



Case Study

Specification : CBN200N150VIWDW-SP

Size : 17X90XM16

Machine Brand : TOYO

Application : Internal grinding wheel for bearing case

Work piece	Bearing Case
Material	SAE1010(1018MAC)
Hardness	HRC59~64
Roundness	+0.025mm
Roughness	Less than Ra0.51um

Wheel Speed	2700 m/min
Work Speed	74.5 m/min
Total stock removal	0.3 mm
Infeed (coarse)	0.12 mm
Infeed (finish)	0.02 mm
Result	Better wheel life (about 15,000 pcs grinding) Longer dressing cycle time(250pcs/dressing)

SUITABLE
MATERIAL for
VITRIFIED BOND

Hardened materials like speed steels, chromium steels.

SUITABLE
MACHINE for
VITRIFIED BOND

On internal and jig grinding machines.