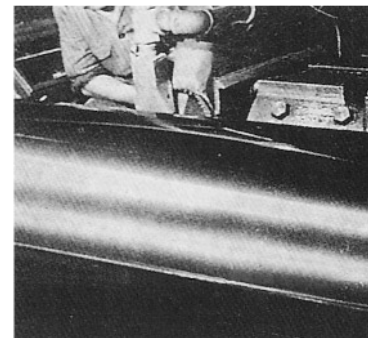


Rolls are widely used on rolling machines in steel mills, paper mills, aluminum, brass, copper industries, etc. Roll grinding wheels are used to regrind the rolls. The operation is similar to cylindrical grinding, except the workpiece is large and geometry and highly accurate surface finishes are required.



ATTENTION:

When ordering, please mark "Roll Grinding Wheel" in your orders.

Starting Specification Recommendation

Application		Wheel Specification	
		Roughing	Finishing
Hot Mill Work Roll	Chilled Iron	GC36-KB	GC80-IB
Back-Up Roll	Forged Steel	32A36-JB	
Cold Mill Work Roll	Hardened Steel	32A80-KB	32A220-KB
Back-Up Roll	Hardened Steel	32A36-KB	
Sendzimir Mill Roll	High Speed Steel	GC80-IV	GC320-HB
Back-Up Roll		C60-IV	
Paper Mill Roll	Chilled Iron	GC36-KV	BGC60-KV
	Rubber-Covered	C36-IV	C60-IV
Chromium Plated Roll		93A60-IVP	GC220-HB GC600-GB
Stainless Steel Roll	400 Series	32A80-KV	
	300 Series	GC60-JV	
Rubber Roll	Soft	C24-JV	C46-LV
	Hard	C36-JV	

Standard Wheel Size & max. rpm

D x T x H		Vitrified	Resinoid
inch	mm	33m/s	50m/s
14" x 1-1/2" x 5"	355 x 38 x 127.0	1,793	2,690
18" x 3" x 5"	455 x 75 x 127.0	1,399	2,099
20" x 2" x 12"	510 x 50 x 304.8	1,248	1,872
20" x 3" x 7-1/2"	510 x 75 x 190.5	1,248	1,872
24" x 3" x 12"	610 x 75 x 304.8	1,044	1,565
26" x 3" x 12"	660 x 75 x 304.8	955	1,468
30" x 3" x 12"	760 x 75 x 304.8	838	1,256
30" x 4" x 12"	760 x 100 x 304.8	838	1,256
32" x 3" x 12"	800 x 80 x 304.8	786	1,179
36" x 4" x 12"	915 x 100 x 304.8	696	1,044
36" x 6" x 20"	915 x 150 x 508.0	696	1,044
42" x 4" x 12"	1065 x 100 x 304.8	424	637

Note: 1. Above are recommendations in general. Because roll grinding is a kind of precision grinding, it requires great grinding experiences and skills. One must consider the material of workpiece, machine condition and speeds etc., to have a correct choice of grinding wheel specification.

2. Usually roll grinding machines allow for wheel speed changes. General max. operating speeds for vitrified wheels are 2000 m/min (35 m/s), and for resinoid wheels are 3000 m/min (50 m/s).

Fault Finding and Correction Guide

Problem	Possible Causes	Suggested Correction
1. Poor quality of finish	Contaminated coolant Accumulated grit inside guard Traverse speed too fast Poor wheel dressing Roll speed too low Depth of cut too high	Clean coolant tank and filter regularly Clean and flush inside of guard regularly Reduce traverse speed Dress the wheel smoother Increase roll speed Increase roll speed Reduce depth of cut, in last few passes
2. Chatter marks	Worn spindle bearings Roll speed too low Inadequate lubrication of roll centers wheel too hard	Check bearings for wear and alignment Reduce roll speed until vibration stop Check conditions of work rest and pour oil in roll centers Reduce wheel speed or use softer grade
3. Burning of workpiece	Roll speed too low wheel too hard Wheel dressed too smooth Wheel glazing	Increase roll speed Reduce wheel speed or use softer grade Dress wheel coarser Dress wheel

For further information, such as new roll grinding or regrinding of aluminum foil roll, carbide roll, and printing roll etc., please contact **KINIK** sales representatives.