

CASE STUDY

AFTER

BEFORE



■ Features of CBS Wheel

1. With elastics and absorbability, the hardness can be adjusted with the additive, which gives a mutual consideration to polishing and cutting.
2. It is suited for various kind of work piece such as tape-recording magnetic head, all kinds of bearing pin, driving shaft in a compressor and mold working.
3. CBS wheel suits for various kind of grinder. The wheel specification and size is customized.
4. The good self-sharpening ability of CBS could reduce the dressing frequency.
5. Suit for high extensibility and softer material grinding.



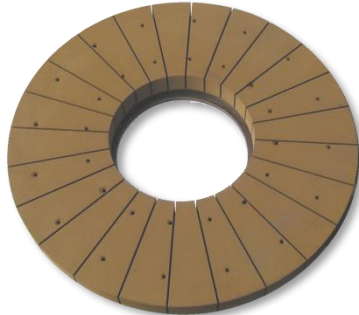
Case of CBS mirror finished polishing

■ Applications of CBS Wheel :

- Aluminum alloy polishing
- Utility knife, shear polishing
- Industrial knife and tool polishing
- Heterogeneous Surface Polishing - HSP (Copper Clad Laminate)

SPECIFICATION

Material	Abrasive
Aluminum Alloy	GC
SUS · SKD	WA



Grit Size	
280#	800#
320#	1000#
500#	2000#
600#	3000#

Hardness	
Hard	2H
	1H
Middle	3M
	2M
	1M
Soft	2S
	1S

■ For further inquiry, please contact us via the company information below.

CASE STUDY

Grinding Issue : Aluminum Alloy Polishing

The original bonded wheel was used to grind Aluminum 5XXX and resulted in a bad surface roughness with scratch, due to the dropped abrasive.

Roughness Requirement :

Ra0.3 ~ 0.5

Solution :

Using Anchor CBS GC320# grinding wheel which was expected to reduce abrasive dropping and enhance the roughness.

Test Result :

GC3201M25CBS1A reached the requirement of Ra0.27 and even better than customer's expectation on roughness. The online balance correcting is also helpful to improve the roughness and increase yield.

Material and Parameter		
Material	Aluminum Alloy 5XXX	
Machine	SEEDTEC Surface Grinder	
Wheel speed	Rough 3100 rpm	Finish 3100 rpm
Infeed	Rough 5um / time	Finish 1um / time
Non-sparking	Rough 0 time	Finish 5 times
Through feed	Rough 13m / min	Finish 13m / min
Cross feed	Rough 2.5mm/ time	Finish 2.5mm/ time
Stock removal	Rough 20 um	Finish 5 um
Dressing tool	Single-Point Dresser	
Dressing speed	800 rpm	
Dressing infeed	2um/time , total removal 10um	
Wheel Specification and Size		
Specification	GC3201M2-5CBS1A	
Size	205 mm X 13 mm X 31.75 mm	

COMPANY INFORMATION

- For details, please contact the following agency.

Anchor[®]

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- While using grinding wheels, it is essential that you observe correct procedures to protect yourself.