

MASTER[®]

CASE STUDY #1009


Cylindrical Grinding Wheel

Workpiece:	Shaft O/D Grinding
Operation:	O/D Grinding
Machine:	Paragon CNC
Material/Hardness:	Steel @ 55-65 HRC
Cutting speed (grinding wheel):	45m/s
Stock Removal:	0.3mm on Diameter
Grinding wheel:	01_500x150x203 2CG 80 L 8 VC8
Dresser:	Stationary Single Point
Dressing Frequency:	Every Part
Coolant:	Emulsion 4%
Surface Finish:	0.4 Ra
Improvement:	<ul style="list-style-type: none">• Improved wheel life• Reduced cycle times



SOLUTIONS FOR INDUSTRY

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