

3.

3-5

(1)

가

가



< 3-14>



< 3-15>



< 3-16> 가

. 가

가

3-15 C

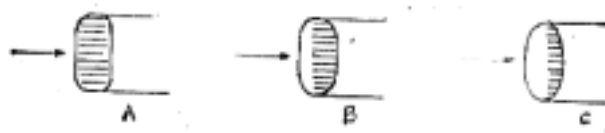
가 30

(land)

가

3-17 A

C



< 3-17>

1)

:

가 .

2) : .

가 .

3) : .

4) : 가 .

5) : 가

가 .

1~2 5000kg

.

(2)

(traverse wheel grinder)

75mm

100mm

750rpm

900rpm

. 3.75m/min가 .

가 .

가 가 가

.

.

1)

.

2)

3)

가

가

4)

가

가

300m/min

5)

6)

가

가

가

가

가

7)

8)

가

9)

0.025mm

15

가

2 가

가

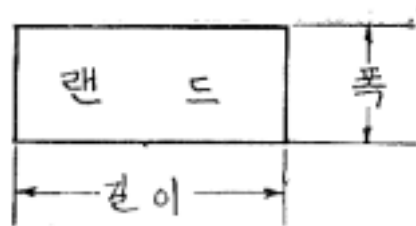
가

10)

가

가

100 (150)



< 3-18>

(3) (grinding stone)

Resinoid general grindstone

1) .(3-3)

< 3-3>

white melted aluminium oxide	WA
brown melted aluminium oxide	A
green silicon carbide(grade)	GC
green silicon carbide(grade)	BGC BG
silicon carbide	C

2)

< 3-4>

No. 10, 12, 14, 16, 20, 24	(coarse)
No. 30, 36, 46, 54, 60	(medium)
No. 70, 80, 90, 100, 120, 150, 180, 220	가 (fine)
No. 240, 280, 320, 400, 500, 600, 700, 800	가 (very fine)

3) 3-5 22 .

4)

E.C.C 3-6 .

< 3-5>

E.F.G.	(very soft)
H.I.J.K	(soft)
L.M.N.O.	(medium)
P.Q.R.S.	(hard)
T.U.V.W.X.Y.Z	(very hard)

< 3-6>

	WA 36/46 JVLP WA 36/46 JVLP A 46/L7V WA 80-PE31

Toyoda

WA60-1 "

100mm,

50mm

(4)

1) 1 (grinding “back of point”)

3-19

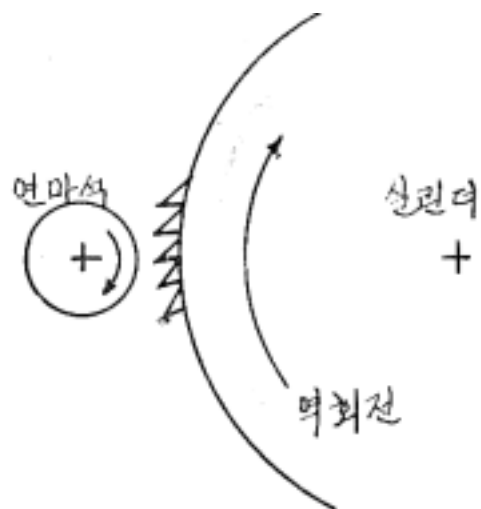
가

가

가

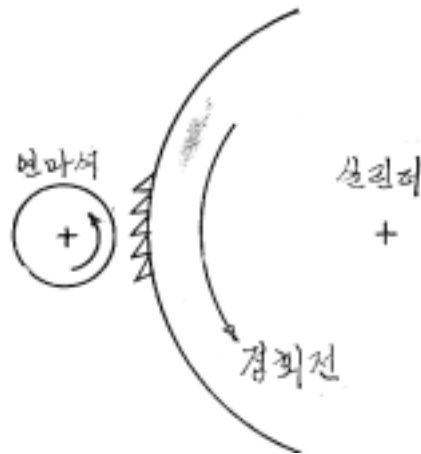
가

가



2) 2 (grinding “against the point”)

가
가 .



< 3-20> 2

3-6 (burnishing)

가

가

. 1

700~750rpm ,

. 가 0.25~0.37mm

가 1

33.5

가 .

