

Table 1: Vertical Spindle Disc Grinder Exhaust – Hood and Branch Pipe Connections

Dia D. Inches		Exhaust E		Volume Exhausted	
		No.		at 4,500 ft/min.	
Min.	Max.	Pipes	Dia.	ft ³ min.	Note
	20	1	4 1/2	500	When one-half or more of the disc can be hooded, use exhaust ducts as shown at the left.
Over 20	30	2	4	780	
Over 30	72	2	6	1,770	
Over 53	72	2	8	3,140	
	20	2	4	780	When no hood can be used over disc, use exhaust ducts as shown at the left.
Over 20	30	2	5 1/2	1,480	
Over 30	53	4	6	3,530	
Over 53	72	5	7	6,010	

Entry loss = 1.0 slot velocity pressure + 0.5 branch velocity pressure