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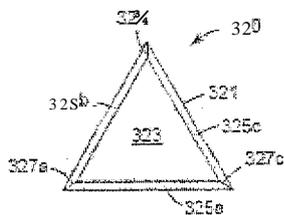


Fig. 6A

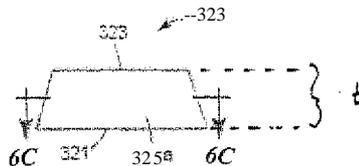


Fig. 6B

(57) **Abstract:** The present invention relates to a bonded abrasive article comprising specific shaped abrasive particles and a bonding medium comprising a vitreous bond. The present invention also relates to the use of an article according to the present invention in grinding applications, in particular in high performance grinding applications and to the use of an article according to the present invention for abrading a workpiece material particularly a workpiece material selected from steels, non-ferrous metals, and alloys. In addition, the present invention relates to a method for abrading a workpiece, the method comprising frictionally contacting at least a portion of an abrasive article according to the invention with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.

WO 2013/045251 A1

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BONDED ABRASIVE ARTICLE

The present invention relates to bonded abrasive articles, particularly those which are useful in high performance grinding.

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Abrasive machining using bonded abrasive articles (such as grinding wheels) continues to develop its capabilities. This development has created an increasing demand for high-performance grinding wheels: wheels which can remove material faster at exacting tight tolerances, but without causing damage at the workpiece, thus able to provide reductions in grinding cycle time and lower grinding costs per part.

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Bonded abrasive articles have abrasive particles bonded together by a bonding medium. The main types of bonding systems used to make bonded abrasive articles are: resinoid, vitrified, and metal. Resinoid bonded abrasives utilize an organic binder system (e.g., phenolic binder systems) to bond the abrasive particles together to form the shaped mass. Another major type are bonded abrasive articles (for example vitrified bonded wheels) in which a vitreous binder system is used to bond the abrasive particles together. These bonds are usually vitrified at temperatures between 700°C to 1500°C. Metal bonded abrasive articles typically utilize sintered or plated metal to bond the abrasive particles. Vitrified bonded abrasive articles are different from resinoid bonded abrasive articles in that they use a vitreous phase to bond the abrasive grain and thus are processed at substantially higher temperatures. Vitrified bonded abrasive articles can withstand higher temperatures in use and are generally more rigid and brittle than resinoid bonded wheels.

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Bonded abrasives are three-dimensional in structure and typically include a shaped mass of abrasive particles, held together by the binder. Such shaped mass can be, for example, in the form of a wheel, such as a grinding wheel. Ideal bonded abrasive articles have a long life time and are able to abrade the workpiece with constant cut over time. However, when the abrasive particles are worn and dulled, these abrasive particles are expelled from the bonded

abrasive to expose new, fresh cutting abrasive particles. In the ideal situation, the bonded abrasive article is self-sharpening. However, in reality, particularly, when the forces get high enough, the bonded abrasive articles can break down, breaking and ejecting grit particles and the grinding power drawn decreases beyond the starting value of the grinding application as the bonded abrasive article wears away rapidly and loses its preferred shape. Bonded abrasive articles therefore typically show cyclical grinding curves (grinding power consumption as a function of grinding time). At the end point of a grinding cycle dressing of the bonded abrasive article (such as a grinding wheel) has to be set up in order to avoid defects at the workpiece to be abraded and in order to provide for constant abrading performance of the bonded abrasive article. Dressing is typically performed using a dressing tool such as a diamond dressing tool. Frequent dressing cycles are undesirable since the production process has to be interrupted frequently which will add on costs, besides reducing service life of the wheel. What is desired in the industry is a bonded abrasive article requiring a minimum of dressing cycles resulting in a long total service life of the wheel. Such an article typically draws a minimum of power when operating.

Vitrified bonded grinding wheels incorporating irregularly shaped (for example, crushed) abrasive particles are known to be useful for abrading workpieces such as hardened and unhardened metal components. However, the dressing cycles of these abrasives articles can be more frequent than desired, i.e., resharpening has to be set up more frequently to avoid dulling of the grains. Sometimes constant grinding performance in terms of workpiece quality and/or long dressing cycles cannot be provided, particularly under severe grinding conditions, e.g., high feed rates. In particular, in case of a grinding cycle not having a phase of substantially constant grinding performance (for example in terms of material removal rate) over a period of time it can be difficult to achieve constant grinding results of the workpiece to be abraded.

What is desired in the industry is a bonded abrasive article, for example, a grinding wheel, that has an improved service life and can provide constant grinding results (particularly in terms of surface quality of the workpiece) over a long period of time, particularly under severe grinding conditions.

Surprisingly, it has been found that shaped abrasive particles in combination with a vitrified bond can provide abrasive articles which can solve the aforementioned problems. In particular, such articles have been found to be particularly effective in high performance grinding applications.

