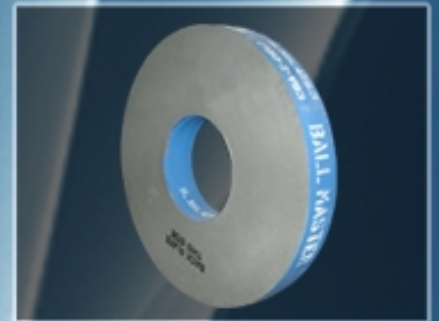




Abrasives for Ball Grinding Industry



Ball Grinding Wheels

CUMI's Ball Grinding Wheels are manufactured to exacting standards and are acknowledged to be of the highest quality by many of the largest ball manufacturing companies in the world.

CUMI manufactures a wide range of ball grinding wheels by high performance bond systems in an unique manufacturing process .

The CUMI standard range of Vitrified ball grinding wheels

Diameter	280 - 660 mm	661 - 1000 mm
Thickness* (max)	80 mm	140 mm
Abrasive Type	C / FC	C / FC
Grit Range	G 100 - 400	G 100 - 400
Hardness	V, X & Z	V, X & Z
Bond	VB	VB
Toughness	1, 3, 5	1, 3, 5

Ball Wheel- Wheel marking system

Standard grading of a CUMI ball grinding wheel

C	180	Z	VB1
↓	↓	↓	↓
Grain	Grit Size	Hardness Grade	Bond / Toughness

Initial grading selection of CUMI Ball Grinding wheels

	Max Ball Diameter (mm)	< = 6	7-11	12-25	> 25
Criterion No. 1	Grit selection	G400 G320	G280 G240 G220	G180 G150	G120 G100
Criterion No. 2	Grinding ratio	Low	Medium		High
	Wheel hardness selection	V	X		Z
Criterion No. 3	Material removal rate (MRR)	High	Intermediate		Low
	Wheel toughness selection code	1	3		5

Benefits of using CUMI Ball Grinding Wheels:

- High material removal rate
- Longer wheel Life
- Reduction in grinding cost.
- Good surface finish
- Reducing the cycle time results in higher Productivity.
- Batch to batch consistency



Ball Lapping Wheels

CUMI has added to its portfolio the high performance Ball Lapping wheels – thus becoming one of the few Global Manufacturers providing the entire range of abrasive products used in the Ball Manufacturing Industry. CUMI ball lapping wheels are made by unique manufacturing process ensures product consistency.

CUMI Standard Range of Ball Lapping Wheels

Abrasive Type	CA
Grit Ranges	600 – 1500
Hardness	Y , Z
Wheel Diameter	450 - 915 mm
Thickness	100 mm
Bond	BL393
Toughness	3,4

CUMI Standard Grading

Rough Lapping	CA 600 Z4 BL393 CA 800 Z4 BL393
Semi Finish Lapping	CA1000 Z4 BL393
Finish Lapping	CA1200 Z4 BL393 CA1500 Z4 BL393
* Sketch wheels available on request	



Benefits :

- . Higher productivity due to higher material removal rate
- . Longer wheel life
- . Environment friendly due to lapping compounds being removed
- . Reduction in machine cleaning time
- . Excellent surface finish
- . Reduction in lapping cost

Features :

- . High degree of Homogeneity over the total width of the wheel
- . Eliminates frequent addition of lapping compound variables during the process.