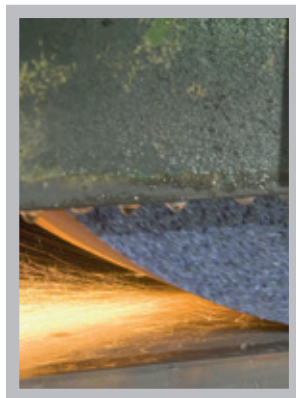
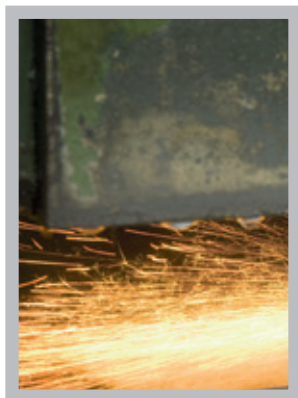


GRINDING OF TOOL STEEL



Introduction

The high alloy content of tool steel means that such steel are often more difficult to grind than conventional structural steel.

In order to achieve successful results when grinding tool steel, it is necessary to choose the grinding wheel with care. In turn, choosing the right grinding wheel and grinding data requires an understanding of how a grinding wheel works.

This brochure provides a quite detailed description of the make up of the wheel, of how it works when grinding and of the parameters that determine the final result. It also includes recommendations for grinding wheels for use with ASSAB tool steel.

Grinding wheel design

In principle, a grinding wheel consists of the following components:

- Abrasive
- Binder
- Air pores

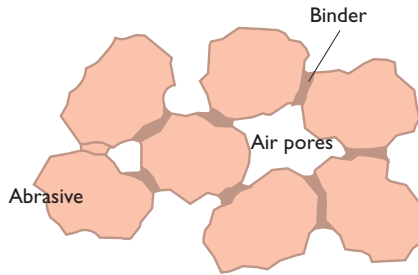


Figure 1. The arrangement and proportions of abrasives grains, air pores and bond bridges (made up of binder) determine grinding wheel characteristics.

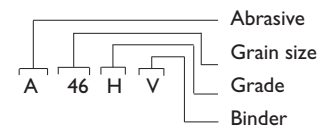
Certain special grinding wheels, such as metallically bonded diamond wheels, contain no air pores.

It is the composition and variation of the above components that determines the characteristic of a grinding wheel.

An identification system, which has now been ratified as an international standard by ISO, indicates the composition of grinding wheels.

The identification consists of numerals and letters in a particular sequence, defining the abrasive, grain size, grade and binder.

Example:



ABRASIVE

It is important that the abrasive fulfils requirements in respect of:

- hardness
- sharpness
- thermal resistance
- chemical stability

Today, the following four main groups of abrasives (all synthetic) are used, fulfilling the above requirements to greater or lesser extents.

1. Aluminium oxide designation A (SG)
2. Silicon carbide designation C
3. Cubic boron nitride designation B
4. Diamond designation SD

Abrasives have different application areas, depending on their particular characteristics, as shown partially in the table below.

ABRASIVE	HARDNESS KNOOP	THERMAL DURABILITY IN AIR °C
Aluminium oxide	2100	2000
Silicon carbide	2500	1200
CBN	4700	1400
Diamond	7000	650

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Edition 160216

- Aluminium oxide, is the abrasive most commonly used for grinding steel, and is available in several variants. It can be alloyed with other oxides, of which the most common is titanium oxide. The table below shows how the characteristics of aluminium oxide abrasive can be varied by alloying it.

ABRASIVE	COLOUR	PROPERTIES
Normal corundum	Brown, grey	
Mixed corundum	Yellow brown	
Red alumina	Red	
White alumina	White	

Unfortunately, the colour of a grinding wheel does not always necessarily indicate the type of abrasive used in it, due to the fact that some grinding wheel manufacturers colour their abrasives and binders.

There is also another type of aluminium oxide named ceramic or sintered aluminium oxide. This abrasive has a fine crystalline structure, which means that the grains retain their sharpness better. However, its use requires higher grinding pressure. A typical application for it is grinding tool steel in rigid grinding machines. Examples of this type of abrasive are SG (Seeded Gel) from Norton and Cubitron from 3M.

- Silicon carbide is an abrasive that is used primarily for grinding cast iron and austenitic stainless steel, although it can also be used for hardened tool steel. It occurs in two main variants: the black silicon carbide and a somewhat harder green variant, which is more brittle than the black material.
- Cubic Boron Nitride (CBN) is produced in approximately the same way as synthetic diamond, and is an abrasive that is used primarily for grinding hardened high-carbide tool steel and high-speed steel.
A drawback of CBN is its high price—almost twice that of synthetic diamond.

- Diamond is seldom used, despite its high hardness, for grinding tool steel as a result of its low thermal resistance. Diamond is used primarily for grinding cemented carbide and ceramic materials.

ABRASIVE GRAIN SIZE

The grain size of the abrasive is an important factor in selecting the correct grinding wheel.

Grain sizes are classified in accordance with an international mesh size in mesh/inch, ranging from 8 (coarse) to 1200 (superfine). Grain sizes for grinding tool steel are generally in the range 24–100 mesh. Coarse grain sizes are used for rapid rate of removal, when grinding large workpieces, grinding softer materials or when the contact surface of the grinding wheel is large. Fine grain sizes are used to produce high surface finish, when grinding hard materials or when the contact surface of the grinding wheel is small.

The surface smoothness of the ground part depends not only on the grain size of the grinding wheel. The sharpness of the wheel, the bonding material used and the hardness of the wheel also play a considerable part in determining the surface finish produced.

In the case of diamond and CBN grinding wheels, European grinding wheel manufacturers indicate grain size by the diameter of the abrasive grains in microns, while American and Japanese manufacturers indicate it in mesh size.

GRINDING WHEEL GRADE

The grade of a grinding wheel refers to its hardness, i.e. how securely the abrasive grains are held by the binder. It does not, therefore, depend on the hardness of the abrasive used in the wheel.

The grade of a grinding wheel is determined primarily by the quantity of binder used in the wheel. A higher proportion of binder reduces the amount of air pores and produces a harder wheel.

The grade of a wheel is indicated by a letter, indicating the hardness in alphabetical order:

E = very soft composition

Z = very hard composition.

For tool steel, the most commonly encountered compositions are within the hardness range G–K. Indication of the grade is sometimes followed by a numeral, which indicates the spread of the abrasive particles in the wheel.

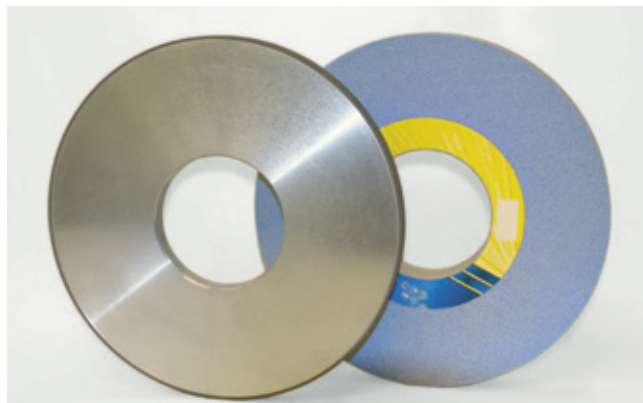
GRINDING WHEEL BINDERS

The following binders are used to bind the grains in a grinding wheel:

- Vitrified designation: V
- Resinoid „ B
- Rubber „ R
- Metal „ M

Vitrified grinding wheels are those most commonly used for grinding tool steel.

Resinoid is used as a binder in grinding wheels intended for high peripheral speed, such as certain CBN wheels.



