

MASTER®

CASE STUDY #1008


External Grinding Wheel

Workpiece:	Steering Worm Shaft O/D Grinding
Operation:	O/D Grinding
Machine:	Custom made
Material/Hardness:	20MnCr5 @ 58-62 HRC
Cutting speed (grinding wheel):	50m/s
Stock Removal:	0.4mm
Grinding wheel:	01_400x10x127 3CG 60 J 8 V32
Dresser:	Stationary
Dressing Frequency:	Every Part
Coolant:	Emulsion 4%
Surface Finish:	4 Rz
Improvement:	<ul style="list-style-type: none">• Improved wheel life• Improved surface finish



SOLUTIONS FOR INDUSTRY

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