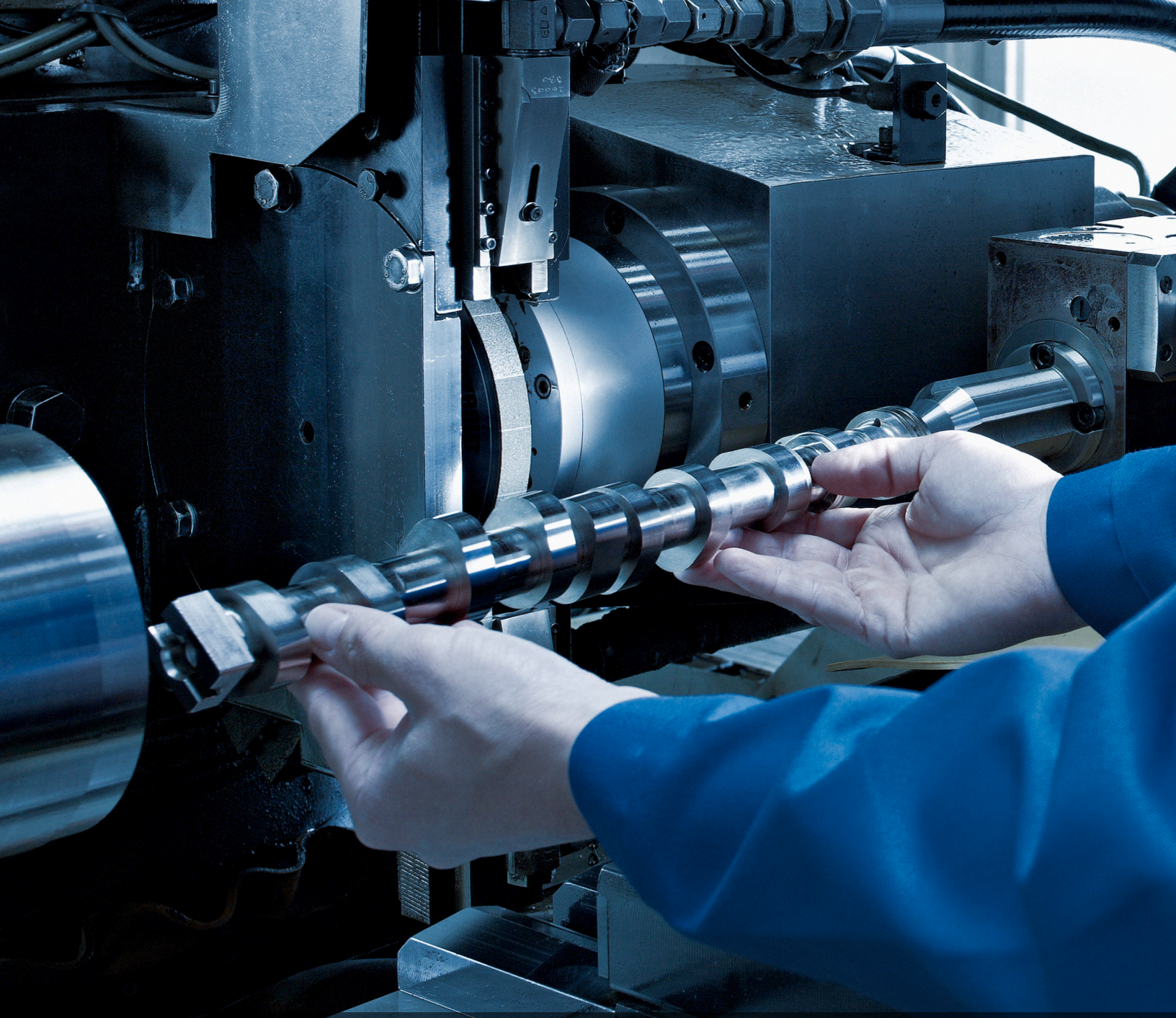


TYROLIT – YOUR PARTNER IN THE AUTOMOTIVE INDUSTRY

GRINDING WHEELS FOR MACHINING ENGINE COMPONENTS

A Tyrolit Company
www.radiac.com

Radiac Abrasives

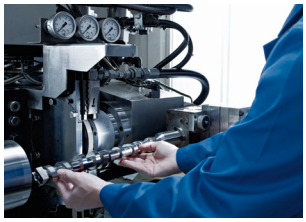
TYROLIT Group
A global company

As one of the world's leading manufacturers of bonded grinding, cutting, sawing, drilling and dressing tools as well as a system supplier of tools and machines for the construction industry, the family-run company TYROLIT has been synonymous with top quality products, innovative spirit and outstanding service since 1919.

Day in, day out, the experts at TYROLIT work on delivering tailor-made solutions for customers around the world, helping to make their businesses successful. An estimated 80,000 available products set the standards in a wide variety of industries.

TYROLIT company headquarters in Schwaz, Austria

TYROLIT business units

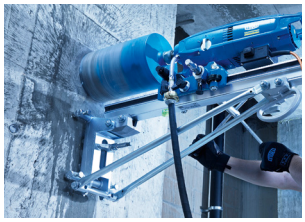


Metal / Precision

From precision machining in the engine and gearbox industry to the production of cut-off wheels with diameters up to 2,000 mm for the steel industry – the TYROLIT product range in the Metal & Precision business unit includes high-tech tools for a wide variety of applications.

