

HEDG GRINDING

High Efficiency Deep Grinding

	Pendulum Grinding	Creep-Feed Grinding	HEDG Grinding
Depth of Cut	Low 0.001 ~ 0.05mm 0.0004 ~ 0.02 in.	High 0.1 ~ 30mm 0.04 ~ 1.2 in.	High 0.1 ~ 30mm 0.04 ~1.2 in.
Work Speed Velocity	High 1 ~ 30 m/min. 40 ~ 1200 in./min.	Low 0.5 ~ 0.5 m/min. 2 ~ 20 in./min.	High 0.5 ~ 10m/min. 20 ~ 400 in./min.
Wheel Speed Velocity	Low 20 ~ 60 m/s 4,000 ~ 6,000 SFPM	Low 20 ~ 60 m/s 4,000 ~ 6,000 SFPM	High 80 ~ 200 m/s 16,000 ~ 40,000 SFPM
Stock Removal Rate	Low 0.1 ~ 10 mm ³ /mm•s 0.01 ~ 1 in ³ /in.•min.	Low 0.1 ~ 10 mm ³ /mm•s 0.01 ~ 1 in ³ /in.•min.	High 50 ~ 2,000 mm ³ /mm•s 5 ~ 200 in ³ /in.•min