The photo shows the difference between a CBN wheel and a conventional grinding wheel. As a result of the high price of CBN, wheels made from it consist of a thin layer of abrasive applied to a central hub, usually of aluminium.

Rubber-bonded wheels are used for high specific grinding pressure, such as for control wheels in centreless grinding.

Metallic binders are used for diamond and certain CBN wheels. Such wheels can withstand very high peripheral speed.

How the grinding wheel works

Grinding is a cutting process in which the cutting edges are formed by the grains of abrasive. The same principles apply for grinding as for other chip-cutting methods, although various factors mean that it is necessary to consider the theory of grinding somewhat differently.

Conditions that are special for grinding.

- The cutting tool has an irregular cutting geometry and the abrasive grains are irregularly placed, which means that cutting, ploughing and sliding will occur, see figure 2.
- The cutting geometry can change. The method of working of an abrasive tool includes a certain degree of “self-sharpening”, which means that grains of abrasive break or are replaced as they wear.
- Negative cutting angles. The irregular “blunt” shapes of the grains mean that the rake angles are often negative.
- A very large number of cutting edges.
- Very high cutting speed. The most common cutting speed for precision grinding, $35 \text{ m/s} = 2100 \text{ m/min.}$, is far above what is normal for other cutting processes.
- Very small chips, i.e. very small cutting depth for each cutting edge.

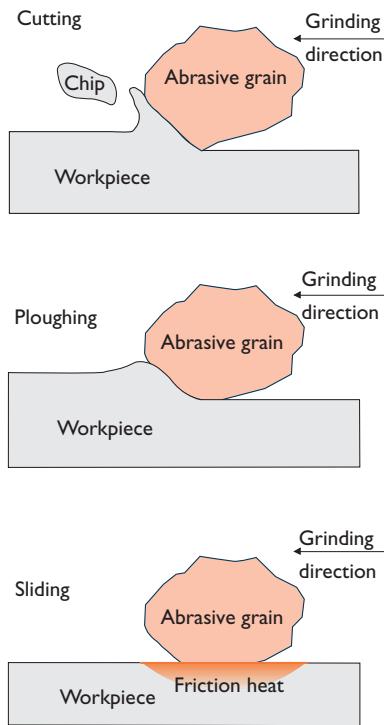


Figure 2. Different conditions during grinding (highly schematic). Cutting angles are generally negative.

GRINDING FORCES

The grinding forces that act on each individual grain of abrasive are referred to as *specific forces*. A mean value of the specific forces can be obtained by dividing the total force by the number of cutting edges, which depends on the size of the contact area and the number of cutting edges in the grinding path.

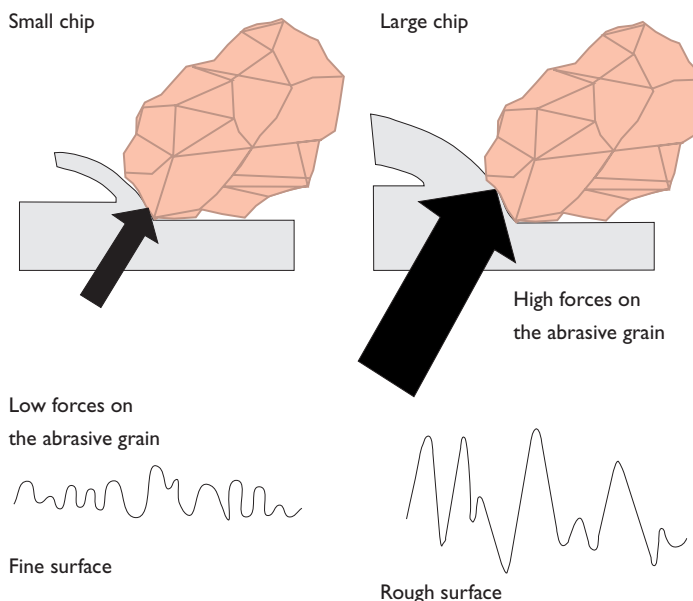


Figure 3. A large chip size results in a rougher surface finish on the workpiece.

The specific forces determine various effects, including the degree of self-sharpening of the grinding wheel, i.e. its “working hardness”. The *total force* is the force arising between the grinding wheel and the workpiece.

GRINDING WHEEL WEAR

The grains of abrasive are initially sharp, but in the same way as with all other cutting edges they wear down in use and become blunt.

Finally, the grains will have become so blunt that they have difficulty in penetrating into the material of the workpiece. They cease to remove material and generate only heat. The grinding wheel is then said to be burning the material, which can cause cracks in it.

For a grinding wheel to work correctly, the stresses in the binder and the strength of the binder must be so balanced that, as the grains become as blunt as can be accepted, they are pulled out of the binder and are replaced by new, sharp grains. The grinding wheel, in other words, *sharpens itself*. Self-sharpening also occurs through grain breakage, which creates new cutting edges. The degree of self-sharpening, i.e. whether the grinding wheel is hard or soft, is affected by the composition of the wheel (its design hardness) and by the conditions under which it is working.

AVERAGE CHIP THICKNESS

Although the chips removed by grinding are small and irregular, the mean value of their thickness at any time is relatively constant. This value varies, depending on the type of grinding operation and in response to the changes in grinding data.

If a grinding wheel is cutting larger chips, this means two things:

1. Higher loading on each cutting edge, i.e. higher specific forces. This increases the self-sharpening characteristic of the wheel and gives it the characteristics of a softer wheel.
2. The surface of the part being ground is coarser, see Figure 3.

A reduction in the average chip thickness represents the opposite. It is therefore important to understand how changes in grinding data and other conditions affect the average chip thickness.

STOCK REMOVAL RATE

When grinding, the amount of chips removed per unit of time can most easily be expressed as mm^3/s . This is often referred to as the stock removal rate, and depends on the machine feed, the composition of the grinding wheel, its cutting speed (peripheral speed) and (in certain cases) on the dimensions of the workpiece.

It is often more meaningful to talk about stock removal rate rather than about table feed speed, feed depth etc., and it is also quite easy to calculate. Cost considerations often dictate that the stock removal rate should be as high as possible. If the stock removal rate is increased without increasing the number of grains of abrasive performing the work, e.g. by greater infeed depth, the chip size will also naturally be increased.

CUTTING SPEED

The peripheral speed of a grinding wheel has a direct effect on the number of cutting edges that actually perform the machining work.

If, for example, the cutting speed

is doubled, twice as many grains of abrasive will pass the workpiece per unit of time. If the workpiece speed is not increased, the mean chip thickness will decrease, thus also reducing the cutting forces on each grain. Self-sharpening will be less effective, i.e. the grinding wheel will be effectively harder, producing a finer surface finish, but with greater risk of burning the surface.

Conversely, reducing the speed of the wheel will increase the chip thickness, with the result that the grinding wheel behaves as a softer wheel.

Generally, both peripheral velocity and workpiece speed are increased in order to increase the total rate of removal.

THE G-RATIO OF A GRINDING WHEEL

The *G-ratio* of a grinding wheel refers to the relationship between the amount of material removed and the amount of grinding wheel consumed. The *G-ratio* is a measure of how effectively a grinding wheel works with the particular workpiece material.

GRINDING WHEEL CONTACT SURFACE

It is at the contact surface between the grinding wheel and the workpiece that the actual cutting operation occurs. A large contact surface means that a greater number of cutting edges participate in the process, thus reducing the chip size and specific forces. Similarly, a reduced contact surface area results in greater chip size and higher specific forces.

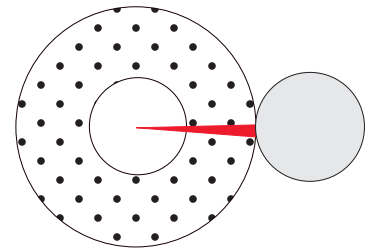
In principle, the contact surface is in the shape of a rectangle. Its extent in the cutting direction is referred to as the *contact length* or *contact arc*, while its extent perpendicular to the cutting direction is referred to as the *contact width*.