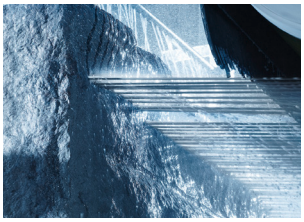
Trade

Thanks to its global sales network, in addition to premium product solutions in the three core areas of cutting, grinding and surface treatment, the trade business unit of TYROLIT guarantees truly customer-focused marketing support.



Construction

In the Construction business unit, TYROLIT is a leading system supplier of drilling systems, wall and wire saws, floor saws and tools for the surface grinding of concrete motorways.



Stone – Ceramics – Glass

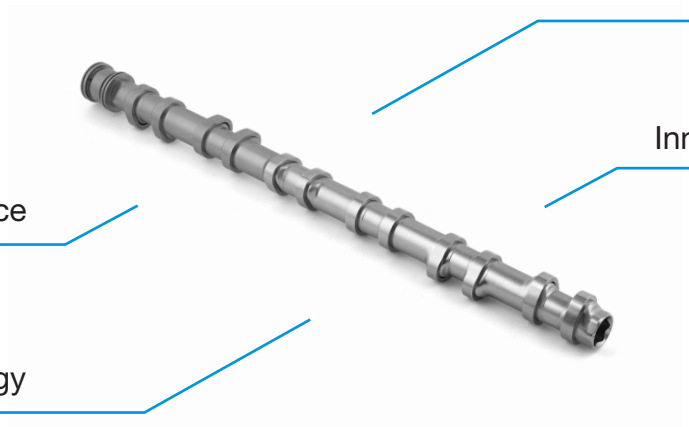
Our tailored diamond tools and grinding solutions in the Stone – Ceramics – Glass business unit impress through their exceptional performance and quality.

A competent partner **in the automotive industry**

Ever growing requirements relating to quality and weight with regard to engine components in the automotive industry make the machining of these components a great challenge. TYROLIT offers its customers a comprehensive service package to meet these requirements.

An extensive product range combined with numerous service offerings make TYROLIT a competent solutions provider for customers around the world.

Our services for the machining of engine components at a glance



Global presence

Innovative products

Expertise & experience

Application technology

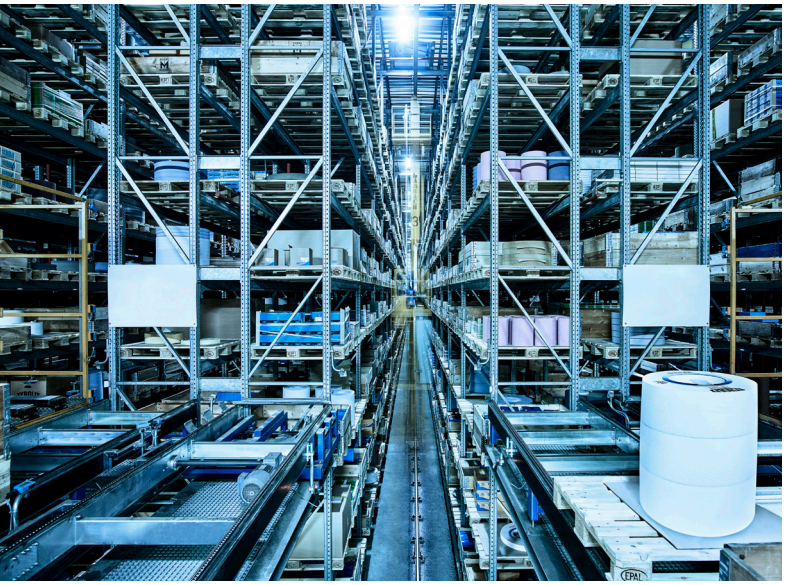
Competency & experience
Professional industry expertise

TYROLIT has long-standing experience in the automotive industry, particularly in the machining of engine shafts. Moreover, we work in close cooperation with established machine manufacturers, universities and numerous automotive suppliers.

Thanks to this expertise, we meet the latest technical standards with regard to the machining processes used in the automotive industry and, with this knowledge, are always in a position to offer our customers an optimally adapted package of grinding solutions and attractive service offerings for the economically efficient machining of engine shafts.

