

FIG.1

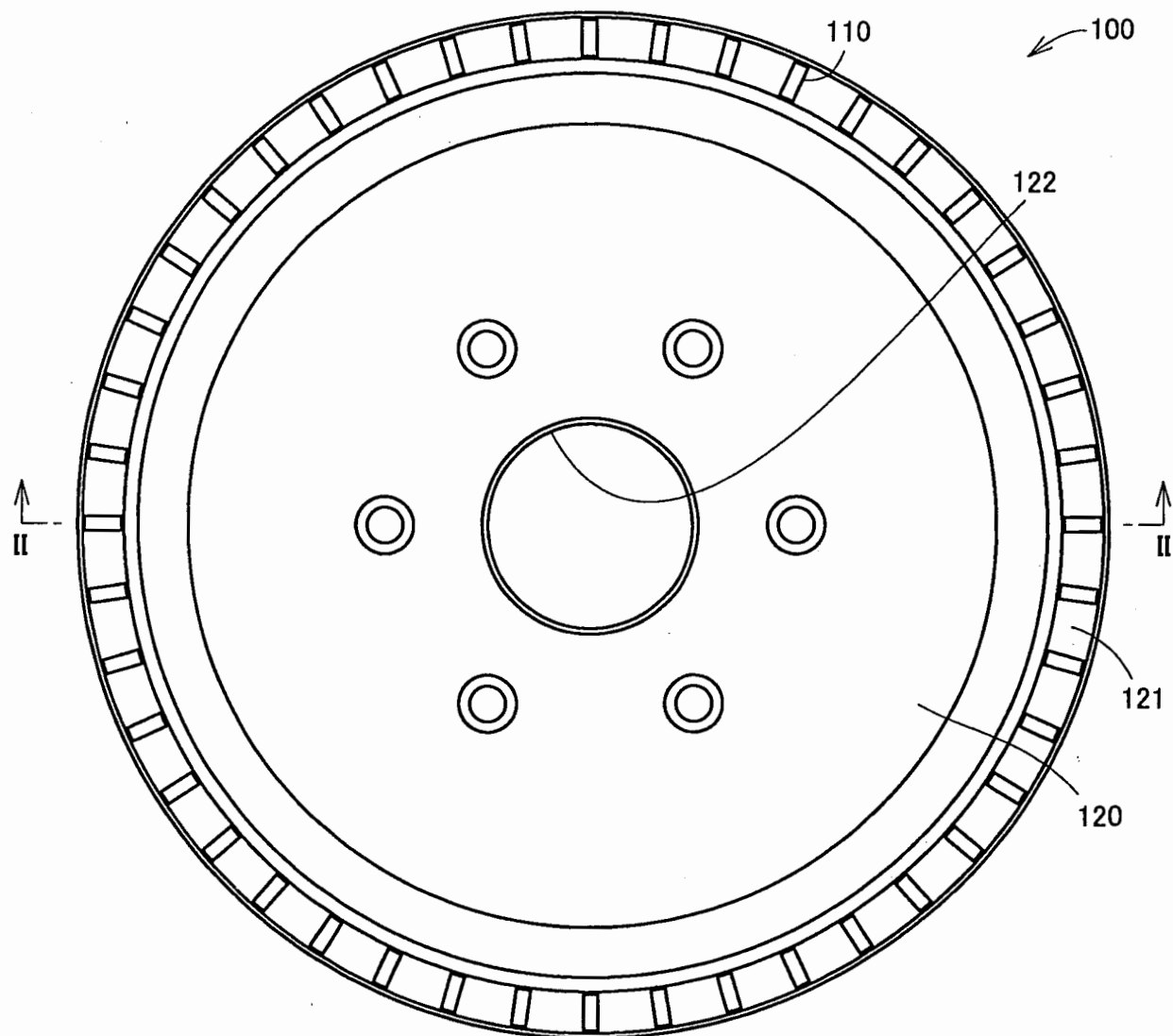


FIG.2

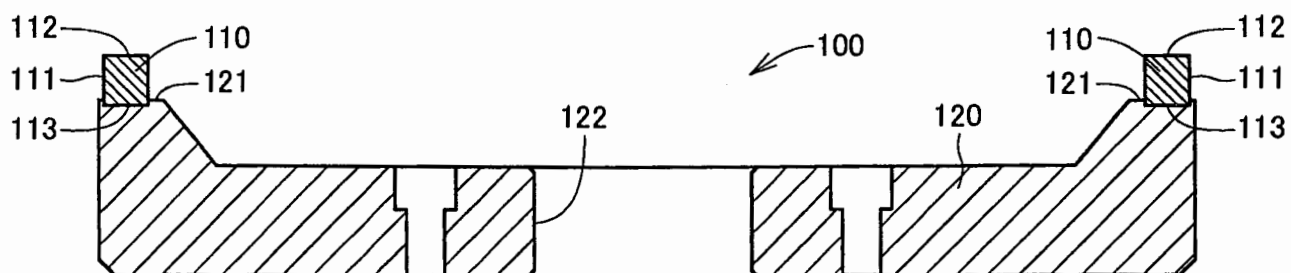


FIG.3

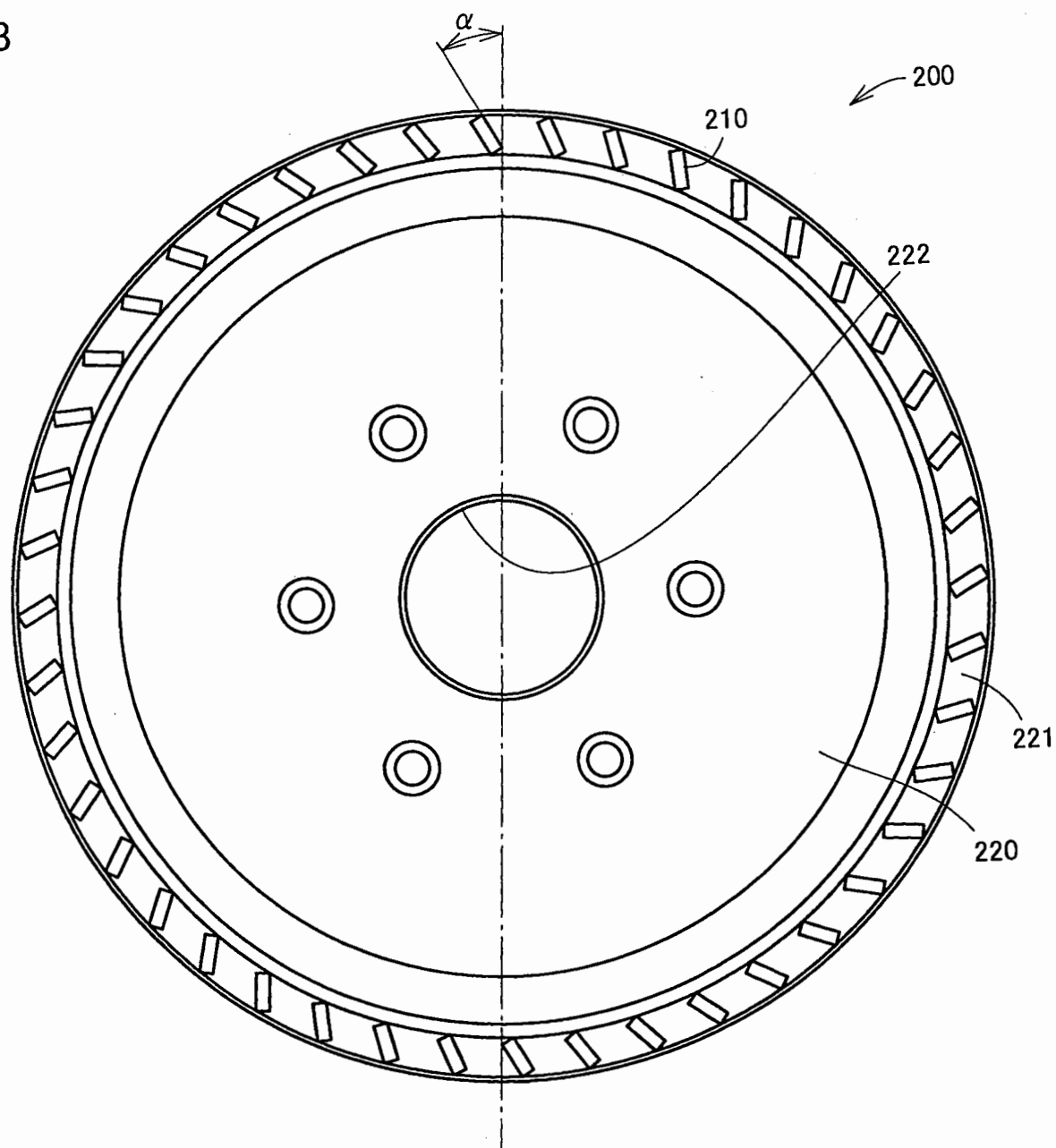


FIG.4

