

MASTER®

CASE STUDY #1004


Vitrified CBN Grinding Wheel

Workpiece:	Injector Control Valve
Operation:	I/D grind small bore
Machine:	Bahmuller
Material/Hardness:	Steel @ 60 HRC
Cutting speed (grinding wheel):	11m/s
Stock Removal:	0.08mm on Diameter
Grinding wheel:	14F1 350x13x127 X=9 R=2 CB51-54-100-V338092
Dresser:	Meister hDD dressing disc
Grinding time:	60 seconds
Coolant:	Neat Oil
Improvement:	<ul style="list-style-type: none">• Reduced dressing amount• Improved parts per dress• Improved process stability• Overall cost saving on abrasive usage



SOLUTIONS FOR INDUSTRY

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