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The present invention relates to a bonded abrasive article comprising shaped abrasive particles and a bonding medium comprising a vitreous bond, said shaped abrasive particles each comprising a first side and a second side separated by a thickness t , wherein said first side comprises a first face having a perimeter of a first geometric shape. The thickness t is preferably equal to or smaller than the length of the shortest side-related dimension of the particle.

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Typically, the ratio of the length of the shortest side related dimension to the thickness of said particle is at least 1:1.

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The present invention also relates to the use of the bonded abrasive articles in high performance grinding applications and to a method for abrading a workpiece.

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FIG. 1 illustrates a graph of the grinding power consumption as a function of the grinding time for Type III Wheels of Example 1 (Examples 1A-1, 1A-2, 2A-1 and 3A-1 and Comparative Examples Ref. 1A-2, Ref. 2A-1, Ref. 3A-1, and Ref. 3A-2) using the conditions of Test Series (I).

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FIG. 2 illustrates a graph of the grinding power consumption as a function of the grinding time for the Type VII Wheels of Example I (Examples 1B-1, 1B-2, 2B-1 and 3B-1) using the conditions of Test Series (I).

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FIG. 3 illustrates a graph of the grinding power consumption as a function of the grinding time for Type III Wheels of Example 1 (Examples 1A-1, 1A-2, 2A-1 and 3A-1 and Comparative Examples Ref. 1A-2, Ref. 2A-1, Ref. 3A-1, and Ref. 3A-2) using the conditions of Test Series (II).

FIG. 4 illustrates a graph of the grinding power consumption as a function of the grinding time for Type VII Wheels of Example I (Examples 1B-1, 1B-2, 2B-1 and 3B-1) using the conditions of Test Series (II).

5 FIG. 5 shows a graph illustrating the surface roughness Ra obtained for Type III Wheels of Example I (Examples 1A-1, 1A-2, 2A-1, 3A-1, and Comparative Examples Ref. 1A-2, Ref. 2A-1, Ref. 3A-1, and Ref. 3A-2).

FIG. 6A is a schematic top view of exemplary shaped abrasive particle 320.

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FIG. 6B is a schematic side view of exemplary shaped abrasive particle 320.

FIG. 6C is a cross-sectional top view of plane 3-3 in FIG. 6B.

15 FIG. 6D is an enlarged view of side edge 327a in FIG. 6C.

While the above-identified drawing figures set forth several embodiments of the present disclosure, other embodiments are also contemplated, as noted in the discussion. The figures may not be drawn to scale. Like reference numbers may have been used throughout the figures to denote like parts.

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As used herein, forms of the words "comprise", "have", and "include" are legally equivalent and open-ended. Therefore, additional non-recited elements, functions, steps or limitations may be present in addition to the recited elements, functions, steps, or limitations.

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As used herein, the term "abrasive dispersion" means a precursor (in typical cases an alpha alumina precursor) that can be converted into an abrasive material (for example, alpha alumina) that is introduced into a mold cavity. The composition is referred to as an abrasive dispersion until sufficient volatile components are removed to bring about solidification of the abrasive dispersion.

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As used herein, the term "precursor shaped abrasive particle" means the unsintered particle produced by removing a sufficient amount of the volatile component from the abrasive

dispersion, when it is in the mold cavity, to form a solidified body that can be removed from the mold cavity and substantially retain its molded shape in subsequent processing operations.

5 As used herein, the term "shaped abrasive particle", means an abrasive particle with at least a portion of the abrasive particle having a predetermined shape that is replicated from a mold cavity used to form the shaped precursor abrasive particle. Except in the case of abrasive shards (e.g. as described in US Patent Application Publication Nos. 2009/0169816 and 2009/0165394), the shaped abrasive particle will generally have a predetermined geometric
10 shape that substantially replicates the mold cavity that was used to form the shaped abrasive particle. Shaped abrasive particle as used herein excludes abrasive particles obtained by a mechanical crushing operation.

As used herein, the term "nominal" means: of, being, or relating to a designated or
15 theoretical size and/or shape that may vary from the actual.

With respect to the three-dimensional shape of the abrasive particles in accordance with the present invention, the length shall mean the longest particle dimension, the width shall mean the maximum particle dimension perpendicular to the length. The thickness as referred to
20 herein is also typically perpendicular to length and width.

As used herein, the term "thickness", when applied to a particle having a thickness that varies over its planar configuration, shall mean the maximum thickness. If the particle is of substantially uniform thickness, the values of minimum, maximum, mean, and median
25 thickness shall be substantially equal. For example, in the case of a triangle, if the thickness is equivalent to "a", the length of the shortest side of the triangle is preferably at least "2a". in the case of a particle in which two or more of the shortest facial dimensions are of equal length, the foregoing relationship continues to hold. In most cases, the shaped abrasive particles are polygons having at least three sides, the length of each side being greater than
30 the thickness of the particle. In the special situation of a circle, ellipse, or a polygon having very short sides, the diameter of the circle, minimum diameter of the ellipse, or the diameter of the circle that can be circumscribed about the very short-sided polygon is considered to be the shortest facial dimension of the particle.

