



ROLLGRIND

CONCEPTION OF QUALITY GRINDING

Roll grinding wheels for maximum performance and cost savings

How you benefit?

- Lower production costs
- Less power consumption
- Less downtime for change overs

Advantages

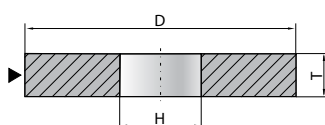
- Faster material removal rate up to + 20 %
- Increased G-ratio up to + 20 %
- Wheel life increase up to + 30 %
- All types of workpiece material
- High and low horsepower machines

VITRIFIED & RESIN BONDED GRINDING WHEELS

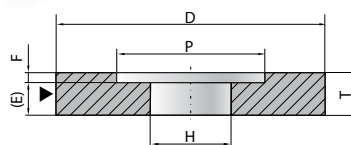
ROLLGRIND



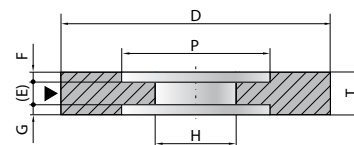
F1



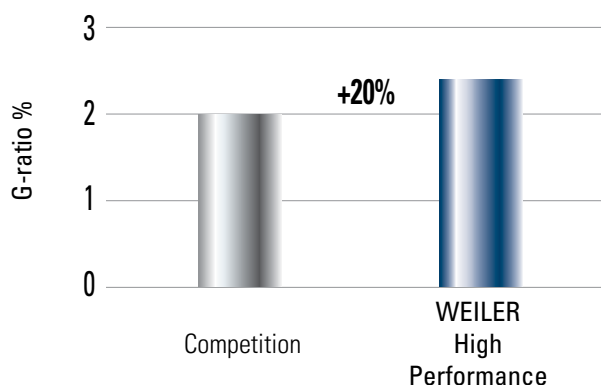
F5



F7



G-ratio HSS Rolls



Dimensions

D (mm)	T (mm)	H (mm)
350	38	127
600	50/60/70/100/125	203.2/304.8
700	60/80/100/125	304.8
750	80/100/125	304.8
762	80/100/125	304.8
800	80/100/125	304.8/381
900	80/100/150	304.8/355/457.2
920	80/100/127/150	304.8/355/457.2/508
1000 - 1100	60/75/80/100/127/150	304.8/355/457.2/508

Case Study

- Grinding Machine: POMINI
- Form: 1
- Dimensions: 1065 x 152 x 508
- Backup Roll:
2130 x 4000, HiCr 72Sch
- Roughness Ra: $\leq 1,0$ Ra
- Infeed - mm: 0,02 - 0,04 mm/pass
- Crossfeed - mm/min: 1200 mm/min
- Working Speed: 42 m/s
- Roll Speed (1/min): 16 m/s
- Total Stock Removal: 0,8-1,8 mm

Materials

	Type of roll	Material	Surface quality (Ra)	Standard	High performance
Hot Rolling Mills	Work Roll	Indefinite	0,4 - 0,8 #46 0,6 - 1,2 #36	SC30-46J-KBK	S3HC30-46J-KBK
		High Cr Steel, Cast, HSS		82A/8A/15HA 30-46I-JBK	S38HA30-46I-JBK
		All			S38HAC30-46I-JBK
	Back-up Roll	All			S38HA30-46J-KBK
Cold Rolling Mills	Work Roll	Forged Cr Steel HSS	0,4 - 0,8 #46 0,3 - 0,6 #60 0,2 - 0,4 #80	82A/8A/15HA 46-100F-JBK	38HA-100F-JBK
	Back-up Roll	All		15HA-46-60F-JBK	38HA/38HC36-60H-KJBK

