

NORTON

SAINT-GOBAIN®

WINTER

v-Prime

ULTIMATE EDGE STABILITY IN CNC GRINDING OF ROUND TOOLS

Norton Winter V-PRIME has been designed to provide excellent edge stability in gashing and clearance angle grinding of round tools. 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. V-PRIME combines the extreme edge stability of a hybrid or metal bond with the free cutting and easy to dress properties of a standard resin bond. The new V-PRIME wheels can be easily implemented without any machine or process adjustments, offering manufacturers immediate improvements.

ROUND TOOL APPLICATIONS

END GASH | CLEARANCE OR RELIEF ANGLE GRINDING

www.nortonabrasives.com

NORTON

SAINT-GOBAIN

WINTERV-PRIME
ROUND TOOL
GRINDING

- V-PRIME demonstrates remarkable edge stability with reduced grinding forces and excellent performance, offering higher feed rates and lowering process times and costs
- New innovative bond system combines extreme wear resistance with the dressing ability of a standard resin bond
- More stable grinding process leads to better part quality and less sub-surface damage
- Optimized grinding wheel preparation: off-line dressing is simpler and faster, saving time and money

Availability

SHAPE	SIZE (D X T X H)	INSERT LENGTH (U)	ABRASIVE WIDTH (W)	ANGLE (V)	SPEC	GRIT	PART #
11V9	3-3/4" x 35mm x 1-1/4"	9.3mm		70°	D64V-Prime 5406 H -1/8	240	662602 13487
11V9	3-3/4" x 35mm x 1-1/4"	9.3mm		70°	D54V-Prime 5406 H -1/8	320	662602 13321
11V9	3-3/4" x 35mm x 1-1/4"	9.3mm		70°	D46V-Prime 5406 H -1/8	400	662602 13282
11V9	100mm x 35mm x 1-1/4"	10mm		70°	D64V-Prime 5406 H -3mm	240	662602 12804
11V9	5" x 40mm x 1-1/4"	9.3mm		70°	D64V-Prime 5406 H -1/8	240	662602 13286
11V9	5" x 40mm x 1-1/4"	9.3mm		70°	D54V-Prime 5406 H -1/8	320	662602 13284
11V9	5" x 40mm x 2"	9.3mm		70°	D54V-Prime 5406 H -1/8	320	662602 13287
12V9	100mm x 20mm x 1-1/4"	10mm		45°	D46V-Prime 5406 H -3mm	400	662601 98315
12V9	125mm x 25mm x 1-1/4"	10mm		45°	D46V-Prime 5406 H -3mm	400	662601 98316
12V9	150mm x 25mm x 1-1/4"	10mm		45°	D64V-Prime 5406 H -3mm	240	662601 98317
1V1	100mm x 10mm x 1-1/4"			45°	D54V-Prime 5406 A -6mm	320	662602 07878
1V1	125mm x 10mm x 1-1/4"			45°	D54V-Prime 5406 A -12mm	320	662602 07786
11V5 (MGM)	100mm x 1-1/4" x 1-1/4"		6mm	30°	D46V-Prime 5406 A -10mm	400	662602 04642

Also available in 1A1, 1V1, 1B1, 11A2 shapes, as well as additional sizes, abrasive depths, and grits. cBN for high speed steel (HSS) available upon request.

Case Study: V-Prime

APPLICATION: Gashing and Radius clearance grinding of tungsten carbide end mill \varnothing 12mm

MACHINE: Anca MX7 Linear

NORTON WINTER TOOL / SPECIFICATION: Norton Winter D64 V-PRIME 5406

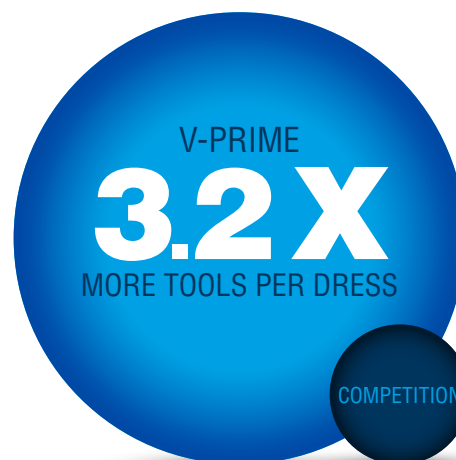
COOLANT: Oil

PROCESS CONDITIONS:

- Feed rate: +50% compared to competition
- Infeed: a_e ~0.3 mm max
- Cutting Speed: V_c = 22m/s

BENEFIT:

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



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FORM #8839 REV. 04/20

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NO-RISK TEST

