

MASTER®

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:	<ul style="list-style-type: none">• Improved wheel life• Improved process stability• Improved surface finish



SOLUTIONS FOR INDUSTRY