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<b>Centerless grinding machine</b>	Make: Officine Monzesi Spa - Model: 1500 - wheel speed m/s: 45 (8856 fpm) - rpm: 1670		
<b>Grinding wheel</b>	Specification: <b>ZB</b>	Dimensions mm. 508 x 355 x 254 ( inches 20x14x10 )	
<b>Regulating wheel</b>	Specification: <b>A80V4R</b>	Dimensions mm. 305 x 355 x 140 ( inches 12x14x5,5 )	
<b>Dressing tool</b>	Diamond tool bit		
<b>Work piece</b>	Shaft for synchronous motor		
<b>Material</b>	UNI X30Cr13	DIN 27-68MK	AISI/SAE 420C
<b>Hardness</b>	46-50 Hrc		
<b>Initial dimensions of work piece</b>	Ø mm. 3,68 ( .144" )	Lenght mm. 68,00 ( 2,67" )	
<b>Final dimensions of work piece</b>	Ø mm. 3,50 ( .137" )	Lenght mm. 68,00 ( 2,67" )	
<b>Stock removal</b>	Total mm. 0,18 ( .007" )	Roughing/finishing removal	mm. 0,18 ( .007" ) one pass
<b>Feed rate</b>	Roughing/finishing	mt/min' 3,2 ( 126 ipm )	
<b>Dimensional tolerances</b>	Straightness	mm. 0,004 ( .00015" )	
	Parallelism	mm. 0,002 ( .000078" )	
	Roundness	mm. 0,001 ( .000039" )	
<b>Surface finish</b>	Ra 0,10	Rt 0,90	Rz 0,50
<b>Dressing cycle</b>	Dressing depth	mm. 0,03 ( .0011" )	
	Dressing speed	mm. 400/min' ( 15,74"/min )	
	Dressing frequency	every 4 hours	
	Reason of the dressing	restore diameter and reduce Ra	
<b>Coolant</b>	Water soluble coolant with 3% semi-synthetic oil Ph 9		
<b>Notes</b>	<i>The life of this <b>ZB</b> grinding wheel has been one year, working 16 hours a day.</i>		