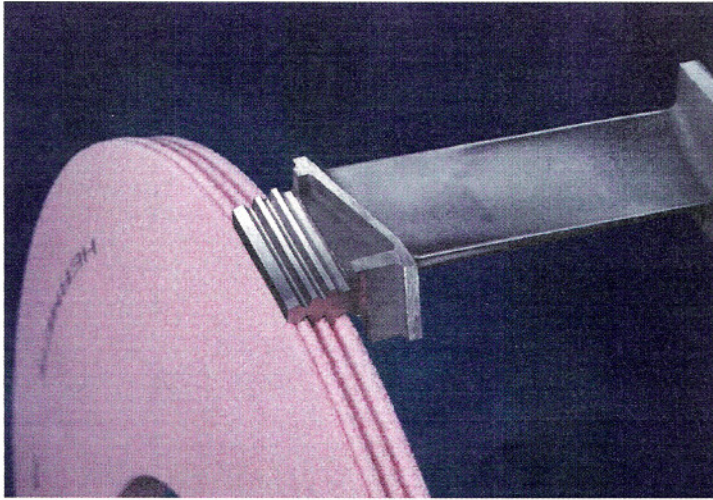


Creep Feed Grinding of Turbine Blades



Wheel Data

Size: 14" x 2" x 5" Type 1
Hermes Spec: ERT 60 E 16 V62 P44 XO
Competitor Spec: 32A 60 D 38 VCF2

Part Data

Work Piece: Turbine Blade
Operation: Root Form
Material: Inconel
Finish: 32 RMS

Truing Data

Dressing Device: Rotary diamond roll 30/40 mesh
Dress Ratio: 0.8 unidirectional mode

Machine Data

Micron Macro Continuous dress equipped
28 Horsepower spindle drive

Process Parameters:

Continuous dress creep feed grinding in a down cut grind. Hermes abrasives provided a 36% reduction in timesavings. Process improvement of wheel usage by reducing continuous dress infeed amount and increasing number of parts per wheel.

BCH02



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