For further illustration, in case of a tetrahedral-shaped abrasive particle, the length would typically correspond to the side length of one triangle side, the width would be the dimension between the tip of one triangle side and perpendicular to the opposite side edge and the thickness would correspond to what is normally referred to as "height of a tetrahedron", that is, the dimension between the vertex and perpendicular to the base (or first side).

If an abrasive particle is prepared in a mold cavity having a pyramidal, conical, frusto-pyramidal, frusto-conical, truncated spherical, or a truncated spheroidal shape, the thickness is determined as follows: (1) in the case of a pyramid or cone, the thickness is the length of a line perpendicular to the base of the particle and running to the apex of the pyramid or cone; (2) in the case of a frusto-pyramid or frusto-cone, the thickness is the length of a line perpendicular to the center of the larger base of the frusto-pyramid or of the frusto-cone and running to the smaller base of the frusto-pyramid or of the frusto-cone; (3) in the case of a truncated sphere or truncated spheroid, the thickness is the length of a line perpendicular to the center of the base of the truncated sphere or truncated spheroid and running to the curved boundary of the truncated sphere or truncated spheroid.

The length of the shortest side-related dimension of the particle is the length of the shortest facial dimension of the base of the particle (if the particle has only one base, typically the first face) or the length of the shortest facial dimension of the larger base of the particle (if the particle has two bases, for example in cases where the second side comprises a second face).

As used herein in referring to shaped abrasive particles, the term "length" refers to the maximum dimension of a shaped abrasive particle. In some cases the maximum dimension may be along a longitudinal axis of the particle, although this is not a necessary requirement. "Width" refers to the maximum dimension of the shaped abrasive particle that is perpendicular to the length. "Thickness" refers to the dimension of the shaped abrasive particle that is perpendicular to the length and width.

As used herein the term "circular sector" or "circle sector" refers to the portion of a disk enclosed by two radii and an arc, including minor sectors and major sectors.

5 As used herein the term "circular segment" refers to an area of a circle informally defined as an area which is "cut off" from the rest of the circle by a secant or a chord. The circle segment constitutes the part between the secant and an arc, excluding the circle's center. This is commonly known as Meglio's Area.

10 As used herein the term "drop shape" is intended to refer to a shape having a perimeter (the path that surrounds the drop shape area) that can be described as consisting of one vertex and one curved line, wherein the vertex is formed at the point wherein the ends of the curved line meet.

15 As used herein the term "rhombus" refers to a quadrilateral having four edges of equal length and wherein opposing vertices have included angles of equal degrees as seen in FIGS. 1 and 3 of WO 201 1/068714.

20 As used herein the term "rhomboid" refers to a parallelogram wherein the two intersecting edges on one side of the longitudinal axis are of unequal lengths and a vertex between these edges has an oblique included angle as seen in FIG. 4 of WO 201 1/068714.

25 As used herein the term "kite", as seen in FIG. 5 of WO 201 1/068714, refers to a quadrilateral wherein the two opposing edges above a transverse axis are of equal length and the two opposing edges below the transverse axis are of equal length, but have a different length than the edges above the transverse axis. If one took a rhombus and moved one of the opposing major vertices either closer to or further away from the transverse axis a kite is formed.

30 As used herein the term "superellipse" refers to a geometric figure defined in the Cartesian coordinate system as the set of all points (x, y) defined by Lamé's curve having the formula

$$\left| \frac{x}{a} \right|^n + \left| \frac{y}{b} \right|^n = 1$$

where n , a and b are positive numbers. When n is between 0 and 1, the superellipse looks like a four-armed star with concave edges (without the scallops) as shown in FIG. 2 of WO 2011/068714. When n equals 1, a rhombus $a=b$ or a kite $a < b$ is formed. When n is between 1 and 2 the edges become convex.

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As used herein the term "secondary abrasive particles" is intended to generally refer to abrasive particles which differ from the shaped abrasive particles to be used in accordance with the present invention

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The term "hard materials" as used in the present invention is intended to refer to materials which can typically be characterized as having a Knoop Hardness of $3500 \text{ kg}_f/\text{mm}^2$ or less (typically, about 1500 to about $3000 \text{ kg}_f/\text{mm}^2$).

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The term "superhard materials" as used in the present invention is intended to refer to materials which can be typically characterized as having a Knoop Hardness of more than $3500 \text{ kg}_f/\text{mm}^2$ (typically, about 4000 to about $9000 \text{ kg}_f/\text{mm}^2$).

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The term "superabrasives" as used in the present invention is intended to refer to abrasive materials which can be typically characterized as having a Knoop Hardness of 4500 or more than $4500 \text{ kg}_f/\text{mm}^2$ (typically 4700 to about $9000 \text{ kg}_f/\text{mm}^2$).

