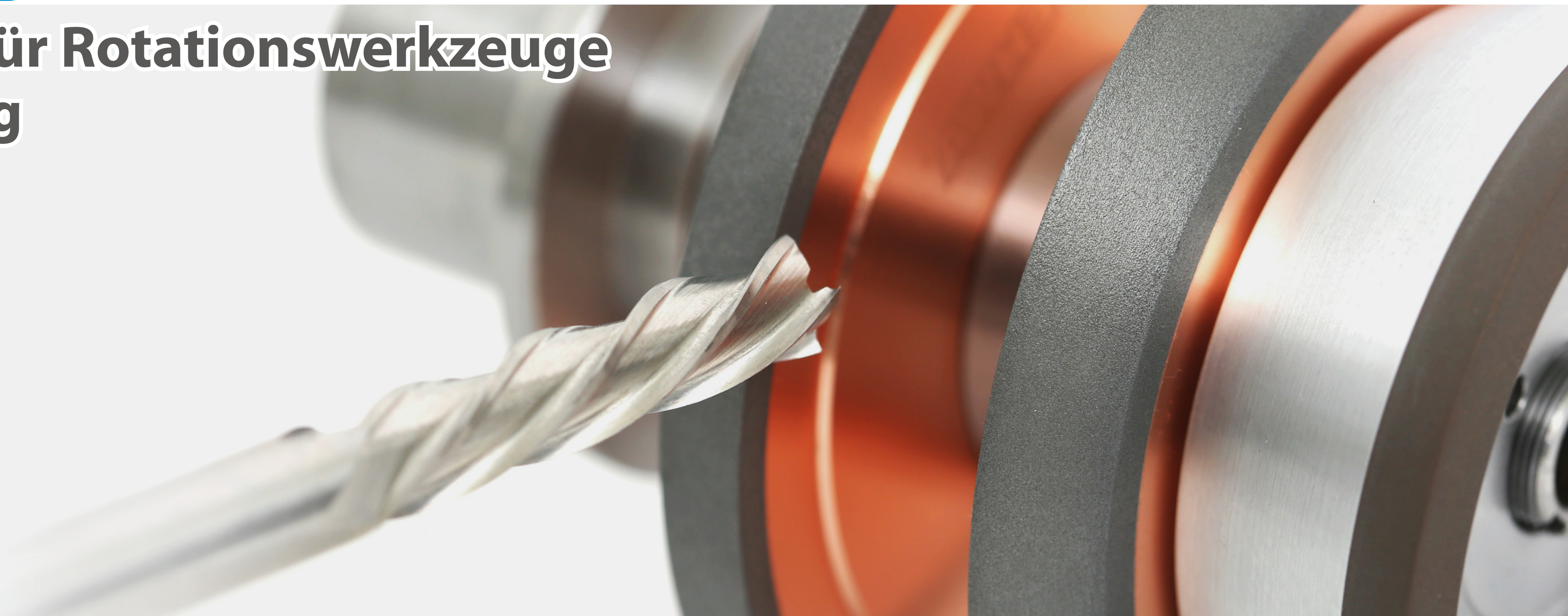
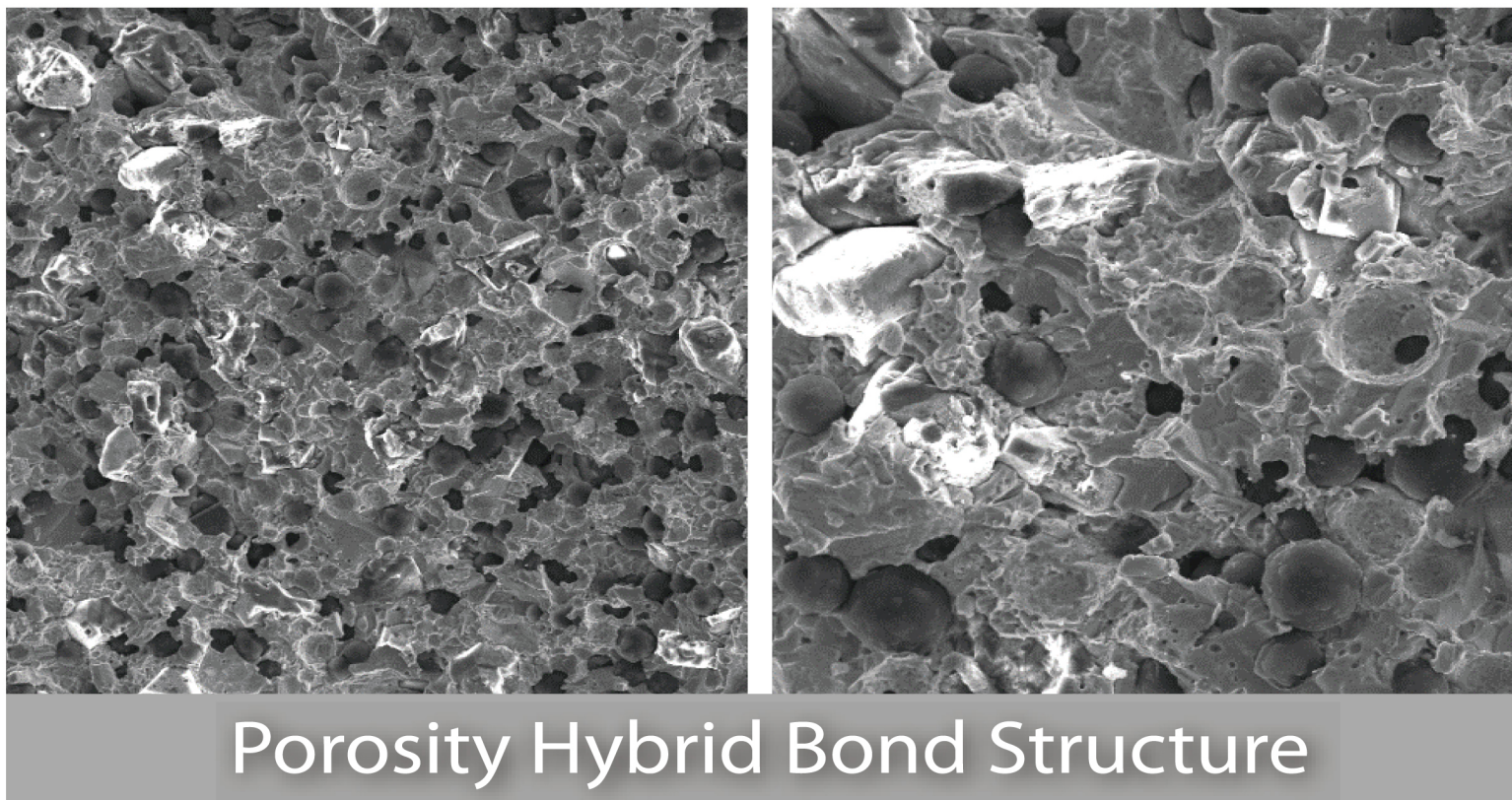


Diamond Grinding Wheel for Rotation Tool

Diamant-Schleifscheibe für Rotationswerkzeuge in poröser Hybridbindung



■ EHWA porosity hybrid wheel shows excellent grinding performance.



