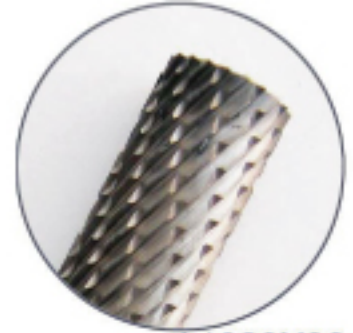


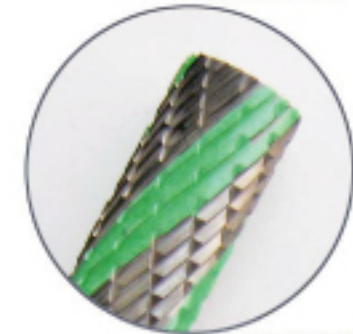
# Speedway & Double Cut Sample Grinding Test

December 12, 2005

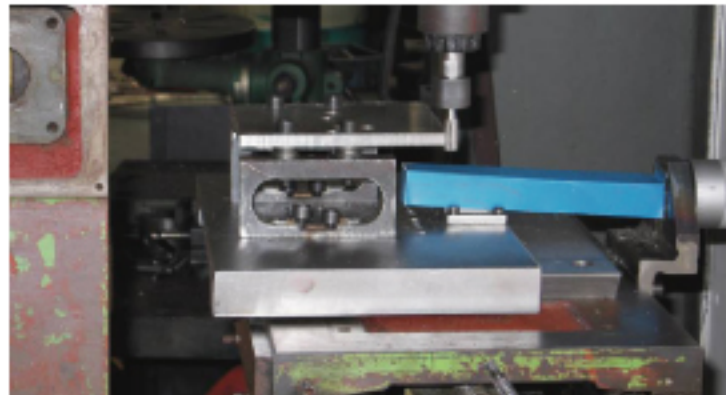
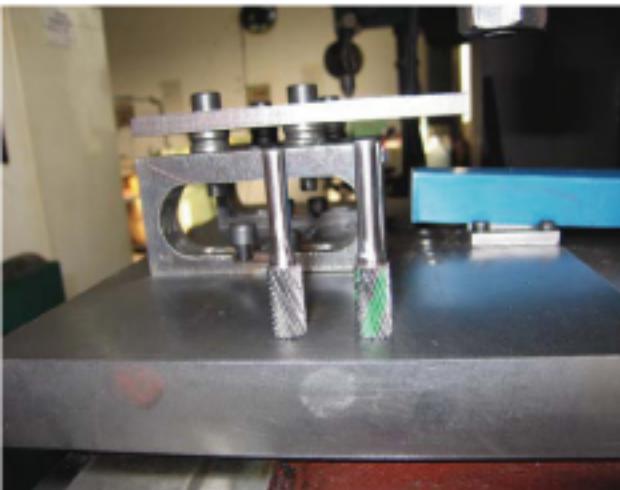
Grinding tool RPM: 23000/min  
Grinding depth: 1mm  
Grinding Path Length: 171mm  
Propelling Power: 3Kgf  
Automatic feeding/Grinding mode  
Material: Steel Board  
Thickness 7mm, 45#, 15HRC



A1020X06



A1020V06



# Carbide Burr Test Report

## Speedway VS Double Cut

2006-3-15

Description	Part No.	Cutter Size Before	1st Test Decrement	2nd Test Decrement	3rd Test Decrement	Average Decrement
Speedway.01	A1020V06	9.95mm	0.01mm	0.03mm	0.02mm	0.0180mm
Speedway.02	A1020V06	9.86mm	0.03mm	0.02mm	0.01mm	
Speedway.03	A1020V06	9.84mm	0.01mm	0.02mm	0.01mm	
Speedway.04	A1020V06	9.90mm	0.02mm	0.02mm	0.01mm	
Speedway.05	A1020V06	9.80mm	0.02mm	0.03mm	0.01mm	
DoubleC.01	A1020X06	10.02mm	0.05mm	0.02mm	0.01mm	0.0227mm
DoubleC.02	A1020X06	10.06mm	0.03mm	0.03mm	0.02mm	
DoubleC.03	A1020X06	9.92mm	0.03mm	0.02mm	0.02mm	
DoubleC.04	A1020X06	9.92mm	0.02mm	0.03mm	0.02mm	
DoubleC.05	A1020X06	10.15mm	0.01mm	0.02mm	0.01mm	

- Grinding Tool RPM: 23,000/min
- Grinding Depth : 1 mm
- Grinding Path Length : 171mm
- Material : 45# Carbon Steel; Hardness HRC 15
- Tool : Electric Grinder; Stop Watch; 3Kg Poise;

测试条件为：

7mm 厚45#钢板 ; HRC 15  
 进刀深度为 1mm ; 运行轨迹长度 171mm  
 牵引力 3KG 砝码 ; 电磨转速 23000rpm  
 每支测试三次 , 秒表计时 , 测量刃径变化

Description	Part No.	Cutter Size Before	Cutter Size After 1st Test	Time	Cutter Size After 2nd Test	Time	Cutter Size After 3rd Test	Time	Speed & RPM
Speedway.01	A1020V06	9.95mm	9.94mm	110/sec	9.91mm	133/sec	9.89mm	165/sec	0.87mm*1mm/sec 23,000rpm
Speedway.02	A1020V06	9.86mm	9.83mm	199/sec	9.81mm	165/sec	9.80mm	238/sec	
Speedway.03	A1020V06	9.84mm	9.83mm	190/sec	9.81mm	321/sec	9.80mm	240/sec	
Speedway.04	A1020V06	9.90mm	9.88mm	172/sec	9.86mm	176/sec	9.85mm	206/sec	
Speedway.05	A1020V06	9.80mm	9.78mm	232/sec	9.75mm	250/sec	9.74mm	325/sec	
<b>Analysis</b>		Max/Average	<b>232/sec / 181/sec</b>		<b>321/sec / 209/sec</b>		<b>325/sec / 235/sec</b>		
DoubleC.01	A1020X06	10.02mm	9.97mm	117/sec	9.95mm	129/sec	9.94mm	204/sec	0.77mm*1mm/sec 23,000rpm
DoubleC.02	A1020X06	10.06mm	10.03mm	146/sec	10.00mm	167/sec	9.98mm	235/sec	
DoubleC.03	A1020X06	9.92mm	9.89mm	242/sec	9.87mm	230/sec	9.85mm	267/sec	
DoubleC.04	A1020X06	9.92mm	9.90mm	260/sec	9.87mm	328/sec	9.85mm	557/sec	
DoubleC.05	A1020X06	10.15mm	10.14mm	148/sec	10.12mm	259/sec	10.11mm	365/sec	
<b>Analysis</b>		Max/Average	<b>260/sec / 183/sec</b>		<b>328/sec / 223/sec</b>		<b>557/sec / 326/sec</b>		