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Most oxide ceramics have a Knoop hardness in the range of 1000 to $1500 \text{ kg}_f/\text{mm}^2$ (10 – 15 GPa), and many carbides are over $2000 \text{ kg}_f/\text{mm}^2$ (20 GPa). The method for determining Knoop Hardness is specified in ASTM C849, C1326 & E384.

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The present invention relates to a bonded abrasive article comprising specific shaped abrasive particles (which can be typically characterized as thin bodies) and a bonding medium comprising a vitreous bond. The present invention also relates to the use of an article according to the present invention in grinding applications, in particular in high performance grinding applications and to the use of an article according to the present invention for abrading a workpiece material particularly a workpiece material selected from steels, non-ferrous metals, and alloys. In addition, the present invention relates to a method for abrading a workpiece, the method comprising frictionally contacting at least a portion of

an abrasive article according to the invention with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article (while in contact) to abrade at least a portion of the surface of the workpiece.

5 In accordance with the present invention, the bonded abrasive article comprises shaped abrasive particles. Three basic technologies that have been employed to produce abrasive grains having a specified shape are (1) fusion, (2) sintering, and (3) chemical ceramic.

10 Any one of these basic technologies or any combination of two or all of these technologies may be used in order to provide shaped abrasive particles for use in the present invention.

The materials that can be made into shaped abrasive particles of the invention include any suitable hard or superhard material known to be suitable for use as an abrasive particle.

15 Accordingly, in one embodiment, the shaped abrasive particles comprise a hard abrasive material. In another embodiment, the shaped abrasive particles comprise a superhard abrasive material. In yet other embodiments, the shaped abrasive particles comprise a combination of hard and superhard materials.

20 Specific examples of suitable abrasive materials include known ceramic materials, carbides, nitrides and other hard and superhard materials such as aluminum oxide (for example alpha alumina) materials (including fused, heat treated, ceramic and sintered aluminum oxide materials), silicon carbide, titanium diboride, titanium nitride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride (CBN), garnet, alumina-zirconia,
25 sol-gel derived abrasive particles, cerium oxide, zirconium oxide, titanium oxide or a combination thereof.

The most useful of the above are typically based on aluminum oxide, and in the specific descriptions that follow the invention may be illustrated with specific reference to aluminum
30 oxide. It is to be understood, however, that the invention is not limited to aluminum oxide but is capable of being adapted for use with a plurality of different hard and superhard materials.

With respect to the three basic technologies for preparing shaped abrasive particles (i.e., fusion, sintering and chemical ceramic technologies), in the present invention, the shaped abrasive particles may be based on one or more material(s) prepared by any one of these technologies, i.e. on one or more fused, sintered or ceramic materials, with a preferred material being aluminum oxide (preferably alpha aluminum oxide). In other words, preferred shaped abrasive particles according to the invention are based on alumina, i.e. such particles either consist of alumina or are comprised of a major portion thereof, such as for example greater than 50%, for example 55 to 100%, or 60 to 80%, more preferably 85 to 100% by weight of the total weight of the abrasive particle. The remaining portion may comprise any material which will not detract from the shaped abrasive particle acting as an abrasive, including but not limited to hard and superhard materials as outlined in the foregoing. In some preferred embodiments, the shaped abrasive particles consist of 100% aluminum oxide. In yet other preferred embodiments, the shaped abrasive particles comprise at least 60% by weight aluminum oxide or at least 70% by weight of aluminum oxide. Useful shaped abrasive particles may, for example, include but are not limited to particles which comprise a major portion (for example 50% or more and preferably 55% or more by weight) of fused aluminum oxide and a minor portion (for example, less than 50% and preferably less than 45 % by weight) of an abrasive material different from fused aluminum oxide (for example zirconium oxide).

It is also within the scope of the present invention to use abrasive particles that have a surface coating for example of inorganic particles thereon. Surface coatings on the shaped abrasive particles may be used to improve the adhesion between the shaped abrasive particles and a binder material in abrasive articles, or can be used to aid in electrostatic deposition of the shaped abrasive particles. In one embodiment, surface coatings as described in U.S. Patent No. 5,352,254 (Celikkaya) in an amount of 0.1 to 2 percent surface coating to shaped abrasive particle weight may be used. Such surface coatings are described in U.S. Patent Nos. 5,213,591 (Celikkaya et al.); 5,011,508 (Wald et al.); 1,910,444 (Nicholson); 3,041,156 (Rowse et al.); 5,009,675 (Kunz et al.); 5,085,671 (Martin et al.); 4,997,461 (Markhoff-Matheny et al); and 5,042,991 (Kunz et al.). Additionally, the surface coating may prevent the shaped abrasive particle from capping. Capping is the term to describe the phenomenon where metal particles from the workpiece being abraded become

welded to the tops of the shaped abrasive particles. Surface coatings to perform the above functions are known to those skilled in the art.

