

## MB SPARK



Double disc metal bond wheel for electro-discharge truing

**MB SPARK**

### The next generation of double disc grinding systems

Suitable for surface quality improvement of elements used in automotive and household appliance in the progress of energy saving and miniaturization.

Extends the truing interval in combination with electro-discharge truing compared with conventional resin bond wheel.

#### ■ Features

1. Metal bond wheel with excellent electro-discharge truing capability. Easy high-accuracy truing on a grinder.
2. Long lasting cutting performance and high-wear resistance.
3. Less industrial waste-stops sludge produced from wheel during truing.

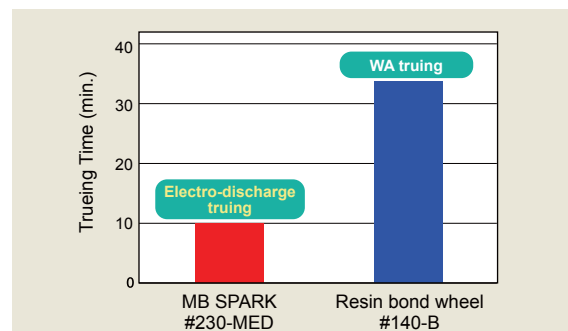
#### ● Grinding Conditions

Grinder	Koyo KVD-300
Grinding Wheel	Ø305-75W-3X-Ø80H MB SPARK #230-MED Resin Bond Wheel #140-B
Workpiece	Oil pump component Powdermetal SMF4040
Wheel Rotation	Upper : 1500min <sup>-1</sup> (C.C.W) Lower : 1500min <sup>-1</sup> (C.C.W)
Total Stock Removal	0.2mm (both sides)
Rough Stock Removal	0.19mm (both sides)
Rough Grinding Speed	0.035mm/sec
Finish Stock Removal	0.01mm (both sides)
Finish Grinding Speed	0.015mm/sec
Spark out	2sec

#### □ High Truing Performance

- MB SPARK allows for shorter work time on grinder quick truing with high accuracy using special low-melting metal bond suitable for electro-discharge truing.
- Further benefits are attained with fine grit of superabrasive applied. Excellent flatness acquired in a short time frame.

#### ● Comparison of Truing Performance

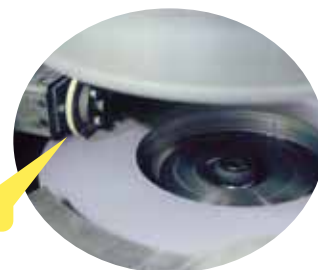


- 3 times longer tool life than conventional resin bond wheel

#### Electro-discharge Truing

Machine : Koyo Machinery

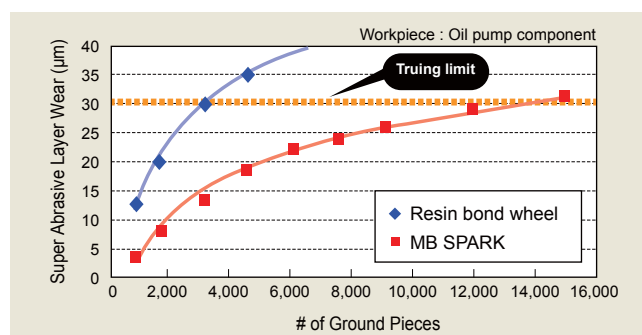
#### Discharge Electrode



#### □ Long Lasting Quality

MB SPARK has higher wear resistance than conventional resin bond wheel and keeps flatness of super abrasive layer longer. Truing interval is extended and suitable for automated production line.

#### ● Comparison of Grinding Capability



#### □ High Grindability

MB SPARK applies special metal bond suitable for double disc grinding. Its characteristic of high grit retention and surface retention of abrasive layer show excellent cutting ability to achieve improvement of process.

