

INTERNATIONAL STANDARD

ISO
3002-5

First edition
1989-11-01

Basic quantities in cutting and grinding —

Part 5 : Basic terminology for grinding processes using grinding wheels

*Grandeurs de base en usinage et rectification —
Partie 5 : Terminologie de base propre au meulage*



Reference number
ISO 3002-5 : 1989 (E)

Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 3002-5 was prepared by Technical Committee ISO/TC 29, *Small tools*.

ISO 3002 will consist of the following parts, under the general title *Basic quantities in cutting and grinding*:

- *Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers*
- *Part 2: Geometry of the active part of cutting tools — General conversion formulae to relate tool and working angles*
- *Part 3: Geometric and kinematic quantities in cutting*
- *Part 4: Forces, energy, power*
- *Part 5: Basic terminology for grinding processes using grinding wheels*
- *Part 6: Quantity as a function of time*

Annex A of this part of ISO 3002 is for information only.

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International Organization for Standardization

Case postale 56 • CH-1211 Genève 20 • Switzerland

Printed in Switzerland

Basic quantities in cutting and grinding —

Part 5 : Basic terminology for grinding processes using grinding wheels

1 Scope

The aim of this part of ISO 3002 is to apply the basic terminology defined in ISO 3002, parts 1 to 4, specifically to grinding operations and to define additional quantities specific to grinding.

NOTE — In addition to terms used in the three official ISO languages (English, French and Russian), this part of ISO 3002 gives the equivalent terms in the German, Italian and Dutch languages; these are published under the responsibility of the member bodies for Germany, F. R. (DIN), Italy (UNI), the Netherlands (NNI) and Belgium (IBN). However, only the terms given in the official languages can be considered as ISO terms.

For the purposes of this part of ISO 3002 the meaning of the word grinding is considered in a limited sense as a material removal operation in which the tool is a grinding wheel.

The primary motion¹⁾ is the rotation of the grinding wheel which causes a considerable peripheral speed in the contact area with the workpiece.

A feed motion¹⁾ is applied to the tool or workpiece to obtain a continuation of the removal of workpiece material in the form of small chips by the action of individual cutting edges¹⁾.

The feed motion may consist of several components. The machine surface is generated by the combined effect of the shape of the grinding wheel and the path of the motion components.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 3002. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 3002 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 841 : 1974, *Numerical control of machines — Axis and motion nomenclature.*

ISO 3002-1 : 1982, *Basic quantities in cutting and grinding — Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers.*

ISO 3002-2 : 1982, *Basic quantities in cutting and grinding — Part 2: Geometry of the active part of cutting tools — General conversion formulae to relate tool and working angles.*

ISO 3002-3 : 1984, *Basic quantities in cutting and grinding — Part 3: Geometric and kinematic quantities in cutting.*

ISO 3002-4 : 1984, *Basic quantities in cutting and grinding — Part 4: Forces, energy, power.*

3 General conventions

3.1 Symbols and suffixes

Except when otherwise specified, the basic symbols defined in ISO 3002, parts 1 to 4, are used in grinding together with the following symbols:

- A = surface;
- l = length;
- b = width.

Where appropriate, a suffix is added; among others,

- s relates the quantity considered to the grinding wheel, e.g. v_s = peripheral speed of the grinding wheel;
- w relates the quantity considered to the workpiece, e.g. v_w = peripheral speed of the workpiece;
- m relates the quantity considered to the table or support of workpiece or grinding wheel (see 3.2);
- d relates the quantity considered to the dressing or truing operation or truing tool;

1) See ISO 3002-1 : 1982, 3.6.1 and 3.6.2.

— ' (prime) expresses the quantity considered per unit of active width (4.6.2) or per unit of active profile length (4.6.1) of the grinding wheel, e.g. $F' = F/b$.

3.2 Table

In this part of ISO 3002 the term "table" is used for the machine element moving with respect to the base of the machine tool. The table may support either the grinding wheel or the workpiece.

Only in the case of cylindrical grinding (see 6.1.2) does the workpiece rotate continuously, relative to the table.

With this exception all motions other than the primary motion¹⁾ are considered to be provided by the table.

3.3 Nominal and real value

The nominal value of a parameter is that value set on the machine. The real value of a parameter is its actual value taking into account deformation of the workpiece, of the grinding wheel and of the machine and wear of the grinding wheel.

Where distinction is needed, the suffix "n" or "r" between parentheses may be added to the appropriate symbols, e.g. $h_{(n)}$ and $h_{(r)}$.

3.4 Reference system of planes (figures 2 to 7)

The reference systems of planes are defined in ISO 3002-1.

In grinding, planes are referred to the grinding principal point "D" (4.7) and take into account the direction of the principal feed motion (5.2.1).

In the case where the direction of the primary motion¹⁾ and the direction of the principal feed motion (5.2.1) in the grinding principal point "D" coincide, the orientation of the working plane¹⁾ shall be taken perpendicular to the axis of rotation of the grinding wheel.

3.5 Machine axis convention

The direction of machine axes, whenever it can be applied, should be in accordance with the basic principles of ISO 841.

Some cases may need further specification.

4 Characteristic dimensions of grinding wheels and workpieces (figure 1)

4.1 Grinding wheel and workpiece diameter: d_s, d_w respectively.

4.2 Peripheral length of grinding wheel and workpiece: $\pi d_s, \pi d_w$ respectively.

4.3 Width of the grinding wheel measured parallel to the wheel axis: b_s (see figure 1).

4.4 Surfaces on the grinding wheel

4.4.1 geometric grinding wheel surface: The portions of the grinding wheel surfaces which are prepared or dressed to remove material.

4.4.2 active grinding wheel surface: That portion of the geometric grinding wheel surface which effectively removes material during a revolution of the grinding wheel.

4.4.3 geometric grinding contact surface: The idealized surface of contact between grinding wheel and workpiece which would be determined or calculated by ignoring deformation, wear of the grinding wheel, roughness of grinding wheel and workpiece, and tangential feed motion.

4.4.4 kinematic grinding contact surface: The grinding contact surface which would be determined or calculated by ignoring deformation, roughness of grinding wheel and workpiece, and wear of the grinding wheel, but taking into account the tangential feed motion.

4.4.5 real grinding contact surface: The grinding contact surface which exists when considering feed motions²⁾ together with deformations and surface characteristics of both grinding wheel and workpiece.

4.5 Profiles of the grinding wheel

4.5.1 geometric grinding wheel profile: The curve formed by the intersection of the geometric grinding wheel surface and a plane containing the axis of rotation of the grinding wheel.

4.5.2 active grinding wheel profile: The curve formed by the intersection of the active grinding wheel surface and a plane containing the axis of rotation of the grinding wheel.

4.5.3 real grinding wheel profile: The curve formed by the intersection of the real grinding contact surface and a plane containing the axis of rotation of the grinding wheel and which is perpendicular to the machined surface.

For cases where this definition cannot be applied directly, the method used to determine the real grinding wheel profile shall be clearly specified.

4.6 Dimensions of the active grinding wheel profile

4.6.1 active grinding wheel profile length l_D (figure 1): The length of the curve of the active grinding wheel profile.

1) See ISO 3002-1 : 1982, 3.6.1 and 4.2.2.

2) See ISO 3002-1 : 1982, 3.6.2.

In certain cases, such as in plunge grinding (6.4.4) with a formed wheel, there may be more than one element of the active grinding wheel profile and in such cases the active grinding wheel profile length is the sum of these individual lengths.

4.6.2 active grinding wheel width b_D (figure 1): The length of the perpendicular projection of the active grinding wheel profile onto the axis of rotation of the grinding wheel.

This concept is usually only applied to peripheral grinding operations (6.2.1).

4.7 grinding principal point D (figures 1 to 7): A particular point of the active grinding wheel profile used to locate a reference system to define basic geometric quantities, velocities and force components.

It is recommended that the grinding principal point be located in a plane containing the axis of rotation of the grinding wheel and perpendicular to the direction of the principal feed motion (5.2.1) and at the position which divides the length of the active grinding wheel profile into two equal parts.

NOTE — In face grinding (6.2.2), these conditions may be impossible to achieve and the grinding principal point may have to be located elsewhere in which case it should be designated by D' and its position clearly identified.

4.8 Grinding arc in peripheral grinding

The following definitions can be applied only to peripheral grinding operations (6.2.1).

4.8.1 geometric grinding arc: The curve formed by the intersection of the geometric grinding contact surface and a plane perpendicular to the grinding wheel axis and passing through the grinding principal point.

4.8.2 kinematic grinding arc: The curve formed by the intersection of the kinematic grinding contact surface and a plane perpendicular to the grinding wheel axis and passing through the grinding principal point.

4.8.3 real grinding arc: The curve formed by the intersection of the real grinding contact surface and a plane perpendicular to the grinding wheel axis and passing through the grinding principal point.

4.9 Contact length in peripheral grinding

The following definitions can be applied only in peripheral grinding operations (6.2.1).

The contact lengths defined are the lengths of the grinding arcs defined in 4.8.

4.9.1 geometric contact length l_g (figure 4): The length of the geometric grinding arc.

For practical purposes and assuming that f_r is small in relation to both d_s and d_w , and that v_w is small compared with v_s ,

$$l_g = \sqrt{2f_r \cdot r_{eq}}$$

which represents the chord of the geometric grinding arc and where r_{eq} is the equivalent grinding wheel radius (see 4.10).

4.9.2 kinematic grinding length l_k : The length of the kinematic grinding arc.

$$l_k = l_g \left(1 + \frac{1}{|q|} \right)$$

where $|q|$ is the absolute value of the speed ratio defined in 5.3.3.

4.9.3 real contact length l_e : The length of the real grinding arc.

4.10 equivalent grinding wheel radius r_{eq} : The radius of an imaginary grinding wheel which, if engaged with a flat workpiece, would give the same geometric contact length as a grinding wheel of radius r_s engaged with a workpiece of radius r_w in peripheral grinding operations.

