

Title (en)

METHOD AND DEVICE FOR SIMULTANEOUSLY TIP FREE ROTARY GRINDING OF MULTIPLE WORKPIECES

Title (de)

VERFAHREN UND VORRICHTUNG ZUM SIMULTANEN SPITZENLOS-RUNDSCHLEIFEN MEHRERER WERKSTÜCKE

Title (fr)

PROCEDE ET DISPOSITIF DE RECTIFICATION CYLINDRIQUE SANS POINTE SIMULTANEE DE PLUSIEURS PIECES USEEES

Publication

**EP 3269500 B1 20190130 (DE)**

Application

**EP 16179084 A 20160712**

Priority

EP 16179084 A 20160712

Abstract (en)

[origin: US2018015587A1] A method and device for simultaneous centreless cylindrical grinding of multiple workpieces (11, 12, 13, 14), at least sections of which are rotationally symmetrical, the workpieces are arranged on a support apparatus (200) one behind the other between at least one grinding wheel (110) and at least one regulating wheel (120), and wherein the axis of rotation of the regulating wheel is inclined with respect to a horizontal plane extending parallel to the workpiece axes of rotation and the grinding wheel axis of rotation by an inclination angle ( $\alpha$ ). During grinding the workpieces are arranged with a height offset relative to each other corresponding to at least a quarter of the inclination angle ( $\alpha$ ) of the axis of rotation of the regulating wheel with respect to the parallel plane to render the respective bearing angles ( $\gamma$ ) of the workpieces on the inclined regulating wheel consistent.

IPC 8 full level

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CPC (source: EP US)

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