

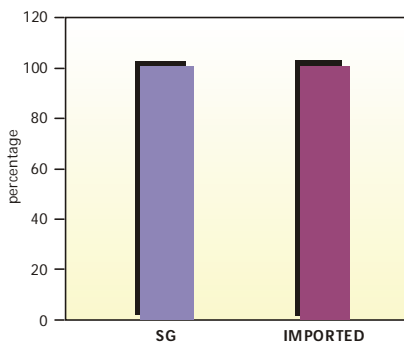
SG in Roll Grinding

Case Study -6

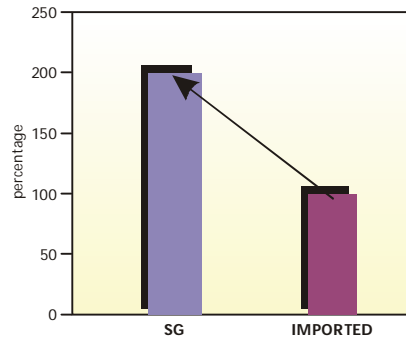
GRINDING RESULTS

Standardization of one specification for both ICDP and HiCr rolls.

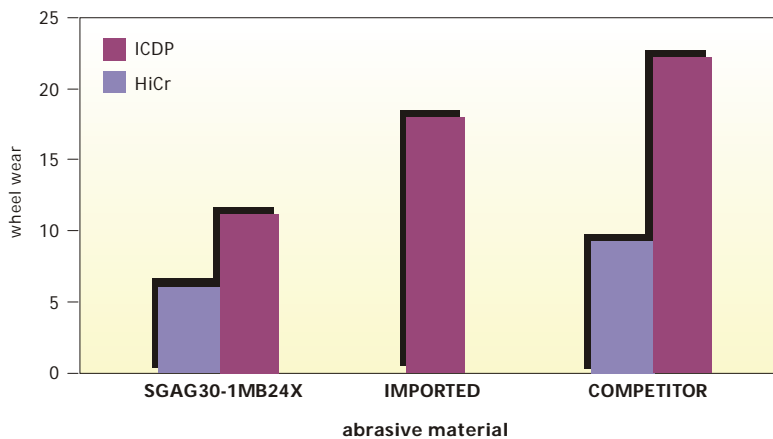
PERFORMANCE CHART (MRR%)



PERFORMANCE CHART (GRINDING RATIO %)



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



MACHINE TOOL FACTORS

- Make : Hercules
- Power : 87 kw
- Speed : 45 m/s

WORK MATERIAL FACTORS

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

OPERATIONAL FACTORS

- Stock : 700 mic on dia
- Grind time : 45 min

ABRASIVE PRODUCT

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

CONCLUSION:

Single specification standardization for ICDP and HiCr rolls. Improved cutting action with **100% improvement in GR and equivalent MRR** as compared to imported wheel.

NORTON GRINDWELL NORTON LTD.

SAINT-GOBAIN
ABRASIVES