

MASTER ABRASIVES

CASE STUDY

#1010

Centreless Grinding Nozzles

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 (2 weeks)• Reduced part temperature• Increased drive friction

CONTACT US FOR MORE INFORMATION

MASTER
ABRASIVES

T:01327-703813

sales@master-abrasives.co.uk

www.master-abrasives.co.uk