Porosity Hybrid Bond Structure



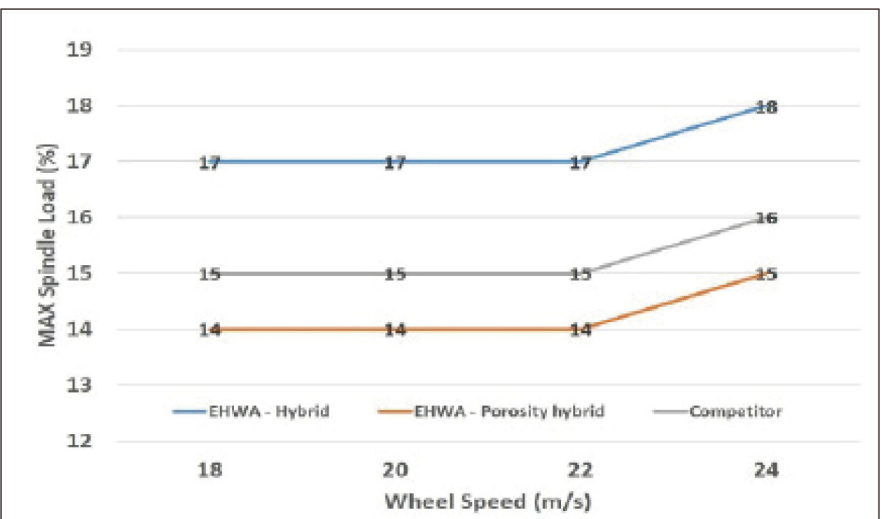
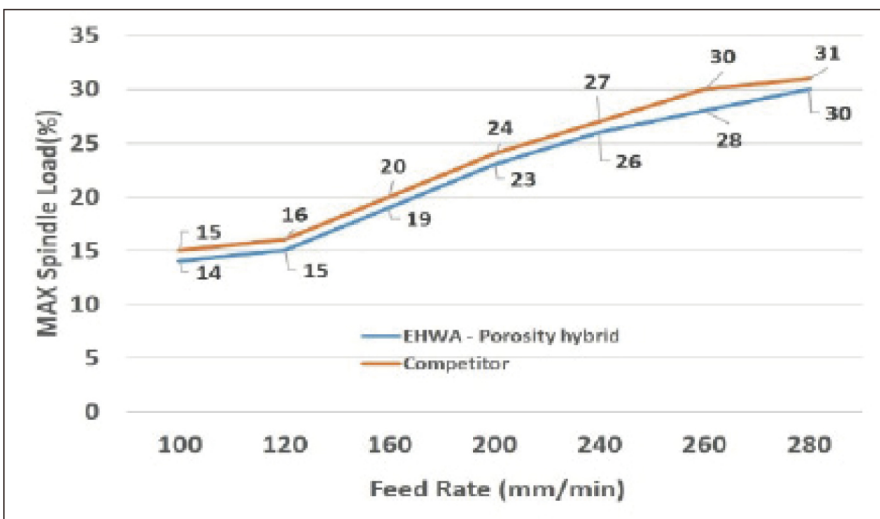
1A1

Advantages

- Longer cycle time
- High feed rates
- Outstanding stock removal rates
- Less residual stress & thermal damage
- High dimensional stability
- Excellent surface finish and edge quality
- Long dressing interval
- Low power consumption

Applications

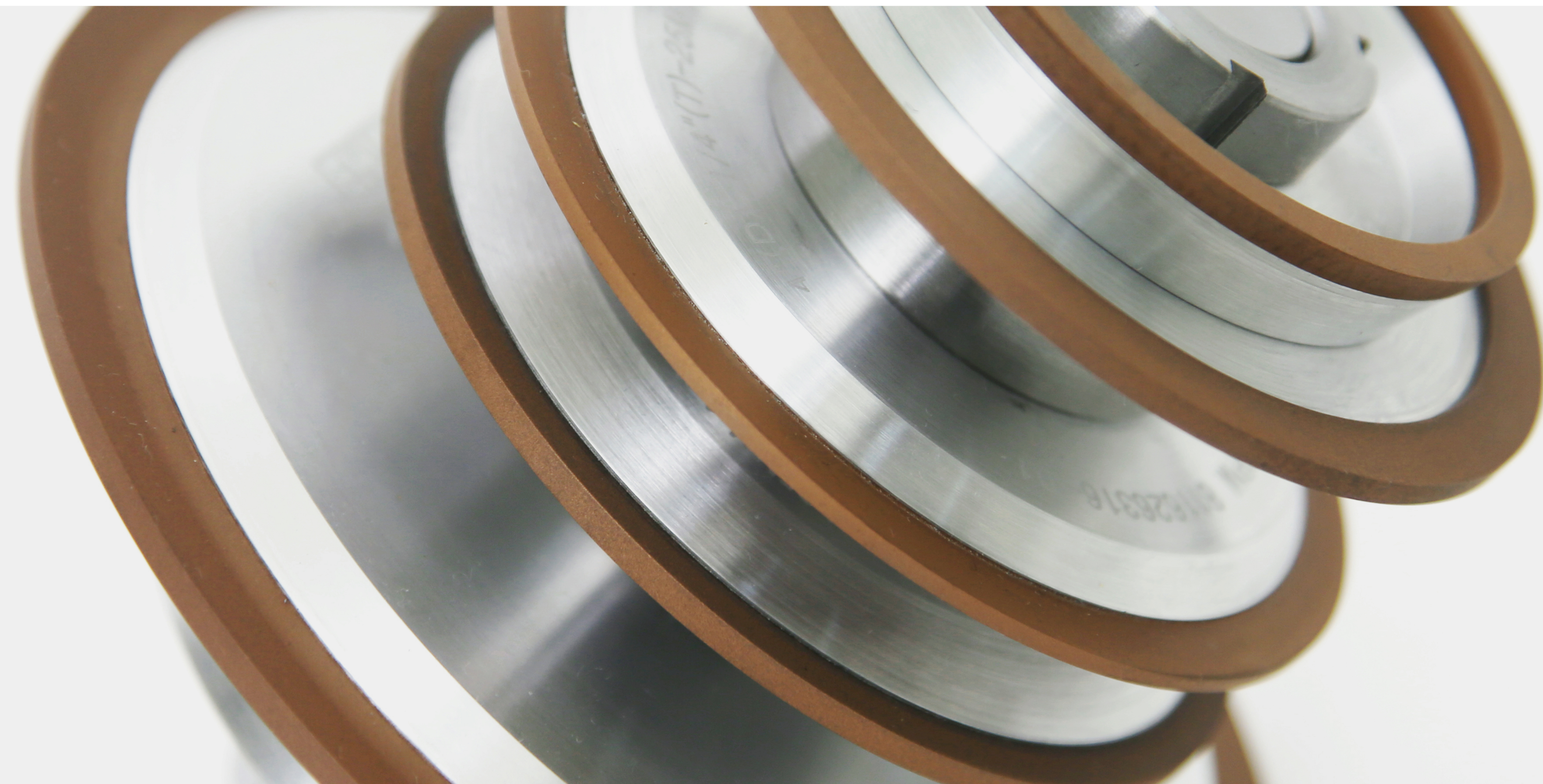
- Fluting tungsten carbide drill and endmills
- Gashing tungsten carbide drills
- Clearance angle grinding
- Test Result
 - M/C : ANCA MX7 Linear
 - SPEC : D54 Porosity hybrid bond