It is a function of the radius of the workpiece r_w and the radius of the grinding wheel r_s at the grinding contact surface and is evaluated from the relationship

$$r_{eq} = \frac{r_w \cdot r_s}{r_w \pm r_s}$$

The positive sign is used if the centre of the curvature of the transient surface¹⁾ and the centre of the grinding wheel are on opposite sides of the grinding contact surface, e.g. in external cylindrical grinding (see 6.1.2 and 6.3.1).

The negative sign is used if the centre of the curvature of the transient surface and the centre of the grinding wheel are on the same side of the grinding contact surface, e.g. in internal cylindrical grinding (see 6.1.2 and 6.3.2).

5 Motions and speeds (figures 2 to 7 and table 1)

All motions and speeds are considered at a certain instant in time at a selected point of the active grinding wheel profile. Usually the selected point is the grinding principal point "D" (4.7). Whenever any other point is selected for determining motions and speeds, then its location shall be clearly specified.

A schematic layout of the motions is given in table 1.

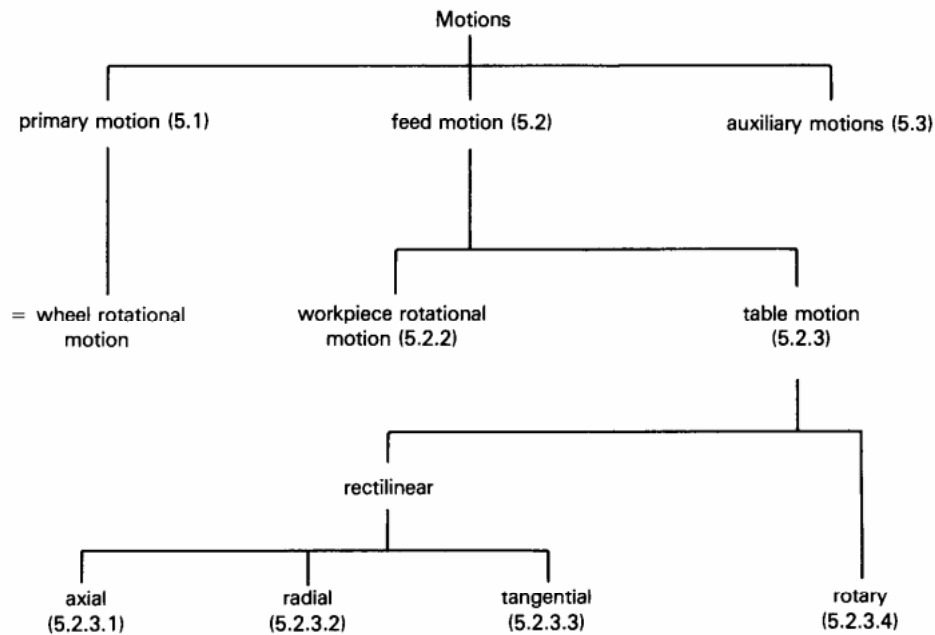
5.1 Primary motion and related quantities

The primary motion²⁾ is the rotary motion of the grinding wheel.

1) See ISO 3002-1 : 1982, 3.1.3.

2) See ISO 3002-1 : 1982, 3.6.1.

Table 1 — Schematic representation of relative motions between grinding wheel and workpiece



5.1.1 cutting speed v_c : The tangential velocity of the grinding wheel at a selected point of the grinding contact surface and measured relative to the grinding wheel support [recommended unit: metre per second (m/s)].

5.1.2 grinding wheel peripheral speed v_s : The tangential velocity of the grinding wheel at the wheel periphery measured at the maximum diameter and relative to the grinding wheel support [recommended unit: metre per second (m/s)].

5.1.3 grinding wheel rotational frequency n_s : The number of revolutions of the grinding wheel per unit of time measured relative to the grinding wheel support [recommended unit: second to the power minus one (s^{-1})].

5.2 Feed motion and related quantities

The definition of feed motion given in ISO 3002-1 : 1982, 3.6.2, applies also in grinding. However, in grinding the feed motion often results from the combination of different independently controlled motions of the workpiece and machine elements, which need to be considered separately.

The feed motion components may be continuous or discontinuous (per stroke or per pass¹⁾ or per revolution) and may be produced by the rotation of the workpiece with respect to the table or/and by the motion of the table with respect to the base of the machine tool.

NOTES

1 To conform with ISO 3002-1, the suffix "f" may be used, followed by a second suffix indicating the component considered. However, for

the sake of simplicity, the index "f" for feed can be omitted when no confusion is possible.

2 Feed may be specified and measured in terms of displacement per stroke, per pass or per revolution of the workpiece relative to the table or of the table relative to the base of the machine tool. Feed speeds are established in terms of displacement per unit of time.

5.2.1 principal feed motion: The continuous feed motion which has the highest feed speed for the grinding operation considered.

In certain grinding operations the direction of principal feed motion may change and therefore the principal feed motion may require further specification.

5.2.2 workpiece rotational motion (figure 2 and table 1): The rotation of the workpiece around its axis, relative to the table, in the case of cylindrical grinding.

5.2.2.1 workpiece peripheral speed v_w : The instantaneous velocity of the workpiece periphery relative to the table at the selected point [recommended unit: millimetre per second (mm/s)].

NOTE — In surface grinding (6.1.1) and/or cylindrical grinding (6.1.2), when the workpiece is fixed upon the table, only the table motion v_m should be considered and $v_w = 0$.

5.2.2.2 workpiece rotational frequency n_w : In cylindrical grinding (6.1.2) the number of revolutions per unit of time of the workpiece relative to the table [recommended unit: second to the power minus one (s^{-1})].

1) See ISO 3002-3 : 1984, 8.1.

5.2.3 table motions and related quantities

Table motions are considered to be motions of that machine element upon which the grinding wheel or workpiece is mounted relative to the base of the machine.

These motions are designated as table feed motions and may be rectilinear or rotary.

Rectilinear table feed motions are designated according to their orientation with respect to the grinding wheel: axially, radially, or tangentially.

The rotary table feed motion is defined as such (see 5.2.3.4).

5.2.3.1 axial table feed motion: That motion of the table, considered at the selected point, which is in a direction parallel to the grinding wheel axis.

5.2.3.1.1 axial table feed speed v_{fa} (figures 1 to 3): The velocity of the axial table feed motion relative to the machine base [recommended unit: millimetre per second or micrometre per second (mm/s or $\mu\text{m/s}$)].

5.2.3.1.2 axial table feed f_a (figures 2 and 4): The displacement of the table relative to the machine base caused by the axial table feed motion and measured per revolution of the workpiece or per stroke.

In the case of cylindrical grinding (6.1.2), the recommended units are millimetre per revolution of the workpiece or micrometre per revolution of the workpiece.

In the case of surface grinding (6.1.1), the axial table feed motion may be discontinuous and takes place at the end of every stroke; in this case, it is called axial table feed per stroke, or axial incremental table feed per stroke (recommended unit: millimetre per stroke or micrometre per stroke).

5.2.3.2 radial table feed motion: The motion of the table, considered at the selected point, which is in a direction perpendicular to the grinding wheel axis.

5.2.3.2.1 radial table feed speed v_{fr} (figures 1, 2, 3, 5 and 6): The velocity of the radial table feed motion relative to the machine base (recommended unit: millimetre per second (mm/s)).

5.2.3.2.2 radial table feed f_r (figures 3, 5, 6 and 7): The displacement of the table relative to the machine base caused by the radial table feed motion and measured per revolution of the workpiece or per stroke, or per pass¹⁾.

In the case of cylindrical grinding (6.1.2), the recommended units are millimetre per revolution of the workpiece or micrometre per revolution of the workpiece.

In the case of surface grinding (6.1.1), the radial table feed motion may be discontinuous and takes place when a further

layer of material is to be removed; it is then called "incremental radial infeed" (recommended unit: millimetre per pass or micrometre per pass).

5.2.3.3 tangential table feed motion: That motion of the table, considered at the selected point, which is parallel to the grinding wheel peripheral speed.

5.2.3.3.1 tangential table feed speed v_{ft} (figures 2, 3 and 4): The velocity of the tangential table feed motion relative to the machine base at the selected point.

5.2.3.3.2 tangential table feed f_t : The table displacement relative to the machine base caused by the tangential table feed motion and measured per revolution of the workpiece or per stroke.

In the case of cylindrical grinding (6.1.2), the recommended units are millimetre per revolution or micrometre per revolution.

5.2.3.4 rotary table feed motion: The motion of the table around its axis.

5.2.3.4.1 table rotational frequency n_m (of the rotary table feed motion): The number of revolutions per unit of time the table performs relative to the base of the machine [recommended unit: second to the power minus one (s^{-1})].

5.2.3.5 principal table feed motion: The component of the continuous table feed motion which has the highest velocity at the selected point.

5.2.3.6 incremental feed: The discontinuous displacement of the grinding wheel which takes place at the end of a stroke or a pass¹⁾ in a plane tangential to the machined surface²⁾ (recommended unit: millimetre per stroke or per pass or micrometre per stroke or per pass).

5.2.3.7 incremental infeed: The discontinuous displacement of the grinding wheel perpendicular to the transient surface²⁾ in order to remove a further layer of material over the whole machined surface²⁾ (recommended unit: millimetre per stroke or micrometre per stroke).

5.2.4 total length of table feed motion l_{fH} : The total length of the table feed motion travelled during a particular operation. These lengths can be related to the directions of the table feed motions. The symbol l should have an appropriate suffix to indicate the direction of measurement.

5.2.4.1 active length of table feed motion l_{fa} : The length of the table feed motion travelled during a particular operation while actual grinding takes place.

5.2.4.2 idle length of table feed motion l_{fo} : The part of the length of the table feed motion travelled during a particular operation during which no actual grinding takes place.

NOTE: $l_{fH} = l_{fa} + l_{fo}$

1) See ISO 3002-3 : 1984, 8.1.

2) See ISO 3002-1 : 1982, 3.1.2 and 3.1.3.

5.3 Auxiliary motions and other quantities

5.3.1 approach motion: The motion which positions the grinding wheel in the proximity of the workpiece immediately prior to grinding taking place.

5.3.2 compensation motion: The continuous or discontinuous motion provided in order to compensate for grinding wheel wear, thermal deformation, elastic deformation or similar variations.

