

HYBRID BOND

**Flute grinding stainless steel  
( Dental-Technik )**

1 ) Operation : Flute grinding

Workpiece: Drills Ø4-5 mm  
Flute length about 10-12 mm  
Material : 1.4112 (AISI 440B) / 56 HRC

Machine : Rollomatic 620 SX  
Coolant: Oil 8 bar

Dressing unit: Geiger maschine (outside CNC, on spindle)

Wheel: *E48960019T526415 3A1 75 4 8 10*  
B 46 SE 110 M415

**Parameters:**

Wheel speed: 21,2 m/s Vc= 5400 U/min  
Feed: Vw= 40 mm/min  
Depth of cut: ae= 0,6 mm

**Results:** The corner stability was better than any ceramic bonded wheel. The customer can hold a radius  $R < 0,05$  mm. No burr or burns.

