

## **RON-Centric-T options for large rings**

The work principle and roundness correction effects are the same.

### 1. Traditional pivot setup.

(+) maximum improvement stiffness for OD grinding ( $4.0 \times C$ )

*(C – the net stiffness of the ring)*

(+) convenient ring loading from the top

(-) adapters and bottom shoes to install

(-) narrow work ranges ( $\pm 0.01 \times D$ )

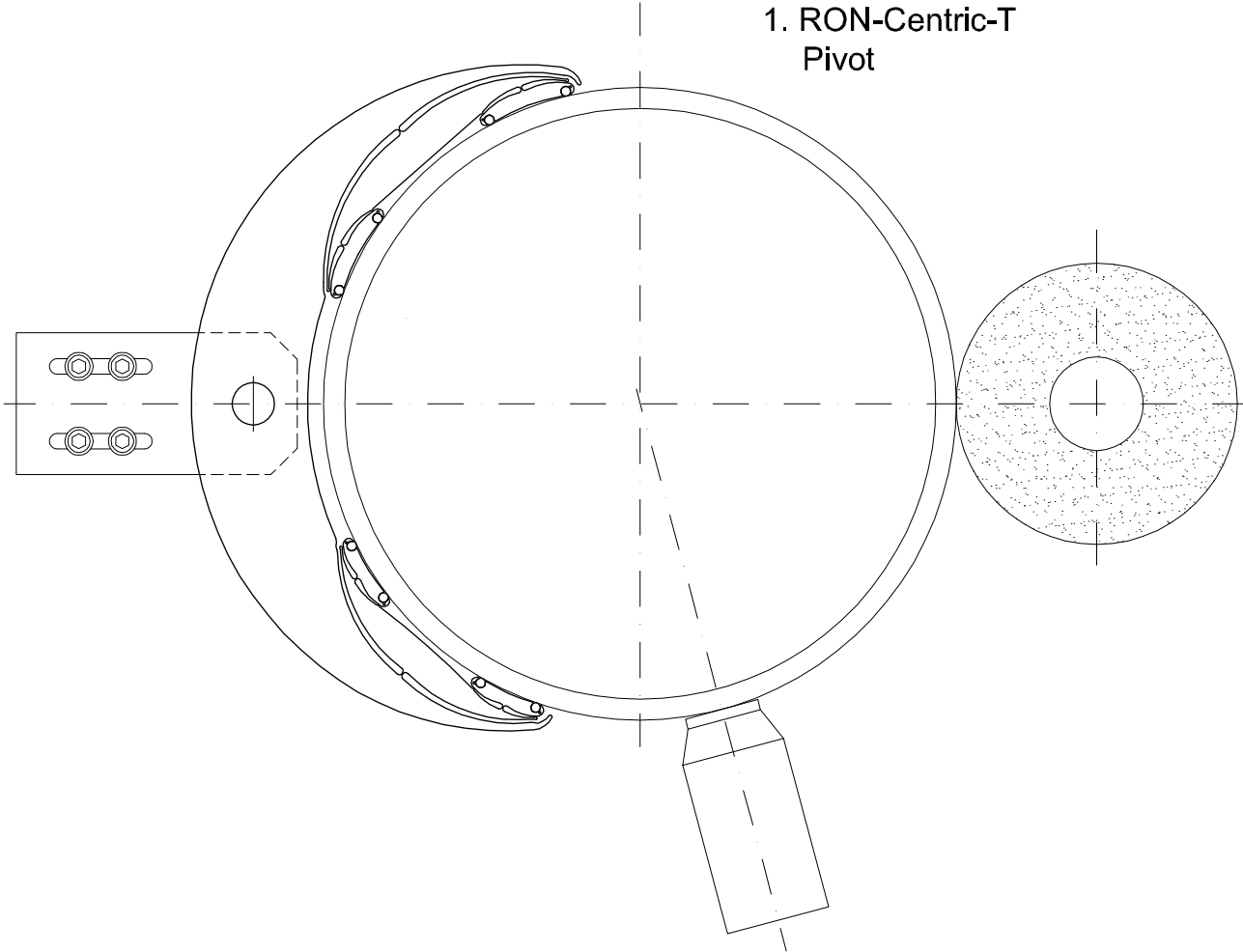
*(D – the outer diameter of the ring)*

(-) lower stiffness in ID grinding ( $2.1 \times C$ )

(-) can be too heavy for large diameters with thin walls

It is recommended for  $OD < 550\text{mm}$  and for the grinding machines being used with the smaller RON-Centric tools.

