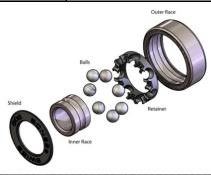


case study #1006

**Centreless Grinding Wheel** 

Workpiece:	Ball Bearing Outer
Operation:	Through-feed Centreless Grinding
Machine:	Lidkoping
Material/Hardness:	Bearing Steel 62-65 HRC
Cutting speed (grinding wheel):	45m/s
Stock Removal:	0.4mm on Diameter single pass
Grinding wheel:	01_610x102x305 made in 6 pieces
	FSW 54-1 K6 VC11 2x Section 1
	FSW 60-1 K6 VC11 3x Section 1
	FSW 100 K6 VC11 1x Section 1
Dresser:	Multi-point Stationary
Dressing Frequency:	Every 1500 seconds
Coolant:	Emulsion 4%
Surface Finish:	0.2 Ra
Improvement:	Improved wheel life
	Improved process stability
	Improved surface finish



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