

# ROLL GRINDING

Technical Solutions for Roll Grinding



*Innovative Grinding Technology since 1895*

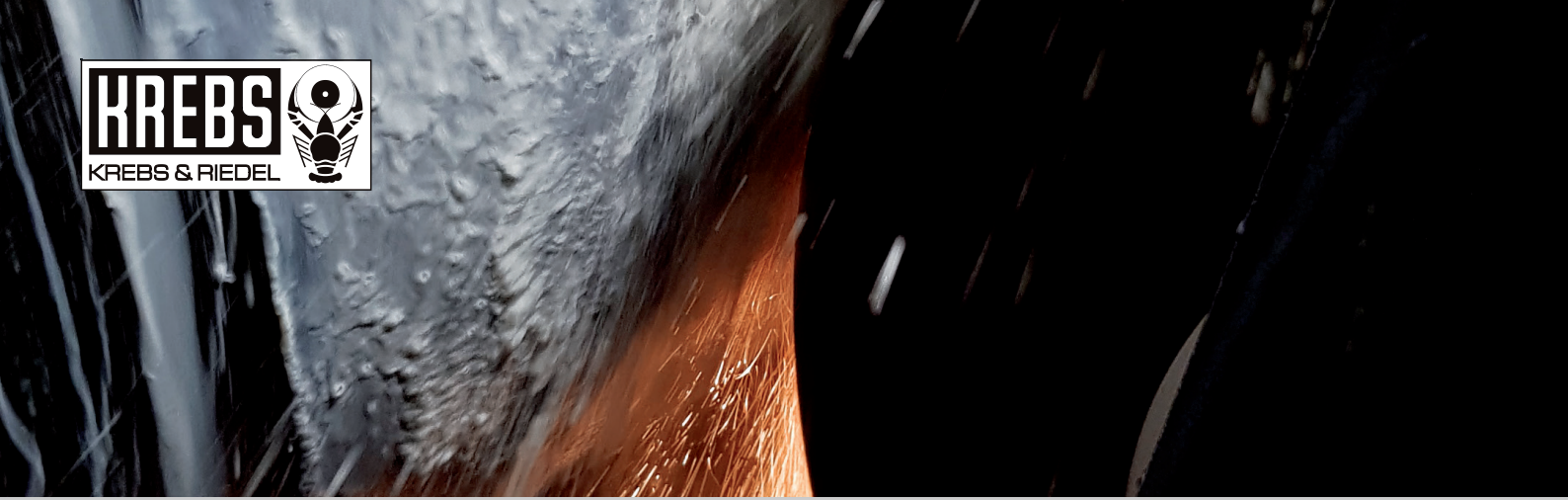
**ADVANCED GRINDING  
SOLUTIONS**

**Steel Industry**

**Aluminum Industry**

**Paper Industry**





## Universal use on all roll materials and types.

Roll grinding wheels are used for the production and reworking of rolls in the steel, aluminum, brass, paper and printing industries, among others. The main consumption of rolls is primarily in the steel industry, where the rolling process is most commonly used to produce strips and sheets with the required thickness and surface quality. The type and dimensions of rolls vary depending on the rolling application.

Krebs & Riedel offers a wide range of products from 400 to 915mm with state-of-the-art and customized bonds.

## Your benefits

- Cost reduction and productivity increase
- Highest stock removal rate
- Reduces grinding times
- Excellent tool life

## Hot Working Rolls

Grit size in Mesh	Surface finish Ra μm	Bond type
24 - 36	1,2 - 2,5	Resin B70
36 - 46	0,8 - 1,2	Resin B70
46 - 60	0,5 - 1,0	Resin B70
Materials	Cr-Steel, HSS, Indefinite	
Surface finish	Not so critical like on cold mills	
High allowance with high stock removal rate		

## Cold working rolls

Grit size in Mesh	Surface finish Ra $\mu\text{m}$	Bond type
46	0,6 - 1,0	Vitrified V, Resin B70
60	0,4 - 0,8	Vitrified V
80	0,3 - 0,6	Vitrified V
100	0,2 - 0,4	Vitrified V
120	0,15 - 0,3	Vitrified V, Resin B70
180 and finer	0,1 - 0,2	Vitrified V, Resin B70
Materials	Forged steel, HSS, Powder steel	
Surface finish	Highest standard on visual inspections and surface finish	
Mostly lower stock removal		



## Backup Rolls

Grit size in Mesh	Surface finish Ra μm	Bond type
30	1,5 - 3,0	Resin B70
36	1,0 - 2,5	Resin B70
46	0,6 - 1,5	Resin B70
Materials	2 - 5 % Cr steel, HSS, Cast steel	
Surface finish	Relatively high and gripy surface finish	
Mostly larger diameter with high stock removal		

## Paper & Printing Rolls

Typical Applications	Abrasives	Bond type
Roughing chilled cast iron	CBN	Vitrified V
Coatings e.g. HVOF WcCo	Diamond	Vitrified V
Plastic compounds, Hardcoatings e.g. Metso	Diamond	Vitrified V
Rubber soft / hard	33A / 47A	Vitrified V
Plastic, PUR, Rilsan, etc. >50Sh	45A / 47A	Vitrified V

