

# MASTER®

## CASE STUDY #1010

### Centreless Grinding Nozzles

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|--|---|
| <b>Workpiece:</b>                      | Ball Bearing Outer  |
| <b>Operation:</b>                      | Through-feed Centreless Grinding  |
| <b>Machine:</b>                        | Lidkoping   |
| <b>Material/Hardness:</b>              | Bearing Steel 62-65 HRC   |
| <b>Cutting speed (grinding wheel):</b> | 45m/s   |
| <b>Stock Removal:</b>                  | 0.4mm on Diameter single pass   |
| <b>Grinding wheel:</b>                 | 01_610x102x305 Made in 6 pieces<br>FSW 54-1 K6 VC11 2x Section 1<br>FSW 60-1 K6 VC11 3x Section 1<br>FSW 100 K6 VC11 1x Section 1                     |
| <b>Dresser:</b>                        | Multi-point Stationary  |
| <b>Dressing Frequency:</b>             | Every 1500 seconds  |
| <b>Coolant:</b>                        | Emulsion 4%   |
| <b>Surface Finish:</b>                 | 0.2 Ra  |
| <b>Improvement:</b>                    | <ul style="list-style-type: none"><li>• Improved Wheel Life (2 weeks)</li><li>• Reduced part temperature</li><li>• Increased drive friction</li></ul> |



**SOLUTIONS FOR INDUSTRY**