Your benefits

- Customer-specific system solutions from a single source
- Individually adapted tool specifications for machines and processes
- Optimum tool design for maximum economic efficiency
- Close cooperation with machine manufacturers
- Hosting of workshops and training courses



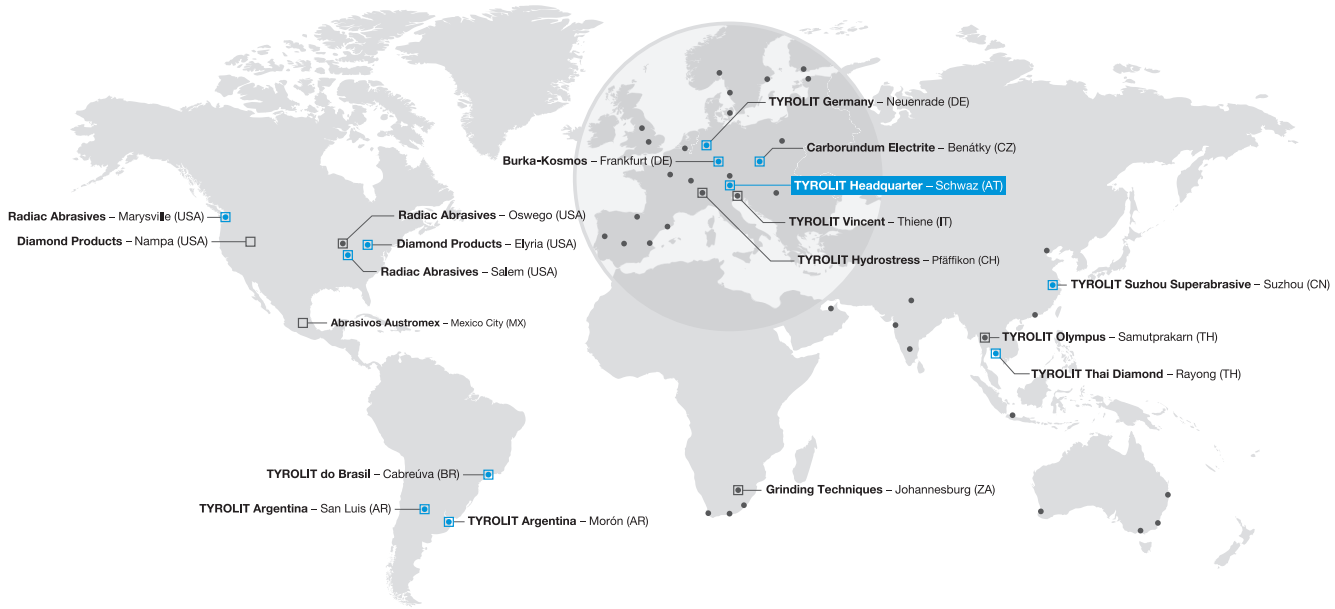
Global presence
In your vicinity

Global presence
TYROLIT stands for global thinking and activities. With a worldwide sales network currently in 65 countries and with our own production plants in 12 countries on five continents, we offer our customers all the advantages of a globally operating company.

Local availability
Global thinking, local action – in your national language and in your vicinity. This is the principle we follow in dealing with our customers. Local contacts near your premises and a global team of specialist application engineers ensure optimum customer support and first-class service.

Your benefits

+ Global presence with local contacts
+ Short response and service times



TYROLIT Metal / Precision production locations **TYROLIT production locations** **TYROLIT sales locations**

Application technology
The best team for your application

An experienced team of specialist application engineers is available to our customers throughout the world and works to produce the most economically efficient solutions. All employees in the various countries have excellent links to our headquarters in Austria, where they obtain thorough support on all technical issues.

Jointly with our customers, TYROLIT application engineers improve grinding processes with an aim to reducing the component costs to a minimum.

TYROLIT application technology in practice

- Documenting and analysing the customer-specific task
- Drawing up individual proposals for a solution to the customer's requirements
- Working on a process solution in close consultation with the customer
- Implementing the process solution at the customer's site
- Passing on acquired knowledge in training sessions

Your benefits

+ The global presence of our application engineers
+ Tailor made solutions and process optimization to suit individual tasks
+ Close cooperation with machine manufacturers
+ Internal and external seminars and training courses

Innovative products
Quality that impresses

TYROLIT is one of the world's leading manufacturers of grinding wheels for cutting and grinding a large number of widely differing components.

All products are manufactured and tested to the highest quality standards. In addition, specialised expert teams ensure the continuous further development of products, under consideration of individual customer needs. An extensive product portfolio provides our technicians with a wide variety of abrasives and bond systems and consequently to meet customer-specific requirements.

Your benefits

- Continuous improvement of existing products
- Innovative products for optimising economic efficiency
- System solutions, comprising grinding and dressing tools from a single source
- Cooperation with machine manufacturers and universities

Conventional abrasives (A + C)

TYROLIT offers its customers a comprehensive range of conventional grinding wheels based on corundum and silicon carbide. Conventional grinding wheels are primarily used for external cylindrical grinding of bearing journals and for the centreless grinding of camshaft tubes.

Superabrasives (D + B)

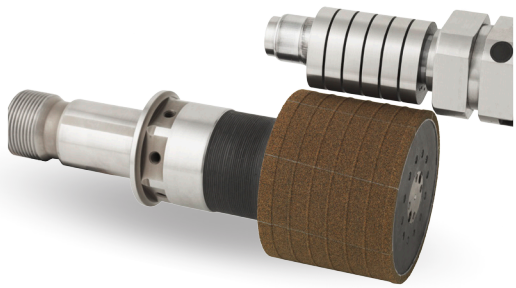
Extremely hard abrasives - known as superabrasives - are primarily used for machining ultra-hard materials. TYROLIT boasts a wide range of tailored CBN tools based on different bond systems (metal, resin, ceramic, electroplated). Superabrasives show their strengths particularly where low component machining costs are the priority, as is the case with camshafts and crankshafts, for example.

