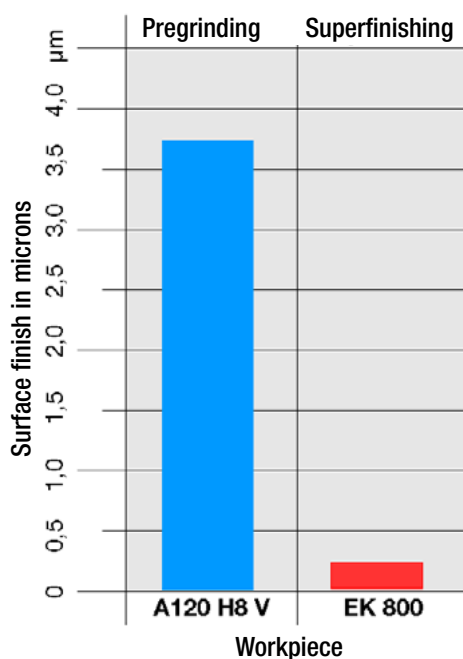


Where superfinishing of machine shafts and spindles is concerned, a surface finish of less than 1 micron is achievable when compared to conventional vitrified grinding wheels producing only 3-4 micron.

Elastic-bonded abrasives from **ARTIFEX** can be used on almost all existing cylindrical grinding machines without the need for additional investment.



## MASCHINE

- For example: Bahmüller GMBH (Type B44-2 CNC)

## ARTIFEX ELASTIC-BONDED WHEEL

Bonding: Densely formed Polyurethane  
Grit size: EK 800  
Size: 400 x 20 x 127,00 mm  
Spindle speed: 40 m/sec

The relationship between bonding hardness and grit size can be varied considerably to achieve the desired result.

## MATERIAL

- Unalloyed structural steel such as St 52-3, 1.0569 or similar

## WORKPIECE

- Camshafts
- Crankshafts and other engine components

## PROCESS PARAMETERS

To achieve optimal results, the following settings for machine and workpiece should be investigated:

- Infeed of the wheel to the component
- Spark-out time
- Lateral oscillation of the abrasive wheel to the rotation direction
- Cutting speed

Profit from our Know-how

We customize our approach to match your requirements!

