

Title (en)
METHOD AND GRINDING TOOL FOR HIGHLY ACCURATE CENTRE-LESS GRINDING OF SHAFT PARTS WITH HIGH SURFACE QUALITY

Title (de)
VERFAHREN UND SCHLEIFWERKZEUG ZUM HOCHGENAUEN CENTERLESS-SCHLEIFEN VON WELLENTEILEN MIT HOHER OBERFLÄCHENGÜTE

Title (fr)
PROCÉDÉ ET OUTIL DE RECTIFICATION POUR LA RECTIFICATION SANS CENTRE HAUTE PRÉCISION D'ÉLÉMENTS DE TYPE ARBRE, À UN HAUT NIVEAU DE QUALITÉ DE SURFACE

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Application
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Abstract (en)
[origin: WO2014124907A1] Disclosed is a grinding tool (1) for highly accurate centre-less grinding in continuous process for shaft-like workpieces (16), comprising at least one conical (3) and one cylindrical grinding region (4). With its first grinding cover (13), the conical grinding region (3) is primarily intended for grinding larger cutting volumes, whereas the cylindrical grinding region (4), with its second grinding cover (14) is primarily intended for achieving the highest surface quality, without, in the case of the latter, having to remove large cutting volumes. The grinding covers (13, 14) differ at least in respect of the grinding agent used, CBN preferably being used in the conical region and diamond being used in the cylindrical region. Further disclosed is a method, which works with the grinding tool (1) as per the invention and which grinds the shaft-like workpieces (16). Oversize and surface quality are at least temporarily simultaneously ground.

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