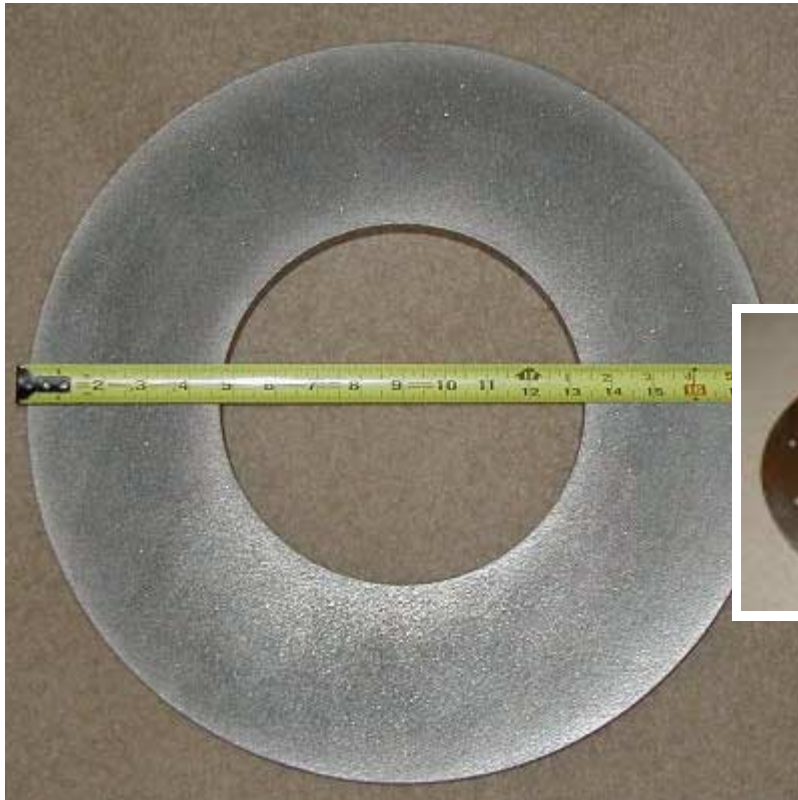
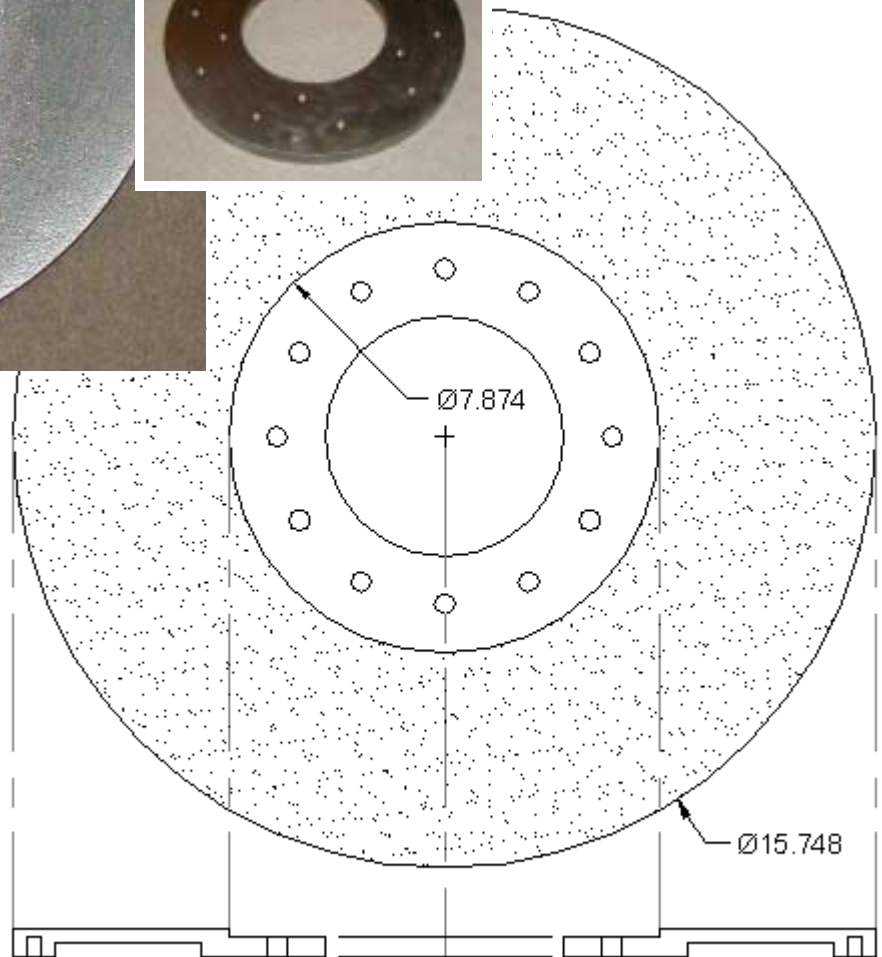


CBN Discs for Spring Grinding



CBN plated disc wheels are available for most types of spring grinders including: OMD, Bennet, and Moyer machines. Superabrasive CBN discs:

- require less size adjustment
- produce less heat when grinding
- Grind faster or last longer
- produce more consistent quality



The CBN (cubic boron nitride) crystal can be electroplated with a nickel based bond on most steel surfaces. While this CBN coating is only the thickness of an average 60 grit grain (about 0.011 inch), the normal wheel life often exceeds a conventional aluminum oxide disc wheel several inches thick. The exposed grain in a plated wheel is very open and reduces loading during grinding.

CBN is used on double disc spring grinders with good bearings, and spindle speeds that exceed 6,000 SFM. For best results the disc center hole should be about half the diameter.

CBN plated disc wheels are manufactured to your design for each machine's mounting pattern. Wheels up to 18 inches in diameter can be plated. Discs are normally ½ to 1" thick and have a slight leading edge designed for a range of spring wire. Typical wires ground range from 0.020" to 0.062" diameter. Used CBN discs can be stripped and re-plated with new grits if the steel disc is not damaged.



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