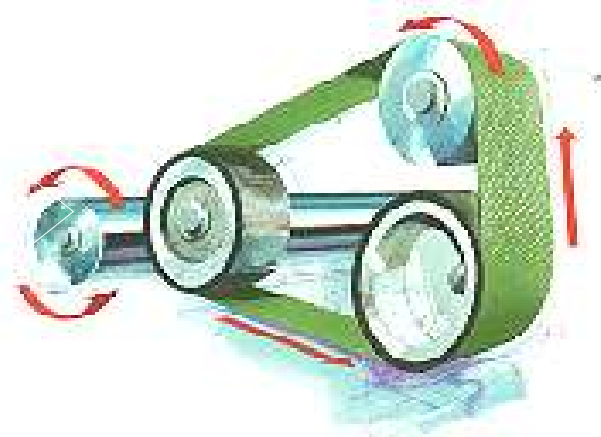


## Belt Grinding

- stock removal
- dimensional control

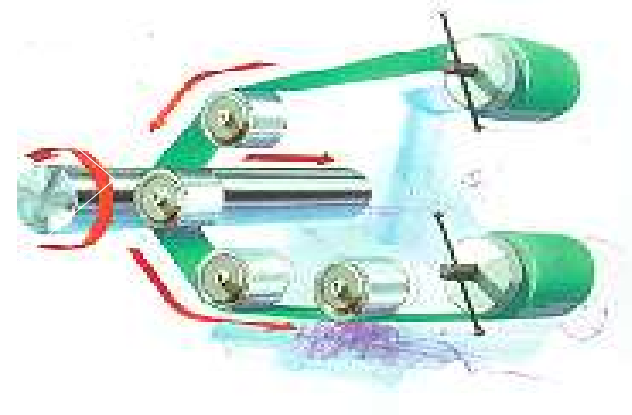


## Microfinishing

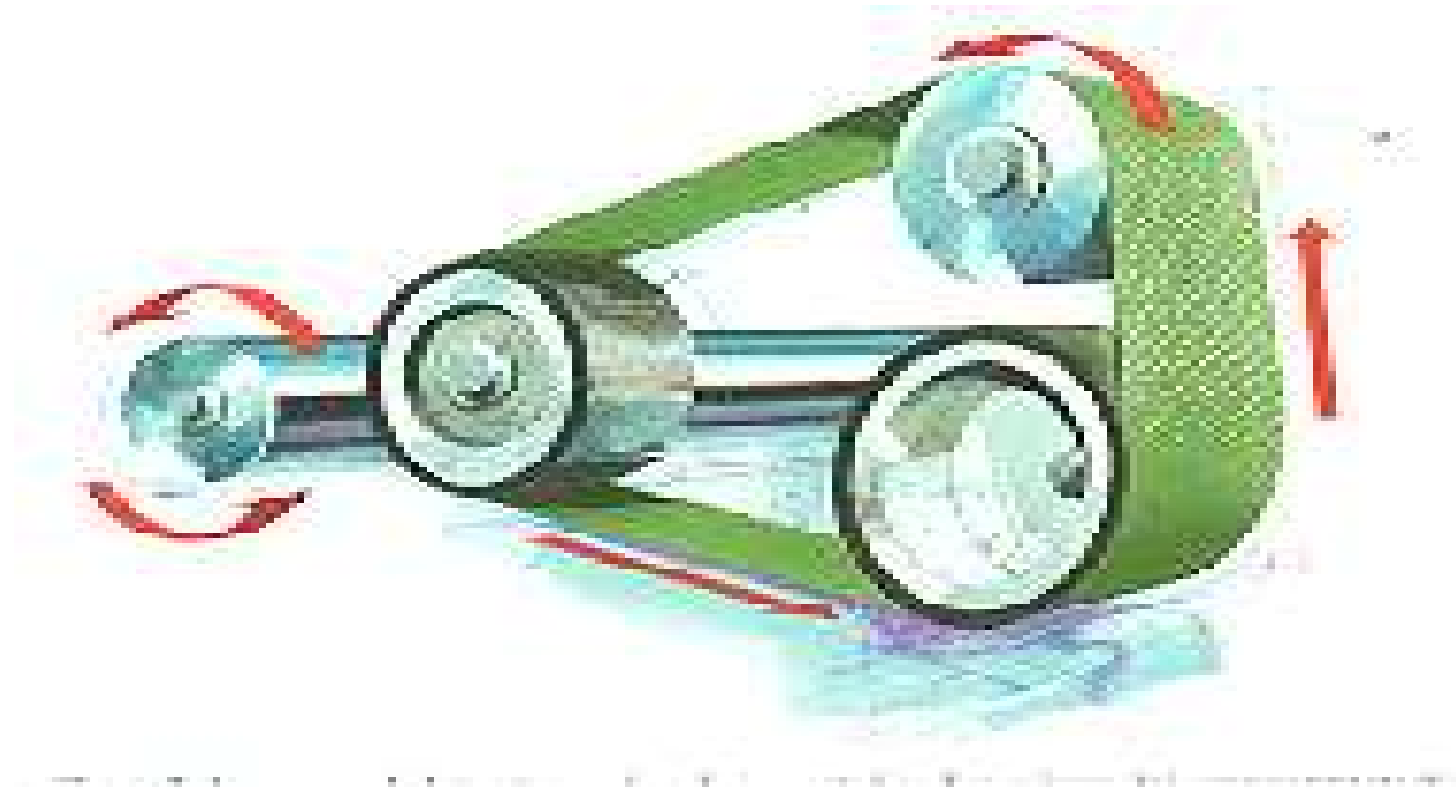
- uniform, consistent

## Superfinishing

- Below 1 micron Ra.



