

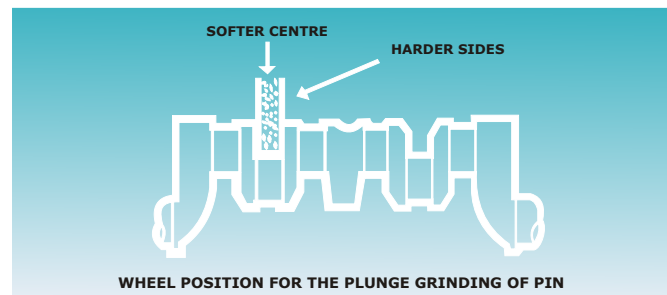
Bonded Abrasives



Crankshaft Grinding Wheels

CUMI's crankshaft grinding wheels are made using special, high performance bond systems in a unique manufacturing process, tailored to suit each market segment. This manufacturing technology coupled with the application engineering expertise offered, makes CUMI's crankshaft grinding wheels highly cost effective. Besides optimising grinding efficiencies, these wheels also provide a surface finish as fine as 4 microns.

CUMI also makes dual grade, sandwich wheels with harder sides and softer centres, ideal for grinding crankshafts of differential hardness in diameter and fillet radius. These provide surface speeds upto 60 mps.



Wheel Types for OEM's

Plain	Sandwich	Dual Grade
Type 5 		

Product Recommendation

Material	Size & Grading	Bond
Forged Steel - Soft	A463 N5 V10; A543L5V10X	V223, V2020, V500
Forged Steel - Hard	A463 I5 V10; DA543K5V2020	VK5
Cast Iron	DA46 I5 V10	VC500, VCAE
Nodular Iron	AA46 L5 V8	VC500, VCAE

Product Range

Abrasive	Diameter	Thickness	Grit	Speed	Hardness	Structure
A	600 - 1200	20 - 50*	46 - 80	45 mps	J - O	3 - 5
DA/AA/SA	600 - 1200	20 - 50*	60 - 80	60 mps	J - O	3 - 5
SG	600 - 1200	20 - 75	60 - 80	60 mps	J - O	6 - 8

*Upto 75mm for replacement market

Crankshaft grinding