

Recommending Parameters for Surface Grinding

Materials Ground	Abrasive Types	Parameters			
Carbide	Diamond	linear speed: 20 to 30 m/s	Cross Feeding: Approx. ½ Of Wheel width/stroke	Work piece Traverse speed:. m/min. 5....15 .inch/min. 200...400	Depth of Cut: .018mm / .0007inch
Hardened Steel	CBN	linear speed: 25 to 40 m/s	Cross Feeding: Approx. ½ Of Wheel width/stroke	Work piece Traverse speed:. m/min. 10....20 .inch/min. 400...800	Depth of Cut: .018mm / .0007inch

