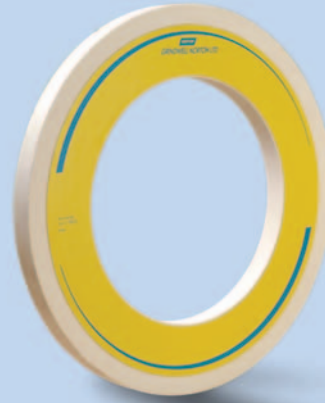


THREAD GRINDING WHEELS

**NORTON
ADVANTAGE**

Grindwell Norton Thread Grinding Wheels have been engineered with precision for precision grinding; to meet productivity as well as quality requirements.



TYPICAL APPLICATIONS

- ▶ External thread grinding - taps, rolls
- ▶ Internal thread grinding - gauges, dies
- ▶ Thread chasers
- ▶ Worm grinding

Industry	Bearing	Auto OEM	Auto Ancillaries	Cutting Tool	General Engg
Usage	●	●	●	●	●
	● Primary Use	● Primary Use	● Primary Use	● Primary Use	● Secondary Use

BETTER THREAD GRINDING WHEELS

FEATURES

- ▶ New improved Norton bonds, VTHRD
- ▶ 35A Abrasive upto # 180
- ▶ SG Abrasive upto # 150

BENEFITS

- ▶ Better form retention, longer life
- ▶ Lower dressing frequencies
- ▶ Better finish
- ▶ Cool cutting on tool steels
- ▶ Premium product, high MRR and no metallurgical damage

TROUBLESHOOTING GUIDE

PROBLEM

POSSIBLE CAUSES

SUGGESTED CORRECTION

Burning/ discolouration of workpiece

- Inadequate supply of coolant
- Too heavy infeed
- Too slow work speed
- Direction of cut

- Ensure coolant is directed at cutting point
- Reduce amount of stock per pass
- Increase work speed and reduce infeed proportionately
- Arrange cycle to finish on "Up-Cut"

Poor finish or chatter

- Diamond lines (evenly placed scratches)
- Surface roughness
- Scratches
- Out of balance wheel
- Work speed too high

- Use slower diamond feed or lighter cut
- Use lighter cut or slower work speed on finishing pass
- Clean grinding oil
- Retrieve and rebalance wheel
- Use slower work speed

SpecCheck

ABRASIVE	GRIT	GRADE	BOND
SG	80	J	VS3
35A	↕	↕	VTHRD
38A	320	N	VBE

PITCH RANGE	STARTING SPECIFICATION
1	38A 320 M9 VTHRD
1.25	38A 280 M9 VTHRD
1.5	38A 220 L8 VTHRD
1.75	38A 180 L8 VS3
2.25	38A 180 L8 VS3
3.0	38A 120 L8 VS3
4.0	38A 100 L8 VS3
6.0	38A 80 M8 VS3

TechTips

- ▶ Dress the form from point of wheel towards edges of wheel for better maintenance of root width and edge form.
- ▶ Form dressing, using diamond roll, always gives best results on thread grinding