Diamond Grinding Wheel for Micro Rotation Tool

EHWA
SINCE 1975 50TH

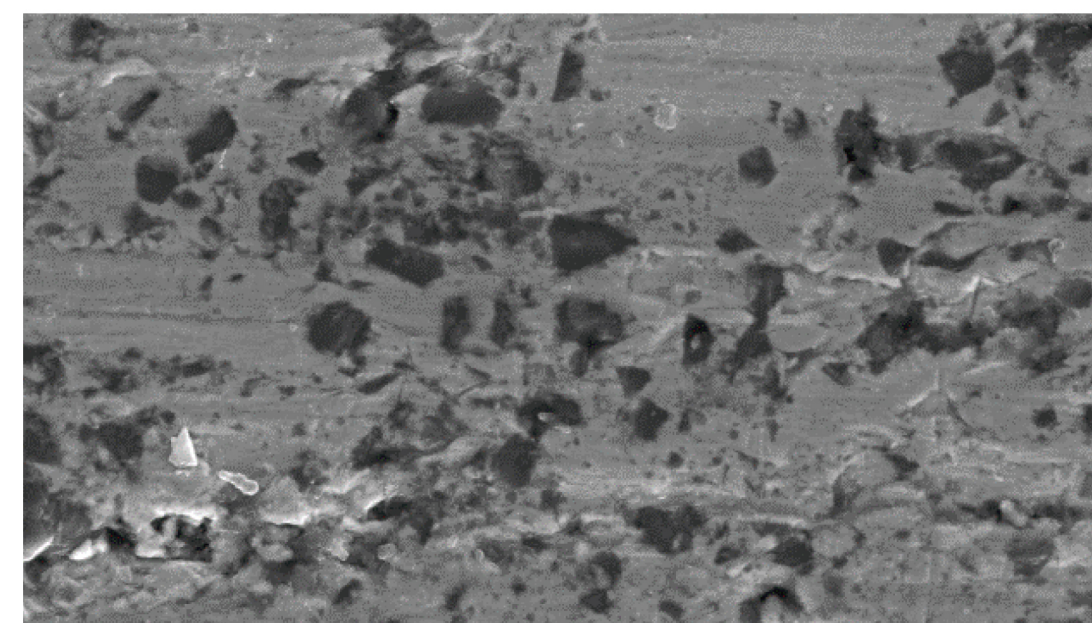
Diamant-Schleifscheibe für Mikro-Rotationswerkzeuge



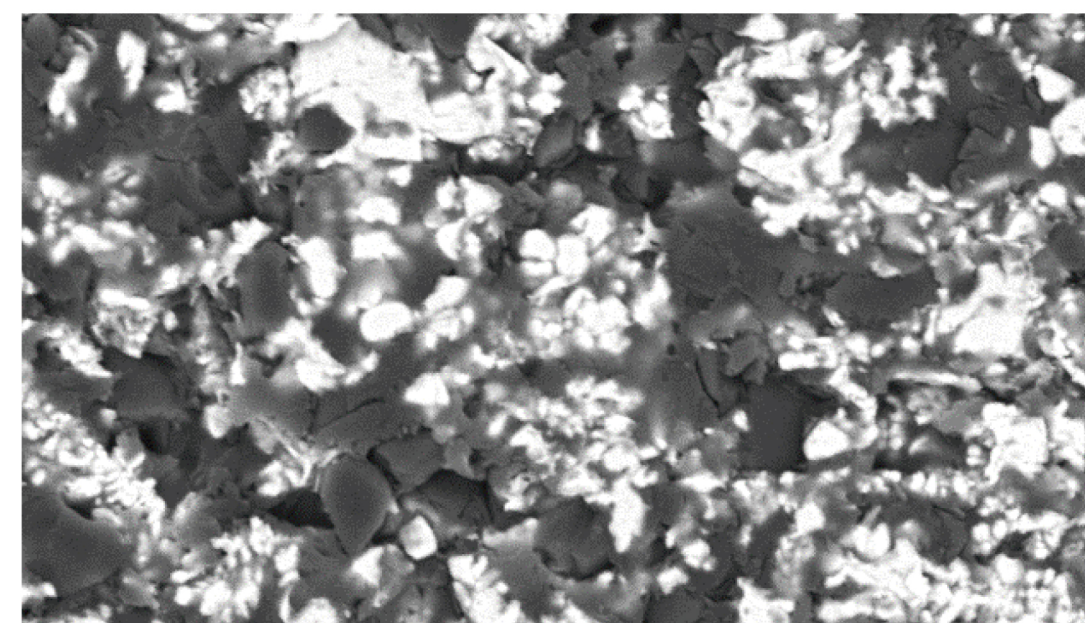
- EHWA Grinding wheel for the micro rotation tool delivers high productivity with the lowest tool cost.

