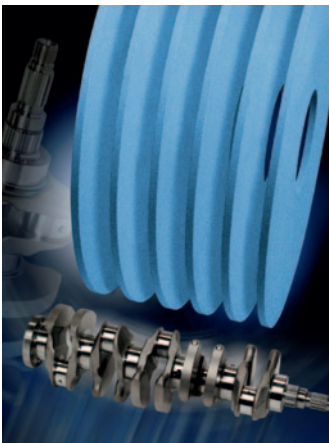


# 3M™ Cubitron™ II Vitrified Wheels

## Crankshaft/Camshaft Grinding

### Application examples

- Camshafts
- Crankshafts



### Advantages of 3M™ Cubitron™ II Wheels over traditional vitrified wheels:

- + Up to 1.5 times the material removal rate  $Q'_w$  Minimal risk of burning
- + Up to 23% faster cycle time per part
- + Up to 3x more parts per grinding wheel
- + Up to 2–4 times longer service life between two dressing cycles
- + Required finish with higher grinding parameters
- + Minimal risk of burning

### Examples for frequently used specifications

Please get a recommendation as to the appropriate specification for your application from our local sales office.

Components	Applications	Grinding operation	Surface quality	Specifications
Crankshafts	Main/pin bearing	Face, radius, diameter grinding	$R_a$ 0.9 $\mu$ m	230DA 463 K9 V722A
			$R_a$ 0.8 $\mu$ m	230DA 543 J9 V722A
		Diameter grinding (bearing with undercut)	$R_a$ 0.6 $\mu$ m	230DA 60 L V722
			$R_a$ 0.4 $\mu$ m	230DA 80 K V722
	Main bearing	Multi-Wheel grinding	$R_a$ 0.6 $\mu$ m	230DA 60 L/M V722A
	Journal and flange		$R_a$ 0.6 $\mu$ m	230DA 603 J9 V722A
Camshafts	Main bearing	Multi-Wheel grinding	$R_a$ 0.8–1.0 $\mu$ m	230DA 60 O/P/Q V722A
			$R_a$ 0.4 $\mu$ m	230DA 80 L/M V722A
	Camlobe		$R_a$ 0.5–0.6 $\mu$ m	230DA 60 L/M V722



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