

MASTER®

CASE STUDY #1007


Creep Feed Grinding Wheel

Workpiece:	Pump Rotor
Operation:	Creep Feed Grinding
Machine:	Blohm
Material/Hardness:	Sintered Steel 68 HRC
Cutting speed (grinding wheel):	45m/s
Stock Removal:	0.2mm per side
Grinding wheel:	01_400x12x127 PA120 J10 VSC
Dresser:	Stationary
Dressing Frequency:	Every Part
Coolant:	Emulsion 4%
Surface Finish:	0.08 Ra
Improvement:	<ul style="list-style-type: none">• Improved Wheel Life• Improved Surface Finish



SOLUTIONS FOR INDUSTRY

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