5 In the present invention, it is preferred to use shaped abrasive particles produced by chemical ceramic technology, i.e., ceramic shaped abrasive particles. However, the present invention is not limited to the use of such particles.

In one embodiment, the ceramic shaped abrasive particles comprise alpha alumina, i.e. the particles are alpha alumina based ceramic shaped particles.

10 In one embodiment, the ceramic shaped abrasive particles comprise sol-gel derived alumina based abrasive particles. Both seeded and non-seeded sol-gel derived alumina based abrasive particles can be suitably used in accordance with the present invention. However, in some instances, it may be preferred to use non-seeded sol-gel derived alumina based abrasive particles.

15 The shaped abrasive particles of the present invention each have a substantially precisely formed three-dimensional shape. Typically, the shaped abrasive particles generally have a predetermined geometric shape, for example one that substantially replicates the mold cavity that was used to form the shaped abrasive particle.

20 Typically, the shaped abrasive particles can be characterized as thin bodies. As used herein the term thin bodies is used in order to distinguish from elongated or filamentary particles (such as rods), wherein one particle dimension (length, longest particle dimension) is substantially greater than each of the other two particle dimensions (width and thickness) as
25 opposed to particle shapes useful in the present invention wherein the three particle dimensions (length, width and thickness as defined herein) are either of the same order of magnitude or two particle dimensions (length and width) are substantially greater than the remaining particle dimension (thickness). Conventional filamentary abrasive particles can be characterized by an aspect ratio, that is the ratio of the length (longest particle dimension) to
30 the greatest cross-sectional dimension (the greatest cross-sectional dimension perpendicular to the length) of from about 1:1 to about 50:1, preferably of from about 2:1 to about 50:1 and more typically greater than about 5:1 to about 25:1. Furthermore, such conventional filamentary abrasive particles are characterized by a cross-sectional shape (the shape of a

cross section taken perpendicular to the length or longest dimension of the particle) which does not vary along the length.

5 in contrast hereto, shaped abrasive particles according to the present invention can be typically characterized by a cross-sectional shape that varies along the length of the particle. Variations can be based on size of the cross-sectional shape or on the form of the cross-sectional shape.

10 The abrasive particles generally each comprise a first side and a second side separated by a thickness t . The first side generally comprises (and more typically is) a first face (in typical cases a planar face) having a perimeter of a first geometric shape.

15 Preferably, the thickness t is equal to or smaller than the length of the shortest side-related dimension of the particle (the shortest dimension of the first side and the second side of the particle; the length of the shortest side-related dimension of the particle may also be referred to herein as the length of the shortest facial dimension of the particle).

20 In typical cases, the second side comprises a vertex separated from the first side by thickness t , or the second side comprises a ridge line separated from the first side by thickness t , or the second side comprises a second face separated from the first side by thickness t . For example, the second side may comprise a vertex and at least one sidewall connecting the vertex and the perimeter of the first face (illustrative examples include pyramidal shaped particles, for example tetrahedral-shaped particles). Alternatively, the second side may comprise a ridge line and at least one sidewall connecting the ridge line and the perimeter of
25 the first face (illustrative examples include roof-shaped particles). Alternatively, the second side may comprise a second face and at least one sidewall (which may be a sloping sidewall) connecting the second face and the first face (illustrative examples include triangular prisms or truncated pyramids).

30 Blends of different shaped abrasive particles in accordance with the present invention can be used in the bonded abrasive articles of the present invention. A blend of shaped abrasive particles can comprise a first plurality of shaped abrasive particles in accordance with the present invention and a second plurality of shaped abrasive particles in accordance with the

present invention wherein the particles of the first plurality are different from the second plurality. Differences can for example be selected based on the shape or grade or chemical composition of the abrasive particle.

5 The thickness t may be the same (for example in embodiments wherein the first and second sides comprise parallel planar faces) or vary over the planar configuration of the particle (for example in embodiments wherein one or both of the first and second sides comprise non-planar faces or in embodiments wherein the second side comprises a vertex or a ridge line as discussed in more detail later herein).

10

In most cases, the ratio of the length of the shortest side-related dimension of the shaped abrasive particle to the thickness of the shaped abrasive particle is at least 1:1 but can range from 1:1 to 10:1, more preferably from 2:1 to 8:1 and most preferably from 3:1 to 6:1. This ratio is also referred to herein as primary aspect ratio.

15

The dimension of the thickness of the particles is not particularly limited. For example in typical cases, the thickness can be about 5 micrometers or more, or about 1.0 micrometers or more, or about 25 micrometers or more, or about 30 micrometers or more, or even about 200 micrometers or more. The upper limit of the thickness can be selected to be about 4 mm or less, or about 3 mm or less for large particles, or about 1600 micrometers or less, or about 20 micrometers or less, or about 1200 micrometers or less, or about 100 micrometers or less, or about 500 micrometers or less or about 300 micrometers or less or even about 200 micrometers or less.

