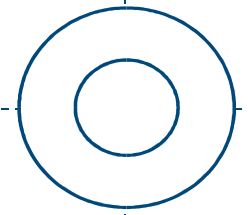


PRODUCT INFORMATION



Control Wheels for Centerless Thru feed and Plunge Grinding in the B ED9 - Bonding

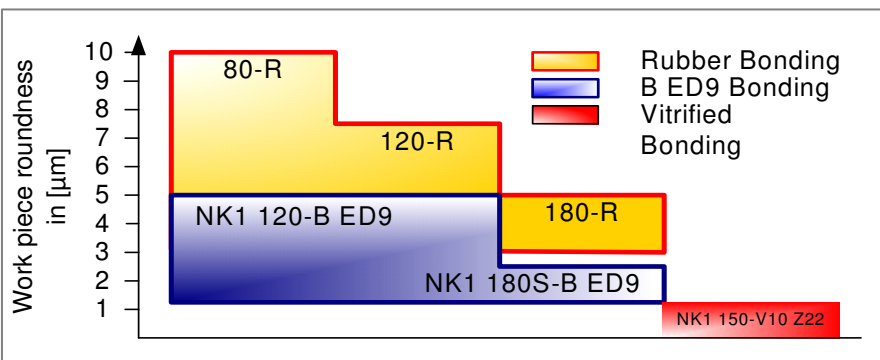
As a recently developed alternative to the widely used rubber or resin bonded control wheels, **ATLANTIC** can now offer the **B ED9 Bonding**. **ATLANTIC** control wheels in the **B ED9 Bonding** enable an economical and stable production process capable of meeting the increasing demands placed on work piece quality, especially with regards to roundness.

In particular the regular distribution of grain within the bonding matrix guarantees a constant and even application of pressure over the entire length of the grinding zone. Uneven control wheel wear is therefore eliminated and the associated variation in work piece quality is greatly reduced.



Interruptions to the work piece surface e.g. holes, slots etc. have major effect on the achievable work piece roundness, however control wheels in **B ED9 Bonding** have demonstrated,

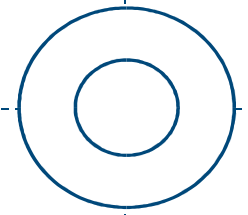
worldwide, that in applications with these work pieces and those demanding high stock removal rates that they enable production processes to keep pace with the in-



creasing re-quirements of this extremely complex grinding operation and have laid the foundations for a further increase in the productivity of centerless grinding.

For processes placing exceptionally high demands on the control wheel (work piece geometry and roundness) we recommend our ceramic bonded control wheel

NK1 150E- Z10 V 22



SPECIFICATION PROPOSALS / WHEEL SIZES

Thru feed grinding

Standard (work pieces $\varnothing > 10$ mm etc.)	NK1 120-B ED9
Medium demands (work pieces with multiple interruptions or $\varnothing < 10$ mm)	NK1 120S-B ED9
High demands (work pieces with multiple interruptions and $\varnothing < 10$ mm)	NK1 180S-B ED9
Bar grinding (Steel industry)	NK1 120S-B ED9

Plunge grinding

Standard (work pieces $\varnothing > 10$ mm etc.)	NK1 120S-B ED9
Medium demands (work pieces with multiple interruptions or $\varnothing < 10$ mm)	NK1 150S-B ED9
High demands (work pieces with multiple interruptions and $\varnothing < 10$ mm)	NK1 180S-B ED9

Control wheel outer diameter

Range of outer diameters [mm]	Commonly used control wheel OD [mm]
100 – 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)

Inch values in brackets

Control wheel width

Range of control wheel widths [mm]	
Single piece	10 - 305
In 2- or 3- pieces	> 305

Control wheel bore diameters

Common bore diameter sizes [mm] and (inch)					
127 (5")	140	152,4 (6")	165	203,2 (8")	280 (11")

(for other sizes please contact our sales team)