Combustion engines of the future
Growing quality requirements for grinding tools

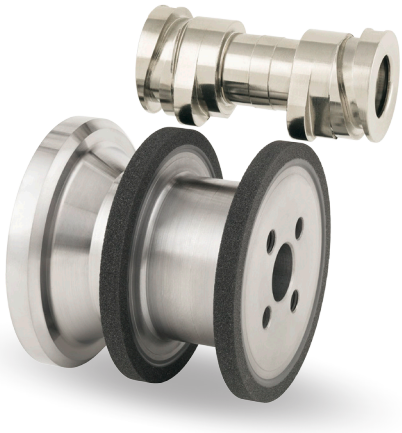
The greatest challenge in the development of future combustion engines will be to resolve the conflicting requirements relating to fuel consumption and range, exhaust emissions, comfort and driving dynamics to the best possible effect. Achieving these objectives place particularly high demands on the complete system during manufacturing. Machine, grinding wheel, dressing tool and process control must all be matched to one another. Reducing friction and downsizing combustion engines continue to offer significant potential in terms of cutting fuel consumption as well as CO_2 emissions. Above all, the weight of the rotating engine components will be reduced in future through the use of new alloys and materials. Improved surface finishes and optimum component geometries will be vital in new engine generations with low fuel consumption and greater power. In order to solve these challenges, TYROLIT acts as a reliable and competent partner to its customers.

Trends with regard to camshafts and crankshafts

- Assemblies and adjustable camshafts for optimal combustion
- Optimization of component geometries (roundness, running truth and surface finish)
- Continuous further development of machining concepts
- New materials for weight reduction



Cam contour grinding in package



Cam contour grinding of a cam disc piece

Customer-specific solutions
Tailored for your industry

Owing to their different designs, the machining of camshafts and crankshafts represent a particular challenge during machining. Over many decades, TYROLIT has gathered well-founded expertise in the machining of these parts and provides its customers with on-site support.

During the optimization of combustion engines, the crankshaft plays a decisive role owing to its large mass. New, lighter, but nevertheless torsionally rigid materials as well as improved component properties (surfaces and geometries) are required.

Variability is perhaps the most important key word when it comes to defining potential for engine optimization. Camshafts of the new generation must perform optimum valve control at different engine speeds and power requirements. This is associated with constantly growing quality requirements.

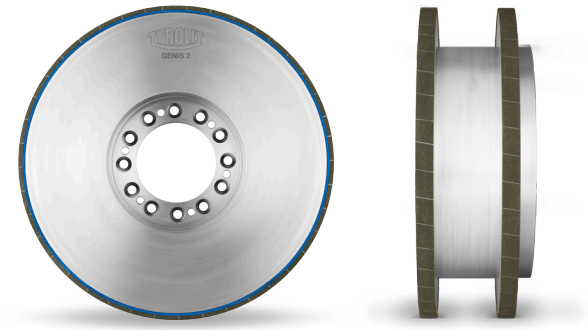
Machining concepts

Component	Grinding position	Grinding process	Product recommendation
Camshaft	Bearing journal Cam profile Camshaft tube Individual cam faces	External cylindrical / elliptical of round Centreless Surface grinding Superfinishing	**GENIS 2 / GENIS 2-CF** **CSS ULTRA / CSS REGULATOR** **POLARIS BASIC / POLARIS PLUS** **CENTURIA** **MICROTEC FINISHING TAPES** **TYROLIT FINISHING STONES**
Crankshaft	Main-bearing journal Crank-pin journal Thrust bearing journal Flange Stub Polygon	External cylindrical Angled flute grinding Side grinding Superfinishing	**GENIS 2 / GENIS 2-CF** **CSS ULTRA** **POLARIS BASIC / POLARIS PLUS** **MICROTEC FINISHING TAPES** **TYROLIT FINISHING STONES**
Balancer shaft	Bearing journal	External cylindrical Superfinishing	**GENIS 2 / GENIS 2-CF** **CSS ULTRA** **MICROTEC FINISHING TAPES** **TYROLIT FINISHING STONES**
Con-rod	Small-end eye Big-end eye	Surface grinding	**CENTURIA**

GENIS / GENIS 2 / GENIS 2-CF

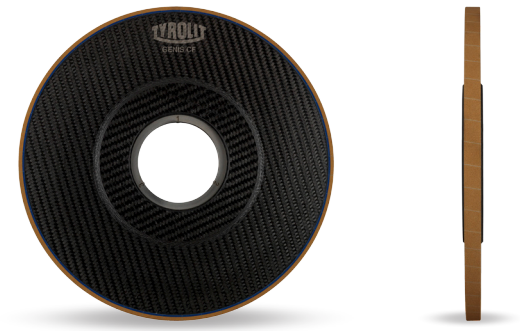
Vitrified bonded CBN grinding tools for external cylindrical grinding

With the GENIS 2 product line, TYROLIT defines a new performance level and a wider range of applications for external cylindrical grinding with vitrified-bonded CBN tools. GENIS 2 is characterised by a high-strength bond with excellent wetting properties, coating the CBN grain and securely binding the grain within the bond. Thus bond volumes can be reduced enabling very open, cool-grinding and extremely easy-cutting specifications with a long lifetime. GENIS 2 is also available with a CF core.



