

**Quality Enhancement
by Angular Dressing of
Grindig Wheels**

 **alphadress**

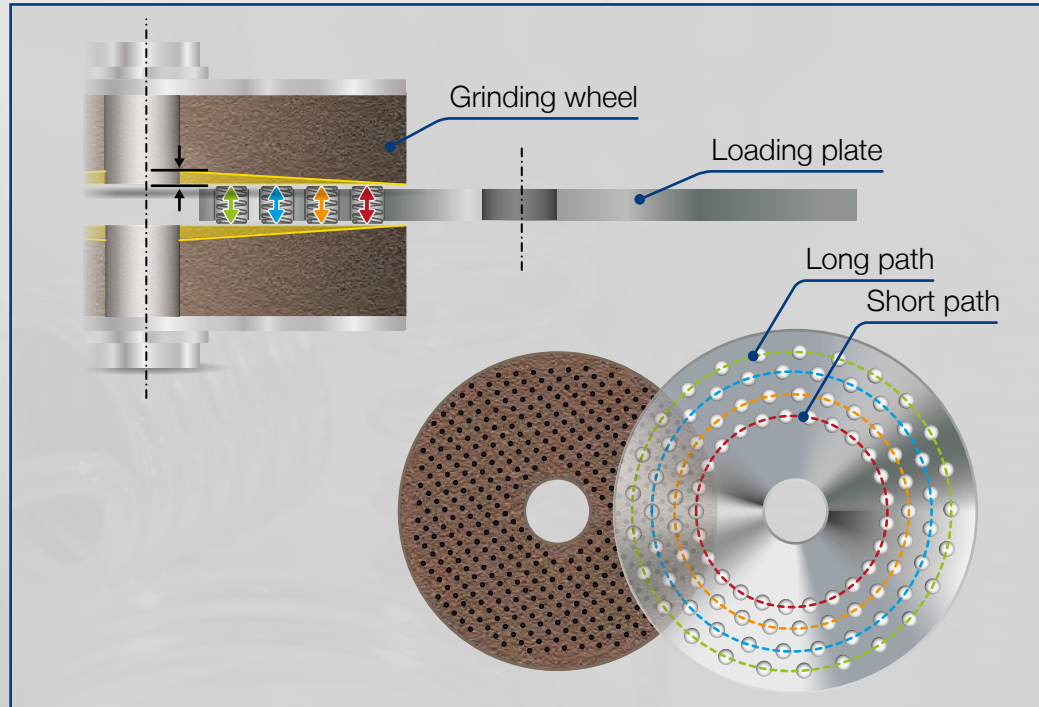
for
spring end grinding machines



Situation

- During the spring end grinding process, the contact time of the springs with the grinding wheel differs depending on which row they are positioned on the loading plate
- Therefore the spring ends are not ground evenly
- Tighter length tolerances, as they are required by small springs and multi-row loading plates, are more difficult to meet

Solution



- *iQalphadress* enables an angular dressing process towards the inner diameter of the grinding wheels
- This enables evenly ground spring ends in all rows of the loading plate
- Due to the slant surface of the grinding wheel, the grinding pressure exerted on the springs that have a longer contact time with the grinding wheel, is reduce
- If required, the grinding wheels can also be dressed in such a way that the grinding wheel surface is rising towards the inner diameter

Requirements

- Consider parallelism of spring contact surfaces (e2)