The *contact length* depends primarily on the type of grinding operation. In addition, it depends on the diameter of the grinding wheel, the cutting depth and in all cases—except for surface grinding—the dimensions of the workpiece. Differences in the contact length are the main reason

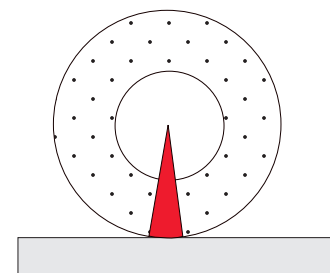
for having to select different grinding wheel compositions for different grinding operations.

If, when performing internal grinding, a grinding wheel is used that has a diameter only a little less than that of the ground hole, the contact length will be very large, resulting in low cutting force per grain. If the wheel is to sharpen itself properly, it must be of a softer composition than one intended for external cylindrical grinding of a similar part. In this latter case, the contact length is shorter, which means that there are higher cutting forces on each grain.

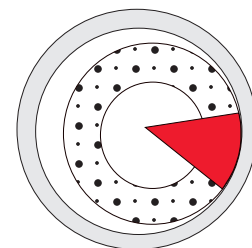
Cylindrical grinding



Surface grinding



Internal grinding



Segmental surface grinding

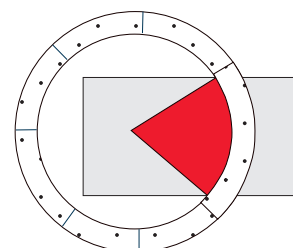


Figure 4. Differences in contact length for different grinding operations.

The *contact width* may be equal to the width of the grinding wheel as, for example, in plunge grinding. However in operations such as surface grinding with a moving table, only part of the grinding wheel is actually cutting and this part changes as the wheel wears down. It is sometimes possible to reduce the contact width, if this is required, by truing of the grinding wheel. This reduces contact surface area, resulting (as already described) in a greater chip thickness, higher loading on the abrasive grains and an effectively softer grinding wheel.

THE NUMBER OF CUTTING EDGES IN THE CONTACT AREA

The number of cutting edges in the contact area is a factor that has a considerable effect on the chip thickness and thus on the grinding process.

A large number of cutting edges per unit area mean that the work of removing material is spread over a larger number of grains, reducing the chip thickness and the specific forces.

The grain size of the abrasive also affects the number of cutting edges, which is the reason for the common observation that fine-grained cutting wheels seem to be harder.

DRESSING AND TRUING GRINDING WHEELS

Dressing and truing of a grinding wheel are often considered to be the same thing because they are often performed as one operation.

Truing is made to produce any profile which may be required on the face of the wheel and to ensure concentricity.

Dressing is a conditioning of the wheel surface to give the desired cutting action. Dressing the wheel exposes sharp cutting edges. One and the same grinding wheel can be given completely different grinding characteristics through application of different dressing tools or different dressing methods. Dressing is therefore a particularly important parameter in achieving good grinding performance.

Dressing resulting in a smooth surface on the wheel results in the cutting edges of the grains of abrasive being close together, while dressing resulting in a rough surface of the wheel gives the wheel a more open structure. Dressing provides a means of making the same grinding wheel give completely different grinding results.

The degree of self-sharpening affects the structure of the grinding wheel surface, i.e. the number of cutting edges per unit of area. A grinding wheel that has a high self-sharpening performance has a different, more open structure than one having poorer self-sharpening performance.

There are many different tools available for dressing and truing grinding wheels, e.g. crushing rolls and diamond tools. CBN wheels are best dressed using a diamond coated roller.

Certain types of grinding wheels, e.g. resinoid bonded CBN wheels, need to be "opened" after dressing. This reveals the abrasive particles and creates space for chip formation. In practice this can be done by pushing a wet aluminium oxide stone into the wheel for a few seconds.

The grinding machine

The type of grinding operation and the machine available has a considerable effect on the choice of appropriate grinding wheel composition. A grinding machine should be as rigid as possible, in order to allow it to work at high grinding pressures. This is because it is the rigidity of the grinder and the method of clamping the workpiece that determine the permissible grinding pressure and therefore restrict the choice of wheels. If the machine is not sufficiently rigid, a softer grinding wheel composition or a smaller contact area between the grinding wheel and the workpiece should be chosen, in order to achieve the required degree of self-sharpening performance.

The speed of the grinder also affects the choice of grinding wheel. CBN wheels often require peripheral speeds of 45 m/s in order to provide good cutting performance.

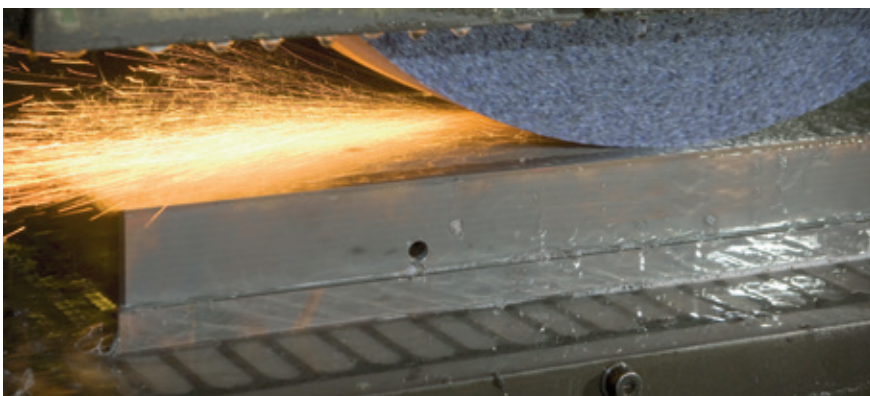
Grinding fluid

When grinding, as with all other cutting operations, a cutting fluid is used primarily to:

- cool the workpiece
- act as a lubricant and reduce friction between the chips, workpiece and grinding wheel
- remove chips from the contact area

There are three main types of cutting fluids that can be used when grinding.

- *Water solutions.* These are liquids that consist of water with synthetic additives in order to increase its wetting performance and prevent corrosion. Such fluids contain no oil and provide good cooling performance but poorer lubrication performance.
- *Emulsions.* These consist of water with an ad-mixture of 2–5% of oil in an extremely finely distributed



form. Sulphur or chlorine additives may also be used as EP (extreme-pressure) additives.

- **Cutting oils.** These are composed of a mineral oil base with EP-type additives. Cutting oils provide effective lubrication but poorer cooling.

Water solutions are most suitable when grinding with diamond wheels.

Emulsions are used nowadays for the majority of grinding operations because they are ecologically beneficial and perform adequately.

Cutting oils give the best results for profile and plunge grinding with fine grained wheels, e.g. when grinding threads. Cutting oil also provides the longest life for resinoid bonded CBN wheels, although high-oil emulsions are often chosen in the interests of pollution reduction.

The tool steel

The alloying constituents of a tool steel have a considerable effect on its ease of grinding.

There is seldom any problem in grinding low-alloy tool steel. At the other end of the scale, however, the high-alloy carbide-rich steel can cause problems when being ground, and require a careful choice of grinding wheel and operating parameters.

The higher the wear resistance of a steel, the more difficult it is to grind. The wear resistance of a steel, and thus also its ease of grinding, are determined by its basic hardness and by the size, hardness and quantity of the carbides in it.

In order to enhance the wear resistance of a tool steel, the steel is alloyed with carbide-forming alloying elements, of which the most important are chromium and

vanadium. The steel must also have a high carbon content if carbides are to be formed.

