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Centerless grinding machine	Make: Officine Monzesi Spa - Model: 500 - wheel speed m/s: 32 (6297 fpm) - rpm: 1200		
Grinding wheel	Specification: ZB	Dimensions mm. 508 x 250 x 254 (inches 20x10x10)	
Regulating wheel	Specification: A120V4R	Dimensions mm. 305 x 250 x 127 (inches 12x10x5)	
Dressing tool	Diamond tool bit		
Work piece	Shaft for electric motors		
Material	UNI 35SMnPb10	DIN	AISI/SAE 11L37
Hardness			
Initial dimensions of work piece	Ø mm. 15,02 (.5913")	Lenght mm. 224,00 (8,81")	
Final dimensions of work piece	Ø mm. 15,00 (.5905")	Lenght mm. 224,00 (8,81")	
Stock removal	Total mm. 0,02 (.0008")	Finishing removal mm. 0,02 (.0008") one pass	
Feed rate	Finishing	mt/min' 1,68 (66 ipm)	
Dimensional tolerances	Straightness	mm. 0,001 (.000039")	
	Parallelism	mm. 0,001 (.000039")	
	Roundness	mm. 0,0075 (.00029")	
Surface finish	Ra 0,16	Rt 1,30	Rz 0,90
Dressing cycle	Dressing depth	mm. 0,025 (.001")	
	Dressing speed	mm. 350/min' (14,90"/min)	
	Dressing frequency	every 4-5 hours	
	Reason of the dressing	restore surface and reduce Ra	
Coolant	Water soluble coolant with 3% semi-synthetic oil Ph 8		
Notes	<p><i>This grinding wheel perform the finishing of the shafts and is the second centerless machines of a line of two. (see the sheet nr. 2)</i></p> <p><i>The life of this ZB grinding wheel has been one year, working 16 hours a day.</i></p>		