| Advantages |

- High productivity and cost saving
- Excellent heat resistance
- Better surface and edge quality
- Precise dimensional edge stability



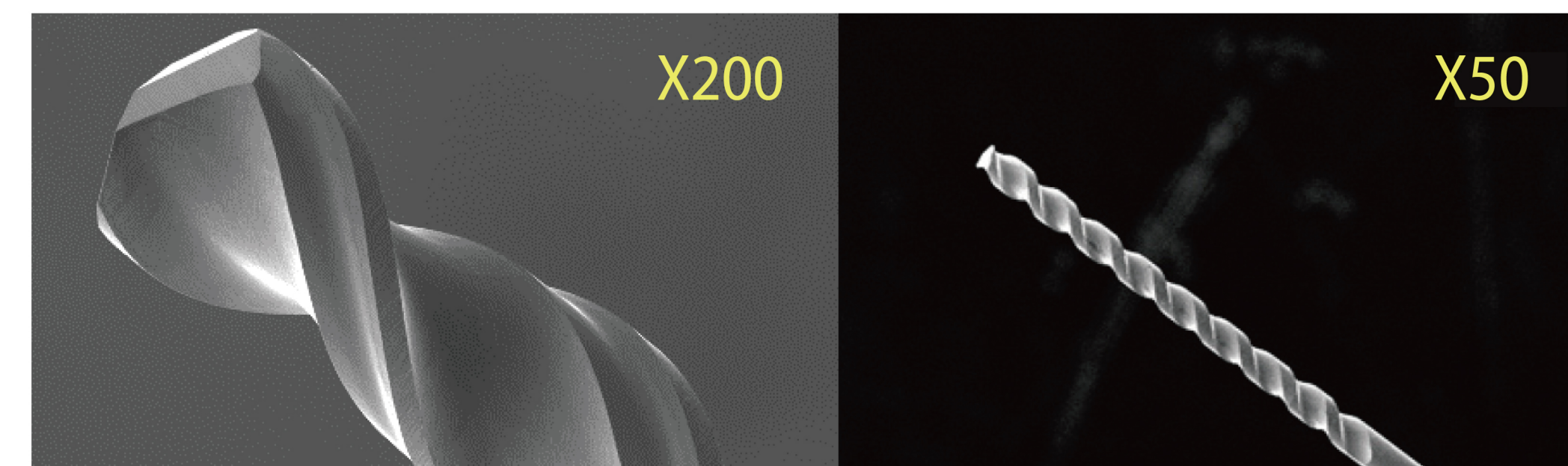
Hybrid bond



High performance Polyimide

| Applications |

- Manufacturing micro rotation tools such as micro drills, micro endmills and router bits
- Machine : ROLLOMATIC, ANCA, and WALTER, etc.



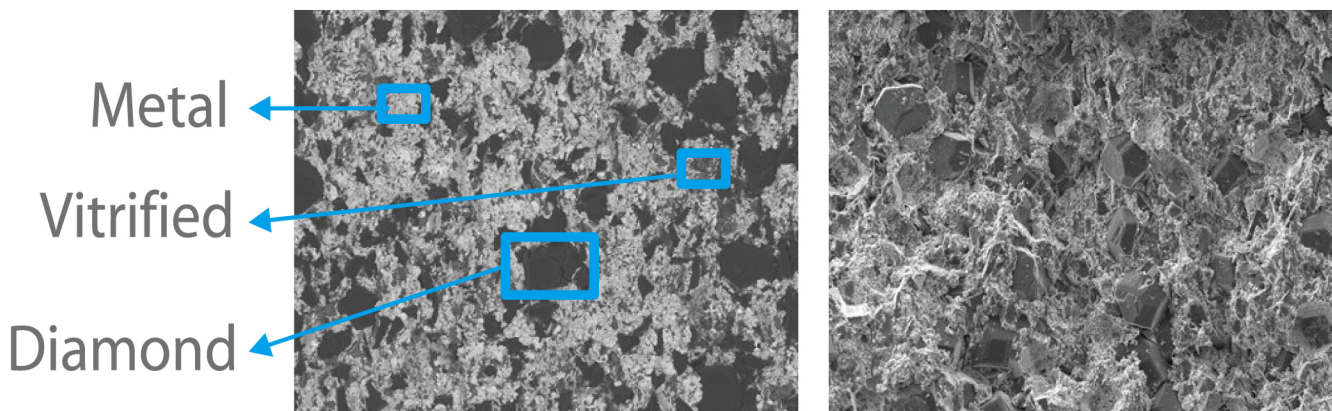
Micro rotation cutting tool

Hybrid-Schleifscheibe in Metall-/Keramikkbindung

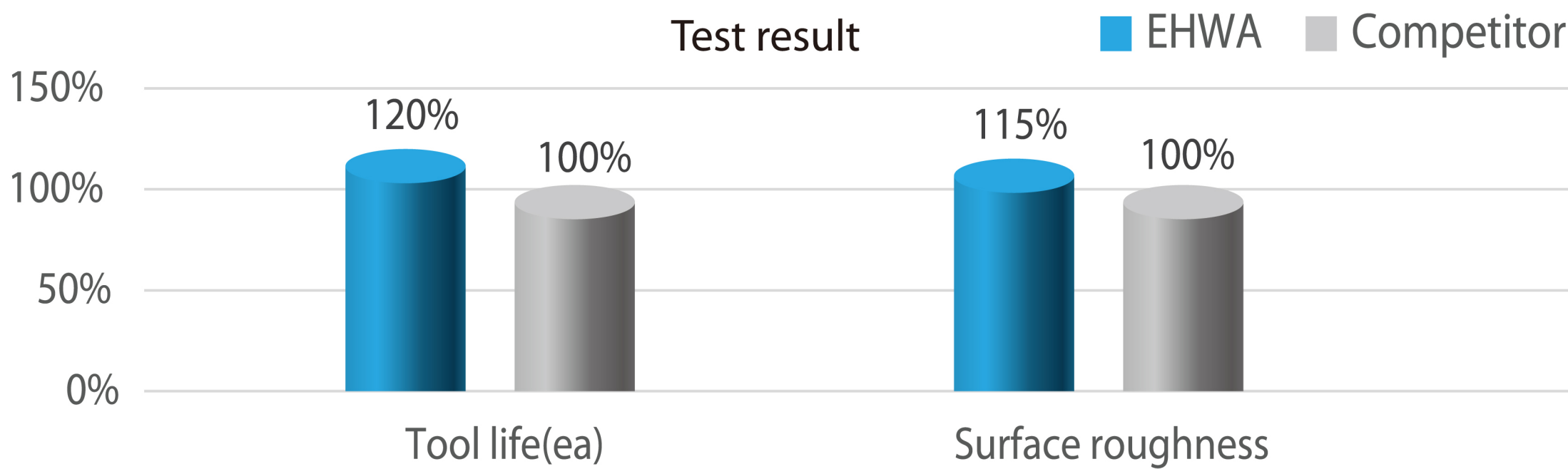


| Advantages |

- Specially developed hybrid wheel, targeting strong wear resistance of metal bond and excellent grinding performance of vitrified bond
- Show long tool life and good profile stability