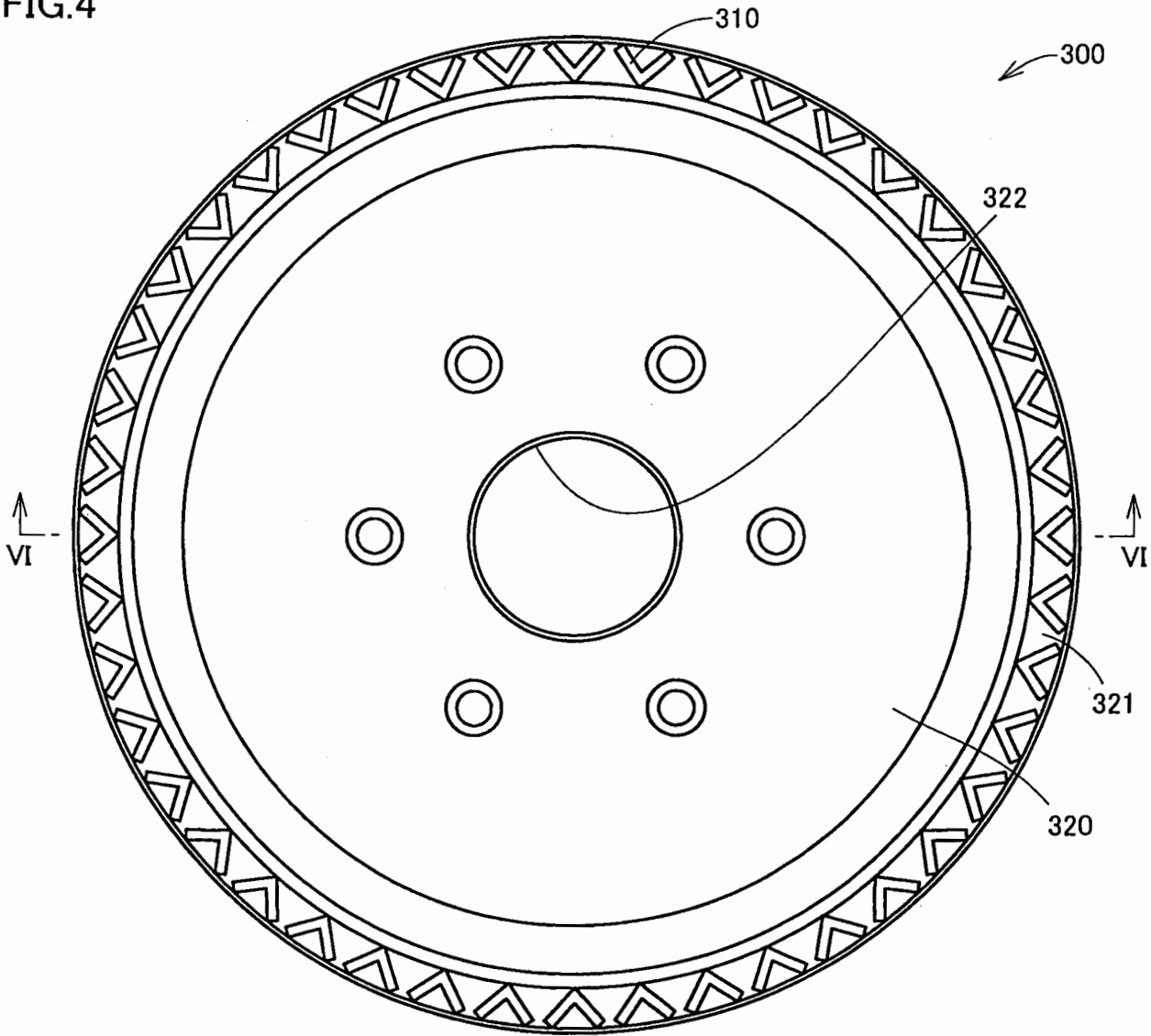


FIG.5

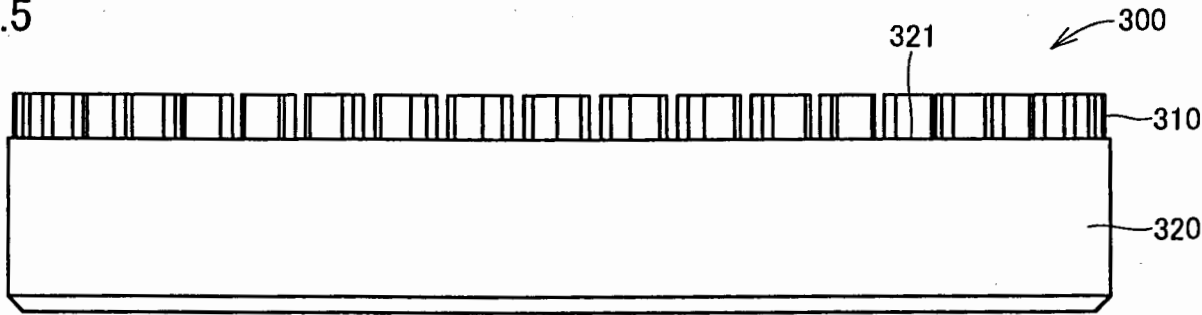


FIG. 6

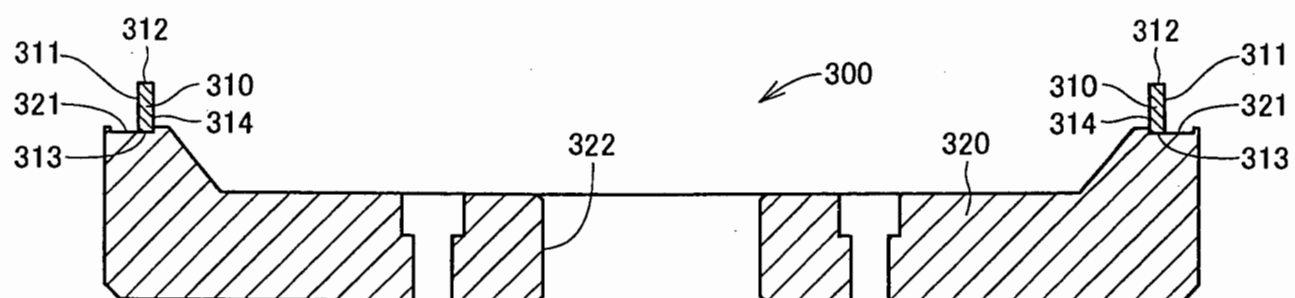


FIG. 7