# Roll Grinding Diagram

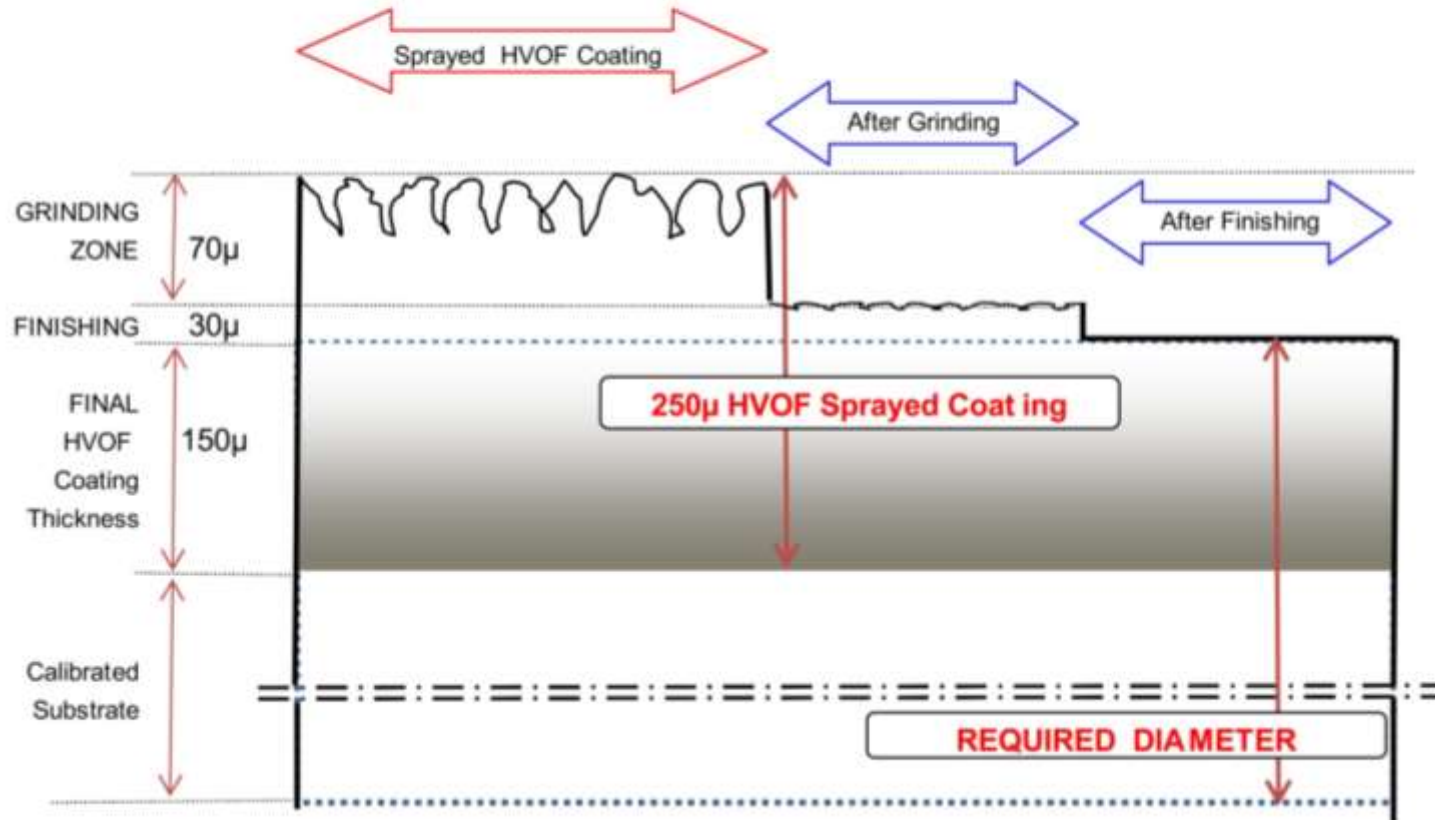


## Roll grinding with Diamond Belts – Surface Finish - HVOF Spray Coating

	TUNGSTEN CARBIDE	CHROME CARBIDE
Colour Grit	Ra: $\mu\text{m}$	Ra: $\mu\text{m}$
GN - 60	2.42	
BK - 120	1.82	
RD - 200	0.65	1.30
YE - 400	0.16	0.55
WH - 800	0.09	0.38
BL - 1500	0.05	0.13
OR - 3000	0.02	0.07

## GRINDING AND POLISHING HVOF OR CERAMIC COATED CYLINDERS

FIG. XX : Schematic Diagram showing Target grinding and finishing zones



# Belt Grinder



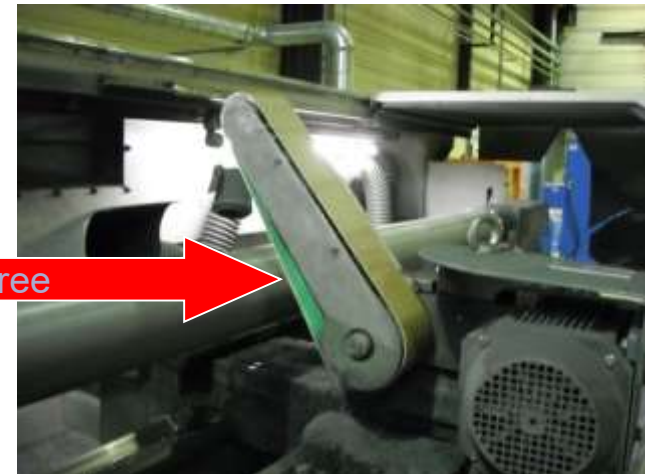
## Floating or Fixed Head

Depending on machinery set-up options available for the TPG

- ❖ FIXED HEAD (Totally Rigid – controlled In-feed))
- ❖ FLOATING HEAD (Variable Pressure & In-feed)
- ❖ FREE RUNNING (Not grinding on the Pulley)

Each setting affects the grind stock removal and finish.  
For accurate calibration of 2.5D rolls use Fixed Head.

For slightly conical or curved rolls a  
Floating Head is generally required.



## Pressure

- The rigidity and pulley hardness limit the grinding pressure available –
- As will the power rating deliverable from the motor.
- Results are EXTREMELY variable by PRESSURE –
- increasing the grinding pressure stock removal can go up by 50% - And Ra can vary by 25% !



**Free Running Belt Grinding**

# Bexxon

## Free Running Belt Grinding





# Bexxon Global

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