

### Angular Grinding



#### Part Data

Work Piece: Automotive driveline shaft  
Operation: Angular approach grind, shaft and shoulders  
Material: 17CrNiM06  
Hardness: 58-62  
Surface Finish: 4.0 / 6.3 Rz

#### Wheel Data

Size: 600mm x 85mm x 203mm  
Hermes Spec: 3CB3/9 46 K 8 V09 A-50

#### Truing Data

Dressing Device: Rotary diamond form roll  
Dress Ratio: 0.8

#### Machine Data

Junker BUAJ 51 CNC using synthetic coolant

#### Process Parameters:

The cycle time when using the Hermes wheel was reduced from one minute forty-five seconds to fifty-five seconds. Wheel usage was reduced and the number of parts ground per wheel increased.

BCH01



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