5.3.3 speed ratio q : The ratio between the cutting speed¹⁾ and the feed speed¹⁾ relative to the machine base and measured in a tangential direction through the selected point.

In cylindrical grinding (6.1.2):

$$q = v_c / v_w$$

In surface grinding (6.1.1):

$$q = v_c / v_{ft}$$

5.3.4 overlap [traverse overlap] U in surface or cylindrical grinding with axial feed: The ratio between the active grinding wheel width and the axial table feed:

$$U = \frac{b_D}{f_a}$$

6 Terminology of common grinding operations (table 2)

For clarification of what follows, there is a need to define the basic terminology of grinding operations.

The principal operations can be identified according to the following criteria, the order of which is not necessarily related to their importance:

- the type of surface produced;
- the active part of the grinding wheel;
- the relative positions of workpiece and grinding wheel;
- the direction of the principal feed motion of the workpiece with respect to the grinding wheel;
- the relative orientation of the tangential velocities of the grinding wheel and workpiece at the selected point;
- special features.

6.1 Terminology considering the shape and method of generating the transient surface²⁾

6.1.1 surface grinding: A grinding operation which produces a flat surface.

6.1.2 cylindrical grinding: A grinding operation which produces a cylindrical surface.

6.1.3 grinding on a rotary table: A grinding operation in which the principal table feed motion is a rotation.

6.1.4 shape grinding: The generic term for grinding operations which produce surfaces which are neither flat, nor cylindrical, i.e. thread grinding, gear grinding, etc.

6.1.4.1 generative grinding: A shape grinding operation in which the profile of the workpiece is mainly produced by controlling the feed motions (e.g. copying, or NC, etc.).

6.1.4.2 grinding with a profiled grinding wheel: A shape grinding operation in which the profile of the grinding wheel corresponds with the profile to be ground.

6.2 Terminology based on the part of the grinding wheel which is active

6.2.1 peripheral grinding: A grinding operation in which the cylindrical periphery of the grinding wheel, or a significant part of it, is performing the major part of the grinding operation.

6.2.2 face grinding: A grinding operation in which the major part of the grinding is performed by a surface of the grinding wheel which can be considered as perpendicular or slightly skew with respect to the axis of the grinding wheel.

6.3 Terminology based on the position of the grinding wheel relative to the workpiece

6.3.1 external grinding: A grinding operation which produces an external surface of a workpiece.

6.3.2 internal grinding: A grinding operation which produces an internal surface of a workpiece.

6.4 Terminology based on the direction of the principal table feed motion relative to the grinding wheel

6.4.1 axial grinding: A grinding operation in which the principal table feed motion is oriented parallel to the axis of the grinding wheel.

6.4.2 tangential grinding: A grinding operation in which the principal table feed motion is parallel to the grinding wheel peripheral speed, at the grinding principal point D.

6.4.3 radial grinding: A grinding operation in which the principal table feed motion, at the grinding principal point D, is oriented radially to the grinding wheel.

1) See ISO 3002-1 : 1982, 3.6.1.2 and 3.6.2.2.

2) See ISO 3002-1 : 1982, 3.1.3.

Table 2 – Basic grinding operations

		Grinding operation					
		Peripheral			Face		
		radial (plunge)	tangential	axial	radial	tangential	axial (plunge)
Grinding operation	Surface	rectilinear table motion					
		rotary table motion					
	Cylindrical	external					
		internal					
Shape	generative						
	profile						

6.4.4 Plunge grinding

6.4.4.1 peripheral plunge grinding: A peripheral grinding operation in which there is a continuous radial table feed motion.

6.4.4.2 face plunge grinding: A face grinding operation in which there is a continuous axial table feed motion.

6.5 Terminology based on the relative orientation of grinding wheel and workpiece velocities at the grinding principal point "D" (4.7)

6.5.1 up grinding: A grinding operation in which the tangential motions of the grinding wheel and workpiece relative to the machine base and considered through the grinding principal point have opposite directions.

6.5.2 down grinding: A grinding operation in which the tangential motions of the grinding wheel and workpiece relative to the machine base and considered through the grinding principal point have the same direction.

6.6 Additional terminology

6.6.1 reciprocating grinding: A grinding operation in which an incremental table feed is given at both ends of the stroke.

6.6.2 alternating grinding: A grinding operation in which an incremental table feed is given at one end of the stroke.

6.6.3 cut-off grinding: A peripheral grinding operation used to cut pieces into parts.

6.6.4 creep feed grinding: A peripheral grinding operation with a relatively slow principal feed speed and in which a relatively large contact surface exists.

6.6.5 oblique grinding: A cylindrical or surface grinding operation where the axis of the grinding wheel is neither parallel nor perpendicular with respect to either the axis of the workpiece or the workpiece surface [see figures 1c), 1d) and 6].

Oblique grinding can be a plunge grinding or a tangential grinding operation.

7 Wheel engagement and related quantities

(figures 3 to 7)

7.1 engagement of a grinding wheel a : The distance measured between two planes perpendicular to the chosen direction and respectively passing through two points of the geometric grinding contact surface and so located that the distance between the two planes is a maximum in the chosen direction.

7.2 working engagement a_o : The engagement of the grinding wheel measured in the working plane (see 3.4) and in a direction perpendicular to the direction of principal feed motion.

7.3 back engagement a_D : The engagement of the grinding wheel measured perpendicularly to the working plane (see 3.4).

7.4 feed engagement a_f : The engagement of the grinding wheel measured parallel to the direction of principal feed motion.

NOTE — Engagement can further be related to any other direction specified, e.g.

- a) to wheel and related directions :
 - radial engagement a_r ,
 - tangential engagement a_t ,
 - axial engagement a_a ;
- b) to the machine reference system a_x, a_y, a_z ;
- c) etc.

8 Material removal — Wheel wear

All definitions in this clause can be considered for the active grinding wheel surface as a whole or for any portion of it. The actual portion considered shall be clearly specified.

8.1 material removal V_w : The volume of workpiece material removed during a certain period of time.

8.1.1 material removal per unit active grinding wheel width V'_w : The material removal divided by the active grinding wheel width :

$$V'_w = \frac{V_w}{b_D}$$

8.1.2 material removal per unit active grinding wheel profile length V'_{wD} : The material removal divided by the active grinding wheel profile length :

$$V'_{wD} = \frac{V_w}{l_D}$$

8.1.3 material removal rate Q_w : The volume of workpiece material removed per unit of time, at a certain instant in time :

$$Q_w = \frac{\Delta V_w}{\Delta t}$$

8.1.4 material removal rate per unit active grinding wheel width Q'_w : The material removal rate divided by the active grinding wheel width :

$$Q'_w = \frac{Q_w}{b_D}$$

8.1.5 material removal rate per unit active grinding wheel profile length Q'_{wD} : The material removal rate divided by the active grinding wheel profile length :

$$Q'_{wD} = \frac{Q_w}{l_D}$$

8.2 volumetric grinding wheel wear V_s : The volume of grinding wheel material lost during a certain period of time.

8.2.1 volumetric grinding wheel wear per unit active grinding wheel width V'_s : The volumetric grinding wheel wear divided by the active grinding wheel width:

$$V'_s = \frac{V_s}{b_D}$$

8.2.2 volumetric grinding wheel wear per unit active grinding wheel profile length V'_{sD} : The volumetric grinding wheel wear divided by the active grinding wheel profile length:

$$V'_{sD} = \frac{V_s}{l_D}$$

8.2.3 grinding wheel wear rate Q_s : The volume of the grinding wheel material lost per unit of time:

$$Q_s = \frac{\Delta V_s}{\Delta t}$$

8.2.4 grinding wheel wear rate per unit active grinding wheel width Q'_s : The grinding wheel wear rate divided by the active grinding wheel width:

$$Q'_s = \frac{Q_s}{b_D}$$

8.2.5 grinding wheel wear rate per unit active grinding wheel profile length Q'_{sD} : The grinding wheel wear rate divided by the active grinding wheel profile length:

$$Q'_{sD} = \frac{Q_s}{l_D}$$

8.3 grinding ratio G : The ratio of material removal and volumetric grinding wheel wear during the same period of time:

$$G = \frac{V_w}{V_s}$$

8.4 grinding wheel radial wear Δr_s : The decrease of grinding wheel radius due to the grinding wheel wear.

8.5 grinding wheel axial wear Δb_s : The decrease of active grinding wheel width measured parallel to the axis of rotation of the grinding wheel.

9 Forces, energy and power

The definitions given in ISO 3002-4 can be applied directly to grinding operations, provided that the term "principal point" is replaced by "grinding principal point" and the term "nominal width of cut" is replaced by "active grinding wheel width".

All definitions in this clause can be considered for the active grinding wheel surface as a whole or for any portion of it. The actual portion considered shall be clearly specified.

The following terms 9.1 and 9.2 are defined in addition to those given in ISO 3002-4.

9.1 grinding force per unit active grinding wheel width F' : The grinding force divided by the active grinding wheel width:

$$F' = \frac{F}{b_D}$$

9.2 grinding force per unit active grinding wheel profile length F'_D : The grinding force divided by the active grinding wheel profile length:

$$F'_D = \frac{F}{l_D}$$

10 Equivalent grinding thickness

(figures 3 and 8)

All definitions in this clause can be considered for the active grinding wheel surface as a whole or for any portion of it. The actual portion considered shall be clearly specified.

10.1 equivalent grinding thickness per unit active grinding wheel width h_{eq} : The ratio of material removal rate per unit active grinding wheel width Q'_w and the cutting speed v_c :

$$h_{eq} = \frac{Q'_w}{v_c}$$

10.2 equivalent grinding thickness per unit active grinding wheel profile length h_{eqD} : The ratio of material removal rate per unit active grinding wheel profile length Q'_{wD} and the cutting speed v_c :

$$h_{eqD} = \frac{Q'_{wD}}{v_c}$$

NOTE — The equivalent grinding thickness can be represented as the thickness of a continuous ribbon of material flowing away along the grinding wheel at the cutting speed v_c and the volume of which is equal to that of the material removal V_w during the same time period. The ribbon can be seen along the active grinding wheel width (10.1) or along the active grinding wheel profile length (10.2).

