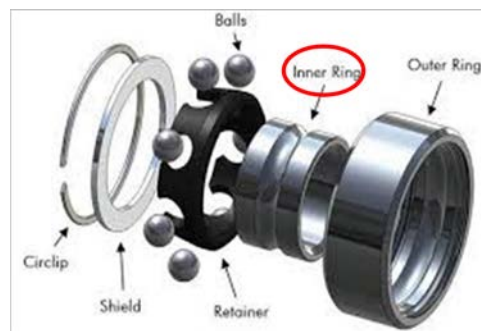


MASTER®

CASE STUDY #1003


Vitrified CBN Grinding Wheel

Workpiece:	Bearing Track – Inner Ring
Operation:	O/D grind bearing track
Machine:	Bryant
Material/Hardness:	Bearing Steel @ 63 HRC
Cutting speed (grinding wheel):	40m/s
Stock Removal:	0.2mm on Diameter
Grinding wheel:	14F1 350x13x127 X=9 R=2 CB51-54-100-V338092
Dresser:	Full Form Profile Roller
Grinding time:	25 seconds
Coolant:	Neat Oil
Improvement:	<ul style="list-style-type: none">• Converted from conventional wheel• Less burning and size problems• Greatly increased parts per dress• Longer wheel life



SOLUTIONS FOR INDUSTRY

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