

FBB Grinding Wheel

■ Polishing performance for **multiple materials**

Metals

Materials				Surface roughness		Stock removal	Plunge			Traverse			
							Depth of cut	Contact time	Spark-out	Depth of cut	Feed speed	Pass	Spark-out
EN	W.-nr	ANSI	JIS	μmRa	μmRz	μm	μm	sec	sec	μm	m/min	Pass	Pass
AlCuMg2	—	2124	A2024	0.074	0.61	15	30	7	35		1.3	1	5
GD-AISI12	—	A413.0	A6061	0.055	0.45	15	30	7	35		1.3	1	5
X5CrNi18-10	1.4301	304	SUS304	0.035	0.28	15	30	7	7		1.3	1	1
X6Cr17	1.4742	430	SUS430	0.034	0.29	15	30	7	7		1.3	1	1
X5CrNiCuNb16-4	1.4542	UNS S17400	SUS630	0.031	0.25	15	30	7	7		1.3	1	1
Titanium alloy			64Ti	0.057	0.46	10	30	7	35		1.3	1	5
C45E	1.1191	1045	S45C	0.029	0.26	14	30	7	7		1.3	1	1
25CrMo4	1.7262	4130	SCM415	0.021	0.18	3	30	7	7		1.3	1	1
100Cr6	1.3505	52100	SUJ2	0.034	0.31	5	50	7	7		1.3	1	1

