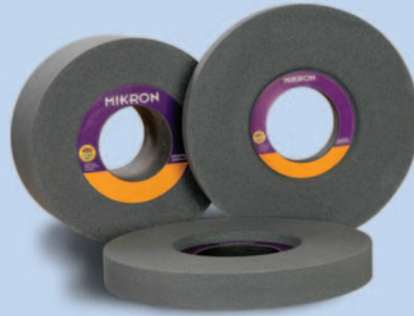


# CYLINDRICAL WHEELS

**Grindwell Norton supplements its existing range of cylindrical wheels with the new Mikron range of wheels. Mikron wheels give you the best results in terms of cutting action and productivity on all O.D. grinding operations.**



Industry	Steel	Auto OEM	Auto Ancillaries	Cutting Tool	General Engg	Tools & Dies
Usage	●	●	●	●	●	●
	● Primary Use   ● Secondary Use					

## TYPICAL APPLICATIONS

- ▶ O.D. grinding of gear shafts, splined shafts etc.
- ▶ O.D. plunge grinding

**"New MIKRON Plus (VCNM) Wheels reduced my dressing frequency thus resulting in longer life of the wheel."**

- Supervisor - Transmission Division, Auto Manufacturer

## CYLINDRICAL GRINDING WHEELS

	FEATURES	BENEFITS
<b>BEST</b>	<ul style="list-style-type: none"> <li>▶ 38A, SG - VS3 wheels</li> <li>▶ SG - only for plunge grinding application</li> </ul>	<ul style="list-style-type: none"> <li>▶ Optimum grinding efficiency</li> <li>▶ Maximum material removal rate</li> <li>▶ Reduced loading &amp; dressing</li> </ul>
<b>BETTER</b>	<ul style="list-style-type: none"> <li>▶ A, 19A : VS3 wheels</li> </ul>	<ul style="list-style-type: none"> <li>▶ Free cutting</li> <li>▶ Advanced VS3 bond system for excellent form retention</li> </ul>
<b>GOOD</b>	<ul style="list-style-type: none"> <li>▶ A : VCNM wheels</li> </ul>	<ul style="list-style-type: none"> <li>▶ High grinding efficiency</li> <li>▶ Ability to grind various range of materials</li> </ul>

## TROUBLESHOOTING GUIDE

PROBLEM	POSSIBLE CAUSES	SUGGESTED CORRECTION
Chatter marks	<ul style="list-style-type: none"> <li>- Grinding cuts too heavy</li> <li>- Wheel too hard</li> </ul>	<ul style="list-style-type: none"> <li>- Lighter cuts</li> <li>- Use softer wheels, increase dresser feed rate, reduce wheel RPM</li> </ul>
Feed line	<ul style="list-style-type: none"> <li>- Edge digging into work</li> <li>- Head and tail stock out of alignment</li> </ul>	<ul style="list-style-type: none"> <li>- Round off edges of wheel</li> <li>- Check and correct alignment</li> </ul>

## TechTips

- ▶ A fast traverse of the diamond dresser along the wheel face results in an open wheel aiding higher material removal rate.
- ▶ Use abundant supply of coolant during the grinding operation.
- ▶ Use Winter Fliese dressing tools for best performance in SG-VS3 wheels.



### Advanced VS3 Bond

Wheels designed for better corner retention and more number of components between dressings using the VS3 bond system

## STOCK AVAILABILITY TABLE

### Cylindrical Wheels

Size Dia x Thk x Bore	Std. Pkg.	Specification	Stock No.
<b>TYPE 1</b>			
250 x 25 x 76.2	4	A60 M6 VCNM	V231M
300 x 25 x 127	3	A60 M6 VCNM	V267M
350 x 25 x 127	3	A60 M6 VCNM	V306M
350 x 25 x 127	3	A60 N6 VCNM	V307M
350 x 40 x 127	2	38A46 J8 VBE	V316
350 x 40 x 127	2	A60 M6 VCNM	V315M
350 x 50 x 127	2	A60 N6 VCNM	V326M
400 x 40 x 127	1	A60 M6 VCNM	V350M
450 x 63 x 254 1-325 x 13	1	A60 M6 VCNM	V387M
500 x 80 x 203.2	1	A60 M6 VCNM	V408M
<b>TYPE 5</b>			
300 x 40 x 127 1-190 x 16	2	38A 60 K5 VBE	V286
300 x 40 x 127 1-190 x 16	2	A60 M6 VCNM	V285M
350 x 40 x 127 1-190 x 16	2	A60 M6 VCNM	V317M
400 x 40 x 127 1-190 x 16	1	A60 L6 VCNM	V340M
400 x 40 x 127 1-190 x 16	1	A60 M6 VCNM	V352M
500 x 63 x 254 1-325 x 13	1	A60 M6 VCNM	V405M
400 x 50 x 127 1-190 x 16	1	A60 M6 VCNM	V362M