

11V9 Diamond Wheels for Carbide Grills and Endmills Grinding on CNC Machines



Specifications

11V9 100 10 3 20 D 64 P107

Operation: External and clearance angles with big depth of pass
Workpiece: Endmills Z3 Ø 14
Material: Tungsten Carbide

Dressing:

Stick: White
Wheel Speed: < 5 m/s
Rotation: Counter Clockwise

Machine:

Brand: Walter Helitronic Power
Spindle: 24 kW
Coolant: Oil (a centralized filtration unit and a chiller is recommended)

Grinding Parameters:

Wheel Speed: 22 m/s
Depth of Pass: 1 mm
Pass:
Feed: 60 – 120 mm/min

Parameters	Roughing	Finishing
Depth of Pass	0,3 1 mm	0,03 mm
Feed	80 mm/min	120 mm/min
Number of Pass	4	1
Dressing Interval	Over 300 pieces	
Wear Radius (after 300 pieces)	R0,2	
Axial Wear	0,01 mm	

Notes:

The extremely high hybrid bonds removal ability with high diamond concentration allows to work with very high depths of pass, not possible with resin bonds, getting the same time an exceptionally good finishing quality. It is necessary, however, to dispose of a sufficiently rigid machine with adequate spindle power and a well suited neat oil cooling system. Under such premises, the fluting operation turns out to become very easy and economic, furthermore you save a dramatic amount of time (at least half of the time you get with other bonding systems) inducing much lower stresses in the workpiece material.