11 Grain count

11.1 static grain count at a certain depth N_{st} : The number of grains counted at a certain depth in a band situated under the grinding wheel periphery when measured by a quasi-stationary method (stylus, thermocouple, microscope).

11.2 kinematic grain count N_{kin} : The number of grains counted when the grinding wheel is grinding at its nominal speed using a "very small" contact force, so that the contact deformation can be considered as negligible or computed from the static grain count by further kinematic consideration.

11.3 active grain count N_{act} : The number of grains actually engaged in the grinding operation.

11.4 grain distribution (static, dynamic or active): The considered grain count per unit of length or area or volume. These are respectively linear distribution or area distribution or volumetric distribution.

NOTE — The measuring direction should also be specified, e.g. peripheral or axial.

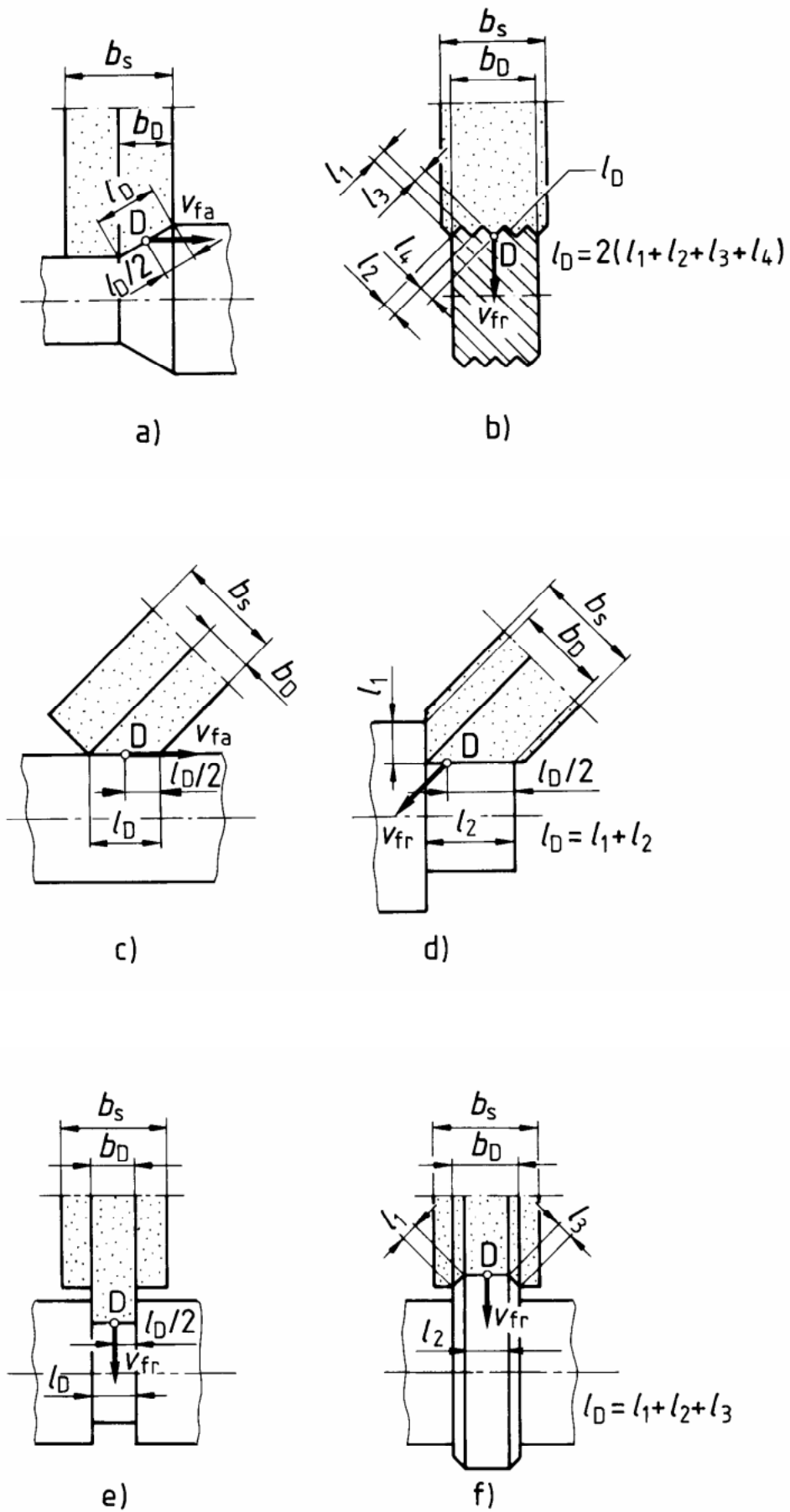
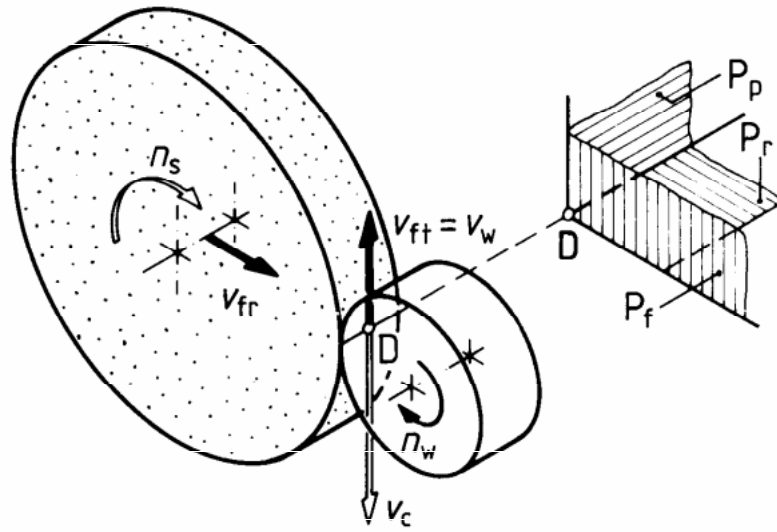
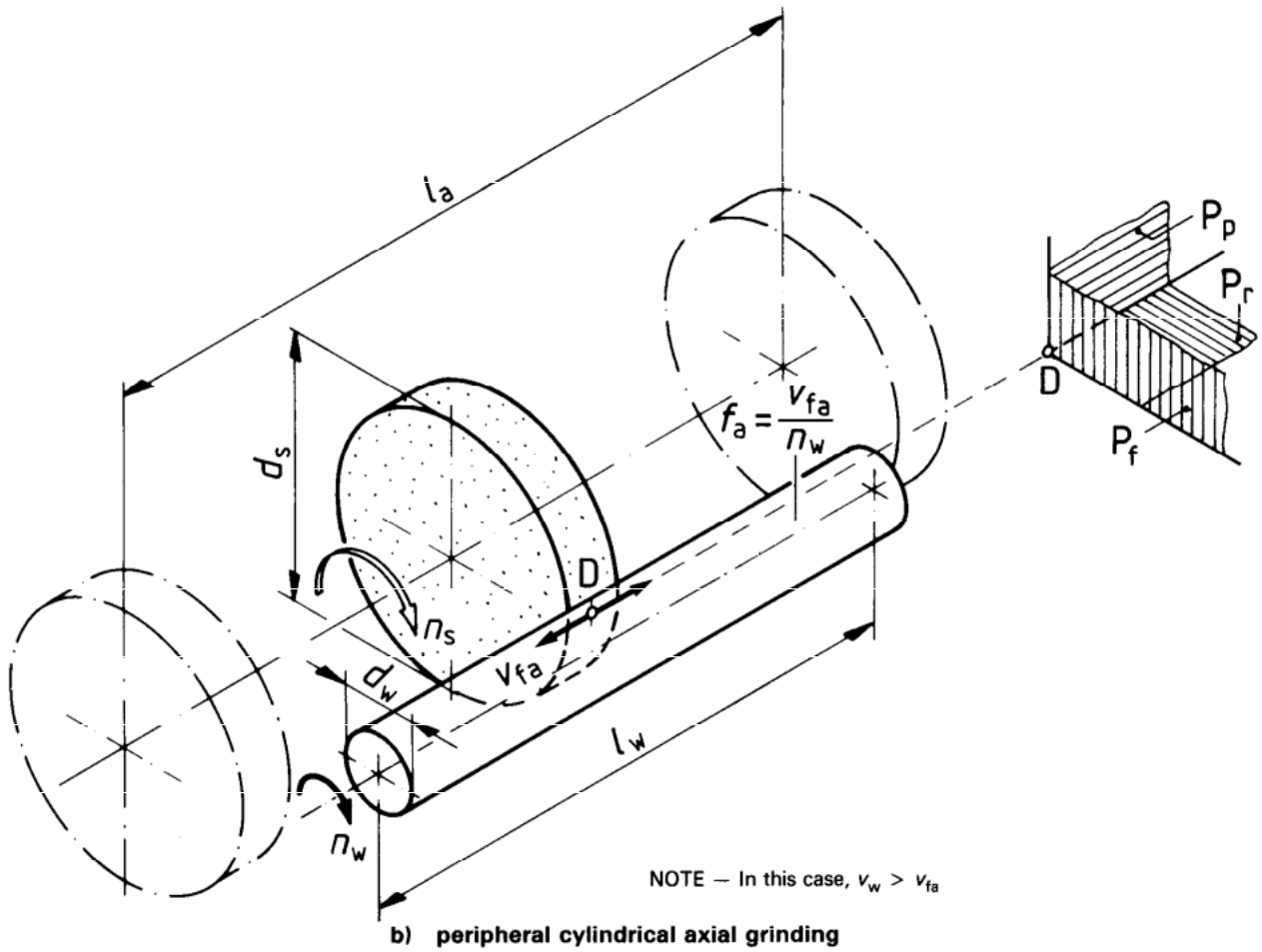


Figure 1 — Basic dimensions in grinding



a) peripheral cylindrical plunge grinding



b) peripheral cylindrical axial grinding

Figure 2 — Motions and reference system of planes in peripheral cylindrical grinding

