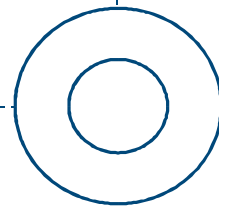


PRODUCT INFORMATION



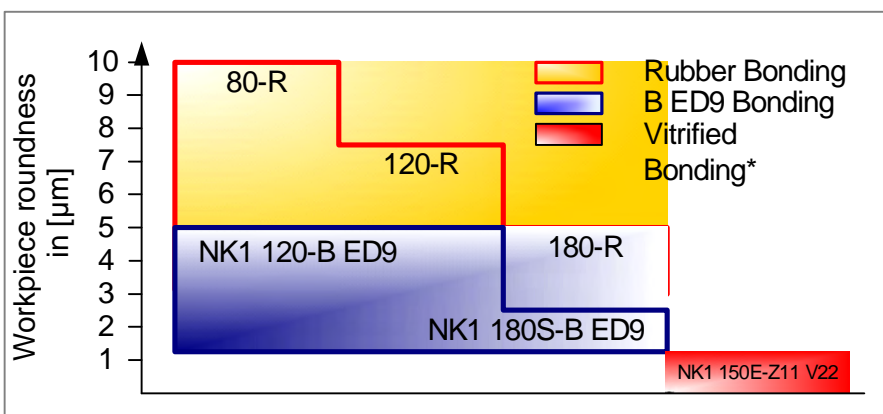
Control wheels in B ED9 – bonding for centerless thrufeed and plunge grinding operations

ATLANTIC can now offer control wheels in **B ED9 Bonding**, a recently developed alternative to the widely used rubber or resin bonded control wheel. ATLANTIC **B ED9** bonded control wheels are a definite prerequisite for a more economic method of manufacture, with particular regard to the ever increasing demands on workpiece quality i.e. roundness.

In particular, the extremely homogeneous structure within the grain-bonding matrix guarantees a constant and even pressure over the total grinding zone. Uneven wear of the control wheel, which results in variations in the workpiece geometry, is thus eliminated.

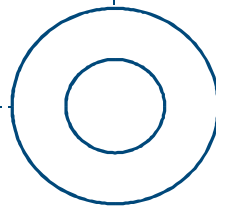


During the centerless grinding process, interruptions on the surface of the workpiece e.g. cross-holes, gear teeth, slots etc. have a profound influence on workpiece roundness. For such workpieces and instances with extremely high stock removal, the **B ED9 bonded** control wheel has universally proven that the increased demands of this complex grinding process have been met, and thus allow for a further productivity increase using the centerless grinding method.



control wheel has universally proven that the increased demands of this complex grinding process have been met, and thus allow for a further productivity increase using the centerless grinding method.

*We recommend our **vitrified bonded** control wheels in in **NK1 150E-Z11 V22** for extreme and severe applications.



GRADE RECOMMENDATIONS / DIMENSIONS

Thrufeed grinding

Standard	(workpieces with $\varnothing > 10$ mm etc.)	NK1 120-B ED9
Medium	(workpieces with interrupted cut or $\varnothing < 10$ mm)	NK1 120S-B ED9
Hard	(workpieces with interrupted cut and $\varnothing < 10$ mm)	NK1 180S-B ED9
Bar grinding	(Steel industry)	NK1 120S-B ED9

Plunge grinding

Standard	(workpieces with $\varnothing > 10$ mm etc.)	NK1 120S-B ED9
Medium	(workpieces with interrupted cut or $\varnothing < 10$ mm)	NK1 150S-B ED9
Hard	(workpieces with interrupted cut and $\varnothing < 10$ mm)	NK1 180S-B ED9

Control wheel outer diameter

Available range of control wheel OD in [mm]	Commonly used control wheel OD in [mm]
from 100 to 406,4	100-200 (8" = 203,2)
	220-225-230-250 (10" = 254,0)
	270-280-300 (12" = 304,8)
	315-330-340-350 (14" = 355,6)
	360-400 (16" = 406,4)

Dimensions in () = Inch sizes

Control wheel width

Available control wheel width in [mm]	
In one part	from 10 to 305
In 2 resp. 3 parts	> 305

Control wheel bore dimensions

Common bore dimensions in [mm] and (Inch)					
127 (5")	140	152,4 (6")	165	203,2 (8")	280 (11")

(other bore dimensions available on request)