

Title (en)

METHOD FOR GRINDING PLANE-PARALLEL ANNULAR SURFACES OF DISK-SHAPED WORKPIECES

Publication

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Application

EP 87114773 A 19871009

Priority

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Abstract (en)

[origin: US4827677A] A method is described for grinding plane-parallel circular annular faces on disk-shaped workpieces, in particular on brake disks of motor vehicle disk brakes, in which the workpieces have different grinding allowances, with respect to their set-point position, on their surfaces to be machined and are machined from both sides with side grinding wheels by the face grinding process, and in which the machining is effected in a plurality of phases at dissimilar feed speeds. The machining is effected in one method step at dissimilar feed speeds (v_3 , v_3'), from the point (P2, P2'), of the first contact of the grinding wheel with the workpiece up to a point (P3) on which on both sides of the workpiece, the same remaining grinding allowance (s_0) with respect to the set-point location of the faces to be machined, exists. The dissimilar feed speeds (v_3 ; v_3') are matched to one another such that the point (P3) at which the same remaining grinding allowance (s_0) exists on both sides is reached from both sides at the same instant (t_3).

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