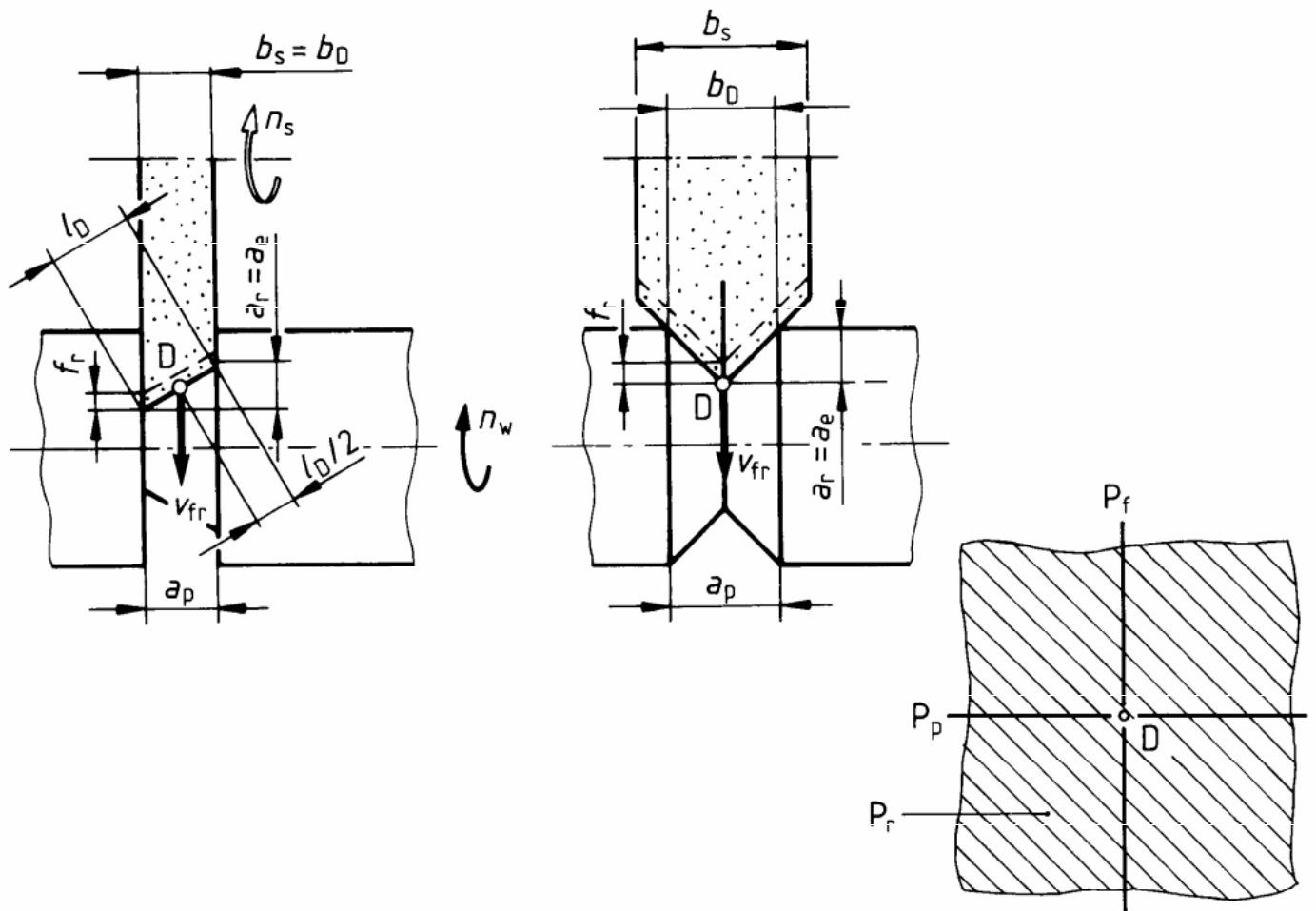


Figure 5 — Comparison of feed and engagement in peripheral cylindrical plunge grinding