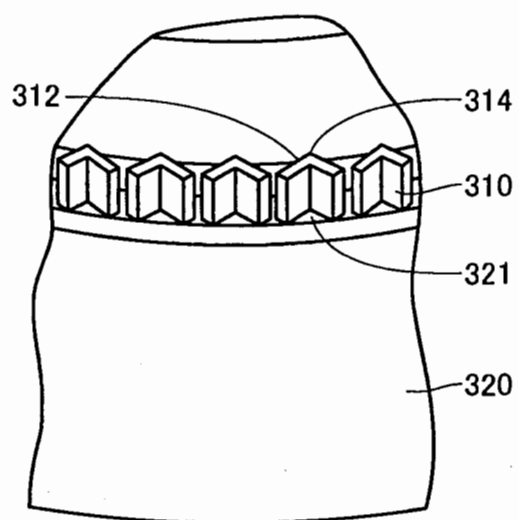


FIG.8

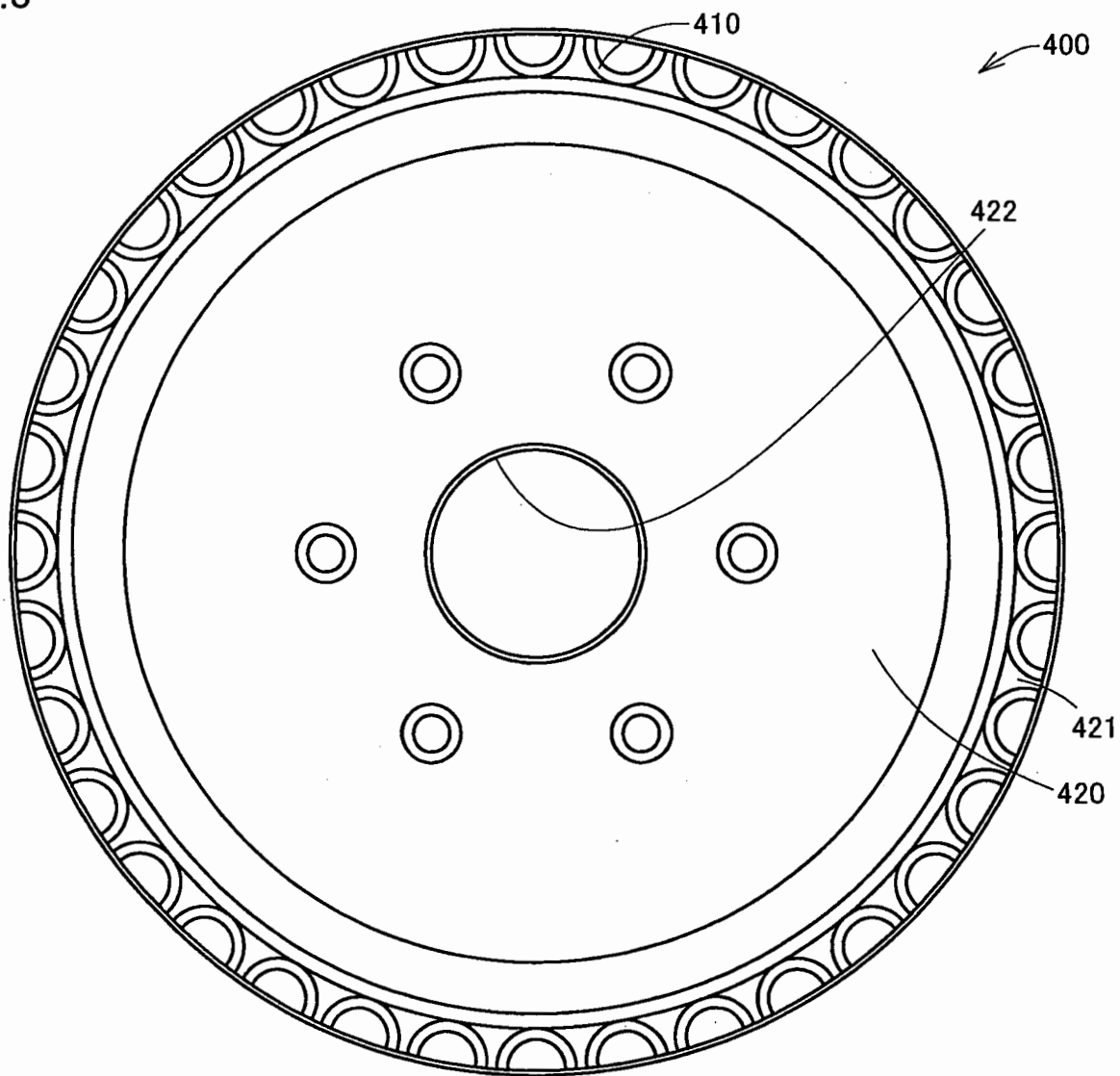


FIG.9

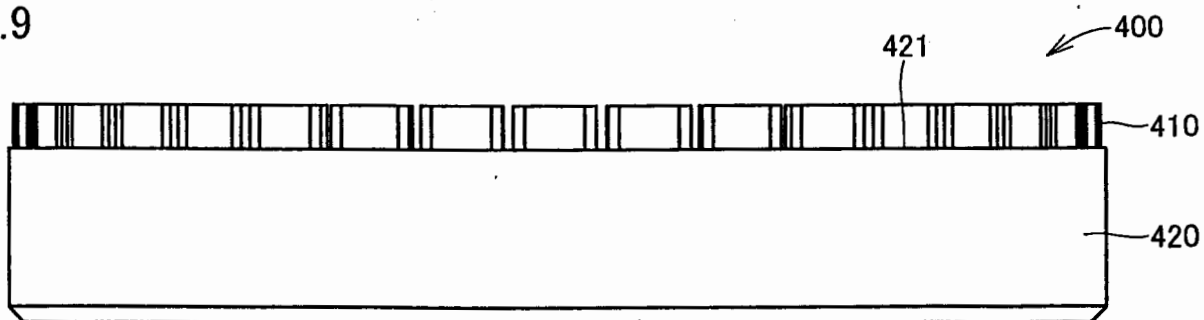


FIG.10

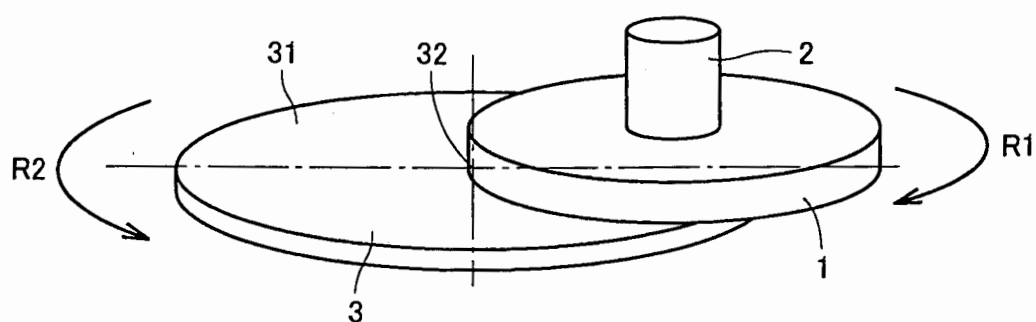