The diagram, Figure 5, shows the hardness of the basic phases found in a tool steel, the hardness of the most common carbides found in tool steel and the hardness of commonly used grinding abrasives.

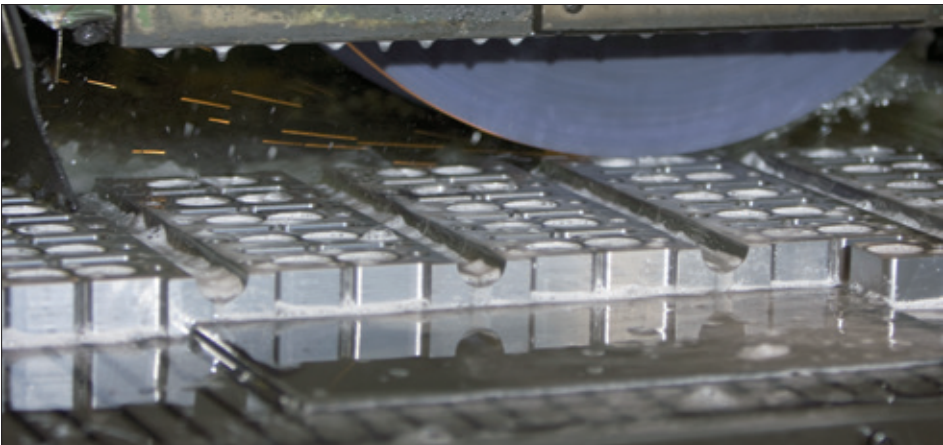
As can be seen in the figure, it is only diamond and CBN that are harder than all the carbides that are found in a tool steel. However, as mentioned earlier, diamond is unsuitable for grinding steel.

The quantity and the size of carbides in a steel has a very considerable effect on the ease of grinding of the material. The greater the number of, and the larger the carbides, the more difficult the material is to grind.

This is the reason why tool steel produced by powder metallurgy processes, having smaller carbides, is easier to grind than a conventionally produced steel having a similar composition.

In practice, powder metallurgy is employed to increase the quantity of carbide in a tool steel, i.e. such steel are more highly alloyed than conventional steel, which generally means that they are more difficult to grind.

The effect of hardness on ease of grinding is also dependent on the quantity of carbide-forming alloying elements in the steel.



Fine grinding of details in hardened Mirrax ESR

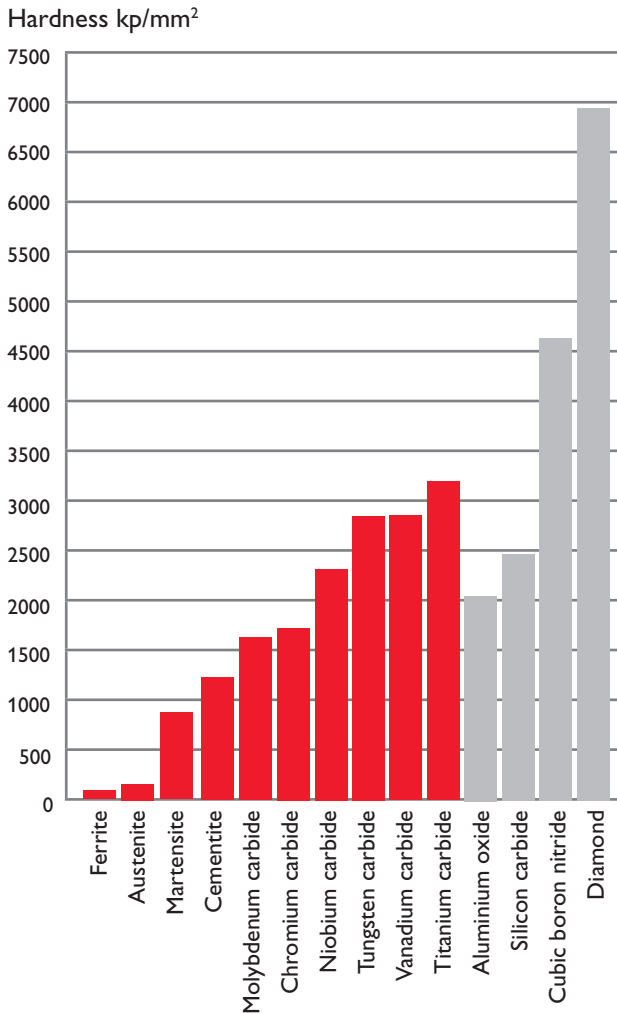


Figure 5. The hardness of grinding abrasives, basic phases found in a tool steel and carbides found in tool steel.

GRINDING CRACKS AND GRINDING STRESSES

The wrong choice of grinding wheels and grinding parameters results in a considerable risk of causing cracks in the workpiece.

Generally, grinding cracks are not as easy to see as in photo shown below. It is usually necessary to examine the part under a microscope, or with magnetic powder inspection, in order to see the cracks.



Grinding cracks.

The formation of grinding cracks, which tend to occur perpendicular to the direction of grinding, usually means the tool has to be scrapped. Hardened steel are more sensitive to grinding cracks than non-hardened steel. A material that has been only hardened, and not tempered, must never be ground: hardened materials should always be tempered before grinding.

Formation of grinding cracks can be explained as follows:

Almost all the energy used in grinding is converted into heat, partly through pure friction and partly as a result of deformation of the material. If the correct grinding wheel has been chosen, most of the heat will be removed in the chips, with only a smaller part heating up the work-piece.

Grindability index

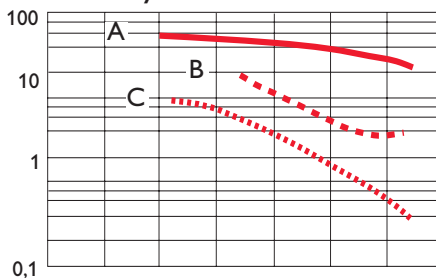


Figure 6. The effect of hardness on grindability for:

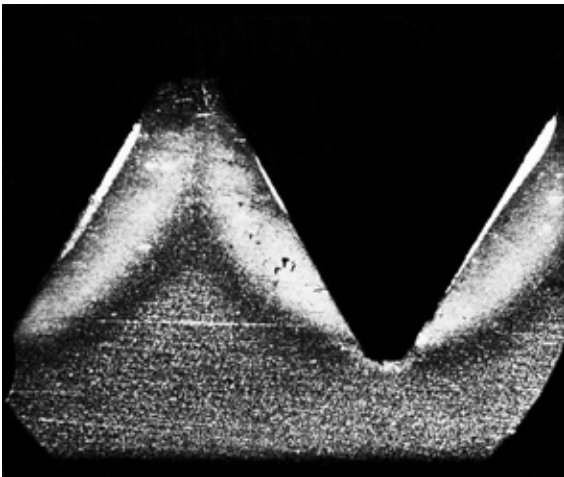
- A – a low-alloy tool steel of ASSAB DF-3 type
- B – a material of ASSAB XW-42 type
- C – material of Vanadis 10 SuperClean type.

As can be seen in Figure 6, hardness has a greater effect on grindability for high-carbide steel.

In order to obtain good grinding performance with high-alloy carbide-rich tool steel, it is important to select the correct grinding wheel. Materials in the Vanadis range, for example, contain a large quantity of vanadium carbides. To cut through a vanadium carbide requires an abrasive that is harder than aluminium oxide or silicon carbide.

CBN wheels are therefore recommended as first choice for grinding this material. The fact that, despite this, material can be removed from Vanadis steel by grinding with aluminium oxide or silicon carbide is due to the fact that it is the material enclosing the carbides that is ground away, so that the carbides are torn out of the basic material of the steel. However, this occurs at the price of high wear of the grinding wheel and a risk of poor grinding performance.

