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Centerless grinding machine	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 33 (6494 fpm) - rpm: 1020		
Grinding wheel	Specification: ZB25B	Dimensions mm. 610 x 355 x 304,8 (inches 24x14x12)	
Regulating wheel	Specification: AZ80VRR	Dimensions mm. 305 x 355 x 140 (inches 12x14x5,5)	
Dressing tool	Diamond tool bit		
Work piece	Shaft for electric motors		
Material	UNI 35SMnPb 10	DIN	AISI/SAE 11L37
Hardness			
Initial dimensions of work piece	Ø mm. 15,20 (.597")	Lenght mm. 224,00 (8,81")	
Final dimensions of work piece	Ø mm. 15,02 (.590")	Lenght mm. 224,00 (8,81")	
Stock removal	Total mm. 0,18 (.007")	Roughing removal mm. 0,18 (.007") one pass	
Feed rate	Roughing	mt/min' 1,68 (66 ipm)	
Dimensional tolerances	Straightness Parallelism Roundness		
Surface finish	Ra	Rt	Rz
Dressing cycle	Dressing depth	mm. 0,025	(.001")
	Dressing speed	mm. 350/min'	(13,78"/min)
	Dressing frequency	every 8 hours	
	Reason of the dressing	restore surface and reduce Ra	
Coolant	Water soluble coolant with 3% semi-synthetic oil Ph 8		
Notes	<p><i>This grinding wheel performs the roughing of the shafts and is located on the 1st centerless machine, positioned after the first grinder. A second centerless grinder performs the finishing (see the sheet nr. 3)</i></p> <p><i>The life of this ZB25B grinding wheel has been one year, working 16 hours a day.</i></p>		