1. RON-Centric-T  
Pivot

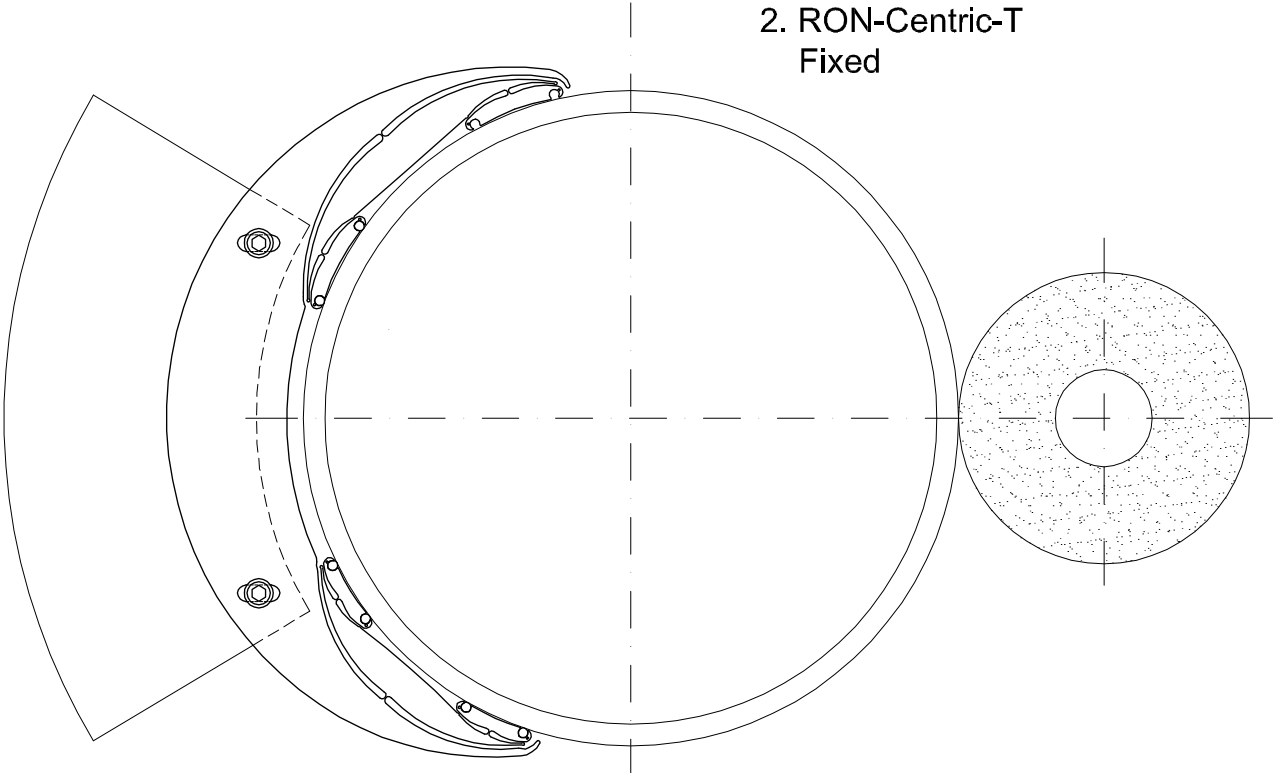


## 2. Fixed setup.

- (+) good stiffness for OD grinding (3.2xC)
- (+) better stiffness for ID grinding (2.4xC)
- (+) no adapters and bottom shoes, can be directly screwed to the plate
- (+) no too heavy moving parts
- (+) the higher stiffness of the shoe screwed to the plate
  - (-) ring loading from the front only
  - (-) narrow work ranges (+/- 0.01xD)

It is recommended for  $OD < 550\text{mm}$  and for the vertical and horizontal grinding machines.