Incorrect grinding of a hardened tool steel can result in such a high temperature at the ground surface that the tempering temperature of the material is exceeded. This results in a reduction in the hardness of the surface. If the temperature is allowed to rise further, the hardening temperature of the material can be reached, resulting in rehardening. This produces a mixture of non-tempered and tempered martensite in the surface layer, together with retained austenite, as shown in photo below. Very high stresses arise in the material, often resulting in the formation of cracks.



Re-hardened layer in an incorrectly ground tool.

The diagram below shows the hardness profile through the surface of a tool steel, incorrectly ground in such a way as to produce re-hardening.

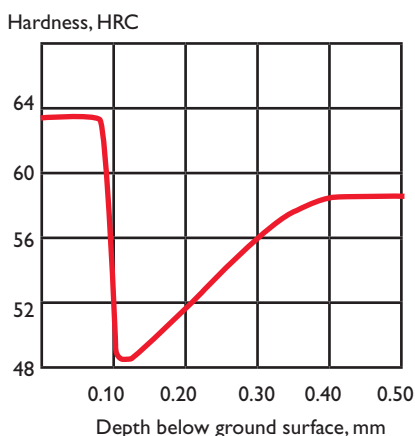


Figure 7. Hardness profile through the surface layer of an incorrectly ground tool.

The surface exhibits a high hardness due to the untempered martensite. An overtempered zone occurs just below the surface, where the hardness is lower than the basic hardness of the workpiece.

Incorrect grinding, resulting in a modified surface layer, often reveals itself through burn marks—discolouration of the ground surface. In order to avoid burning and grinding cracks, it is necessary to keep down the temperature of the ground part, e.g. by means of good cooling, and to employ properly dressed grinding wheels that cut the material with sharp cutting edges instead of simply generating heat through friction.

Alternative B shows a better way to grind the punch. In this case, the side of the grinding wheel has been trued as shown so that the contact surface at (b) is smaller. This results in improved self-sharpening and “cooler” grinding.

Case C shows the preferred way to grind this part. The grinding wheel is set at an angle, so that the two contact surfaces are of approximately the same size.

The retained austenite content of a hardened material can also affect the grinding result. High retained austenite levels increase the risk of crack formation when grinding.

The majority of grinding operations leave residual stresses in the ground surface. These stresses are usually at a maximum close to the surface, and can cause permanent deformation of the ground part when grinding thin materials.

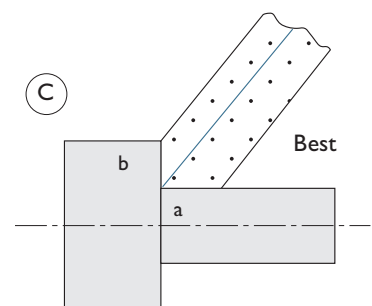
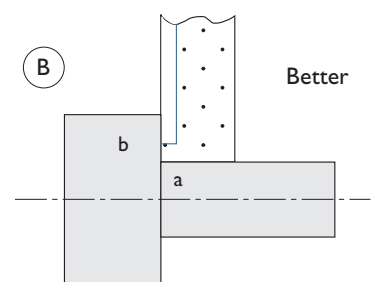
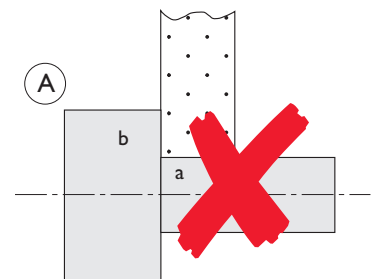


Figure 8. Incorrect grinding can often result in grinding cracks.

A simple example of how incorrect grinding can cause cracks is shown in Figure 8. A hardened punch with a head is to be cylindrical-ground, with the head (b) being ground flat in the same operation.

Alternative A shows the use of a grinding wheel trued with a 90° edge. The grinding wheel, which is suitable for cylindrical grinding of the surface (a), produces a good result on surface (a). Here the contact surface is small so the self-sharpening performance is good. The head, on the other hand, which is to be ground flat, presents a larger contact surface to the grinding wheel. The specific forces on the abrasive grains are low so that the wheel does not self-sharpen. Instead, surface (b) is subjected mainly to rubbing and the heat generated can cause grinding cracks.

Of the three examples shown in Figure 9, *Example 1* is most at risk in respect of crack formation. It exhibits tensile stresses in the surface which can, if they exceed the material's ultimate tensile strength, result in the material cracking.

Examples 2 and 3 are not as dangerous—the surface stresses are compressive stresses, which result in improved fatigue strength of the ground parts.

It is, unfortunately, very difficult to produce a simple check to determine the stress pattern set up in the ground part unless the stresses are so high that grinding cracks are visible.

Grinding stresses can be reduced by stress-relief tempering after grinding. The tempering temperature should be about 25°C below the previous tempering temperature in order to avoid any risk of reducing the hardness of the workpiece.

Another way of reducing grinding stresses is to tumble or blast the ground parts.

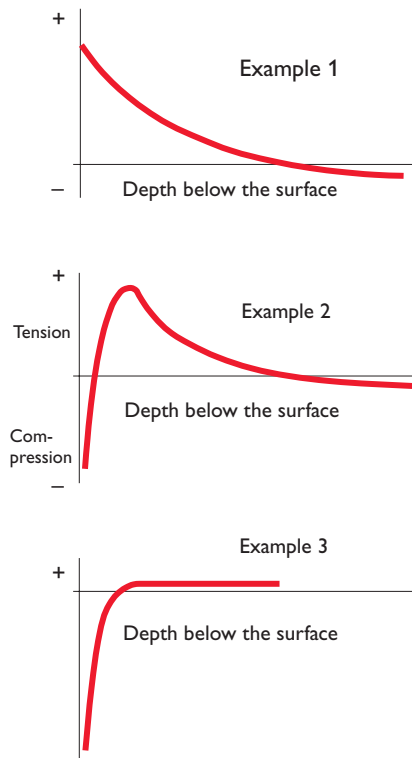


Figure 9. Three typical examples of stress distribution in a ground surface.

Recommendations for grinding of ASSAB tool steel

GRINDING OF HIGH CARBIDE TOOL STEEL

The high carbide content of high carbide tool steel gives them excellent wear resistance, and require special recommendations in respect of grinding operations and selection of grinding wheels. For the majority of grinding operations, CBN wheels are the best choice for such steel.

There are two different types of carbide rich tool steel, conventionally made steel and powder steel. The main differences that affect the grinding properties are the hardness, size and distribution of carbides, see Figure 10 below.

- Powder steel, such as Elmax, Vanadis and Vancron, have in spite of the high alloying level relatively good grinding properties due to the small carbide/nitro carbide size. The small carbides will give the grinding wheel good self-sharpening properties.
- Conventionally made steel, such as ASSAB XW-10, ASSAB 88 and ASSAB XW-42 do not have such good self-sharpening properties as powder steel due to the bigger carbide size. However, the lower

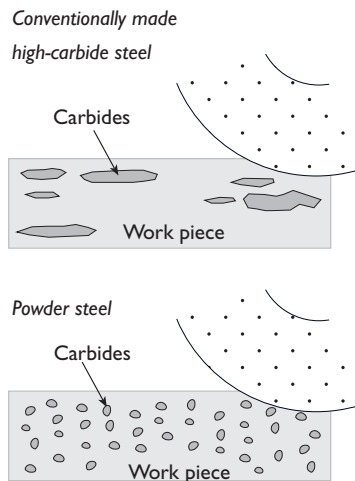


Figure 10. Carbide size and distribution in high-carbide tool steel (highly schematic).

carbide hardness and carbide content will compensate for the grinding properties.