20

The shaped abrasive particles are typically selected to have a length in a range of from 0.001 mm to 26 mm, more typically 0.1 mm to 10 mm, and more typically 0.5 mm to 5 mm, although other lengths may also be used. In some embodiments, the length may be expressed as a fraction of the thickness of the bonded abrasive article in which it is contained. For example, the shaped abrasive particle may have a length greater than half the thickness of the bonded abrasive wheel. In some embodiments, the length may be greater than the thickness of the bonded abrasive wheel.

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The shaped abrasive particles are typically selected to have a width in a range of from 0.001 mm to 26 mm, more typically 0.1 mm to 10 mm, and more typically 0.5 mm to 5 mm, although other dimensions may also be used.

5 The shaped abrasive particles can have various volumetric aspect ratios. The volumetric aspect ratio is defined as the ratio of the maximum cross sectional area passing through the centroid of a volume divided by the minimum cross sectional area passing through the centroid.

10 For some shapes, the maximum or minimum cross sectional area may be a plane tipped, angled, or tilted with respect to the external geometry of the shape. For example, a sphere would have a volumetric aspect ratio of 1.000 while a cube will have a volumetric aspect ratio of 1.414. A shaped abrasive particle in the form of an equilateral triangle having each side equal to length A and a uniform thickness equal to A will have a volumetric aspect ratio
15 of 1.54, and if the uniform thickness is reduced to 0.25 A, the volumetric aspect ratio is increased to 2.64. It is believed that shaped abrasive particles having a larger volumetric aspect ratio have enhanced cutting performance.

In various embodiments of the invention, the volumetric aspect ratio for the shaped abrasive
20 particles can be greater than about 1.15, or greater than about 1.50, or greater than about 2.0, or between about 1.15 to about 10.0, or between about 1.20 to about 5.0, or between about 1.30 to about 3.0.

The abrasive particles are preferably in the shape of thin three-dimensional bodies having various three-dimensional shapes. Typical examples include particles (typically, thin bodies)
25 in the form of flat triangles, fiat rectangles, flat triangles which have at least one face and more preferably two faces that is/are shaped inwardly (for example recessed or concave), as discussed in more detail later herein.

The first side generally comprises (and more typically is) a first face having a perimeter of a
30 first geometric shape.

For example, the first geometric shape can be selected from geometric shapes having at least one vertex, more typically two or more, preferably three or more, most preferably three or four vertices.

5 Suitable examples for geometric shapes having at least one vertex include polygons (including equilateral, equiangular, star-shaped, regular and irregular polygons), lense-shapes, lune-shapes, circular shapes, semicircular shapes, oval shapes, circular sectors, circular segments, drop-shapes and hypocycloids (for example super elliptical shapes).
Specific examples for suitable polygonal geometric shapes include triangular shapes and
10 quadrilateral shapes (for example a square, a rectangle, a rhombus, a rhomboid, a trapezoid, a kite, or a superellipse).

The vertices of suitable quadrilateral shapes can be further classified as a pair of opposing major vertices that are intersected by a longitudinal axis and a pair of opposing minor
15 vertices located on opposite sides of the longitudinal axis. Shaped abrasive particles having a first side having this type of quadrilateral shape can be characterized by an aspect ratio of a maximum length along a longitudinal axis divided by the maximum width transverse to the longitudinal axis of 1.3 or greater, preferably 1.7 to about 5. This aspect ratio is also referred to herein as secondary aspect ratio.

20 In some embodiments it is particularly preferred that the first geometric shape is selected from triangular shapes, such as an isosceles triangular shape or, more preferably, an equilateral triangular shape.

25 In other embodiments, the first geometric shape is selected from quadrilateral shapes, preferably from the group of a square, a rectangle, a rhombus, a rhomboid, a trapezoid, a kite, or a superellipse, more preferably from the group of a rectangle, a rhombus, a rhomboid, a kite or a superellipse.

30 For the purposes of this invention geometric shapes are also intended to include regular or irregular polygons or stars wherein one or more edges (parts of the perimeter of the face) can be arcuate (either of towards the inside or towards the outside, with the first alternative being preferred). Hence, for the purposes of this invention, triangular shapes also include three-

sided polygons wherein one or more of the edges (parts of the perimeter of the face) can be arcuate, i.e., the definition of triangular extends to spherical triangles and the definition of quadrilaterals extends to superellipses.

- 5 The second side may comprise (and preferably is) a second face. The second face may have a perimeter of a second geometric shape.

10 The second geometric shape may be the same or be different to the first geometric shape. Preferably the second geometric shape is selected to have substantially the same shape as the first geometric shape and is preferably arranged in a congruent way with the first geometric shape (although the size or area of the geometric shapes may be different, i.e. the one face may be larger than the other one).

