

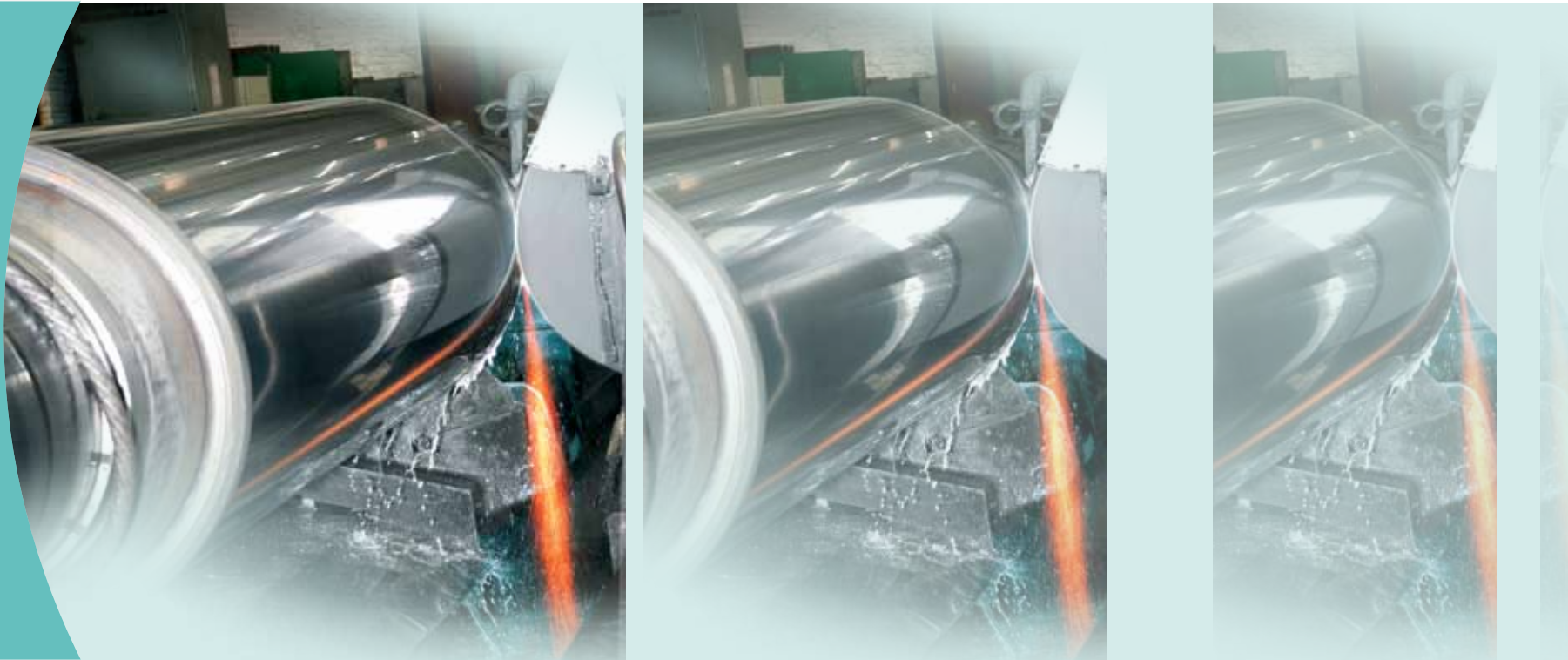
SWATY COMET



Industrial Grinding Tools

12. ROLL GRINDING



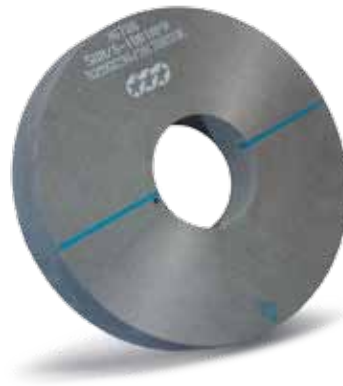
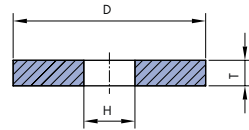




Swatycomet also produces grinding wheels for grinding of new rolls and renewal of used rolls.
 For final grinding of new rolls, two different granulations (rough and fine) are recommended, and the grain to be used depends on the grinding wheel size.
 Due to different types of bonds, grinding wheels can be used at peripheral speeds ranging from 25 to 63 m/s.
 For special materials, such as ASP and WIDIA, tools with CBN and DIAMOND abrasives are produced up to 600 mm in diameter.

