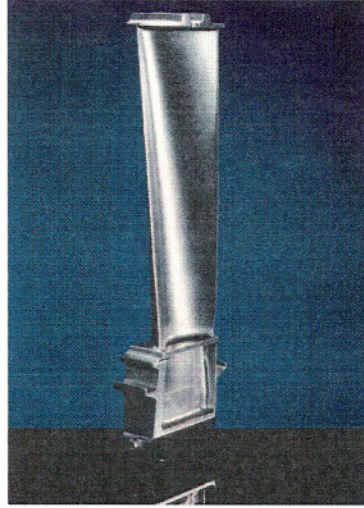


Deep Creep Feed Grinding of Turbine Blades



Part Data

Work Piece: Power generation turbine blade
Operation: Root form and platform
Material: Inconel 718
Finish: 32 RMS

Wheel Data

Size: 20" x 6" x 8" Type 1
Hermes Spec: ERA 60 E 16 V62 P44 XO
Competitor Spec: 38A 60 D 25 VCF 2

Truing Data

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

Machine Data

Blohm Profimat Continuous dress equipped
HP: 106 HP 79 Kw

Process Parameters:

Continuous dress creep feed grinding in a down cut grind. Hermes product provided process improvement of wheel usage by reducing the number of grind passes required by the competitor from four to one in the continuous dress mode, thus increasing the number of turbine blades ground per wheel.

BCH03



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