

NaxoForce

SUGGESTED OPERATING PARAMETERS FOR NAXOFORCE WHEELS

TRUING SPEEDS & FEEDS

	<u>ENGLISH</u>	<u>METRIC</u>
Soft Fine Grit Silicon Carbide Wheel:	1980-3960 sfpm	10 - 20 m/s
CBN / Diamond wheel speed:	594 - 990 sfpm	3 - 5 m/s
Oscillation Feed:	11,8 – 39,4 in/min	300 -1000 mm/min
Infeed / Turning point:	0,0008 – 0,0028 in	0,02 – 0,07 mm

DRESSING STICK (soak in water 5 min)

CBN / Diamond wheel speed:	2970 3960 sfpm	15-20 m/s
Rotation of CBN / Diamond wheel same as during grinding and <u>push</u> the Dressing Stick firmly into the Rotating Wheel		

CLAMPED DRESSING STICK (soak in water 5 min)

CBN / Diamond wheel speed:	2970 - 3960 sfpm	15 - 20 m/s
Depth:	0,02 – 0,04 in	0,5 - 1 mm
Feedrate:	11,8 – 19,7 in/min	300 - 500 mm/min

NaxoFlute Wheel

Roughing:	2954 - 3564 sfpm	15 - 18 m/s
Finishing:	5940 - 6930 sfpm	30 - 35 m/s
Finishing Depth:	0,0008 – 0,002 in	0,02 – 0,05 m

NaxoEdge Wheel (Gashing)

Large Gash:	3960 sfpm	20 m/s
Small Gash:	5940 sfpm	30 m/s

Radial Backing Off (Drills)

	3960 - 4950 sfpm	20 25 m/s
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NaxoClear Wheel

Primary Angle:	4950 - 6930 sfpm	25 - 35 m/s
Secondary Angle:	3960 - 5940 sfpm	20 - 30 m/s

NaxoPolish Wheel

Speed:	35 m/s	6930 sfpm
Depth:	.0004-.0008in	0.01-0.02 mm

*Remember: Large Contact Area = Lower Peripheral Speed
Small Contact Area = Higher Peripheral Speed*