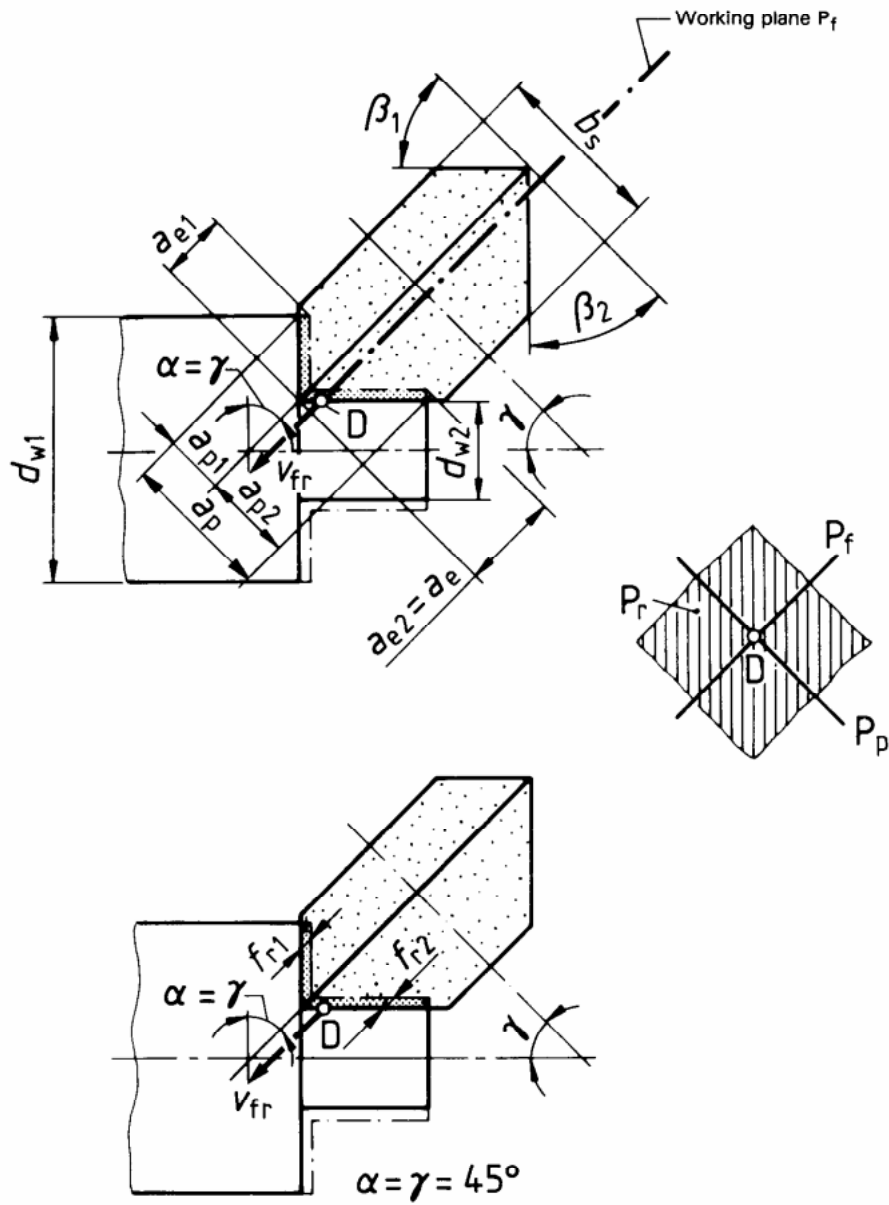


Figure 6 – Feed and engagement in peripheral oblique plunge grinding

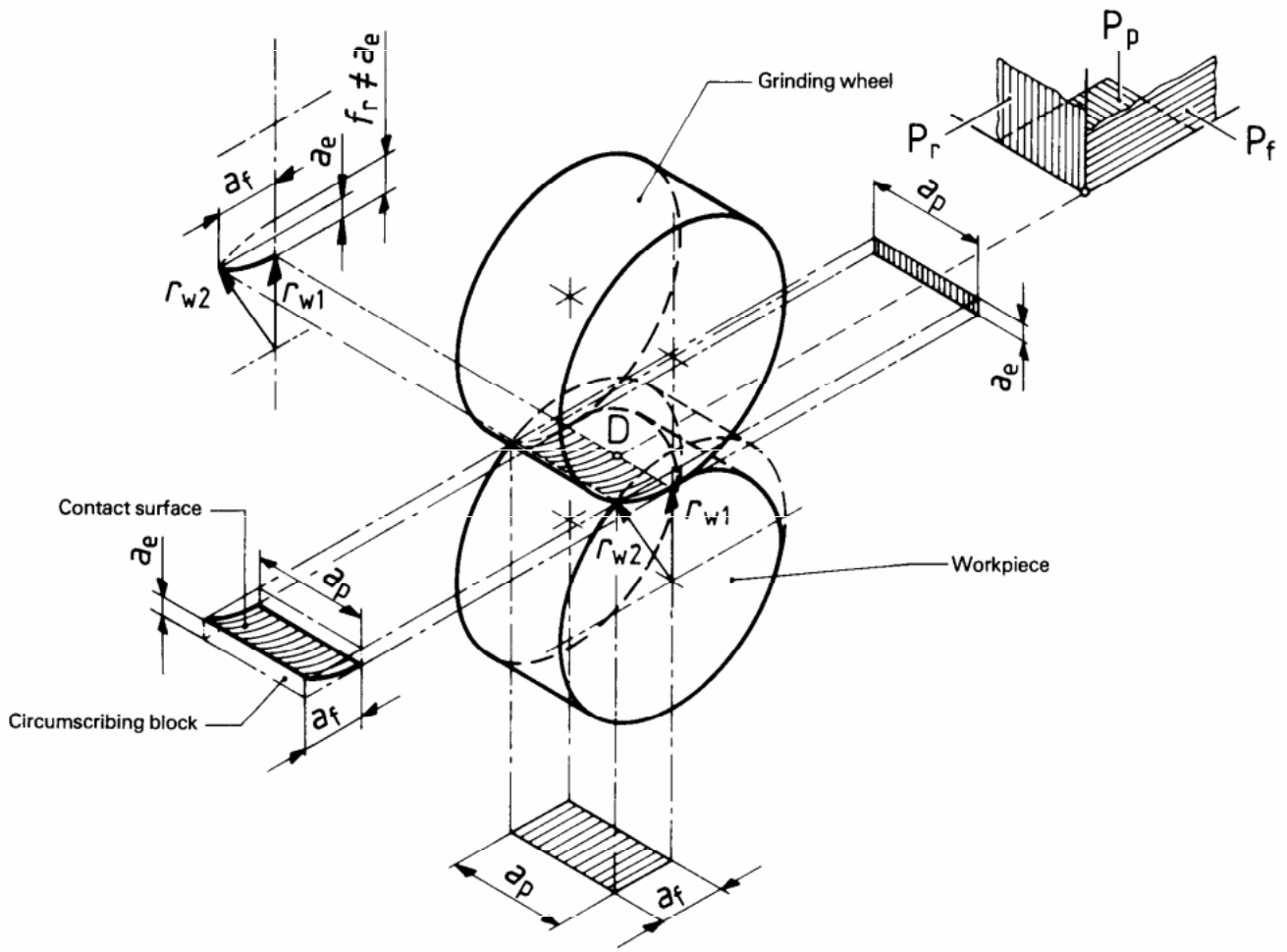


Figure 7 – Feed and engagement in peripheral grinding

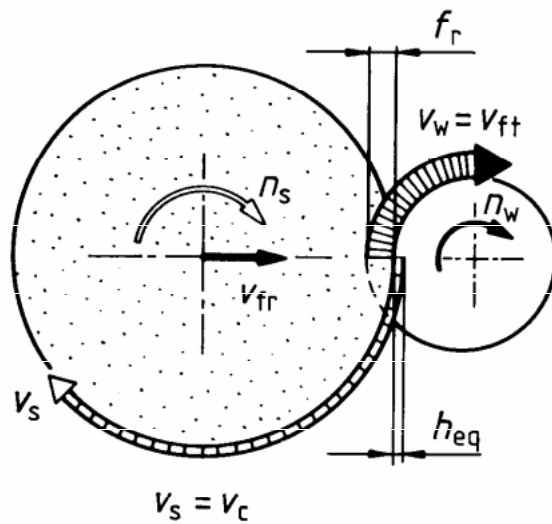


Figure 8 – Equivalent grinding thickness in peripheral cylindrical plunge grinding

List of equivalent terms

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
3.2	—	Table	Table	Стол	Maschinentisch	Tavola	Tafel
3.3	... (n) ... (r)	Nominal value Real value	Valeur nominale Valeur réelle	Номинальная величина Действительная величина	Nominaler Wert Realer Wert	Valore nominale Valore reale	Nominale waarde Werkelijke waarde
3.4	—	Reference system of planes	Système de référence de plans	Система координатных плоскостей	Bezugsebenen	Piani di riferimento	Referentiestelsel van vlakken
3.5	—	Machine axis convention	Conventions relatives aux axes des machines	Система осей станка	Achsen-system der Maschine	Convenzioni relative agli assi delle macchine	Conventie voor machinesassen
4.1	d_s	Grinding wheel diameter	Diamètre de la meule	Диаметр шлифовального круга	Schleifscheibendurchmesser	Diametro della mola	Slijpschijfdiameter
	d_w	Workpiece diameter	Diamètre de la pièce	Диаметр обрабатываемой заготовки	Werkstückdurchmesser	Diametro del pezzo	Werkstukdiameter
4.2	πd_s	Peripheral length of grinding wheel	Périmètre de la meule	Окружная длина шлифовального круга	Schleifscheibenumfangslänge	Perimetro della mola	Omtrek van de slijpschijf
	πd_w	Peripheral length of workpiece	Périmètre de la pièce	Окружная длина обрабатываемой заготовки	Werkstückumfangslänge	Perimetro del pezzo	Omtrek van het werkstuk
4.3	b_s	Width of the grinding wheel	Largeur de la meule	Высота шлифовального круга	Schleifscheibenbreite	Spessore della mola	Breedte van de slijpschijf
4.4.1	—	Geometric grinding wheel surface	Surface géométrique de la meule	Геометрическая поверхность шлифовального круга	Geometrische Schleifscheibenfläche	Superficie geometrica della mola	Geometrisch slijpschijfoppervlak
4.4.2	—	Active grinding wheel surface	Surface active de la meule	Рабочая поверхность шлифовального круга	Aktive Schleifscheibenfläche	Superficie attiva della mola	Aktief slijpschijfoppervlak
4.4.3	—	Geometric grinding contact surface	Surface géométrique de contact de rectification	Геометрическая поверхность контакта при шлифовании	Geometrische Schleifkontakfläche	Superficie geometrica di contatto di rettifica	Geometrisch slijpcontactvlak
4.4.4	—	Kinematic grinding contact surface	Surface cinématique de contact de rectification	Кинематическая поверхность контакта при шлифовании	Kinematische Schleifkontakfläche	Superficie cinematica di contatto di rettifica	Kinematisch slijpcontactvlak
4.4.5	—	Real grinding contact surface	Surface réelle de contact de rectification	Действительная поверхность контакта при шлифовании	Reale Schleifkontakfläche	Superficie reale di contatto di rettifica	Werkelijk slijpcontactvlak
4.5.1	—	Geometric grinding wheel profile	Profil géométrique de la meule	Геометрический профиль шлифовального круга	Geometrisches Schleifscheibenprofil	Profilo geometrico della mola	Geometrisch profiel van de slijpschijf
4.5.2	—	Active grinding wheel profile	Profil actif de la meule	Рабочий профиль шлифовального круга	Aktives Schleifscheibenprofil	Profilo attivo della mola	Aktief profiel van de slijpschijf
4.5.3	—	Real grinding wheel profile	Profil réel de la meule	Действительный профиль шлифовального круга	Reales Schleifscheibenprofil	Profilo reale della mola	Werkelijk profiel van de slijpschijf

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
4.6.1	l_D	Active grinding wheel profile length	Longueur du profil actif de la meule	Длина рабочего профиля шлифовального круга	Länge des aktiven Schleifscheibenprofils	Lunghezza del profilo attivo della mola	Lengte van het actieve profiel van de slijpschijf
4.6.2	b_D	Active grinding wheel width	Largeur active de la meule	Ширина рабочего профиля шлифовального круга	Aktive Schleifscheibenbreite	Spessore attivo della mola	Aktieve breedte van de slijpschijf
4.7	D	Grinding principal point	Point principal de rectification	Особая точка шлифования	Schleifbezugs punkt	Punto principale di rettifica	Basisslijppunt
4.8	—	Grinding arc in peripheral grinding	Arc de rectification en rectification périphérique	Дуга шлифования при периферийном шлифовании	Schleifwinkel beim Umfangsschleifen	Arco di rettifica in rettifica periferica	Slijpboog
4.8.1	—	Geometric grinding arc	Arc géométrique de rectification	Геометрическая дуга шлифования	Geometrischer Schleifwinkel	Arco geometrico di rettifica	Geometrische slijpboog
4.8.2	—	Kinematic grinding arc	Arc cinématique de rectification	Кинематическая дуга шлифования	Kinematischer Schleifwinkel	Arco cinematico di rettifica	Kinematische slijpboog
4.8.3	—	Real grinding arc	Arc réel de rectification	Действительная дуга шлифования	Realer Schleifwinkel	Arco reale di rettifica	Ware slijpboog
4.9	—	Contact length in peripheral grinding	Longueur de contact en rectification périphérique	Длина контакта при периферийном шлифовании	Kontaktlänge beim Umfangsschleifen	Lunghezza di contatto in rettifica periferica	Kontaktlengte
4.9.1	l_g	Geometric contact length	Longueur géométrique de contact	Геометрическая длина контакта	Geometrische Kontaktlänge	Lunghezza geometrica di contatto	Geometrische contactlengte
4.9.2	l_k	Kinematic grinding length	Longueur cinématique de rectification	Кинематическая длина контакта	Kinematische Schleiflänge	Lunghezza cinematica di rettifica	Kinematische slijplengte
4.9.3	l_e	Real contact length	Longueur réelle de contact	Действительная длина контакта	Reale Kontaktlänge	Lunghezza reale di contatto	Werkelijke contactlengte
4.10	r_{eq}	Equivalent grinding wheel radius	Rayon de meule équivalent	Эквивалентный радиус шлифовального круга	Äquivalenter Schleifscheibenradius	Raggio equivalente della mola	Equivalent slijpschijfstraal
5.1	—	Primary motion	Mouvement de coupe	Основное движение	Hauptbewegung	Movimento di taglio	Snijbeweging
5.1.1	v_c	Cutting speed	Vitesse de coupe	Скорость резания	Schnittgeschwindigkeit	Velocità di taglio	Snijsnelheid
5.1.2	v_s	Grinding wheel peripheral speed	Vitesse périphérique de la meule	Рабочая скорость шлифовального круга	Schleifscheibenumfangsgeschwindigkeit	Velocità periferica della mola	Omtreksnelheid van de slijpschijf
5.1.3	n_s	Grinding wheel rotational frequency	Fréquence de rotation de la meule	Частота вращения шлифовального круга	Schleifscheibendrehzahl	Velocità di rotazione della mola	Toerental van de slijpschijf
5.2	—	Feed motion	Mouvement d'avance	Движение подачи	Vorschubbewegung	Movimento d'avanzamento	Voedingsbeweging
5.2.1	—	Principal feed motion	Mouvement principal d'avance	Основное движение подачи	Hauptvorschubbewegung	Movimento d'avanzamento principale	Hoofdvodingsbeweging
5.2.2	—	Workpiece rotational motion	Mouvement de rotation de la pièce	Вращение обрабатываемой заготовки	Werkstückdrehbewegung	Movimento di rotazione del pezzo	Rotatiebeweging van het werkstuk

