



<b>Centerless grinding machine</b>	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 45 (8856 fpm) - rpm: 1400		
<b>Grinding wheel</b>	Specification: <b>ZB</b>	Dimensions mm. 610 x 355 x 254 (inches 23,5x14x10)	
<b>Regulating wheel</b>	Specification: <b>A120V4R</b>	Dimensions mm. 305 x 355 x 140 (inches 12x14x10)	
<b>Dressing tool</b>	Diamod tool bit		
<b>Work piece</b>	Shaft for electric motors		
<b>Material</b>	UNI 9SiMnPb36	DIN 9SiMnPb36	AISI/SAE 12L14
<b>Hardness</b>	50-60 Hrc		
<b>Initial dimensions of work piece</b>	Ø mm. 8,20 (.322")	Length mm. 86,00 (3,38")	
<b>Final dimensions of work piece</b>	Ø mm. 8,00 (.314")	Length mm. 86,00 (3,38")	
<b>Stock removal</b>	Total mm. 0,20 (.008")	Roughing removal mm. 0,16 (.006") one pass Finishing removal mm. 0,04 (.002") one pass	
<b>Feed rate</b>	Roughing	mt/min' 3,7 (145 ipm)	
	Finishing	mt/min' 3,7 (145 ipm)	
<b>Dimensional tolerances</b>	Straightness	mm. 0,001 (.00003")	
	Parallelism	mm. 0,001 (.00003")	
	Roundness	mm. 0,001 (.00003")	
<b>Surface finish</b>	Ra 0,086	Rt 1,68	Rz 0,84
<b>Dressing cycle</b>	Dressing depth	mm. 0,020	(.0008")
	Dressing speed roughing	mm. 300/min'	(11,81"/min)
	Dressing speed finishing	mm. 200/min'	(7,87"/min)
	Dressing frequency	every 4-5 hours	
	Reason of the dressing	restore surface and reduce Ra	
<b>Coolant</b>	Water soluble coolant with 4,5% semi-synthetic oil Ph 8		
	Temperature constant	75°F	
<b>Notes</b>	<i>The life of this grinding <b>ZB</b> wheel has been 8 months, working 16 hours a day.</i>		