



● The SP wheels are CBN bonded wheels developed for compression springs surface grinding of disc type grinding (double disc surface grinding)

The SP wheels prove excellent grinding performance with the special bond and solve longtime problems in the springs business world. In addition, they open a way to full automation and lower personal expence.

● Characteristics

1. No dressing

Dressing is not necessary with its sharp edge that doesn't load.

2. Reduced the inspection charge of spring load and free length.

As compared with conventional wheels, the SP wheels are only worn to about one hundredth, The spring load and free length have been constanted. Therefor it greatly saves the inspection time.

3. Vastly reduced wheel turnover rate.

Because of longer wheel life, the wheel turnover rate can be reduced to a tenth or less.

4. Adapted various materials

SP wheels grind excellent sharpness both steel wire and stainless steel wire. Wheels no longer need to be replaced depending on the materials..

5. Clean operation

Almost few fine particule of grinding wheels, the work environment is comfortably improved.

● Coiling surface grindineg for compression springs

	SP wheels	Conventional
Wheel	CBNC 80 R 225Dx38Tx26Hx84.5Wx3X	A 46 P V 255Dx40Tx86H
Material	Coil spring (sus, swp) wire diameter 0.5~1.6mm	
Grinder	Syowazoki VP2-20-S (Dry)	
Dressing	Non-necessity	2 to 3 times/day
Wheel life	10 months	20 days
Results	Reduced the inspection charge of spring load and zero defects due to deformation.	

● Snap ring surface grinding

	SP wheels	Conventional
Wheel	CBNC 100 P 455Dx48Tx87.5Wx3X	SA 80 M B 455Dx65Tx280H
Material	Snap ring (S60C HV440~450) φ32.5	
Grinder	Nippe V-18	
Dressing	0.5 times/week	3 times/day
Wheel life	6 months	0.5 months
Results	Redused much personal expenses of inspection free length and wheels turnover rate.	

* The CBN abrasive, manufactured with the ultra-high temperature/pressure technology, is the hardest material in the world after diamond. It is twice as hard as conventional grain WA and GC and help maintain sharp edges to realize efficient grinding.