



<b>Centerless grinding machine</b>	Make: Mikrosa - Model: Favorite - wheel speed m/s: 50 (9840 fpm) - rpm: 1570		
<b>Grinding wheel</b>	Specification: <b>ZB</b>	Dimensions mm. 600 x 400 x 304,8	
<b>Regulating wheel</b>	Specification: <b>A120V4R</b>	Dimensions mm. 349 x 400 x 127	
<b>Dressing tool</b>	Diamod tool bit		
<b>Work piece</b>	Shaft for eletric motors		
<b>Material</b>	UNI 9SiMnPb36	DIN 9SiMnPb36	AISI/SAE 12L14
<b>Hardness</b>	Cementation + hardening 50-60 Hrc		
<b>Initial dimensions of work piece</b>	Ø mm. 8,20 ( .322" )	Lenght mm. 86,00 ( 3,38" )	
<b>Final dimensions of work piece</b>	Ø mm. 8,00 ( .314" )	Lenght mm. 86,00 ( 3,38" )	
<b>Stock removal</b>	Total mm. 0,20 ( .008" )	Roughing removal mm. 0,16 ( .006" ) one pass Finishing removal mm. 0,04 ( .002" ) one pass	
<b>Feed rate</b>	Roughing mt/min' 7 ( 275 ipm ) Finishing mt/min' 7 ( 275 ipm )		
<b>Dimensional tolerances</b>	Straightness	mm. 0,001 ( .00004" )	
	Parallelism	mm. 0,001 ( .00004" )	
	Roundness	mm. 0,001 ( .00004" )	
<b>Surface finish</b>	Ra 0,086	Rt 1,68	Rz 0,84
<b>Dressing cycle</b>	Dressing depth	mm. 0,020 ( .0008" )	
	Dressing speed roughing	mm. 300/min' ( 11,81"/min )	
	Dressing speed finishing	mm. 200/min' ( 7,87"/min )	
	Dressing frequency roughing	each 2 hours	
	Dressing frequency finishing	each 5 hours	
	Reason of the dressing	restore surface and reduce Ra	
<b>Coolant</b>	Water soluble coolant with 4,5% semi-synthetic oil Ph 8		
	Temperature constant	75°F	
<b>Notes</b>	<i>The life of this <b>ZB</b> grinding wheel has been 8 months, working 16 hours a day.</i>		