2. RON-Centric-T  
Fixed

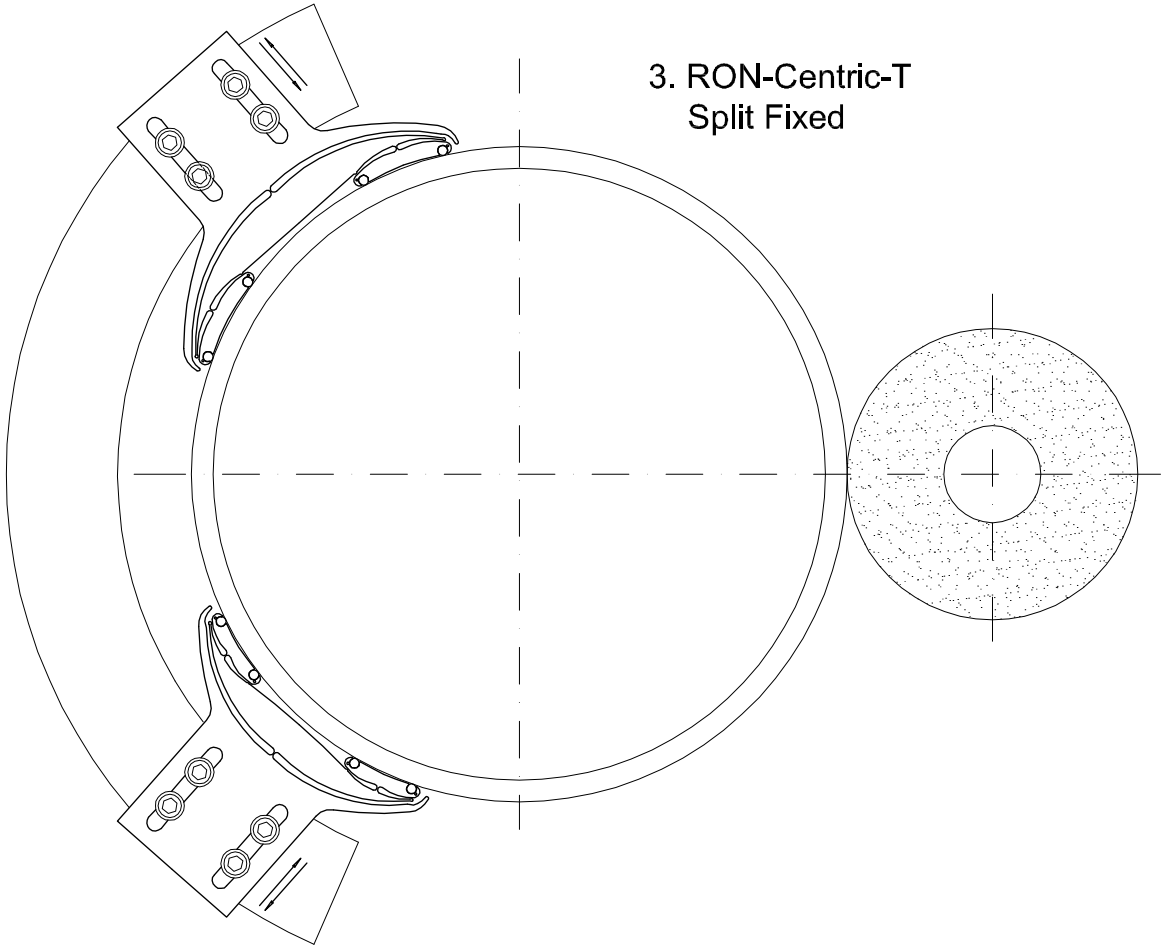


### 3. Split fixed setup

- (+) good stiffness for OD grinding (3.2xC)
- (+) better stiffness for ID grinding (2.4xC)
- (+) increased work ranges (+/- **0.03xD**)  
*due to the separate radial setting of the semi-shoes*
- (+) no too heavy moving parts
- (+) the higher stiffness of the shoe screwed to the plate

It is recommended for  $500\text{mm} < \text{OD} < 750\text{mm}$  and for the vertical grinding machines only.

