

BONULEX WHEELS

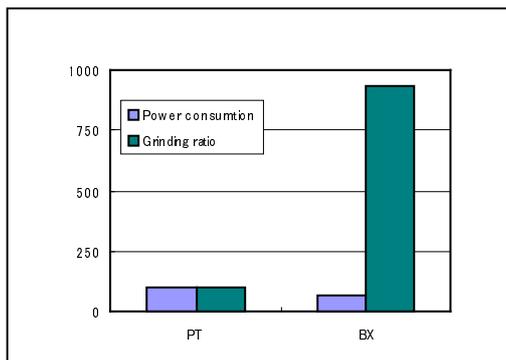


● Applications

CNC tool grinding, groove grinding, gash grinding, surface grinding of products such as dies, grooving of automotive parts, etc.

● Example applications

Carbide (K-10)



SCM

Groove grinding of automotive parts
 Grinder: Special purposed machine tool
 Wheel Dimensions: 14A1 200D x 10T x 50.8H x 5U x 3X
 Wheel Speed: 30 m/s
 Work Feed: 1.5 mm/min
 Depth of cut: 3.5 mm
 Test Wheel: CBN 140 N 100 BX
 Compared with: CBN 120 (competitor's metal bond)

While conventional wheels only lasted for a month, the BX wheels could be used for five months under the same conditions with no need for dressing.

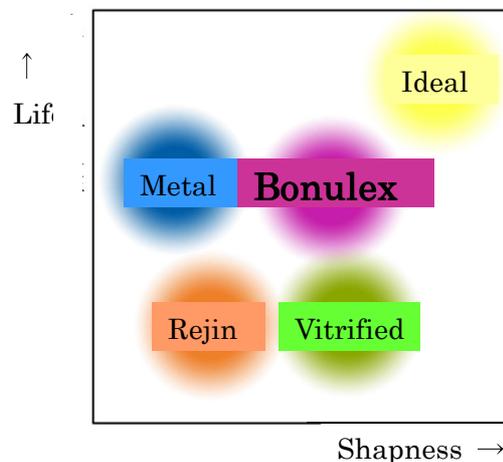
Hybrid Metal Bond Wheel

Grinding wheels one step closer to the ideal have been developed in pursuit of ideal grinding!

We have succeeded in developing a hybrid metal bond that maximizes the abrasive performance. It ensures an amazing grinding performance.

Characteristics of Bonulex Wheels

1. Heavy cutting is permitted by a lower grinding resistance.
2. The efficiency has been improved by the increased grinding speed.
3. Superior in profile holding ability.



Plunge grinding with surface grinder Wet type (solution)
 Wheel Dimensions: 3A1 150D x 10T x 50.8H x 5U x 3X
 Wheel Speed: 20 m/s Feed: 18 m/min Depth of cut: 20μm
 Test Wheel: SD 200 N 100 BX
 Compared with: SDC 200 N 100 PT (Tufflex)

The grinding force required by Bonulex is a half of that required by conventional wheels and the grinding ratio obtained with Bonulex is about ten times as large as that obtained with conventional ones. Bonulex is much superior in sharpness and service life therefore able to increase the depth of cut and feed rate.