Your benefits

- High economic efficiency
- Wide range of applications
- High running precision
- Optimum grain utilisation
- Replating option

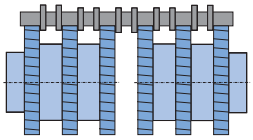


CF core

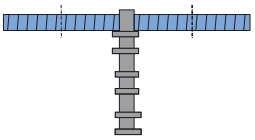
- Low weight
- Best damping
- Simultaneous machining

Camshaft grinding applications

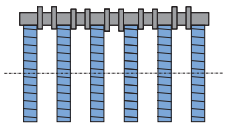
– Bearing journal



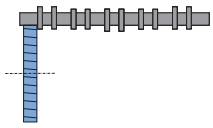
Multi-layer grinding wheel



Vertical grinding machine

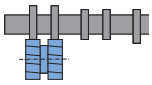


Gang and multi wheel grinding

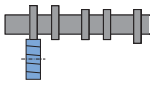


Individual wheel

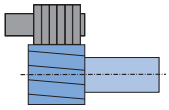
– Cam profile / camshaft tube



Dual-layer grinding wheel

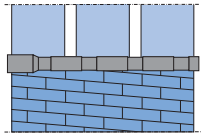


Individual wheel

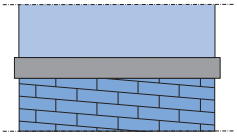


Individual cams in package

Variable cam lobe re-entry



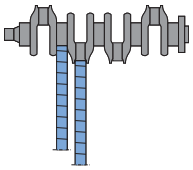
Centreless plunge grinding



Centreless through feed grinding

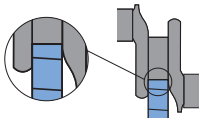
Crankshaft grinding applications

– Crank-pin and main bearing journals

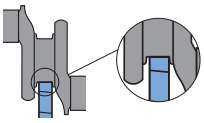


Separate wheels

Different processes for bearing journal grinding

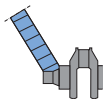


Straight plunge grinding along the entire journal width

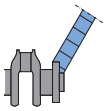


Combined grinding of the shoulders, radii and diameters

– Flange and pin



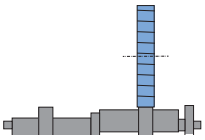
Stub



Flange

Balance shaft grinding applications

– Bearing journal



Individual wheel

CSS ULTRA / CSS REGULATOR

Vitrified bonded grinding tools for external cylindrical grinding & regulating wheels for centerless grinding.

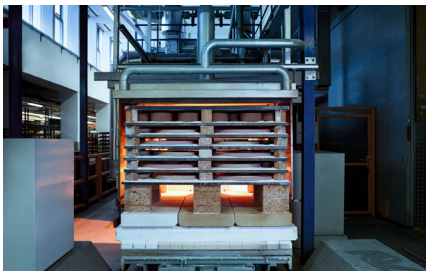
With the CSS ULTRA product line, TYROLIT has created a sustainable grinding wheel micro-architecture through the use of new, high-quality components and innovative sintering technologies.

The CSS REGULATOR from TYROLIT is manufactured as a unitised version. The extremely high compaction ensures uniform quality of the regulating wheel.

Your benefits

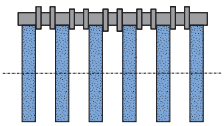
- Long lifetime
- Good profile retention
- Cool grinding
- Shorter grinding time / higher productivity
- Approved up to 125 m/s

- Good profile retention
- High coefficient of friction
- Constant grinding pressure

