

عنوان مقاله:

Influence of the type of coolant lubricant on the grinding with CBN-tools

محل انتشار:

اولین کنفرانس بین المللی و هفتمین کنفرانس ملی مهندسی ساخت و تولید (سال: 1384)

تعداد صفحات اصل مقاله: 8

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خلاصه مقاله:

Oil and emulsion are two main grinding coolant lubricants used in grinding process with CBN tools. As the long systematic researches in KSF, the comparison of these two CLs was performed. The comparison criterion presented in this paper are grinding forces and G-Ratio. The results show that oil presents better function almost in every cases for the selected grinding parameters and workpiece. However it should be notified that the results can probably be different with other type of oil and emulsion.

کلمات کلیدی:

Grinding, CBN, Coolant lubricant

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