3. RON-Centric-T  
Split Fixed

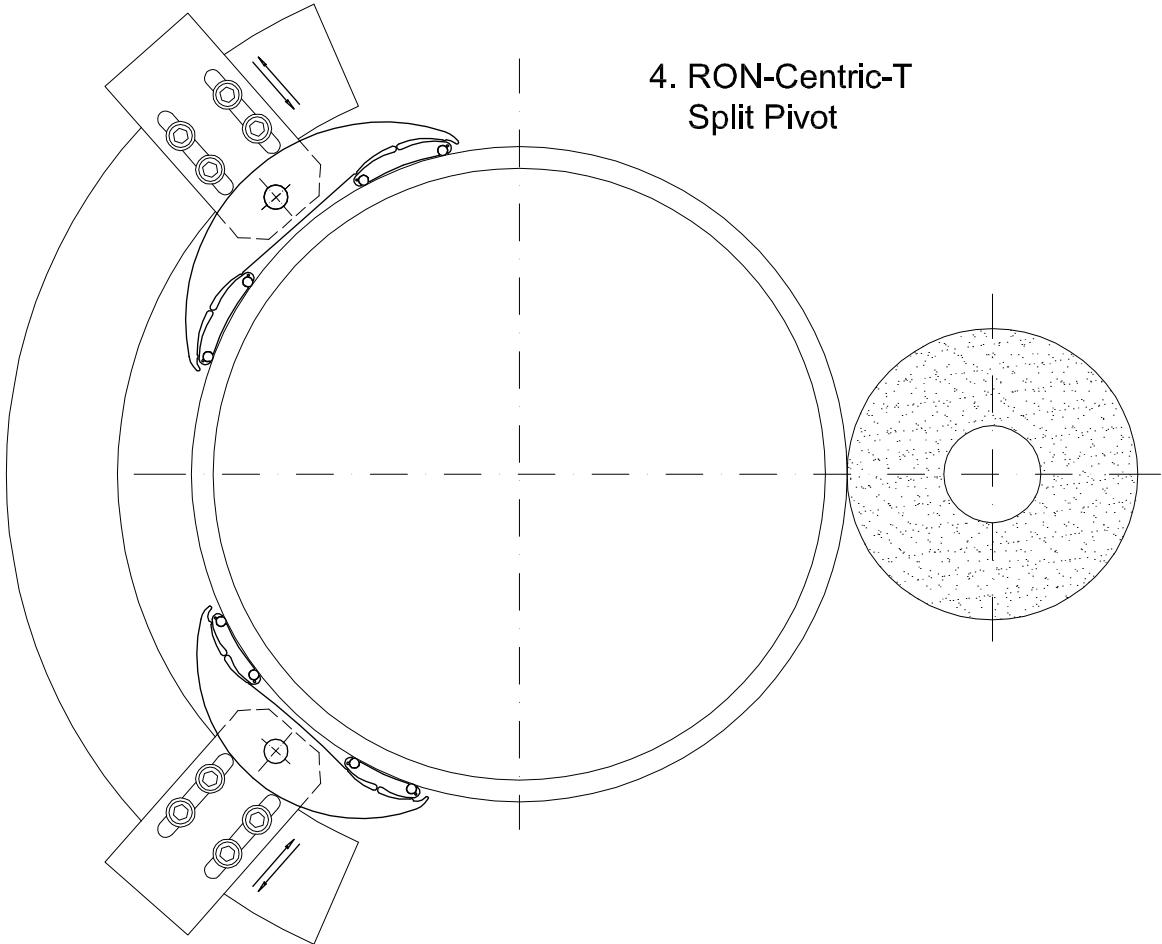


#### 4. Split pivot setup

- (+) good stiffness for OD grinding (3.2xC)
- (+) better stiffness for ID grinding (2.4xC)
- (+) increased work ranges (+/- **0.03xD**)
- (-) adapters to install

It is recommended for  $500\text{mm} < \text{OD} < 750\text{mm}$  and for the vertical grinding machines only (specially if the larger RON-Centric-T is being used on the same machine).

4. RON-Centric-T  
Split Pivot





## 5. Split pivot plus setup

- (+) good stiffness for OD grinding (3.2xC)
- (+) better stiffness for ID grinding (2.4xC)
- (+) increased work ranges (+/- **0.03xD**)
- (+) better roundness for some higher harmonics
- (-) adapters to install

It is recommended for  $500\text{mm} < \text{OD} < 1200\text{mm}$  and for the vertical grinding machines only.

5. RON-Centric-T  
Split Pivot Plus

