



Centerless grinding machine	Make: Officine Monzese Spa - Model: 1500 - wheel speed m/s: 45 (8856 fpm) - rpm: 1060		
Grinding wheel	Specification: ZB	Dimensions mm. 508 x 355 x 254 (inches 20x14x10)	
Regulating wheel	Specification: AZ120VRR	Dimensions mm. 305x 355 x 140 (inches 12x14x5,5)	
Dressing tool	Diamod tool bit		
Work piece	Shaft for electric motor		
Material	UNI 35SiMnPb10	DIN	AISI/SAE 11L37
Hardness			
Initial dimensions of work piece	Ø mm. 15,03 (.591")	Lenght mm. 230,00 (9,05")	
Final dimensions of work piece	Ø mm. 15,00 (.590")	Lenght mm. 230,00 (9,05")	
Stock removal	Total mm. 0,03 (.001")	Finishing removal mm. 0,03 (.001") one pass	
Feed rate	Finishing	mt/min' 1,6 (63 ipm)	
Dimensional tolerances	Straightness	mm. 0,001 (.000039")	
	Parallelism	mm. 0,001 (.000039")	
	Roundness	mm. 0,001 (.000039")	
Surface finish	Ra 0,12	Rt 1,5	Rz 1,0
Dressing cycle	Dressing depth	mm. 0,020 (.0008")	
	Dressing speed roughing	mm. 250/min' (9,8"/min)	
	Dressing speed finishing	mm. 250/min' (9,8"/min)	
	Dressing frequency	every 8 hours	
	Reason of the dressing	restore the roundness	
Coolant	Water soluble coolant with 2,5% semi-synthetic oil Ph 8 Temperature constant 75°F		
Notes	<p><i>This grinding wheel performs the finishing of the shafts and is the second centerless grinding machines of a line of one for roughing + 1 finishing machine.</i></p> <p><i>(see the sheet nr. 13)</i></p> <p><i>The life of this ZB grinding wheel has been 12 months, working 24 hours a day.</i></p>		