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
5.2.2.1	v_w	Workpiece peripheral speed	Vitesse périphérique de la pièce	Окружная скорость обрабатываемой заготовки	Werkstückumfangsgeschwindigkeit	Velocità periferica del pezzo	Omtreksnelheid van het werkstuk
5.2.2.2	n_w	Workpiece rotational frequency	Fréquence de rotation de la pièce	Частота вращения обрабатываемой заготовки	Werkstückdrehzahl	Velocità di rotazione del pezzo	Toerental van het werkstuk
5.2.3	—	Table motions	Mouvement de la table	Движение стола	Tischbewegung	Movimento della tavola	Tafelbewegingen
	—	Rectilinear table feed motions	Mouvements linéaires d'avance de la table	Прямолинейное движение подачи стола	Tischlängsbewegung	Movimento d'avanzamento lineare della tavola	Rechtlijnige tafelbewegingen
	—	Rotary table feed motion	Mouvement rotatif d'avance de la table	Вращательное движение подачи стола	Tischdrehbewegung	Movimento d'avanzamento rotativo della tavola	Draaibeweging
5.2.3.1	—	Axial table feed motion	Mouvement axial d'avance de la table	Осевое движение подачи стола	Axiale Tischbewegung	Movimento d'avanzamento assiale della tavola	Axiale tafelbeweging
5.2.3.1.1	v_{fa}	Axial table feed speed	Vitesse axiale d'avance de la table	Осевая скорость подачи стола	Axiale Tischvorschubgeschwindigkeit	Velocità d'avanzamento assiale della tavola	Axiale tafelsnelheid
5.2.3.1.2	f_a	Axial table feed	Avance axiale de la table	Осевая подача стола	Axialer Tischvorschub	Avanzamento assiale della tavola	Axiale tafelvoeding
		Axial table feed per stroke	Avance axiale par course de la table	Осевая подача стола за проход	Axialer Tischvorschub	Avanzamento assiale della tavola	Axiale tafelvoeding per slag
		Axial incremental table feed per stroke	Avance axiale incrementale par course de la table	Осевая подача стола с наибольшим приращением за проход	Unterbrochener axialer Tischvorschub pro Hub	Avanzamento assiale d'incremento assiale per corsa della tavola	Axiale incrementale voeding per slag
5.2.3.2	—	Radial table feed motion	Mouvement radial d'avance de la table	Радиальное движение подачи стола	Radiale Tischvorschubbewegung	Movimento d'avanzamento radiale della tavola	Radiale tafelbeweging
5.2.3.2.1	v_{fr}	Radial table feed speed	Vitesse radiale d'avance de la table	Радиальная скорость подачи стола	Radiale Tischvorschubgeschwindigkeit	Velocità d'avanzamento radiale della tavola	Radiale tafelsnelheid
5.2.3.2.2	f_r	Radial table feed	Avance radiale de la table	Радиальная подача стола	Radialer Tischvorschub	Avanzamento radiale della tavola	Radiale tafelvoeding
		Incremental radial infeed	Avance incrementale radiale	Радиальная врезная подача с небольшим приращением	Unterbrochener radialer Tischvorschub	Avanzamento incrementale a tufo	Radiale incrementale voeding per slag
5.2.3.3	—	Tangential table feed motion	Mouvement tangentiel d'avance de la table	Тангенциальное движение подачи стола	Tangentiale Tischvorschubbewegung	Movimento d'avanzamento tangenziale della tavola	Tangentiale tafelvoeding
5.2.3.3.1	v_{ft}	Tangential table feed speed	Vitesse tangentielle d'avance de la table	Тангенциальная скорость подачи стола	Tangentiale Tischvorschubgeschwindigkeit	Velocità d'avanzamento tangenziale della tavola	Tangentiale tafelsnelheid
5.2.3.3.2	f_t	Tangential table feed	Avance tangentielle de la table	Тангенциальная подача стола	Tangentiale Tischvorschub	Avanzamento tangenziale della tavola	Tangentiale tafelvoeding
5.2.3.4	—	Rotary table feed motion	Mouvement rotatif d'avance de la table	Вращательное движение подачи стола	Tischdrehbewegung	Movimento d'avanzamento rotativo della tavola	Draaibeweging

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
5.2.3.4.1	n_m	Table rotational frequency (of the rotary table feed motion)	Fréquence de rotation de la table (du mouvement rotatif d'avance de la table)	Частота вращения стола	Tischdrehzahl	Velocità di rotazione della tavola (del movimento d'avanzamento rotativo della tavola)	Toerental van de tafel
5.2.3.5	—	Principal table feed motion	Mouvement principal d'avance de la table	Основное движение подачи стола	Haupttischvorschubbewegung	Movimento d'avanzamento principale della tavola	Hoofdtafelbeweging
5.2.3.6	—	Incremental feed	Avance incrémentale	Подача с небольшим приращением	Unterbrochener Vorschub	Avanzamento incrementale	Incrementale voeding
5.2.3.7	—	Incremental infeed	Avance incrémentale de plongée	Врезная подача с небольшим приращением	Unterbrochene Zustellung	Avanzamento incrementale a tuffo	Incrementale invoeding
5.2.4	l_{FH}	Total length of table feed motion	Longueur totale du mouvement d'avance de la table	Общая длина движения подачи стола	Gesamtlänge der Tischvorschubbewegung	Lunghezza totale del movimento di traslazione della tavola	Totale lengte van de tafelbeweging
5.2.4.1	l_{fa}	Active length of table feed motion	Longueur active du mouvement d'avance de la table	Рабочая длина движения подачи стола	Aktive Länge der Tischvorschubbewegung	Lunghezza attiva del movimento di traslazione della tavola	Aktieve lengte van de tafelbeweging
5.2.4.2	l_{fo}	Idle length of table feed motion	Longueur inactive du mouvement d'avance de la table	Длина холостого движения подачи стола	Leerweg der Tischvorschubbewegung	Lunghezza inattiva del movimento di traslazione della tavola	Inaktieve lengte van de tafelbeweging
5.3.1	—	Approach motion	Mouvement d'approche	Подводящее движение	Anstellbewegung	Movimento di accostamento	Naderingsbeweging
5.3.2	—	Compensation motion	Mouvement de compensation	Компенсирующее движение	Nachstellbewegung	Movimento di compensazione	Compensatiebeweging
5.3.3	q	Speed ratio	Rapport de vitesse	Соотношение скоростей	Geschwindigkeitsquotient	Rapporto delle velocità	Snelheidsverhouding
5.3.4	U	Overlap (traverse overlap) in surface or cylindrical grinding with axial feed	Recouvrement (recouvrement transversal) en rectification plane ou cylindrique avec une avance axiale	Перекрытие (поперечное перекрытие) при плоском и круглом шлифовании с осевой подачей	Überdeckungsgrad beim Plan- oder Rundschleifen mit axialer Vorschubbewegung	Ricoprimento (ricoprimento trasversale) in rettifica piana o cilindrica con un avanzamento assiale	Overlap
6.1.1	—	Surface grinding	Rectification plane	Плоское шлифование	Planschleifen	Rettifica piana	Vlakslijpen
6.1.2	—	Cylindrical grinding	Rectification cylindrique	Круглое шлифование	Rundschleifen	Rettifica cilindrica	Rondslijpen
6.1.3	—	Grinding on a rotary table	Rectification sur table rotative	Шлифование на вращающемся столе	Schleifen mit Drehtisch	Rettifica su tavola rotante	Slijpen op een draaitafel
6.1.4	—	Shape grinding	Rectification de forme	Профильное шлифование	Formschleifen	Rettifica di forma	Vormslijpen
6.1.4.1	—	Generative grinding	Rectification par contourage	Воспроизводящее шлифование	Wälzschleifen	Rettifica di forma per generazione	Genererend slijpen
6.1.4.2	—	Grinding with a profiled grinding wheel	Rectification de profil par meule de forme	Шлифование с профилированным шлифовальным кругом	Profilschleifen mit Schleifscheibe verschiedener Randform	Rettifica di profili con mola sagomata	Profielslijpen met vormslijpschijf
6.2.1	—	Peripheral grinding	Rectification périphérique	Периферийное шлифование	Umfangsschleifen	Rettifica periferica	Omtrekslijpen

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
6.2.2	—	Face grinding	Rectification latérale	Торцевое шлифование	Seitenschleifen	Rettifica laterale	Frontslijpen
6.3.1	—	External grinding	Rectification extérieure	Наружное шлифование	Außenschleifen	Rettifica esterna	Uitwendig slijpen
6.3.2	—	Internal grinding	Rectification intérieure	Внутреннее шлифование	Innenschleifen	Rettifica interna	Inwendig slijpen
6.4.1	—	Axial grinding	Rectification axiale	Осевое шлифование	Axiales Schleifen	Rettifica assiale	Axiaal slijpen
6.4.2	—	Tangential grinding	Rectification tangentielle	Тангенциальное шлифование	Tangentiales Schleifen	Rettifica tangenziale	Tangenciaal slijpen
6.4.3	—	Radial grinding	Rectification radiale	Радиальное шлифование	Radiales Schleifen	Rettifica radiale	Radiaal slijpen
6.4.4	—	Plunge grinding	Rectification en plongée	Врезное шлифование	Einstechschleifen	Rettifica a tuffo	Insteekslijpen
6.4.4.1	—	Peripheral plunge grinding	Rectification périphérique en plongée	Периферийное врезное шлифование	Umfangseinstechschleifen	Rettifica periferica a tuffo	—
6.4.4.2	—	Face plunge grinding	Rectification latérale en plongée	Торцевое врезное шлифование	Seiteneinstechschleifen	Rettifica laterale a tuffo	—
6.5.1	—	Up grinding	Rectification en opposition	Встречное шлифование	Gegenlaufschleifen	Rettifica in discordanza	Tegenlopend slijpen
6.5.2	—	Down grinding	Rectification en avalant	Полутное шлифование	Gleichlaufschleifen	Rettifica in concordanza	Meelopend slijpen
6.6.1	—	Reciprocating grinding	Rectification réciproque	Возвратно-поступательное шлифование	Pendelschleifen mit Zustellung pro Hub	Rettifica con incremento ad ogni inversione di corsa	Heen- en weergaand slijpen
6.6.2	—	Alternating grinding	Rectification alternée	Попеременное шлифование	Pendelschleifen mit Zustellung pro Doppelhub	Rettifica con incremento ad ogni doppia corsa	Alternerend slijpen
6.6.3	—	Cut-off grinding	Tronçonnage (à la meule)	Абразивная отрезка	Trennschleifen	Troncatura	Doorslijpen
6.6.4	—	Creep feed grinding	Rectification dans la masse	Шлифование с ползучей подачей	Tiefschleifen	Rettifica profonda (dal pieno)	Kruipslijpen
6.6.5	—	Oblique grinding	Rectification oblique	Перекрестное шлифование	Schrägschleifen	—	Schuin slijpen
7.1	a	Engagement of a grinding wheel	Engagement d'une meule	Зацепление шлифовального круга	Eingriff einer Schleifscheibe	Impegno di una mola	Ingrijping van de slijpschijf
7.2	a_e	Working engagement	Engagement de travail	Рабочее зацепление	Schnitttiefe (Schnittbreite)	Impegno di lavoro (profondità di passata)	Werkingrijping
7.3	a_p	Back engagement	Engagement arrière	Обратное зацепление	Schnittingriff	Impegno verso il retro (larghezza della passata)	Achterwaartse ingrijping
7.4	a_f	Feed engagement	Engagement d'avance	Зацепление при подаче	Vorschubingriff	Impegno d'avanzamento	Voedingsingrijping
	a_r	Radial engagement	Engagement radial	Радиальное зацепление	Radialer Eingriff	Impegno radiale	Radiale ingrijping
	a_t	Tangential engagement	Engagement tangentiel	Тангенциальное зацепление	Tangentiaal Eingriff	Impegno tangenziale	Tangenciale ingrijping
	a_a	Axial engagement	Engagement axial	Осевое зацепление	Axialer Eingriff	Impegno assiale	Axiale ingrijping

