

SUPERFIN1 wheels for mirror finishing carbide tools on CNC grinding machines



MEMBER OF THE **MIRKA** GROUP

Specifications: 1A1 100 10 6 SUPERFIN1

Operation: Mirror finishing

Machine : CNC grinding machine

Workpiece : Drills $\varnothing 8 \div 20$

Material: Tungsten carbide



Dressing:

Type: White aluminium oxyde wheel in 220 mesh or stick 600 grit size

Wheel speed: < 5 m/s for the SUPERFIN1 wheel

Rotation: counter clockwise

Machine:

Model: Walter, Schneebeger, Isog, Saacke, Haas, Cuoghi, etc.

Spindle power : not important

Coolant : oil, if possible microfiltration with chiller

Working parameters:

Wheel speed : 22 m/s

Removal: max. 0,05 mm

Feed: 50 mm/min, it depends on drill or endmill geometry.

Parameter	Required performance	Results
Total removal	0,1 mm	0,03 mm
Number of workpieces	300	300
Surface finish	Ra 0,1	Ra 0,04
Dress every	50 pcs	200 pcs
Working time	1'	1'

Note:

- 1) SUPERFIN1 can remove few microns only so we suggest to flute grind with Cafro M405 (*) before
- 2) The SUPERFIN1 wheel geometry must have the same as the roughing diamond wheel
- 3) Surface Quality obtained in every 300 pieces is less than 0,05 μ m. Need precise set up.
- 4) Wheel wear : < 0,01mm after 100 pcs $\varnothing 8$ mm
- 5) You can work with loader: the wheel wear is so small, it does not need much compensation
- 6) The depth of cud depends on workpiece tool diameter, the bigger \varnothing the smaller.



Management System
ISO 9001:2015
ISO 14001:2015
OHSAS 18001:2007
ID 9105085630

(*)free cutting bond for rough grinding: please ask for literature or technical advices

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