

L-14: Polish Center

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- Be careful. The abrasive head of the center polishing machine rotates at high speed, and can throw off grit.

EQUIPMENT

- Part with unsatisfactory center recess
- Center polishing machine
- Polishing cloth cone

RESOURCES

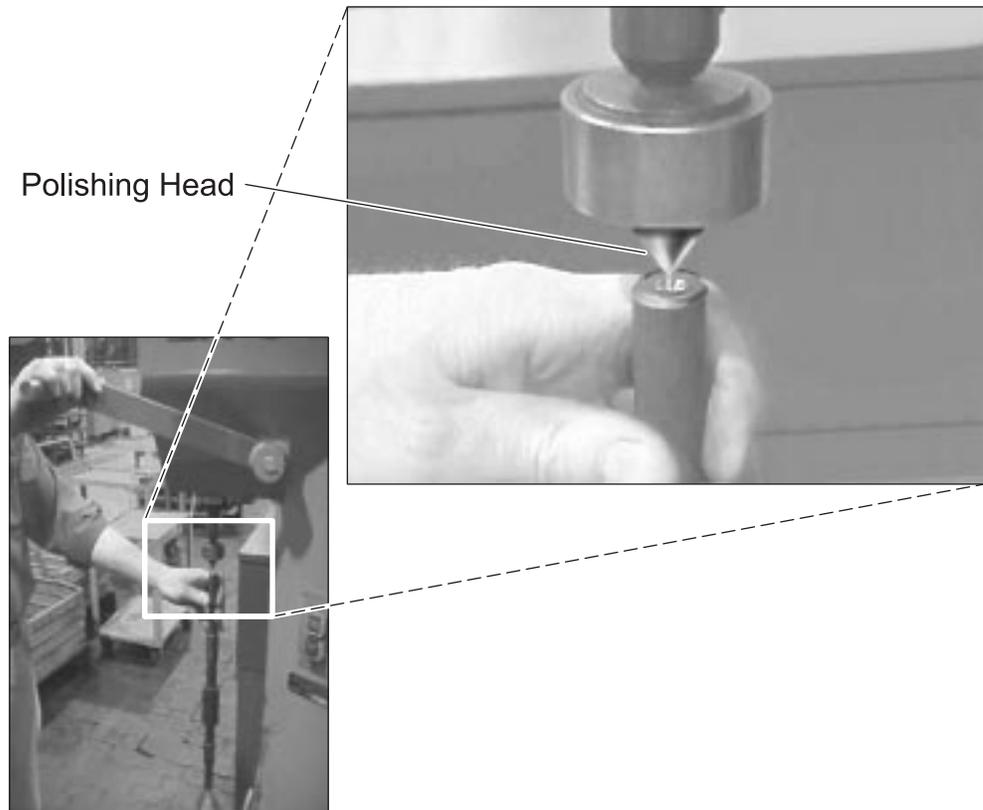
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Polish Center

Note: This is done first on all jobs except jobs that have been across the Center Grinder. Check process sheet.

1. **Inspect and clean the center recesses of all parts before installing them between centers on a grinding machine.**
2. **If a center recess will not wipe clean with a rag, or shows scoring, rust, scale, nicks, or burrs, take it to the center polishing machine.**
3. **Select a suitable abrasive head for the center recess.**
4. **Replace the polishing cloth cone on the abrasive head if scored or otherwise damaged.**
 - Unscrew the holding collar and remove the old abrasive cloth.
 - Place a new abrasive cloth over the head and screw the holding collar down on it.
5. **Adjust the tailstock on the center polishing machine for the length of the part.**
6. **Stand the part vertically on the tailstock work center.**

7. Turn on the abrasive head drive.
8. Hold the part centered under the abrasive head.
9. Lower the abrasive head into the part center recess as shown below.



Lining Up the Polishing Head and the Part

10. Hold the part to keep it from turning, but do not apply any lateral force to the part while the abrasive head is cleaning the center recess.

Note: The center polishing machine is intended for cleanup only, not to create or enlarge a center recess or remove significant stock.

11. Inspect the polished center recess. Repeat step 6 until the surface is smooth and bright.