

# FBB Grinding Wheel

## ■ Polishing performance for **multiple materials**

### Plastics

Materials		Surface roughness		Plunge				Traverse					
Matrix	Fillers/Reinforcing	Fiber	$\mu\text{mRa}$	$\mu\text{mRz}$	Stock removal	Depth of cut	Contact time	Spark-out	Depth of cut	Feed speed	Pass	Spark-out	
	materials	Content			$\mu\text{m}$	mm	sec	sec	$\mu\text{m}$	m/min	Pass	Pass	
Thermoplastic	POM	-	-	0.049	0.6	6	30	7	35	30	1.3	1	5
	polyacetal	Carbon Fiber	20%	0.16	1.8	5	60	7	35	30	1.3	1	5
		Glass Fiber	25%	0.17	2.3	12	30	7	7	30	1.3	1	1
	PTFE	-	-	0.16	1.5	10	30	7	7	30	1.3	1	1
	polytetrafluoroethylene	Glass Fiber	-	0.37	4.2	8	30	7	7	30	1.3	1	1
Thermosetting	PF	Paper	-	0.44	3.2	23	40	7	35	40	1.3	1	5
	phenol-formaldehyde resin	Fabric	-	0.23	1.8	20	40	7	35	40	1.3	1	5
	EP	Carbon Fiber	-	0.53	4.5	14	55	7	35	55	1.3	1	5
	epoxy resin												

