheel. Then continue to cut flywheels.
3. Use plenty of clean coolant when cutting.
4. Hand feed the wheel until it makes contact with the flywheel, then feed down .005" to .010" per turn (continuous-do not wait for wheel to spark out) until the flywheel surface becomes clean, back off .008" to .010" and let wheel spark out for best finish.

Do not baby the wheel, it must be worked to perform properly.

**MUST BE USED WITH CLEAN COOLANT!**

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