



ATLANTIC

SCHLEIFSCHEIBEN + HONSTEINE

Process reliability from heavy plate to aluminium foil
Roll grinding wheels for high removal rates up to 500 kg per hour and finest surface finish up to 0.03 $\mu\text{m Ra}$



SHORT INFORMATION

**ROLL GRINDING
WHEELS FOR
HOT & COLD MILLS**

GET YOUR PERFORMANCE ADVANTAGES ROLLING WITH OUR ROLL GRINDING WHEELS FOR HOT & COLD MILLS



Specification proposals and case studies

The general ATLANTIC recommendations are applicable to the regrinding of rolls used in hot and cold rolling mills, and are based on many years of experience in both these applications. These proposals may require slight modification to optimize the process. To formulate a specification for your exact requirements, it is essential to provide certain information e.g. power of the grinding spindle, grinding wheel dimensions, material to be ground, including roll dimensions, hardness, and surface finish required.

We would be pleased to optimize your grinding process with regards to quality and productivity.

Roll type	Roll material	Roughness Ra [μm]	Standard	High Performance
Work rolls	High chrome & HSS	0,4–1,2	Corundum #36– #46	Corundum & Sol Gel #46
		> 1,6	Corundum #24– #30	Corundum & Sol Gel #30
	Indefinite & Cast Steel	0,4–1,2	Silicon carbide #36– #46	Silicon carbide & Sol Gel #46
		> 1,6	Silicon carbide #24– #30	Silicon carbide & Sol Gel #30
	Forged Steel	0,2–0,6	Corundum #60– #100	Corundum & Sol Gel #60– #100
	Back-up rolls	All materials	--	Corundum #30

Case examples:

	Example 1	Example 2	Example 3
	Work roll	Work roll	Back-Up roll
Machine:	Waldrich	Herkules	Waldrich
Power:	100 kW	100 kW	100 kW
Coolant:	Emulsion, 2 %	Emulsion, 2 %	Emulsion, 2,5 %
Roll dimensions:	Ø 650 x 1900 mm	Ø 750 x 2200 mm	Ø 1430 x 2030 mm
Roll material:	Cast high chrome Indefinite	Cast high chrome	Cast steel
Roll hardness:	75 – 85 ° ShC	80° ShC	65° ShC
Stock Removal on Ø:	0,3 – 0,5 mm	0,5 mm	2 mm
Grinding wheel dimensions:	915 x 125 x 304,8 mm	915 x 102 x 304,8 mm	915 x 100 x 304,8 mm
Grinding wheel speed:	45 m/s	50 m/s	45 m/s
Max. current consumption:	130 A	130 A	175 A
Grinding time per roll:	45 min.	40 min.	120 min.
No. of rolls per wheel:	300 pcs.	150 pcs.	40 pcs.



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