



$Q = 500 \text{ cfm/wheel, minimum}$

Not less than 250 cfm/ft^2 total open area

Minimum duct velocity = 3500 fpm, 4500 fpm if
material is wet or sticky

$$h_e = 1.78 VP_s + 0.25 VP_d$$

On small, 2 or 3 spindle machines, one take-off may be used.
Multiple take-offs desirable.

Note:

1. Consult applicable NFPA standards, Reference 10.80.2
2. Caution: Do not mix ferrous and non-ferrous
metals in same exhaust system.



TITLE

CIRCULAR AUTOMATIC
BUFFING

FIGURE

VS-80-34

DATE

02-91