| Performance |



| Applications |

- Workpiece: TC (Endmill, Drill), Alloy tools, Honing stones for gear

Grit size	Wheel size	Bond MNC
#60~#3000	40D~450D	MJ, MS Series



Vitrified CBN Wheel

EHWA
SINCE 1975 50TH

CBN-Schleifscheibe in Keramikbindung



Grinding parts

① ID (Inner race internal diameter) / ② IR (Inner race) / ③ OR (Outer race) / ④ Lip / ⑤ Ring face

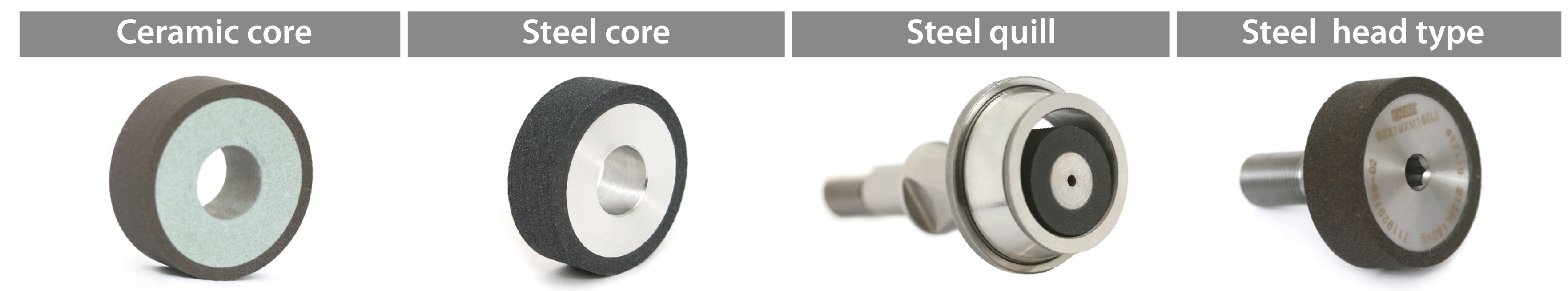
| Advantages |

- Higher removal rates and shorter cycle times
- Reduced grinding force
- Reduced mechanical & thermal damage to the bearing
- Stable and precise grinding performance for superior quality, surface finish, cylindricity and less dimensional deviation

| Grinding Condition |

- Wheel speed : 30 ~ 80 m/s
- Removal amount : 0.1 ~ 0.35mm D
- Dressing amount : 5 ~ 30 μ m
- Dressing ratio : 0.3~0.6
- Dresser : Diamond rotary dresser
- Coolant : Oil, emulsion

| Mounting type |



CV Joint Grinding

EHWA
SINCE 1975 50TH

CV-Gelenkschleifen



Vitrified CBN wheel
for CV joint

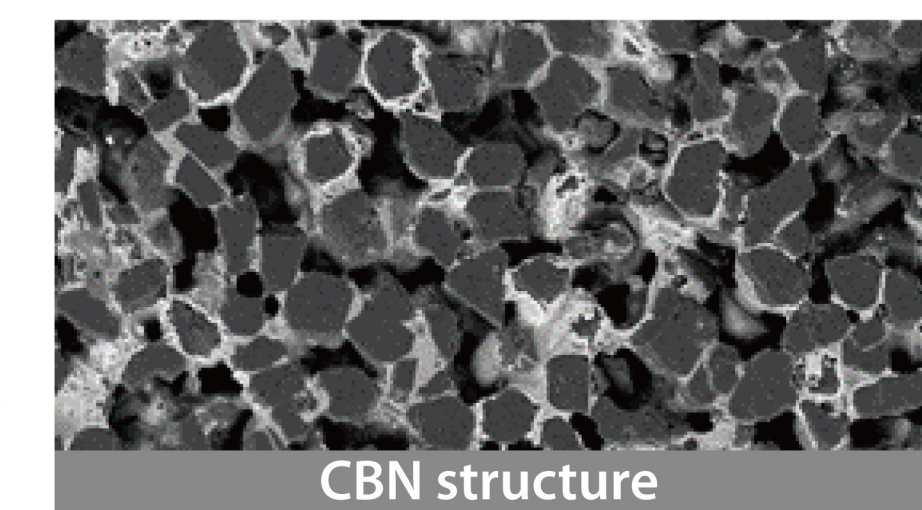


| Advantages |

- High stock removal for improved production capacity
- Outstanding surface quality with low heat and tight tolerance
- Longer dressing intervals & less wheel wear to reduce cost and improve consistency
- EHWA has specialized solution for cv joint part grinding