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
8.1	V_w	Material removal	Volume d'enlèvement de matière	Наработка	Zerspanungsvolumen	Volume di materiale asportato	Volume afgenomen materiaal
8.1.1	V'_w	Material removal per unit active grinding wheel width	Volume d'enlèvement de matière par unité de largeur active de la meule	Съем материала на единицу рабочей ширины шлифовального круга	Bezogenes Zerspanungsvolumen	Volume di materiale asportato per unità di spessore attivo della mola	Volume afgenomen materiaal per eenheid aktieve breedte van de slijpschijf
8.1.2	V'_{wD}	Material removal per unit active grinding wheel profile length	Volume d'enlèvement de matière par unité de longueur de profil actif de la meule	Съем материала на единицу длины рабочего профиля шлифовального круга	Profilbezogenes Zerspanungsvolumen	Volume di materiale asportato per unità di lunghezza del profilo attivo	Volume afgenomen materiaal per eenheid lengte van het aktieve profiel van de slijpschijf
8.1.3	Q_w	Material removal rate	Débit d'enlèvement de matière	Скорость съема материала	Zeitspannungsvolumen	Tasso d'asportazione di materiale	Afname debiet
8.1.4	Q'_w	Material removal rate per unit active grinding wheel width	Débit d'enlèvement de matière par unité de largeur active de la meule	Скорость съема материала на единицу рабочей ширины шлифовального круга	Bezogenes Zeitspannungsvolumen	Tasso d'asportazione di materiale per unità di spessore attivo della mola	Afname debiet per eenheid aktieve breedte van de slijpschijf
8.1.5	Q'_{wD}	Material removal rate per unit active grinding wheel profile length	Débit d'enlèvement de matière par unité de longueur de profil actif de la meule	Скорость съема материала на единицу длины рабочего профиля шлифовального круга	Profilbezogenes Zeitspannungsvolumen	Tasso d'asportazione di materiale per unità di lunghezza del profilo attivo della mola	Afname debiet per eenheid lengte van het aktieve profiel van de slijpschijf
8.2	V_s	Volumetric grinding wheel wear	Volume d'usure de la meule	Объемный износ шлифовального круга	Schleifscheibenverschleißvolumen	Usura volumetrica della mola	Volumetrische slijpschijfslijtage
8.2.1	V'_s	Volumetric grinding wheel wear per unit active grinding wheel width	Volume d'usure de la meule par unité de largeur active de la meule	Объемный износ шлифовального круга на единицу рабочей ширины шлифовального круга	Bezogenes Schleifscheibenverschleißvolumen	Usura volumetrica della mola per unità di spessore attivo della mola	Volumetrische slijpschijfslijtage per eenheid aktieve breedte van de slijpschijf
8.2.2	V'_{sD}	Volumetric grinding wheel wear per unit active grinding wheel profile length	Volume d'usure de la meule par unité de longueur de profil actif de la meule	Объемный износ шлифовального круга на единицу длины рабочего профиля шлифовального круга	Profilbezogenes Schleifscheibenverschleißvolumen	Usura volumetrica della mola per unità di lunghezza del profilo attivo della mola	Volumetrische slijpschijfslijtage per eenheid lengte van het aktieve profiel van de slijpschijf
8.2.3	Q_s	Grinding wheel wear rate	Taux d'usure de la meule	Скорость износа шлифовального круга	Schleifscheibenverschleißvolumen pro Zeiteinheit	Tasso d'usura della mola	Volumieke slijpschijfslijtage
8.2.4	Q'_s	Grinding wheel wear rate per unit active grinding wheel width	Taux d'usure de la meule par unité de largeur active de la meule	Скорость износа шлифовального круга на единицу рабочей ширины шлифовального круга	Bezogenes Schleifscheibenverschleißvolumen pro Zeiteinheit	Tasso d'usura della mola per unità di spessore attivo della mola	Volumieke slijpschijfslijtage per eenheid aktieve breedte van de slijpschijf
8.2.5	Q'_{sD}	Grinding wheel wear rate per unit active grinding wheel profile length	Taux d'usure de la meule par unité de longueur de profil actif de la meule	Скорость износа шлифовального круга на единицу длины рабочего профиля шлифовального круга	Profilbezogenes Schleifscheibenverschleißvolumen pro Zeiteinheit	Tasso d'usura della mola per unità di lunghezza del profilo attivo della mola	Volumieke slijpschijfslijtage per eenheid lengte van het aktieve profiel van de slijpschijf

No.	Symbol	English	Français	Русский	Deutsch	Italiano	Nederlands
8.3	G	Grinding ratio	Rapport de rectification	Коэффициент шлифования	Abtragsquotient	Rapporto di rettifica	Slijpverhouding
8.4	Δr_s	Grinding wheel radial wear	Usure radiale de la meule	Радиальный износ шлифовального круга	Schleifscheibenradialverschleiß	Usura radiale della mola	Radiale slijpschijfslijtage
8.5	Δb_s	Grinding wheel axial wear	Usure axiale de la meule	Осевой износ шлифовального круга	Schleifscheibenaxialverschleiß	Usura assiale della mola	Axiale slijpschijfslijtage
9.1	F'	Grinding force per unit active grinding wheel width	Force de rectification par unité de largeur active de la meule	Усилие шлифования на единицу рабочей ширины шлифовального круга	Bezogene Schleifkraft	Forza di rettifica per unità di spessore attivo della mola	Slijpkracht per eenheid aktieve breedte van de slijpschijf
9.2	F'_D	Grinding force per unit active grinding wheel profile length	Force de rectification par unité de longueur du profil actif de la meule	Усилие шлифования на единицу длины рабочего профиля шлифовального круга	Profilbezogene Schleifkraft	Forza di rettifica per unità di lunghezza del profilo attivo della mola	Slijpkracht per eenheid lengte van het aktieve profiel van de slijpschijf
10	—	Equivalent grinding thickness	Épaisseur équivalente de rectification	Эквивалентная толщина шлифования	Äquivalente Spannungsdicke	Profondità equivalente di molatura	Equivalente slijpdikte
10.1	h_{eq}	Equivalent grinding thickness per unit active grinding wheel width	Épaisseur équivalente de rectification par unité de largeur active de la meule	Эквивалентная толщина шлифования на единицу рабочей ширины шлифовального круга	Bezogene Äquivalente Spannungsdicke	Profondità equivalente di molatura per unità di spessore attivo della mola	Equivalente slijpdikte per eenheid aktieve breedte van de slijpschijf
10.2	h_{eqD}	Equivalent grinding thickness per unit active grinding wheel profile length	Épaisseur équivalente de rectification par unité de longueur du profil actif de la meule	Эквивалентная толщина шлифования на единицу длины рабочего профиля шлифовального круга	Profilbezogene Äquivalente Spannungsdicke	Profondità equivalente di molatura per unità di lunghezza del profilo attivo della mola	Equivalente slijpdikte per eenheid lengte van het aktieve profiel van de slijpschijf
11.1	N_{st}	Static grain count at a certain depth	Relevé statique du nombre de grains à une profondeur donnée	Статическое число зерен	Statische Kornzahl	Rilevamento statico del numero dei grani	Statisch korrelaantal
11.2	N_{kin}	Kinematic grain count	Relevé dynamique du nombre de grains	Кинематическое число зерен	Kinematische Kornzahl	Rilevamento dinamico del numero dei grani	Kinematisch korrelaantal
11.3	N_{act}	Active grain count	Relevé du nombre de grains actifs	Число рабочих зерен	Aktive Kornzahl	Numero dei grani attivi rilevati	Aantal aktieve korrels
11.4	—	Grain distribution	Répartition des grains	Распределение зерен	Kornverteilung	Distribuzione dei grani	Korrelverdeling
	—	Linear distribution	Répartition linéique	Линейное распределение	Lineare Verteilung	Distribuzione lineica	Lineaire verdeling
	—	Area distribution	Répartition surfacique	Распределение по площади	Flächenmäßige Verteilung	Distribuzione areica	Oppervlakte verdeling van de korrels
	—	Volumetric distribution	Répartition volumique	Объемное распределение	Volumetrische Verteilung	Distribuzione volumica	Volumeverdeling

ISO 3002-5 : 1989 (E)

UDC 621.923 : 001.4

Descriptors : tools, cutting tools, grinding machines (tools), grinding wheels, symbols, definitions.

Price based on 23 pages
