

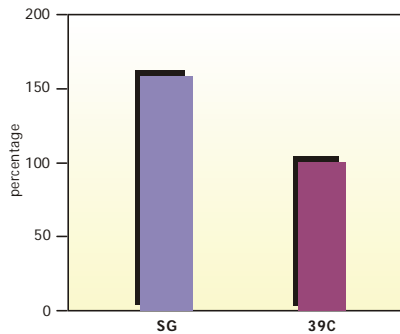
SG in Roll Grinding

Case Study - 5

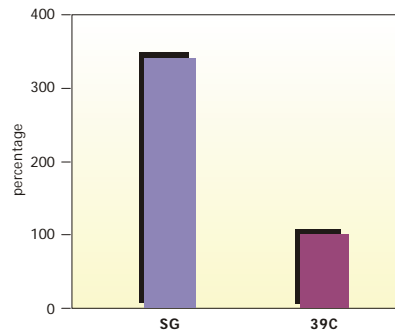
GRINDING RESULTS

Standardization of one specification for both ICDP and HiCr rolls.

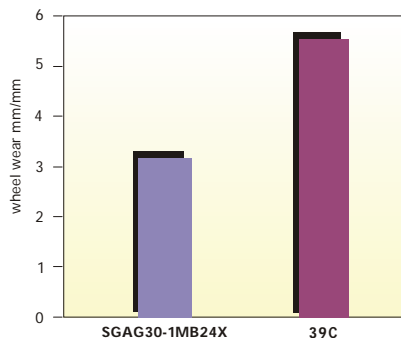
PERFORMANCE CHART (MRR%)



PERFORMANCE CHART (GRINDING RATIO %)



COMPARISON OF WHEEL WEAR (mm of wheel wear/mm of roll reduction)



	SG	39C
MRR (cmm/s)	1173	337
GR	3.65	2.18

MACHINE TOOL FACTORS

- Make : Toshiba
- Power : 110 kw
- Speed : 45 m/s

OPERATIONAL FACTORS

- Stock : 7000 mic on dia
- Grind time : 45 sec

WORK MATERIAL FACTORS

- Steel scrolls used for rolling of sheets
- Material : ICDP and Hi Cr

ABRASIVE PRODUCT

- Old: Imported along with machine
- New : SGAG30-1MB24X [GNO]

CONCLUSION:

Single specification standardization for ICDP and HiCr rolls. Improved action with **65% improvement in GR** and **250% improvement in mrr** over 39C.

NORTON GRINDWELL NORTON LTD.

SAINT-GOBAIN
ABRASIVES