



WINTER

Reshaping
your
world.

v-Prime

ULTIMATE EDGE
STABILITY IN CNC
GRINDING OF
ROUND TOOLS





Norton Winter V-PRIME is the new and improved version of V-PRO wheels for round tool grinding, delivering the ultimate edge stability.

V-PRIME has been designed to provide excellent edge stability in gashing and clearance angle grinding. In today's challenging economic environment, it is more important than ever to maintain constant wheel geometry for as long as possible, without the need for correction, as this enables increased output and improved quality. The new V-PRIME can be easily implemented without any machine or process adjustments, offering manufacturers immediate improvements.

ADVANTAGES:

- With V-PRIME, the excellent durability of the previous generation of V-PRO is even longer thanks to reduced wear
- The innovative V-PRIME demonstrates remarkable edge stability with reduced grinding forces and excellent performance, offering higher feed rates and lowering process times and costs
- The more stable grinding process leads to better part quality and less sub-surface damage
- The new V-PRIME optimises grinding wheel preparation: off-line dressing is simpler and faster, saving time and money

CASE STUDY: COMPLETE MACHINING WITH V-PRIME

Applications

- Complete machining on a tungsten carbide end mill \varnothing 12mm

Machine

- Anca MX7 Linear

Grinding Tool

- Norton Winter D64 V-PRIME 5406

Coolant

- Oil

Process Conditions

- Feed rate: +50% compared to competition
- Infeed: $a_e \sim 0.3$ mm max
- Cutting Speed: $v_c = 22$ m/s

BENEFIT

- ✓ Extremely durable
- ✓ ~20% reduction of grinding time
- ✓ Significant cost savings
- ✓ Faster machine set-up with easier wheel preparation

MATERIAL	ART NO.
2K11V9-75-3-10 20*D46 V-PRIME5406 H	66260173572
2K11V9-75-3-10 20*D64 V-PRIME5406 H	66260165023
10K11V9-100-3-10 20*D46 V-PRIME5406 H	66260165042
10K11V9-100-3-10 20*D64 V-PRIME5406 H	66260164307
11K11V9-125-3-10 20*D46 V-PRIME5406 H	66260178973
11K11V9-125-3-10 20*D64 V-PRIME5406 H	66260168014
3K12V9-100-3-10 20*D46 V-PRIME5406 H	66260167741
3K12V9-100-3-10 20*D64 V-PRIME5406 H	66260165036
5K12V9-125-3-10 20*D46 V-PRIME5406 H	66260165639
5K12V9-125-3-10 20*D64 V-PRIME5406 H	66260165037
K1V1-100-10-10-45 20*D64 V-PRIME5406 A	66260174928
K1V1-125-10-10-45 20*D64 V-PRIME5406 A	66260176643



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