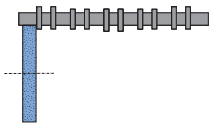


Camshaft grinding applications

– Bearing journal

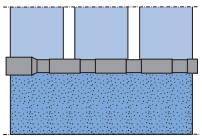


Grinding wheel set

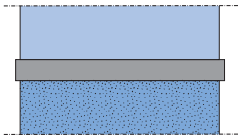


Individual wheel

– Camshaft tube



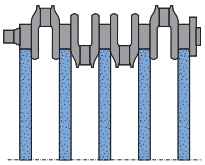
Centreless plunge cut grinding



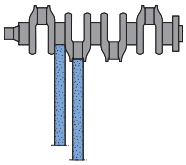
Centreless through-feed grinding

Crankshaft grinding applications

– Crank-pin and main bearing journals

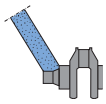


Multi wheel set

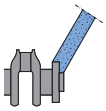


Separate wheels

– Flange and pin



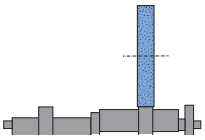
Stub



Flange

Balancer shaft grinding applications

– Bearing journal



Individual wheel

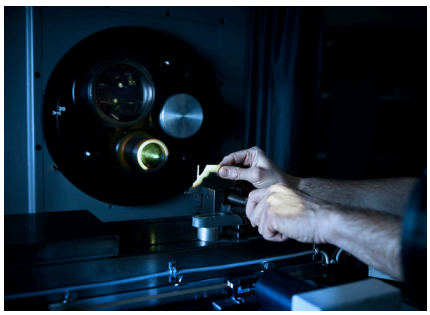
POLARIS BASIC / POLARIS PLUS

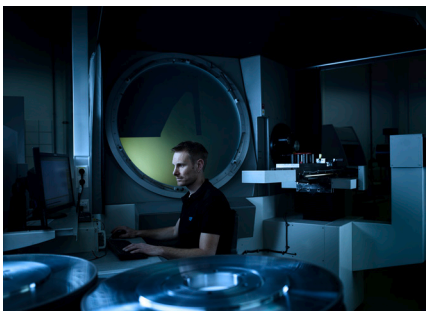
Electroplated CBN grinding tools for external cylindrical grinding

With its POLARIS product line, TYROLIT is the market and technology leader in the production of electroplated and bonded grinding wheels. State-of-the-art production facilities, expertise and application engineering competence are prerequisites for long tool lifetimes. Even the smallest axial or radial run-out errors as any imbalance reduces the service life of the grinding wheels. With the POLARIS PLUS variant, the zones with the highest levels of tool wear can be specifically reinforced, which further extends the lifetime of the grinding wheel.

Your benefits

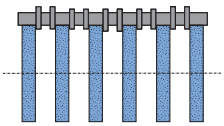
- Customized production
- Maximum lifetime
- Maximum profile accuracy
- Constant optimization
- Replating option



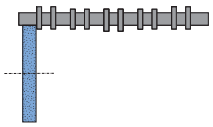


Camshaft grinding applications

– Bearing journal (pre-grinding)

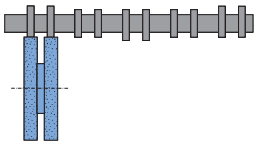


Multi wheel set



Individual wheel

– Cam profile (pre-grinding)

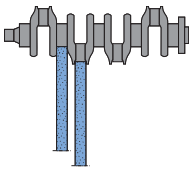


Dual-layer grinding wheel

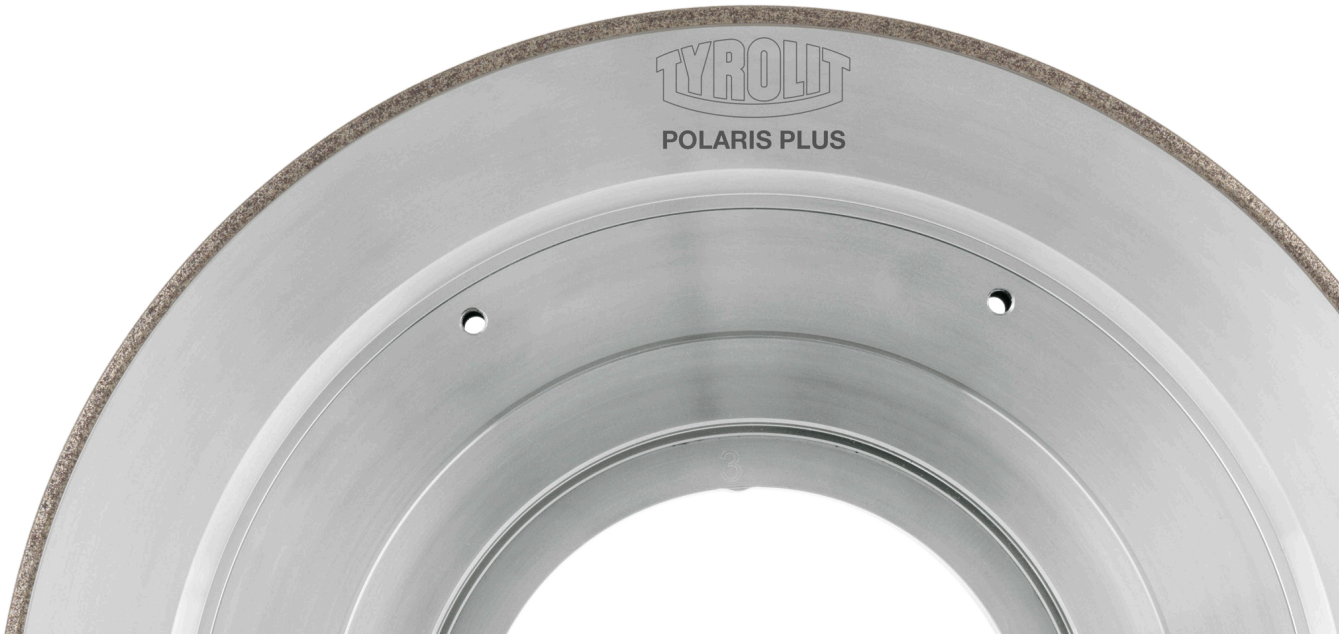
Individual wheel

Crankshaft grinding applications

– Crank-pin and main bearing journals (pre-grinding)



Separate wheels



CENTURIA

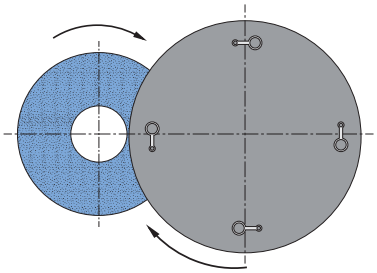
Resin-bonded grinding tools for side grinding

With its CENTURIA product line, Tyrolit offers a complete range of conventional, resin-bonded tools for surface grinding. Different surface grinding methods are used for the efficient production of functional surfaces that must satisfy exacting requirements in terms of flatness, plane parallelism and surface finish. Either both faces are machined simultaneously (double side face grinding), or just one face is machined using single wheels, segments, rings or cup wheels. The components are often mass-produced, which means they face stringent requirements with respect to process stability.