Figure 11 shows the results of surface grinding trials on Vanadis 10 SuperClean with aluminium oxide, fine crystalline aluminium oxide and CBN grinding wheels.

As can be seen in Figure 11, material is removed more quickly, and the G-ratio is higher, using CBN wheels. These wheels have a “colder” cut, with less risk of “burning” the surface.

If the material is to be profile-ground, bear in mind that a considerable quantity of heat will be generated. Experiments have shown that vitrified CBN wheels are preferable for this application. These wheels also operate well for other grinding operations, provided that a high peripheral speed can be maintained.

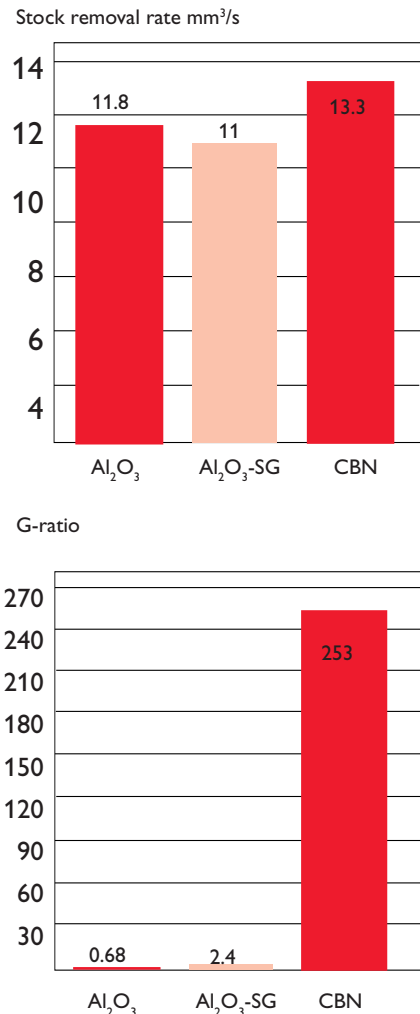


Figure 11. Surface grinding of Vanadis 10 SuperClean with various grinding wheels. (Grinding wheel width: Al₂O₃ 40 mm, CBN 20 mm.)

Where boron nitride wheels cannot be used, the type of grinding wheel must be chosen with care. White aluminium oxide or green silicon carbide wheels are recommended. Fine-crystalline aluminium oxide wheels, such as the Norton SG, give good results if the grinding set-up is rigid.

When grinding high-carbide steel, the grinding wheel should always be somewhat softer in order to ensure good self-sharpening performance. In addition, the following points must be borne in mind:

- the grinder must be vibration-free, rigid and in good condition
- the workpiece must be securely clamped. Use a steady rest when grinding long, thin workpieces
- use sharp conical diamonds when dressing Al_2O_3 and SiC wheels. The dressed finish must be rough
- maintain a high peripheral speed of grinding wheels
- ensure an adequate supply of coolant to the grinding zone
- if grinding is carried out without a coolant, select a grinding wheel that is one grade softer than would have been used if grinding was performed with coolant
- never grind a hardened workpiece before it has been tempered

GRINDING OF CONVENTIONAL TOOL STEEL

This group covers all the other conventionally produced tool steel. Providing that common grinding recommendations are followed, problems are seldom encountered when grinding these tool steel. For these steel, ordinary aluminium oxide grinding wheels are perfectly suitable. CBN wheels can also be used if the steel are to be ground in the hardened and tempered condition.

GRINDING OF PRECIPITATION HARDENING STEEL

Precipitation hardening steel, such as Corrax, behaves in a little different

way from tool steel when grinding. It tends to clog the grinding wheel, especially if the grinding wheel is hard and has a close structure. The clogging can cause problems like low material removal rate and rough surface finish. To prevent the clogging, observe following recommendations:

- the wheel should have an open and porous structure
- use a softer wheel grade (hardness) than for other types of tool steel
- the wheel dressing should be done frequent and rough
- the coolant concentration should be high (>5%) for efficient lubrication

Conventional Al_2O_3 wheels are recommended, but SiC wheels can be a better choice for high surface finish when a small amount of material is to be ground. No particular difference in grindability between solution treated and aged condition. In the table with recommended grinding wheels, page 13-14, suitable standard type of grinding wheels are recommended. However, if a lot of grinding is to be done in this type of steel, it is recommended to select a wheel with a more open structure than a standard wheel type.

Cutting speed and feed

GRINDING WHEEL SPEED (CUTTING SPEED)

When using small grinding machines, the spindle speed often restricts choice of cutting speed.

A common safety limit for vitrified grinding wheels is 35 m/s. However, some grinding wheels are approved for peripheral speeds of 125 m/s.

A common cutting speed for surface and cylindrical grinding is 20–35 m/s. Varying the peripheral speed of the wheel makes it possible to modify its grinding performance. Increasing the peripheral speed of the wheel while

retaining the same workpiece speed means that the wheel behaves as if it was harder. Reducing the peripheral speed makes the wheel seem softer.

A suitable peripheral speed for resinoid CBN wheels is 30–40 m/s. For vitrified CBN wheels, a cutting speed ≥ 45 m/s is often necessary.

When grinding high-carbide tool steel, the peripheral speed of the grinding wheel should be high. Tests on cylindrical grinding of Elmax SuperClean has shown that the G-ratio of the grinding wheel dropped from 127 to 28 when the peripheral speed was dropped from 60 m/s to 30 m/s. Cutting speed, in other words, has a considerable effect on the economics of grinding.



WORKPIECE SPEED

For surface grinding, the speed of the workpiece should be 10–20 m/min. For conventional cylindrical grinding, this speed should be 15–20 m/min. This speed should be reduced for smaller diameter workpieces, for which 5–10 m/min is suitable.

Varying the workpiece speed also provides a means of modifying the grinding performance of the wheel. Increasing the speed of the workpiece makes the wheel seem softer, while reducing its speed produces a harder wheel.

CROSS-FEED

The cross-feed speed of a grinding wheel, i.e. its sideways motion, is higher for rough grinding than for fine grinding.

In the case of cylindrical grinding, the cross-feed should be about 1/3–1/2 of the width of the wheel for each revolution of the workpiece. For fine surface finish, this ratio should be reduced to 1/6–1/3 of the width of the grinding wheel per revolution of the workpiece.

If a very high standard of surface finish is required, cross feed can be further reduced to 1/8–1/10 of the grinding wheel width.

When surface grinding with a straight wheel, choose a transverse feed of 1/6–1/3 of the width of the grinding wheel for each stroke. Again, reduce this feed for high surface finish requirements.

Note that when the cross-feed is increased, the active contact surface area between the grinding wheel and the workpiece becomes larger, resulting in an apparent increase in hardness of the grinding wheel.

INFEEED

The infeed of the grinding wheel depends on the type of wheel and the rigidity of the grinder and/or workpiece clamping.

Guide values for cylindrical grinding using conventional grinding wheels are:

Rough finish ~0.05 mm/pass.

Fine finish ~0.005–0.010 mm/pass.

The above feeds should be halved for cylindrical grinding using CBN wheels.

For surface grinding using a straight grinding wheel, the feed depths for conventional wheels are:

Rough finish ~0.025–0.075 mm/pass.

Fine finish ~0.005–0.010 mm/pass.

The feed depths when using CBN wheels are:

Rough finish ~0.010–0.040 mm/pass.

Fine finish ~0.005–0.010 mm/pass.

When using grinding wheels having fine-crystalline aluminium oxide abrasive, such as the Norton SG type, feed depth should be increased somewhat over the above values in order to achieve higher grinding

pressure and hence good self-sharpening performance.