15 In other words, as used herein the terms "substantially the same shape" or "substantially identical shapes" are intended to include the case wherein the area encompassed by said shapes may be different in size.

20 As used herein with respect to the preferred case of substantially identical first and second geometric shapes, the term "arranged in a congruent way with the first geometric shape" is intended to include the case wherein the first and the second geometric shapes are slightly rotated against each other, although it is preferred that said substantially identical first and second geometric shapes are perfectly aligned or only slightly rotated against each other. The degree (or angle of rotation) depends on the particular geometric shape of the first face and of the second face and the thickness of the particle. Acceptable angles of rotation may range from 0 to +/-30 degrees, preferably from 0 to +/- 15, more preferably from 0 to +/- 10 degrees. Most preferably, the angle of rotation is about 0 degrees (for example 0 +/- 5 degrees).

30 Examples of suitable geometric shapes of the perimeter of the second face include shapes as exemplified in the foregoing with respect to the first geometric shapes.

It is particularly preferred that the first and preferably also the second geometric shape is selected from triangular shapes, such as an isosceles triangular shape or, more preferably, an equilateral triangular shape.

5 The first face may be substantially planar or the second face (if present) may be substantially planar. Also, both faces may be substantially planar. In many typical cases, the first face is planar (and identical to the first side).

Alternatively, at least one of the first and the second face (if present) may be a non-planar face. Also both faces may be non-planar faces.

10 For example, one or both of the first and the second face (if present) could be shaped inwardly (for example recessed or concave) or could be shaped outwardly (for example convex).

15 For example, the first face (or the second face, if present) can be shaped inwardly (for example be recessed or concave) and the second face (if present, or the first face) can be substantially planar. Alternatively, the first face (or the second face, if present) can be shaped outwardly (for example be convex) and the second face (if present, or the first face) can be shaped inwardly (for example be recessed or concave), or, the first face can be shaped
20 inwardly (for example be recessed or concave) and the second face (if present) can also be shaped inwardly (for example be recessed or concave).

The first face and the second face (if present) can be substantially parallel to each other. Alternatively, the first face and the second face (if present) can be nonparallel, for example
25 such that imaginary lines tangent to each face would intersect at a point (as in the exemplary case wherein one face is sloped with respect to the other face).

The second face is typically connected to the perimeter of the first face by at least one sidewall which may be a sloping sidewall, as will be discussed later in more detail. The
30 sidewall may comprise one or more facets, which are typically selected from quadrilateral facets.

Specific examples of shaped particles having a second face include prisms (for example triangular prisms) and truncated pyramids.

5 In some embodiments, the second side comprises a second face and four facets that form a sidewall (draft angle α between the sidewall and the second face equals 90 degrees) or a sloping sidewall (draft angle α between the sidewall and the second face greater than 90 degrees). As the thickness, t , of the shaped abrasive particle having a sloping sidewall becomes greater, the shaped abrasive particle resembles a truncated pyramid when the draft angle α is greater than 90 degrees.

10 The shaped abrasive particles can comprise at least one sidewall, which may be a sloping sidewall. Typically, the first face and the second face are connected to each other by the at least one sidewall.

15 In other embodiments the ridge line and the first face are connected to each other by the at least one sidewall.

In even other embodiments, the vertex and the first face are connected to each other by the at least one sidewall.

20 In some embodiments, more than one (for example two or three) sloping sidewall can be present and the slope or angle for each sloping sidewall may be the same or different. In some embodiments, the first face and the second face are connected to each other by a sidewall. In other embodiments, the sidewall can be minimized for particles where the faces taper to a thin edge or point where they meet instead of having a sidewall.

25 The sidewall can vary and it generally forms the perimeter of the first face and the second face (if present). In case of a sloping sidewall, it forms a perimeter of the first face and a perimeter of the second face (if present). In one embodiment, the perimeter of the first face and the second face is selected to be a geometric shape (preferably a triangular shape), and the first face and the second face are selected to have the same geometric shape, although, they may differ in size with one face being larger than the other face.

A draft angle alpha between the second face and the sloping sidewall of the shaped abrasive particle can be varied to change the relative sizes of each face. In various embodiments of the invention, the area or size of the first face and the area or size of the second face are substantially equal. In other embodiments of the invention, the first face or second face can
5 be smaller than the other face.

In one embodiment of the invention, draft angle alpha can be approximately 90 degrees such that the area of both faces are substantially equal. In another embodiment of the invention, draft angle alpha can be greater than 90 degrees such that the area of the first face is greater
10 than the area of the second face. In another embodiment of the invention, draft angle alpha can be less than 90 degrees such that the area of the first face is less than the area of the second face. In various embodiments of the invention, the draft angle alpha can be between approximately 95 degrees to approximately 130 degrees, or between about 95 degrees to about 125 degrees, or between about 95 degrees to about 120 degrees, or between about 95
15 degrees to about 115 degrees, or between about 95 degrees to about 110 degrees, or between about 95 degrees to about 105 degrees, or between about 95 degrees to about 100 degrees.