Cage window grinding

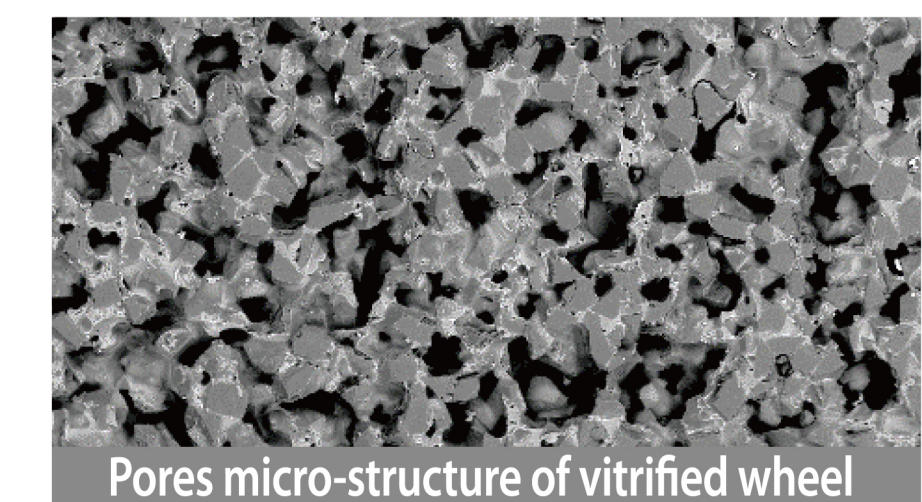
Standard specification
B126M180VBTM



CBN structure

Outer race grinding

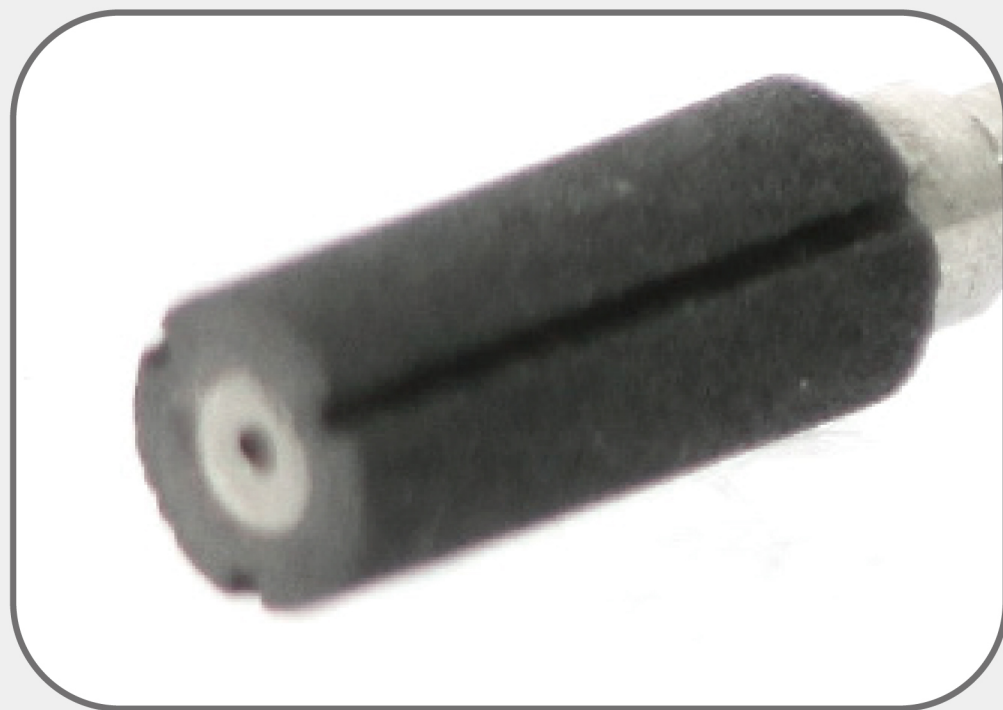
Standard specification
B181M160VBTM



Pores micro-structure of vitrified wheel

Injector Bore Grinding

Einspritzbohrungsschleifen



Bore grinding wheel
for fuel injection



Seat grinding wheel

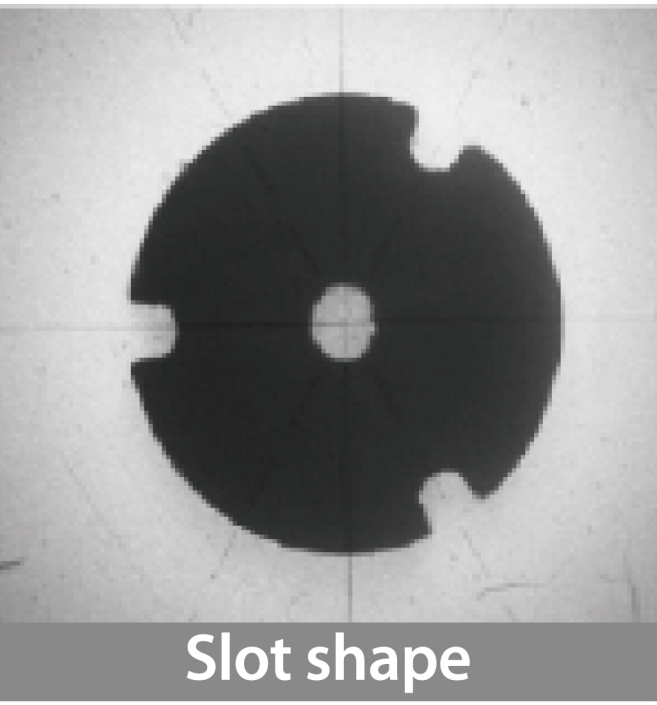


| Advantages |

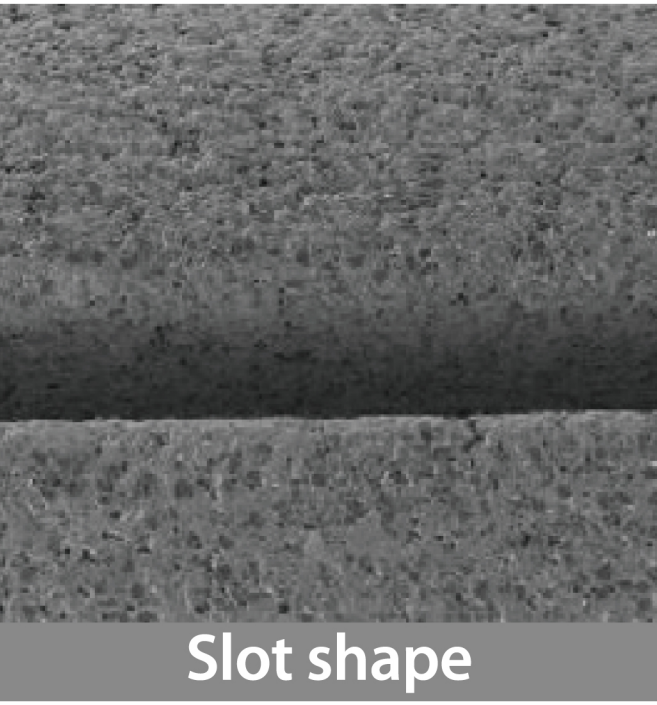
- Free cutting abrasive
- Longer dressing interval & more efficient utilization
- Consistent grinding performance
- Highly precise wheel shape including coolant hole and slots

| Standard Specifications |

Grinding	Bore, Seat
Coolant hole size	H 0.5~1.0mm
Wheel size	D 1.5~20mm
CBN grit size	29μm~76μm
Slot	0.4~1.5mm



