



<b>Centerless grinding machine</b>	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 45 (8856 fpm) - rpm: 1060		
<b>Grinding wheel</b>	Specification: <b>ZB25B</b>	Dimensions mm. 508 x 355 x 254 (inches 20x14x10)	
<b>Regulating wheel</b>	Specification: <b>AZ120VRR</b>	Dimensions mm. 305x 355 x 140 (inches 12x14x5,5)	
<b>Dressing tool</b>	Diamod tool bit		
<b>Work piece</b>	Shaft for electric motor		
<b>Material</b>	UNI 35SiMnPb10	DIN	AISI/SAE 11L37
<b>Hardness</b>			
<b>Initial dimensions of work piece</b>	Ø mm. 15,15 ( .595" )	Lenght mm. 230,00 ( 9,05" )	
<b>Final dimensions of work piece</b>	Ø mm. 15,03 ( .590" )	Lenght mm. 230,00 ( 9,05" )	
<b>Stock removal</b>	Total mm. 0,12 ( .005" )	Roughing removal mm. 0,12 ( .005" ) one pass	
<b>Feed rate</b>	Roughing	mt/min' 1,6 ( 63 ipm )	
<b>Dimensional tolerances</b>	Straightness Parallelism Roundness		
<b>Surface finish</b>	Ra	Rt	Rz
<b>Dressing cycle</b>	Dressing depth	mm. 0,020 ( .0008" )	
	Dressing speed roughing	mm. 250/min' ( 9,8"/min )	
	Dressing frequency	every 8 hours	
	Reason of the dressing	restore the roundness	
<b>Coolant</b>	Water soluble coolant with 2,5% semi-synthetic oil Ph 8 Temperature constant 75° F		

**Notes** *This grinding wheel performs the roughing of the shafts and is the first centerless machine of a line of 2 roughing + 1 finishing (see the sheet nr. 14)  
The life of this grinding wheel has been 12 months, working 24 hours a day.*