

Title (en)
Improved grinding process and apparatus

Title (de)
Verbessertes Schleifverfahren und Vorrichtung

Title (fr)
Procédée et appareil de meulage amélioré

Publication
EP 0903200 B1 20040421 (EN)

Application
EP 98307403 A 19980914

Priority
GB 9719969 A 19970920

Abstract (en)
[origin: EP0903200A1] A grinding machine, particularly for grinding the crankpins (12) of a crankshaft, comprising a CBN grinding wheel (10) and a coolant nozzle (14) supplying a jet of coolant into the region being ground. During the final stage of grinding, when the slow feed of the wheel ceases and the dwell point is reached, a selector valve (18) is operated which reduces the coolant flow. This in turn reduces the lateral force on the crankpin and improves the roundness accuracy of the ground crankpin. <IMAGE>

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B24B 55/03; **B24B 57/02**

IPC 8 full level
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CPC (source: EP)
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Cited by
JP2015116652A; US6767273B1; GB2391188A; GB2391188B; FR2949368A1; JP2019076962A; US9999960B2; WO0130536A1; WO0130534A3; JP2014024122A

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