Slot shape



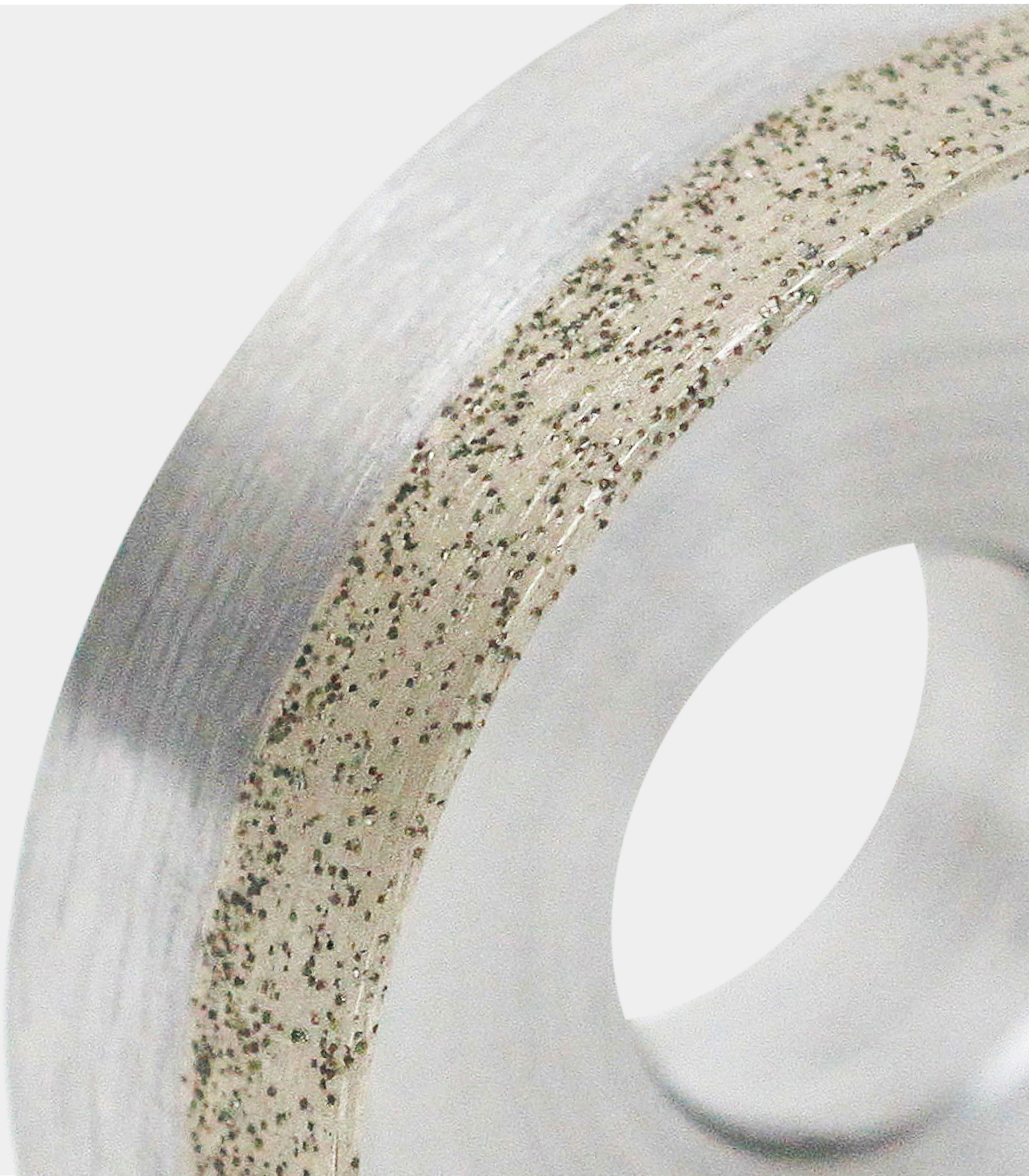
Slot shape

Metal Cup Dresser

Metalltopf-Abrichter



Metal cup dresser
for bearing ID grinding



| Advantages |

- Longer life
 - 20,000~30,000 times (depending on the wheel size)
- Precise dressing
 - Less grinding deviation after dressing
- Longer dressing interval and outstanding performance