Your benefits

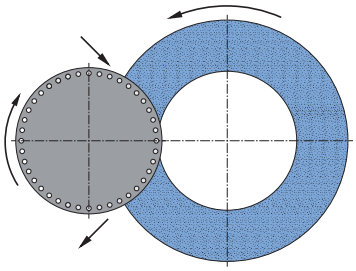
- Consistent grinding behaviour
- Cool grinding
- Long lifetime

Con-rod grinding applications:



Centreless through-feed grinding

Individual cam grinding applications



Centreless through-feed grinding

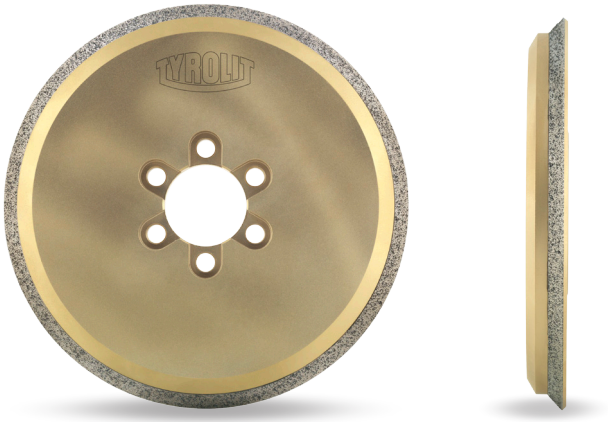
DIAMOND DRESSING TOOLS

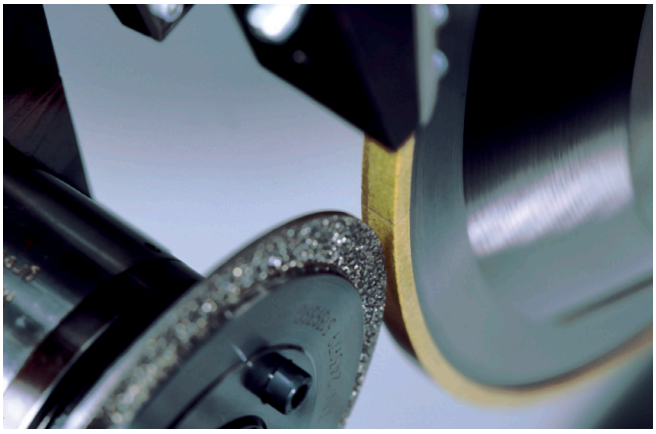
Rotating and stationary diamond tools for dressing grinding tools

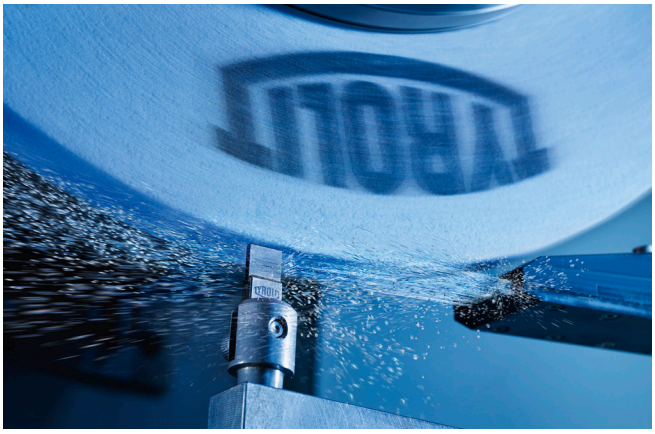
In addition to an extensive range of grinding tools, TYROLIT also supplies the corresponding dressing tools and is therefore able to offer its customers best service as a system supplier. The dressing tools are produced to the highest quality standards at the plant in Neuenrade.

Your benefits

+ Maximum profile accuracy
+ Maximum lifetime
+ Customized production







SOLUTIONS EXPERTISE

AUTOMOTIVE TEAM

Radiac Abrasives is your partner in the automotive industry. For many years now the core business area of Radiac has been as a supplier of grinding tools for machining engine, chassis and transmission components. Radiac is recognized as a reliable partner in this industry thanks to continuous innovations and the high quality standards of its products and product range, customer support and service, as well as delivery reliability.

Application Engineering Team

Radiac's elite group of Application Engineers make up the Application Engineering Team. Each member has a unique set of knowledge and training. The mission is to support growth, drive opportunities and find solutions for our customers.

