

Internal grinding (Reciprocating)

Material Ground	Abrasive Type	Parameters			
		Wheel peripheral Speed	Work piece Peripheral Speed	Wheel oscillation Speed In ID	Radial in-feed/stroke
Carbide	Diamond	.m/sec 15...20 SFM 3,000...4,000	m/min 20..30 in./min 800...1600	inch/min 200...400	.0002 inch
Hardened Steel	CBN	.m/sec 20...40 SFM 4,000..8,000	m/min 20...30 in./min 800...1600	.inch/min 200...400	.0002 inch

Recommended mesh Size or surface finish Requirement

ASD 140/170 R75 B
CBN 140/170 R75 B