



Centerless grinding machine	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 33 (6494 fpm) - rpm: 1020		
Grinding wheel	Specification: ZB	Dimensions mm. 610 x 508 x 304,8 (inches 23,5x20x12)	
Regulating wheel	Specification: A120V4R	Dimensions mm. 305x 508 x 140 (inches 12x20x5,5)	
Dressing tool	Diamod tool bit		
Work piece	Axle for farm tractor		
Material	UNI 18NiCrMo5	DIN	AISI/SAE
Hardness	Vacuum hardening	60 Hrc	
Initial dimensions of work piece	Ø mm. 16,35 (.643")	Lenght mm. 340,00 (13,38")	
Final dimensions of work piece	Ø mm. 16,00 (.629")	Lenght mm. 340,00 (13,38")	
Stock removal	Total mm. 0,35 (.014")	Roughing removal mm. 0,25 (.010") one pass Finishing removal mm. 0,10 (.004") one pass	
Feed rate	Roughing	mt/min' 2,5 (98 ipm)	
	Finishing	mt/min' 2,5 (98 ipm)	
Dimensional tolerances	Straightness	mm. 0,002 (.0000786")	
	Parallelism	mm. 0,003 (.000118")	
	Roundness	mm. 0,002 (.0000786")	
Surface finish	Ra 0,26	Rt 2,2	Rz 1,9
Dressing cycle	Dressing depth	mm. 0,015	(.0006")
	Dressing speed	mm. 250/min'	(9,8"/min)
	Dressing frequency roughing	every 4 hours	
	Dressing frequency finishing	every 6 hours	
	Reason of the dressing	restore surface and reduce Ra	
Coolant	Water soluble coolant with 3% semi-synthetic oil Ph 8		
Notes	<i>The life of this ZB grinding wheel has been 6 months, working 12 hours a day.</i>		