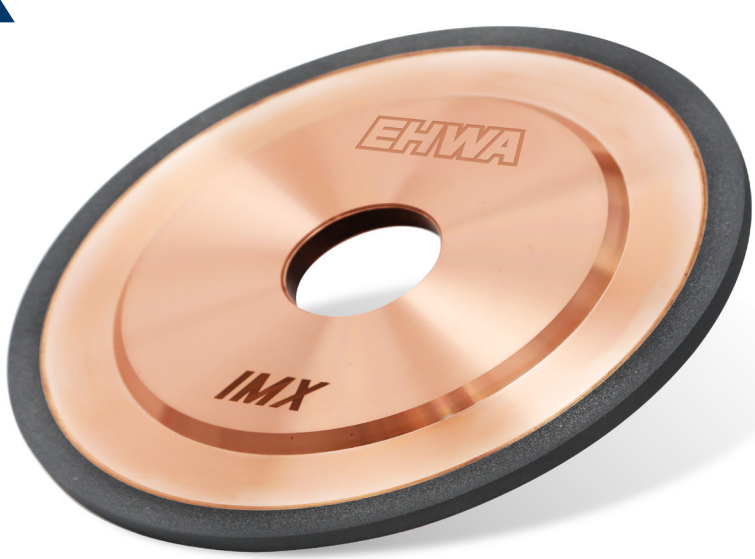
HYBRID BOND PORTFOLIO

BMX vs IMX



MEDIUM FEED RATE ZONE · Q'w ≤ 3

Balanced-Performance Standard Hybrid Bond

- Superior wear resistance for extended wheel life
- Outstanding edge retention for consistent tool quality

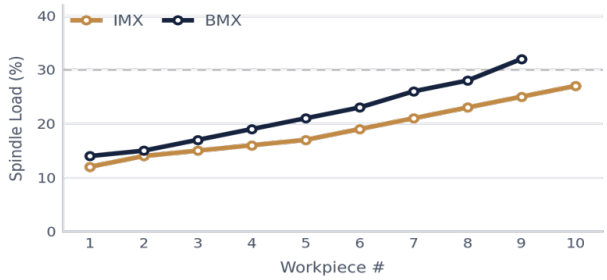
HIGH FEED RATE ZONE · Q'w ≥ 5

Advanced Hybrid Bond for High MRR

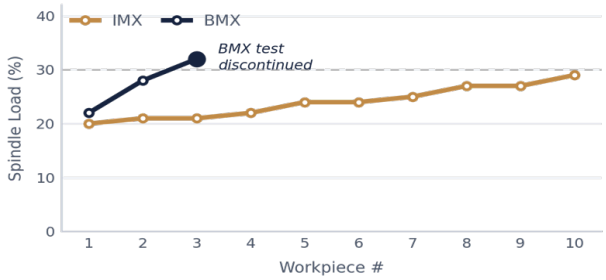
- Reinforced bond structure for high feed rates
- Stable grinding performance under elevated MRR

APPLICATION TEST RESULT — SPINDLE LOAD COMPARISON

Spindle Load at Q'w = 3



Spindle Load at Q'w = 5



Q'w (MRR, mm³/s·mm) = Traverse feed Vt [mm/min] × Infeed (ae) [mm] / 60

TEST DATA

MACHINE	CUTTING SPEED	TOOL	TEST SETUP
ANCA MX7 (38kW)	Vc = 16 m/s	Ø16mm carbide, 4F / 60mm (LOF)	10 workpieces per condition

< 30%
PEAK SPINDLE LOAD

Q'w = 5
MAXIMUM MRR ACHIEVED

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