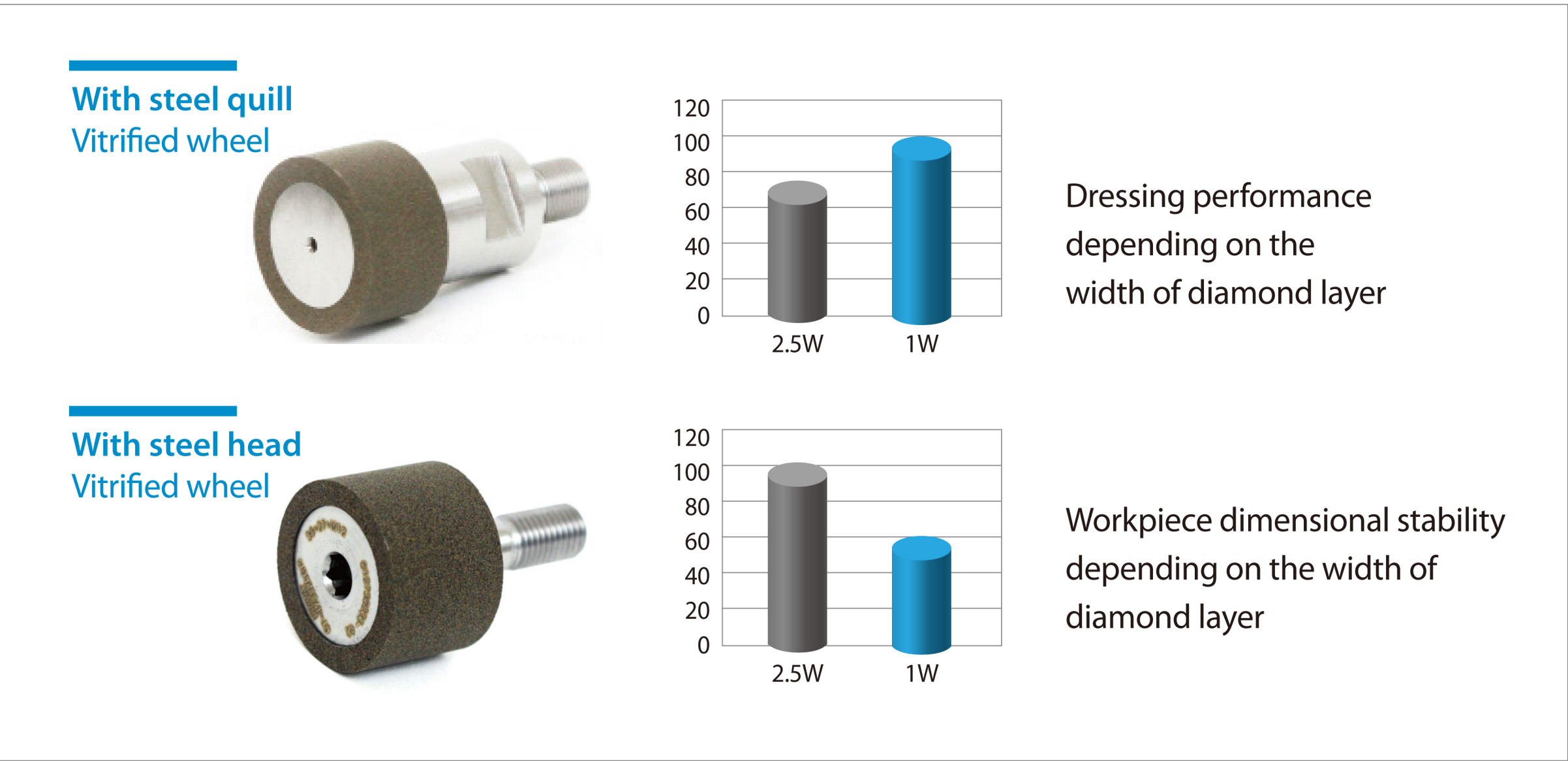


Metal cup dresser



Rotary cup dresser

| Reference |



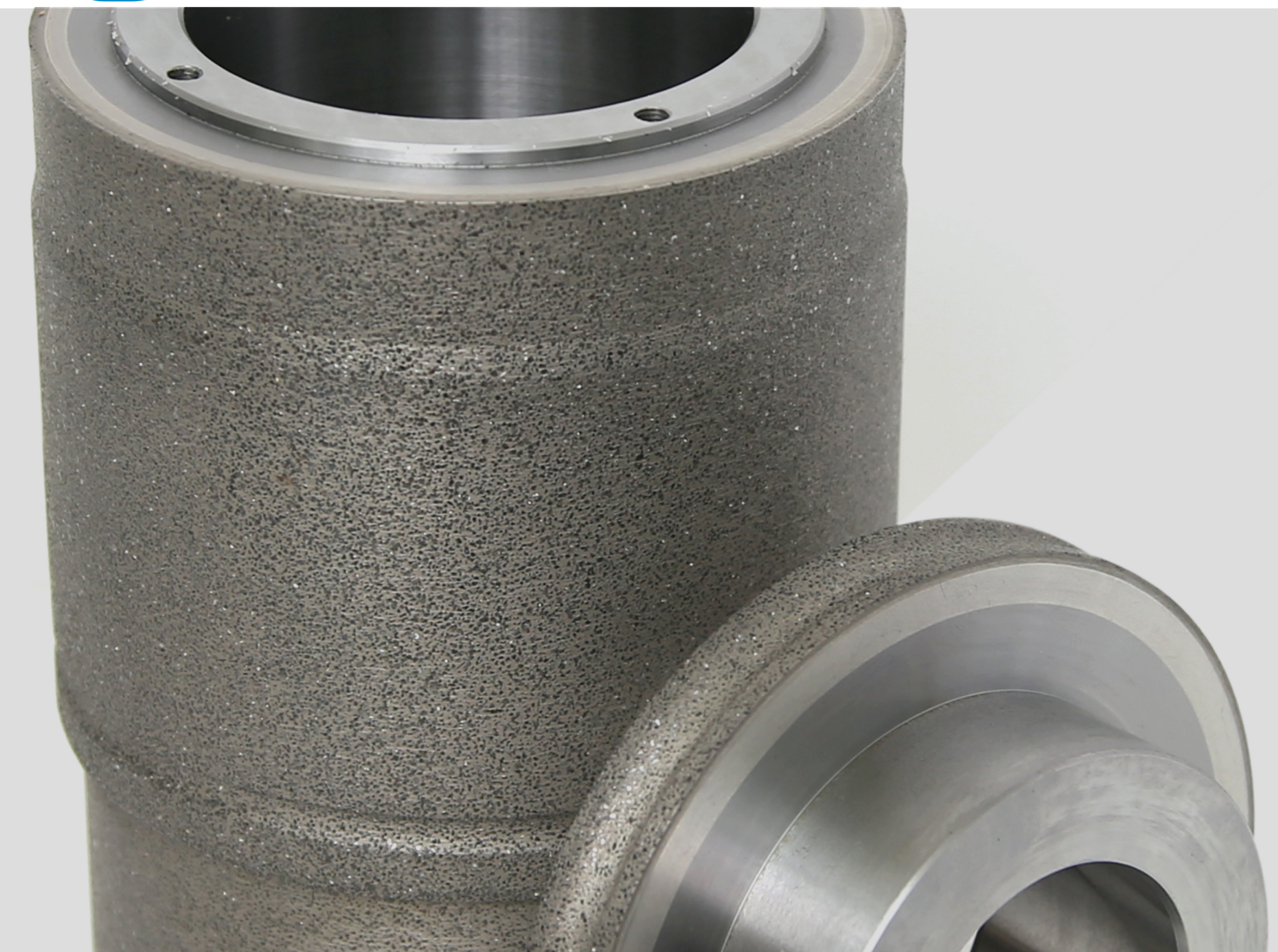
Rotary Dressers for Bearings

EHWA
SINCE 1975 50TH

Abrichtrollen für Lager



Diamond rotary dressers for
ball / roller / hub bearings & water pump bearings



| Advantages |

- Highly precise and complex grinding
- Less dressing load and excellent dressing performance
- Longer tool life and cycle time reduction
- Available for dressing of vitrified CBN wheels

Water pump bearing



Ball bearing



Taper hub bearing