Radiac Technical Institute

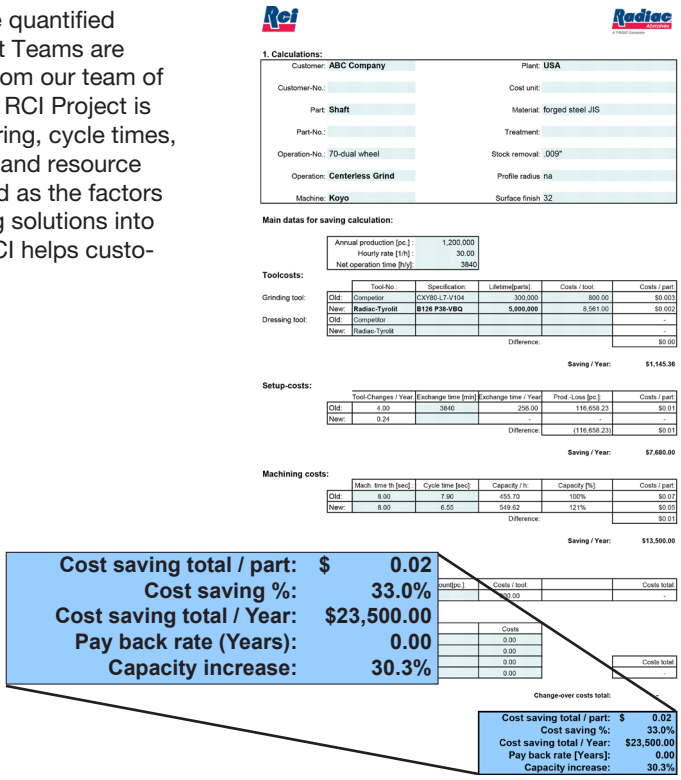
Radiac is proud to introduce Radaic Technical Institute (RTI). RTI was founded to provide training and knowledge to our customers and the sales team. RTI offers training classes both at Radiac and customer facilities. Classes ranging from Abrasives 101 to specific applications are available. Contact your sales representative for more information.

RCI: Radiac Cost Improvement

A RCI Project starts after definition of the quantified goals together with the customer. Project Teams are put together specifically for the Project from our team of specialists. The object of analysis for the RCI Project is the manufacturing unit. Process engineering, cycle times, manufacturing resources, environmental and resource management are analyzed and evaluated as the factors that determine productivity. RCI stands for commitment to putting solutions into practice and goes further than simply recommending answers. RCI helps customers to achieve solutions and achieve the agreed goals.

Benefits of RCI

+ Optimizing productivity and costs
+ Implementing the latest technology
+ Analyzing processes and design systems
+ Improviing your market postiion



1. Calculations:

Customer:	ABC Company	Plant:	USA
Customer-No.:		Cost unit:	
Part:	Shaft	Material:	forged steel JIS
Part-No.:		Treatment:	
Operation-No.:	70-dual wheel	Stock removal:	.009"
Operation:	Centerless Grind	Profile radius	na
Machine:	Koyo	Surface finish	32

Main datas for saving calculation:

Annual production [pc.] :	1,200,000
Hourly rate [1/h] :	30.00
Net operation time [h/y]:	3840

Toolcosts:

		Tool-No.:	Specification:	Lifetime[parts]	Costs / tool:	Costs / part:
Grinding tool:	Old:	Competor	CXY80-L7-V104	300,000	800.00	$0.003
	New:	Radiac-Tyrolit	B126 P36-VBQ	5,000,000	8,561.00	$0.002
Dressing tool:	Old:	Competitor				-
	New:	Radiac-Tyrolit				-
					Difference:	$0.00

Saving / Year: $1,145.36

Setup-costs:

	Tool-Changes / Year:	Exchange time [min]	Exchange time / Year	Prod.-Loss [pc.]:	Costs / part:
Old:	4.00	3840	256.00	116,658.23	$0.01
New:	0.24		-	-	-
				Difference:	($0.01)

Saving / Year: $7,680.00

Machining costs:

	Mach. time th [sec].	Cycle time [sec]:	Capacity / h:	Capacity [%]:	Costs / part:
Old:	8.00	7.90	455.70	100%	$0.07
New:	8.00	6.55	549.62	121%	$0.05
				Difference:	$0.01

Saving / Year: $13,500.00

ount[pc.]	Costs / tool			Costs total:
	0.00			-

	Costs
	0.00
	0.00
	0.00
	0.00

	Costs total:
	-

Change-over costs total: -

Cost saving total / part:	$ 0.02
Cost saving %:	33.0%
Cost saving total / Year:	$23,500.00
Pay back rate [Years]:	0.00
Capacity increase:	30.3%

Cost saving total / part:	$ 0.02
Cost saving %:	33.0%
Cost saving total / Year:	$23,500.00
Pay back rate (Years):	0.00
Capacity increase:	30.3%

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Tel.: 800-851-1095 | Fax: 888-244-8234

ISA INDUSTRIAL SUPPLY ASSOCIATION
Linking Channel Partners

UAMA UNIFIED ABRASIVES MANUFACTURERS' ASSOCIATION

Radiac Abrasives
A TYROLIT Company