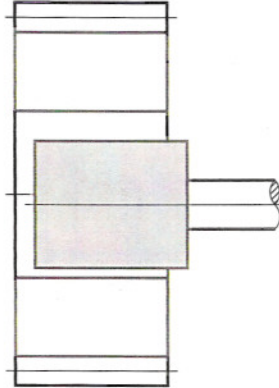


ID Grinding with Vitrified CBN



Part Data

Work Piece: Transmission pinion gears for an American motorcycle manufacturer
Operation: Internal grinding of gear bore
Material: 8620
Hardness: 58-62 HRC

Wheel Data

Size: .500" x .850" 3/8-20 x L2.64
Hermes Spec: 30B 91 (180) C 150 Q3 V04-63
Competitors Spec: CBN S 705 R J 1077 Max Speed

Truing Data

Dressing Device: Diamond cup

Machine Data

Model: Bryant
Coolant: Oil

Process Parameters:

The client processed ten transmission gears before the process required truing the wheel. Hermes product produced thirty two transmission gears before requiring truing of the wheel.

BCH07



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