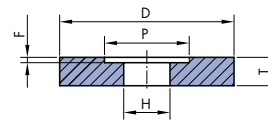
Grinding wheel 1

D x T x H



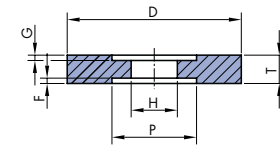
Grinding wheels 5

D x T x H - P x F



Grinding wheels 7

D x T x H - P x F/G



D (mm)	T (mm)	H (mm)
350	38	127
600	50, 60, 70, 100, 125	203.2, 304.8
700	60, 80, 100, 125	304.8
750	80, 100, 125	304.8
762	80, 100, 125	304.8
800	80, 100, 125	304.8, 381
900	80, 100, 150	304.8, 355, 457.2
920	80, 100, 127, 150	304.8, 355, 457.2, 508
1000	60, 75, 80, 100, 127, 150	304.8, 355, 457.2, 508
1065	80, 100, 127	406.4

Machines:
 Waldrich, Herkules, Landis, Schaudt, Churchill, Fortuna, Farrel, etc.

Order printout sample:
 1 900x100x304.8
 S29GC36/2J7BX03L



Roll production

Casts	Rough grinding	51C16/4R4B18
	Final grinding	C80/3H9V60
Steel	Rough grinding	8A54/3IJ7V835
	Final grinding	C120/1H11V60

Steel production

Hot milling - Roll renewal

Working rolls	Casts	Rough	Standard	S9C36/2J7BX03
			High stock removal	S29GC36/2J7BX03
		Fine	Standard	S9C36-60K7BX03
			High stock removal	S29GC36-60J7BX03
	Forged rolls	Rough grinding		S2A46/3K7BM03
		Rough grinding		S2A60/3J7BM03
		Final grinding		C80/2I7V60

Cold milling - Roll renewal

Working rolls	Standard	S2A46/3K7BM03
	High stock removal	S68C36-60 J-B
Back up rolls	Standard	S2A46/3K7BM03

Sendzimir rolls

Thrust bearings	68C60J-B
Back up rolls	68C60J-B
Drive rolls	68C60J-B
Intermediate rolls	68C60J-B
Working rolls	S29GC100/1F10BX03
Working rolls - fine grinding	9C180/9E11BX50/300
Chromium cast rolls	2A60/3J7V
ASP working rolls	102B 46-151R100B47S
WIDIA working rolls	101D 46-151R100B40S

Copper and aluminium mills

Plate	2A60 - 80 H10/3V35 (standard)	8A54 - 60I7V835 (high stock removal)
Sheet	9C150 - 180G-H10/3V35	
Aluminum foil	SC220/1D11BK03L	

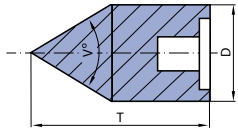
Grinding of rubbered rolls

Hard rubber	2A30/1G13/1V
Hard rubber - fine grinding	2A54/1G13/1V
Soft rubber	1A24/1I7+V
Soft rubber - fine grinding	C60/1G13/1V
Calender rolls	8A60/1H8/6V

Products of other dimensions can be made to special order.

**Grinding cones SGY**

D x T x H - V

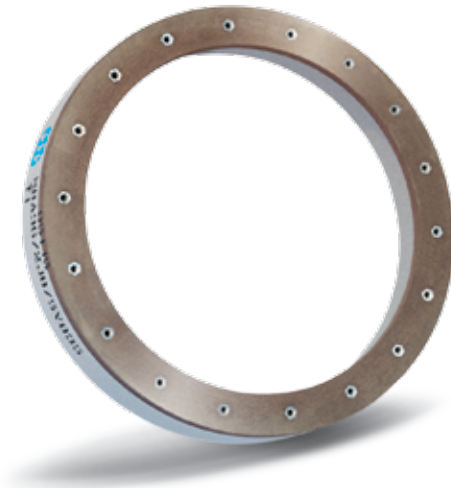
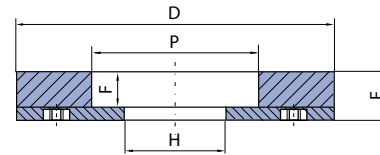


Grinding of threaded center bores in rolls

Type SGY	Specification
18 x 35	8A120/2L9V835
26 x 38	8A120/2L9V835
50 x 39	8A120/2L9V835

Grinding wheels 36

D x T x H - P x F



Grinding length

Type / Dimension	Specification
36 D x T x H - P x F	8A36/2J8V835



Grinding wheel peripheral speed

Material	Type of grinding	m/sec	Infeed - mm/feed	Longitudinal feed
Casts	Coarse production grinding	45-63	0.25	1000 mm/min
	Fine	35-50	0.010-0.020	5000 mm/min
	Renewal grinding	35-40	0.010-0.030	3000 mm/min
Steel	Rough production grinding	35-63	0.020-0.030	5000 mm/min
	Fine renewal grinding	25-30	0.002-0.005	3000 mm/min

Cooling:

Quantity in l/h	200-600 l/min (depending on the grinding wheel's diameter)
Pressure	3-5 bar
Nozzle	Minimal grinding wheel's thickness x 3 mm

Order printout sample:
SGY 26x38x8-V60
8A80/2L8V835



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