



### 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           |
| Coaxiality | < 0.03 mm          |
| 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<br>(about 15,000 pcs grinding)<br>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.