

Title (en)

Burring chamfering method.

Title (de)

Verfahren zum Entgraten und Abfasen.

Title (fr)

Procédé d'ébarbage et de chanfreinage.

Publication

EP 0137859 A2 19850424 (EN)

Application

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Priority

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Abstract (en)

A method of burring and chamfering a workpiece (2) employs an apparatus including: a workpiece carrying belt conveyor (3); one or a plurality of elastic grinding wheels (4) obliquely disposed over the belt conveyor (3), the grinding wheels (4) being arranged in parallel to each other in the same direction; and split-type press rollers (5X, 5Y) disposed along both sides of each of the grinding wheels (4). The method comprises the steps of: passing the workpiece (2) under a first grinding wheel (4X) which has a grinding surface rotating in the direction opposite to the moving direction of the workpiece (2) thereby to effect burring and chamfering; and passing the workpiece (2) under a second grinding wheel (4Y) which is disposed in parallel to the first grinding wheel (4X) and has a grinding surface rotating in the same direction as the moving direction thereby to effect burring and chamfering. The grinding wheels (4X, 4Y) may be rotated while having an angle of about 45 degrees with respect to the moving direction. The moving direction of the belt conveyor (3) may be changed every time a predetermined time elapses. Moreover, the grinding wheels (4X, 4Y) may be vibrated in an axial direction of the grinding wheels.

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