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Centerless grinding machine	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 45 (8856 fpm) - rpm: 1400		
Grinding wheel	Specification: ZB	Dimensions mm. 610 x 355 x 254 (inches 23,5x14x10)	
Regulating wheel	Specification: A80V4R	Dimensions mm. 305 x 355 x 140 (inches 12x14x5,5)	
Dressing tool	Diamond tool bit		
Work piece	Shaft for synchronous motor		
Material	UNI X30Cr13	DIN 27-68MK	AISI/SAE 420C
Hardness	46-50 Hrc		
Initial dimensions of work piece	Ø mm. 6,15 (.242")	Lenght mm. 92,00 (3,62")	
Final dimensions of work piece	Ø mm. 6,00 (.236")	Lenght mm. 92,00 (3,62")	
Stock removal	Total mm. 0,15 (.006")	Roughing/finishing removal mm. 0,15 (.006") one pass	
Feed rate	Roughing/finishing	mt/min' 3,20 (126 ipm)	
Dimensional tolerances	Straightness	mm. 0,003 (.00011")	
	Parallelism	mm. 0,002 (.00007")	
	Roundness	mm. 0,001 (.00003")	
Surface finish	Ra 0,12	Rt 1,05	Rz 0,60
Dressing cycle	Dressing depth	mm. 0,03 (.0011")	
	Dressing speed	mm. 500/min' (19,6"/min)	
	Dressing frequency	every 4 hours	
	Reason of the dressing	restore roundness and reduce Ra	
Coolant	Water soluble coolant with 3% semi-synthetic oil Ph 9		
Notes	<i>The life of this ZB grinding wheel has been one year, working 16 hours a day.</i>		