FIG.11

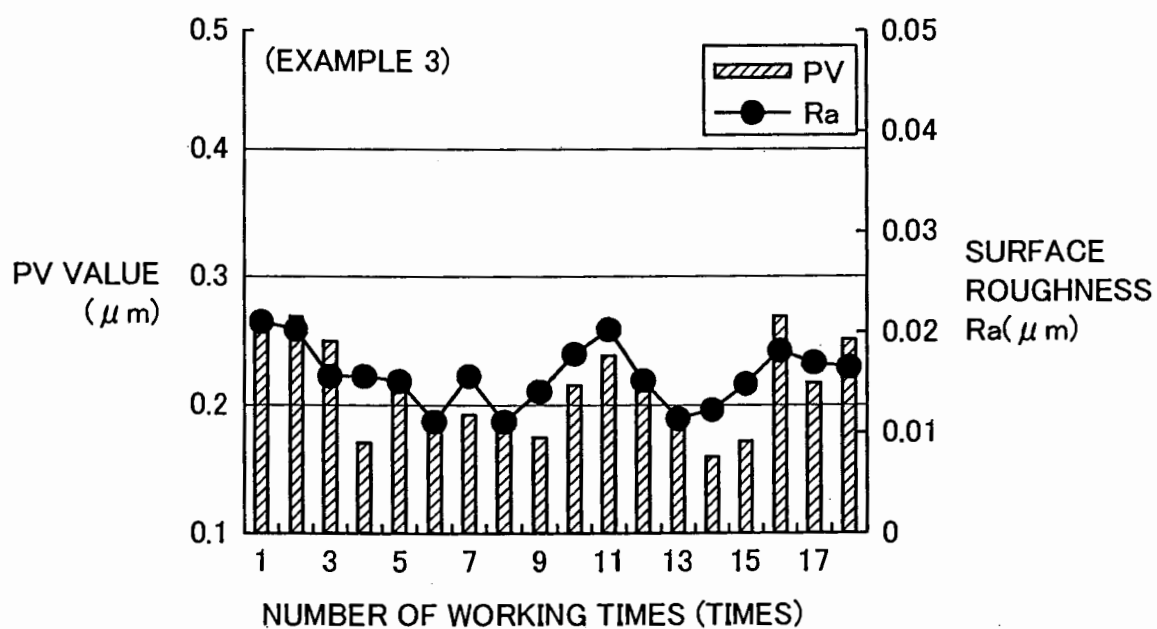


FIG.12

SURFACE
ROUGHNESS $Ra(\mu m)$

0.04

0.03

0.02

0.01

0

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

NUMBER OF WORKING TIMES (TIMES)

- ◆ V (VITRIFIED BOND: EXAMPLE 3)
- R (RESIN BOND: EXAMPLE 5)
- ▲ M (METAL BOND: EXAMPLE 6)
- × S (ELECTRO-DEPOSITION BOND: EXAMPLE 7)

FIG.13

GRINDING
RESISTANCE $F_n(N)$

8

7

6

5

4

3

2

1

0

1

2

3

4

5

6

7

8

9

10

11

12

13

14

15

NUMBER OF WORKING TIMES (TIMES)