Grinding wheel dressing

During dressing a helix along the wheel periphery is made. The lead of helix which the dressing tool is being fed affects the structure of the grinding wheel. The lead of helix depends both of the r.p.m. of the grinding wheel and the speed of the dressing tool.

The following are rules of thumbs for grinding wheel dressing with single point diamonds and similar tools.

	Rough dressing	Fine dressing
Diamond infeed (mm)	0.02-0.04	0.01-0.02
Diamond transverse rate (mm/wheel rev.)	0.15-0.30	0.05-0.10

Diamond is sensitive for high temperatures. Therefore, dressing with diamonds should always be carried out with plenty of coolant. The coolant should always be turned on before the diamond touches the wheel. Single point diamond dressing tool should be systematically rotated to maintain the sharpness.

GRINDING PROBLEMS — REMEDIES

The table shows the most important actions to solve different grinding problems.

SYMPTOM	REMEDY
Chatter marks	Check the wheel balance. Ensure that the diamond is sharp. Ensure that the diamond is fixed.
Finish too coarse	Use fine, slow traverse dress. Decrease work speed. Use finer grit wheel. Use harder grade wheel.
Short wheel life	Ensure that the cutting speed is sufficient. Reduce depth of cut and feed. Use harder grade wheel.
Flecking on surface finish	Check coolant filtration. Flush wheel guard.

Suitable grinding wheels

The examples of grinding wheels in the tables, page 13–14, have been made in consultation with grinding wheel manufacturers, and are based on our own and others experience. However, it must be emphasised that the choice of grinding wheel is strongly dependent on the type of grinding machine, rigidity of clamping and the size of the workpiece, which means that the recommendations should be seen as starting points, from which each particular process should be optimised.

Example of suitable grinding wheels

The grinding wheels are of SlipNaxos¹⁾, Tyrolit²⁾, Norton³⁾ and Unicorn⁴⁾ type. The designations, however, essentially comply with international standards.

ASSAB STEEL GRADE	CONDITION	CENTRELESS	SURFACE GRINDING STRAIGHT WHEEL	SURFACE GRINDING SEGMENT
ALVAR 14 ASSAB DF-3 CALDIE CALMAX DIEVAR MIRRAX ESR ASSAB 8407 SUPREME ASSAB 8407 2M POLMAX QRO 90 SUPREME STAVAX ESR UNIMAX VIDAR 1 ESR	Soft annealed	¹⁾ 33A 60 LVM ²⁾ 89A 60 2 K5A V217 ³⁾ SGB 60 MVX ⁴⁾ 51A 601 L5V MRAA	¹⁾ 43A 46 HVZ ²⁾ 91A 46 I8A V217 ³⁾ 3SG 46 G10 VXPM ⁴⁾ WA 46 HV	¹⁾ 43A 24 FVZ ²⁾ 88A 36 H8A V2 ³⁾ 86A 30 G12 VXPM ⁴⁾ WA 24 GV
	Hardened	¹⁾ 62A 60 LVZ ²⁾ 89A 60 2 K5A V217 ³⁾ SGB 60 MVX ⁴⁾ 48A 601 L8V LNAA	¹⁾ 48A 46 HVZ ²⁾ 97A 46 2 H8A V217 ³⁾ SGB 46 G10 VXPM ⁴⁾ WA 46 GV	¹⁾ 48A 46 FVZP ²⁾ 97A 46 1 H10A V2 ³⁾ 86A 36 F12 VXPC ⁴⁾ WA 36 GV
ASSAB 718 Supreme MIRRAX 40 NIMAX RAMAX HH ROYALLOY	Pre-hardened	¹⁾ 33A 60 LVM ²⁾ 97A 60 1 K5A V217 ³⁾ SGB 60 MVX ⁴⁾ 51A 601 L5V MRAA	¹⁾ 43A 46 HVZ ²⁾ 89A46 2 I7A V217 ³⁾ SGB 46 G10 VXPM ⁴⁾ WA 46 GV	¹⁾ 43A 24 FVZ ²⁾ 88A 36 H8A V2 ³⁾ 86A 36 F12 VXPC ⁴⁾ WA 24 GV
Precipitation hardening steel: CORRAX	Solution treated or aged	¹⁾ 33A 60 KVM ²⁾ 97A 60 2 K5A V227 ³⁾ SGB 60 KVX ⁴⁾ 48A 601 J8V LNAA	¹⁾ 43A 46 GVZ ¹⁾ 15C 46 HVD ²⁾ 89A 46 1 H8A V217 ³⁾ 3SG 46 G10 VXPM ⁴⁾ WA 46 HV	¹⁾ 43A 36 FVZ ¹⁾ 15C 36 GVD ²⁾ 89A 362 I 10A V237 P20 ³⁾ 1TGP 36 F12 VXPC ⁴⁾ WA 24 GV
High carbide steel: ELMAX* ASSAB XW-10 ASSAB 88 ASSAB XW-5 ASSAB XW-42 VANADIS 4 EXTRA* VANADIS 6* VANADIS 10* ASSAB PM 23* ASSAB PM 30* ASSAB PM 60* VANCRON 40*	Soft annealed	¹⁾ 33A 60 LVM ²⁾ 97A 60 2 J5A V227 ³⁾ SGB 60 LVX ⁴⁾ 51A 601 L5V MRAA	¹⁾ 43A 46 HVZ ²⁾ 455A 36 2 K15 V3 P22 ³⁾ 3SG 46 G10 VXPM ⁴⁾ WA 46 HV	¹⁾ 43A 36 FVZ ²⁾ 454A 46 K13 V3 ³⁾ 53A 30 F12 VBEP ⁴⁾ WA 24 GV
ASSAB XW-10 ASSAB 88 ASSAB XW-42 ASSAB PM 23* ASSAB PM 30* VANCRON 40*	Hardened	¹⁾ 48A 60 LVZ ¹⁾ 820A 60 LVQ ²⁾ 97A 60 1 K5A V227 ³⁾ SGB 60 LVX ⁴⁾ 48A 601 L8V LNAA ⁴⁾ 43A 601 L8V LNAA	¹⁾ B151 R50 B3 ¹⁾ 420A 46 G12VQP ²⁾ 51B126 C50B Vib-Star ²⁾ 455A 36 2 K15 V3 P22 ³⁾ SGB 46 HVX ³⁾ 3SG 46G10 VXPM ⁴⁾ B126 V18 KR237 ⁴⁾ 27A 46 HV	¹⁾ 420A 46 FVQP ²⁾ 89A 362 I8A V2 ³⁾ 3SG 36 HVX ⁴⁾ WA 36 HV
ELMAX* ASSAB XW-5 VANADIS 4 EXTRA* VANADIS 6* VANADIS 10* ASSAB PM 60*	Hardened	¹⁾ 48A 60 LVZ ¹⁾ 820A 60 LVQ ²⁾ 97A 60 K5A V217 ³⁾ SGB 60 LVX ⁴⁾ 48A 601 L8V LNAA ⁴⁾ 43A 601 L8V LNAA	¹⁾ B151 R50 B3 ¹⁾ 420A 46 G12VQP ²⁾ 51B126 C50B Vib-Star ²⁾ 455A 36 2 K15 V3 P22 ³⁾ C150 QBA ³⁾ SGB 46 HVX ⁴⁾ B126 V18 KR237 ⁴⁾ 27A 46 HV	¹⁾ 420A 46 FVQP ²⁾ 454A 46 K13 V3 ³⁾ 3SG 46 FVSPF ⁴⁾ WA 46 FV

