Case Study:
Rack finishing EPS

Honing and finishing tools made of corundum and silicon carbide

Grinding competence for high level industrial applications

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**Specifications**

- **Dimension:** 18x4.5x100 R=2.4 / R=13
- **Specification:** 55C/5 1000-45 V781 PS
- **Surface quality:** Ra 0.1 ; Rz 1.0
- **RPM workpiece:** 370 1/min / 500 1/min
- **Passes:** 6 / 2
- **Oscillation angle:** 2.2' / 2'

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**Materials**

- Material: X46Cr13
- Material: 100Cr6
- Material: 1.1248 / CK spring steel
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- Material: Spring steel

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**Technical Details**

- Stock removal: 0.2 mm
- Wheel wear: 2µm/h
- Surface quality: Ra 0.31 ; Rz 2
- Surface quality: Ra 0.25 ; Rz 1.7
- ISO 25178
- SP: 51.19 Ångström
- Dressing interval: 3x / week
- Dressing interval: 7 Stk.

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**Applications**

- Internal cylindrical grinding in CBN and diamond
- External cylindrical grinding tools in CBN and diamond
- Internal cylindrical dressing tools of highly advanced technology
- External cylindrical dressing tools of highly advanced technology
- Internal cylindrical dressing in corundum and silicon carbide
- Top class diamond dressing tools of highly advanced technology
- Double disk fine grinding wheels in CBN and diamond
- Precision grinding tools for the semiconductor industry
- Precision grinding tools for the semiconductor industry
- Grinding in CBN and diamond
- Internal cylindrical grinding in corundum and silicon carbide
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