- ◆ V (VITRIFIED BOND: EXAMPLE 3)
- R (RESIN BOND: EXAMPLE 5)
- ▲ M (METAL BOND: EXAMPLE 6)
- × S (ELECTRO-DEPOSITION BOND: EXAMPLE 7)

FIG.14

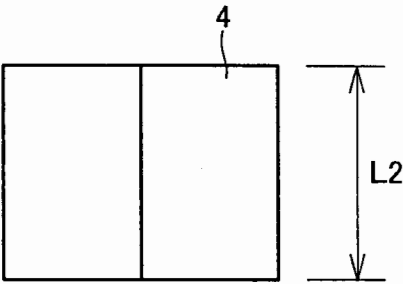


FIG.15

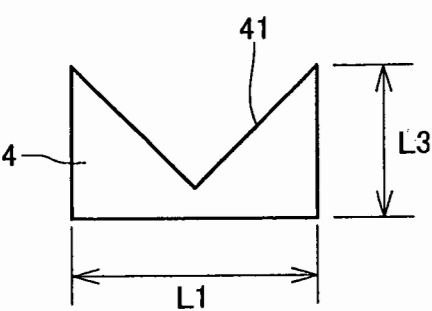


FIG.16

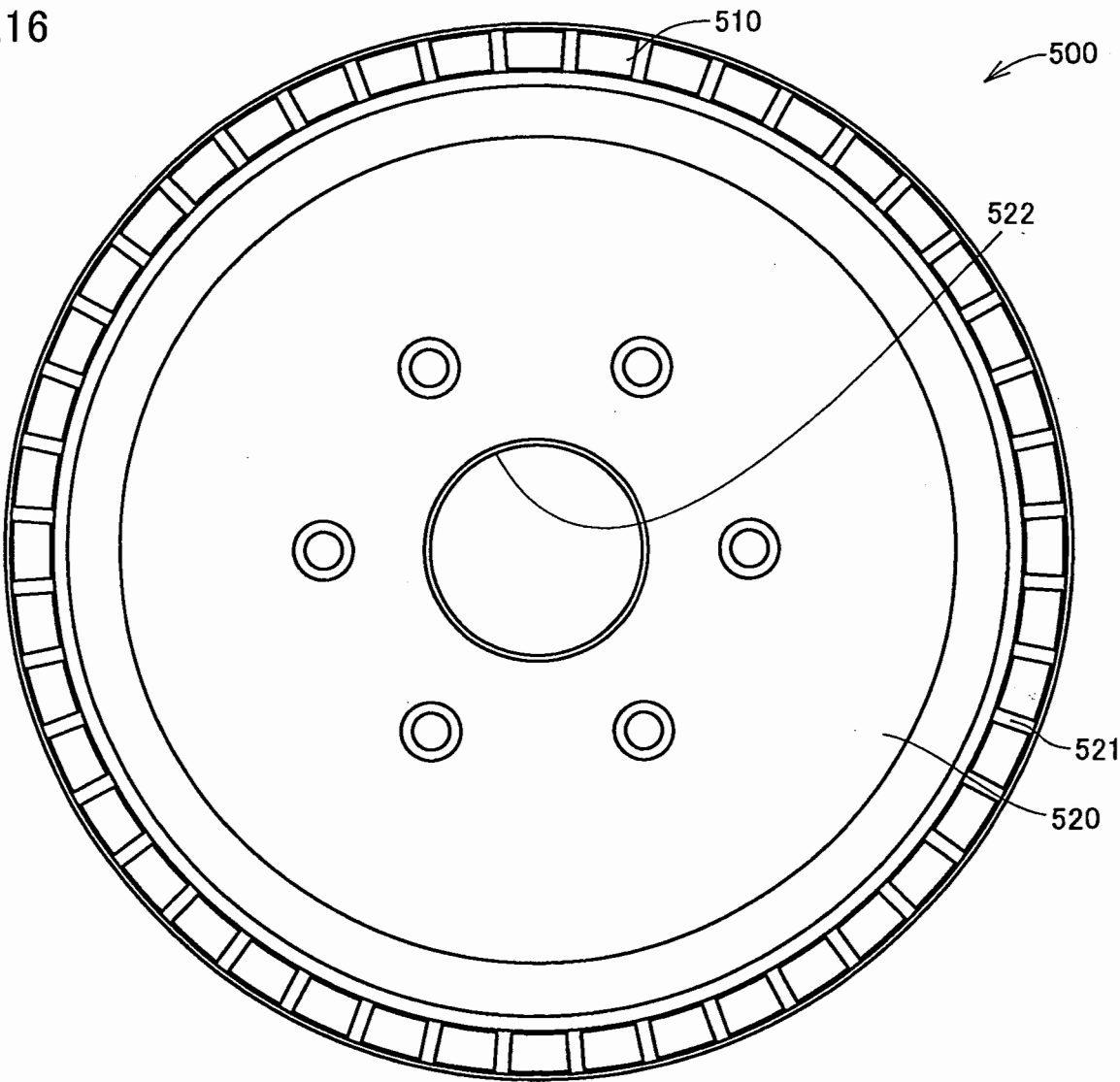


FIG.17

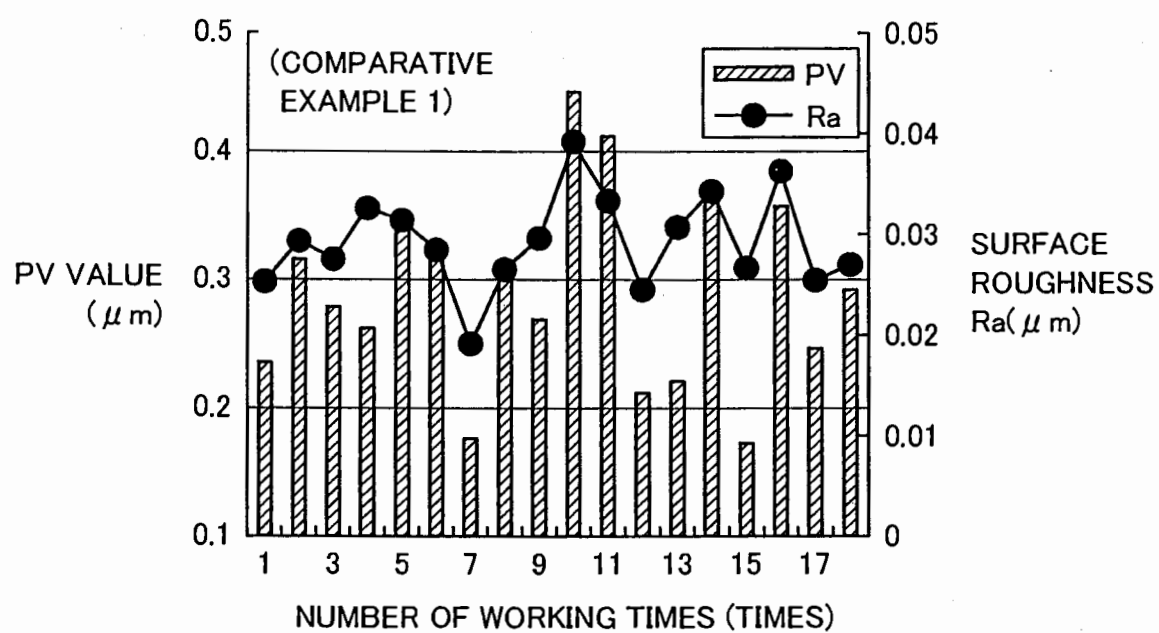


FIG.18

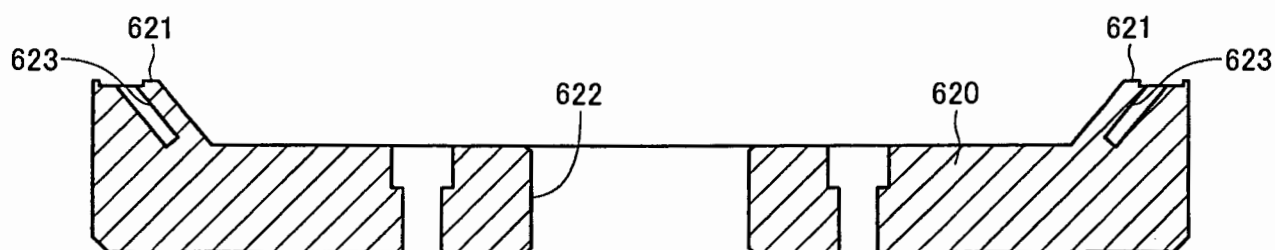


FIG. 19

