

# SWATYCOMET ROLLGRIND

Roll grinding wheels for maximum performance end cost savings

## Conception of Quality Grinding

### Advantages

- Faster material removal rate up to + 20 %
- Increased G-ratio up to + 20 %
- Wheel life increase up to + 30 %
- All types of workpiece material
- High and low horsepower machines

### How you benefit?

- Lower production costs
- Less power consumption
- Less downtime for change overs

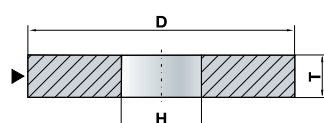


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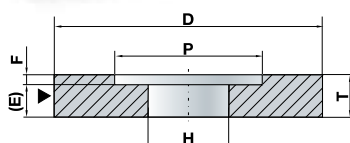
## ROLLGRIND



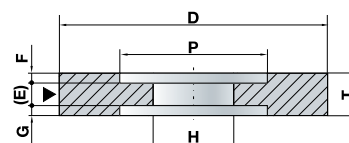
F1



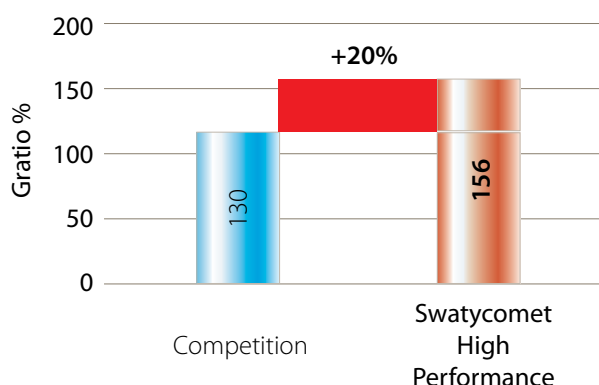
F5



F7



### Gratio



### Dimensions

D (mm)	T (mm)	H (mm)
350	38	127
600	50/60/70/100/125	203.2/304.8
700	60/80/100/125	304.8
750	80/100/125	304.8
762	80/100/125	304.8
800	80/100/125	304.8/381
900	80/100/150	304.8/355/457.2
920	80/100/127/150	304.8/355/457.2/508
1000 -1100	60/75/80/100/127/150	304.8/355/457.2/508

### Case Study

- Grinding Machine: POMINI
- Form: 1
- Dimensions: 1065 x 152 x 508
- Backup Roll: 2130 x 40000, Forged HiCr 72Sch
- Roughness Ra: ≤ 1,0 Ra
- Infeed - mm: 0,02 - 0,04 mm/hod
- Crossfeed - mm/min: 1200 mm/min
- Working Speed: 42 m/s
- Roll Speed (1/min): 16 m/s
- Total Stock Removal: 0,8-1,8 mm

### Materials

	Type of roll	Material	Surface quality (Ra)	Standard	High performance
Hot Rolling Mills	Work Roll	Indefinite	0,4 - 0,8 #46 0,6 - 1,2 #36	S5C30-46J-KBK	S38GC30-46J-KBK
		High Cr Steel High Cr Cast HSS		82A/8A/15GA 30-46I-JBK	S38GA30-46I-JBK
		All			S38GCA30-46I-JBK
	Back-up Roll	All	S38GA30-46J-KBK		
Cold Rolling Mills	Work Roll	Forged Cr Steel HSS	0,4 - 0,8 #46 0,3 - 0,6 #60 0,2 - 0,4 #80	82A/8A/15GA 46-100F-JBK	38GA/GC54-100F-JBK
	Back-up Roll	All	68C46-60I-JBK	38GA/GC36-60H-KJBK	

