

BONDED ABRASIVES FLUTE GRINDING WHEELS

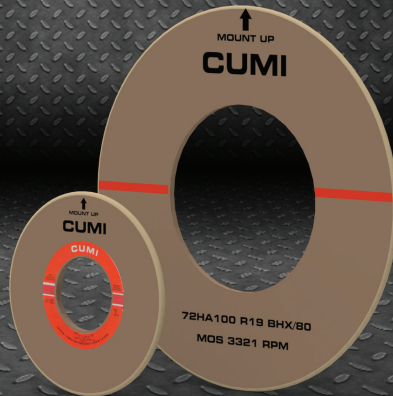
ABOUT FLUTE GRINDING

Being a high depth of cut, form generating grinding process, Flute grinding operations are at high speeds and remove material at rates comparable to machining process rather than grinding. A combination of peripheral and surface grinding actions, the depth of cut, width of cut, form retention and surface finish are crucial parameters.

CUMI Flute grinding wheels are specially engineered high density (near zero porosity), resin bonded wheels which ensure that the form is generated with utmost precision and finesse. These wheels truly are a testament to the expertise that CUMI has built over the years.

FEATURES:

- Special phenolic resin
- Specially treated aluminium oxide grains for higher depth of cut
- Micro crystalline grain for lesser dressing frequency
- Unique manufacturing process for high density packing



ADVANTAGES OF CUMI WHEELS



1. High depth of cut
2. Higher wheel life
3. Better form holding/
reduced dressing
4. Smoke free grinding
5. Burn free components

WIDTH OF PRODUCT RANGE

CUMI Code	Grit	Diameter		Thickness		Structure	Coolant slot	Speed mps
		mm	inch	mm	inch			
CUMISA/CSA	80 - 150	150 - 500	6 - 20	4 - 20	0,16 - 0,8	R	slotted	63
SA						P		
RA						Q		
AA						F		

COMMONLY USED MACHINES:

- Normac
- Hertline
- Gefra

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DRILL



TAP

Operation	Component	Best	Better	Good
Flute grinding	Drills	3CUMISA100 R19 BH99/80	3CUMISA100 R19 BHX/80	3SA100 R19 BHK/80
Point grinding	Drills	-	-	AA100 S12 BHP/60 AA100 S12 BH47/80
Clearance grinding	Drills	3CUMISA100 Q24 BH99/80	3SA100 Q24 BH99/80	AA80 Q21 BH99/80





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