

MASTER®

CASE STUDY #1002


Vitrified CBN Grinding Wheel

Workpiece:	Hydraulic Pump Casing
Operation:	I/D grind internal profile
Machine:	Emag
Material/Hardness:	Steel @ 60-64 HRC
Cutting speed (grinding wheel):	45m/s
Stock Removal:	0.55mm on radius
Grinding wheel:	IS 40 X 80 X 20 X=5 with 6 slots CB114-76-125-V-325424
Dresser:	Metal Bond Disc
Grinding time:	10 mins
Coolant:	Emulsion 4-6%
Improvement:	<ul style="list-style-type: none">• More open wheel face after dressing• Less burning and size problems• Increased parts per dress• Longer wheel life



SOLUTIONS FOR INDUSTRY

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