* SuperClean PM tool steel

ASSAB STEEL GRADE	CONDITION	CYLINDRICAL GRINDING	INTERNAL GRINDING	PROFILE GRINDING
Conventional steel: ALVAR 14 ASSAB DF-3 CALDIE CALMAX DIEVAR MIRRAX ESR ASSAB 8407 SUPREME ASSAB 8407 2M POLMAX QRO 90 SUPREME STAVAX ESR UNIMAX VIDAR 1 ESR	Soft annealed	1)33A 46 KVM 2)89A 60 2 K5A V217 3)19A 60 KVS 4)48A 46 LV	1)77A 60 K9VZ 2)89A 60 2 K6 V112 3)32A 46 L5 VBE 4)WA 46 JV	1)42A 100 IVZ 2)89A 801 G11A V237 P25 3)32A 100 KVS 4)WA 100 LV
	Hardened	1)48A 60 KVZ 2)92A 60 2 I6 V111 3)SGB 60 KVX 4)WA 60 JV	1)77A 80 K9VZ 2)AH 120 K6 VCOL 3)32A 60K5 VBE 4)WA 60 IV	1)42Z 1003 HVZ 2)89A 100 2 H11A V2 3)32A 100 KVS 4)WA120 JV
ASSAB 718 Supreme MIRRAX 40 NIMAX RAMAX HH ROYALLOY	Pre-hardened	1)33A 46 KVM 2)89 60 2 K SA V217 3)19A 60 KVS 4)48A 46 LV	1)77A 60 K9VZ 2)97A 60 2 K6 V112 3)32A 46 L5 VBE 4)WA 46 JV	1)42Z 100IVZ 2)89 80 1G11A V237 P25 3)32A 100 KVS 4)WA 100 LV
Precipitation hardening steel CORRAX	Solution treated or aged	1)42A 60 JVZ 2)15V 60 IVD 3)89A 60 2 J5A V217 4)SGB 60 JVX	1)42A 60 J9 VZ 1)15C 60 IVD 2)64B91 K11 V333 VV 3)32A 46 KS VBE 4)77 461 K7VLNAA	1)42A 100HVZ 2)89A 80 1G11A V237 P25 3)32A 100 JVS 3)77A 100 JBV LNAA 4)25A 601 J85VP MCNN
High carbide steel: ELMAX* ASSAB XW-10 ASSAB 88 ASSAB XW-5 ASSAB XW-42 VANADIS 4 EXTRA* VANADIS 6* VANADIS 10* ASSAB PM 23* ASSAB PM 30* ASSAB PM 60* VANCRON 40*	Soft annealed	1)62A 60 KVZ 2)454A 80 J11 V3 3)SGB 60 KVX 4)48A 46 LV	1)77A 60 K9 VZ 2)AH 120 K6 VCOL 3)32A 46 L5 VBE 4)WA 46 JV	1)42A 100IVZ 2)F13A54 FF22V Strato 3)32A 100 KVS 4)WA 100LV
ASSAB XW-10 ASSAB 88 ASSAB XW-42 ASSAB PM 23* ASSAB PM 30* VANCRON 40*	Hardened	1)B151 R50 B3 1)48A 60 KVZ 2)51B126 C50B Vib-Star 2)454A 80 J11 V3 3)SGB 60 KVX 3)SSGP 70 JVX 4)B126 V18 KR191 4)27A 60 JV	1)B151 R75 B3 1)430A 80 J VQA 2)51B126 C100 B54 2)C202 H5A V18 3)CB150 TBA 3)3SG 60 JVX 4)B126 V24 KR237 4)27A 60 HV	1)B126 R100 B6 1)820A 1003 GVQ 2)B126 C75 B53 2)89A 80 1 G11A V237 P25 3)CB150 TBE 3)SSG 80 KVX 4)B126K V24 KR237 4)27A 100 JV
ELMAX* ASSAB XW-5 VANADIS 4 EXTRA* VANADIS 6* VANADIS 10* ASSAB PM 60*	Hardened	1)B151 BR50 B3 1)420A 54 JVQ 2)51B126 C50 Vib-Star 2)454A 80 J11 V3 3)CB150 QBA 3)SGB 60 KVX 3)SSGP 70 JVX 4)B126 V18 KR191	1)B151 R75 B3 1)430A 80 J VQA 2)51B126 C100 B54 2)C202 H5A V18 3)CB150 TBA 3)3SG 60 JVX 4)B126 V24 KR237 4)27A 60 HV 4)27A 60 IV	1)B126 R100 B6 1)820A 1003 GVQ 2)B126 C75 B53 2)F13A 54 FF22V Strato 3)CB150 TBE 3)SSG 80 JVX 4)B126K V24 KR237 4)27A 100 IV

* SuperClean PM tool steel

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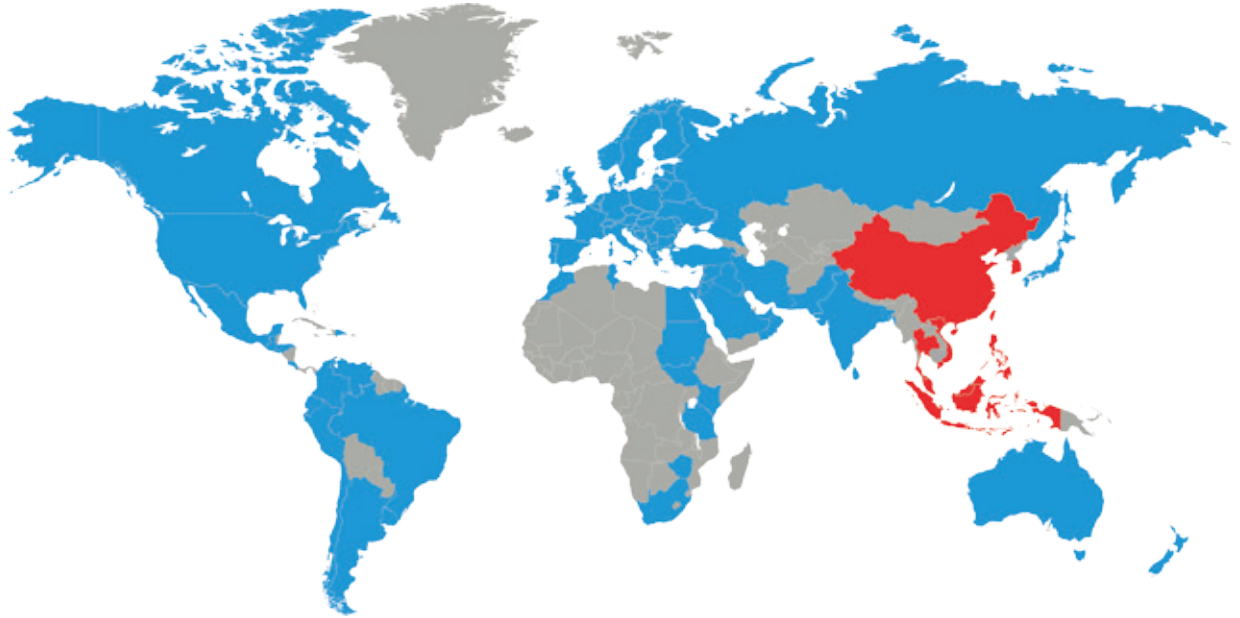
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Choosing the right steel is of vital importance. ASSAB engineers and metallurgists are always ready to assist you in your choice of the optimum steel grade and the best treatment for each application. ASSAB not only supplies steel products with superior quality, we offer state-of-the-art machining, heat treatment and surface treatment services to enhance steel properties to meet your requirement in the shortest lead time. Using a holistic approach as a one-stop solution provider, we are more than just another tool steel supplier.

ASSAB and Uddeholm are present on every continent. This ensures you that high quality tool steel and local support are available wherever you are. Together we secure our position as the world's leading supplier of tooling materials.

For more information, please visit www.assab.com