The first face and the second face can also be connected to each other by at least a first sloping sidewall having a first draft angle and by a second sloping sidewall having a second
20 draft angle, which is selected to be a different value from the first draft angle. In addition, the first and second faces may also be connected by a third sloping sidewall having a third draft angle, which is a different value from either of the other two draft angles. In one embodiment, the first, second and third draft angles are all different values from each other. For example, the first draft angle could be 120 degrees, the second draft angle could be 110
25 degrees, and the third draft angle could be 100 degrees.

Similar to the case of an abrasive particle having one sloping sidewall, the first, second, and third sloping sidewalls of the shaped abrasive particle with a sloping sidewall can vary and they generally form the perimeter of the first face and the second face.
30

In general, the first, second, and third, draft angles between the second face and the respective sloping sidewall of the shaped abrasive particle can be varied with at least two of the draft angles being different values, and desirably all three being different values. In

various embodiments of the invention, the first draft angle, the second draft angle, and the third draft angle can be between about 95 degrees to about 130 degrees, or between about 95 degrees to about 125 degrees, or between about 95 degrees to about 120 degrees, or between about 95 degrees to about 115 degrees, or between about 95 degrees to about 110 degrees, or
5 between about 95 degrees to about 105 degrees, or between about 95 degrees to about 100 degrees.

The sloping sidewall can also be defined by a radius, R, instead of the draft angle alpha (as illustrated in Fig 5B of US Patent Application No. 2010/0151 196). The radius, R, can be
10 varied for each of the sidewalls.

Additionally, the various sloping sidewalls of the shaped abrasive particles can have the same draft angle or different draft angles. Furthermore, a draft angle of 90 degrees can be used on one or more sidewalls. However, if a shaped abrasive particle with a sloping
15 sidewall is desired, at least one of the sidewalls is a sloping sidewall having a draft angle of about greater than 90 degrees, preferably 95 degrees or greater.

The sidewall can be precisely shaped and can be for example either concave or convex. Alternatively, the sidewall (top surface) can be uniformly planar. By uniformly planar it is
20 meant that the sidewall does not have areas that are convex from one face to the other face, or areas that are concave from one face to the other face. For example, at least 50%, or at least 75%, or at least 85% or more of the sidewall surface can be planar. The uniformly planar sidewall provides better defined (sharper) edges where the sidewall intersects with the first face and the second face, and this is also thought to enhance grinding performance.

25 The sidewall may also comprise one or more facets, which are typically selected from triangular and quadrilateral facets or a combination of triangular and quadrilateral facets.

The angle beta between the first side and the sidewall can be between 20 degrees to about 50
30 degrees, or between about 10 degrees to about 60 degrees, or between about 5 degrees to about 65 degrees.

The second side may comprise a ridge line. The ridge line is typically connected to the perimeter of the first face by at least one sidewall which may be a sloping sidewall, as discussed in the foregoing. The sidewall may comprise one or more facets, which are typically selected from triangular and quadrilateral facets or a combination of triangular and quadrilateral facets.

The ridge line may be substantially parallel to the first side. Alternatively, the ridge line may be non-parallel to the first side, for example such that an imaginary line tangent to the ridge line would intersect the first side at a point (as in the exemplary case wherein the ridge line is sloped with respect to the first face).

The ridge line may be straight lined or may be non-straight lined, as in the exemplary case wherein the ridge line comprises arcuate structures.

The facets may be planar or non-planar. For example at least one of the facets may be non-planar, such as concave or convex. In some embodiments, all of the facets can be non-planar facets, for example concave facets.

Specific examples of shaped particles having a ridge line include roof-shaped particles, for example particles as illustrated in Fig. 4A to 4C of WO 2011/068714). Preferred roof-shaped particles include particles having the shape of a hip roof, or hipped roof (a type of roof wherein any sidewalls facets present slope downwards from the ridge line to the first side. A hipped roof typically does not comprise vertical sidewall(s) or facet(s)).

In some embodiments, the first geometric shape is selected from a quadrilateral having four edges and four vertices (for example from the group consisting of a rhombus, a rhomboid, a kite, or a superellipse) and the second side comprises a ridge line and four facets forming a structure similar to a hip roof. Thus, two opposing facets will have a triangular shape and two opposing facets will have a trapezoidal shape.

The second side may comprise a vertex and at least one sidewall connecting the vertex and the perimeter of the first face. The at least one sidewall may be a sloping sidewall, as discussed in the foregoing. The sidewall may comprise one or more facets, which are

typically selected from triangular facets. The facets may be planar or non-planar. For example at least one of the facets may non-planar, such as concave or convex. In some embodiments, all of the facets can be non-planar facets, for example concave facets.

5 Illustrative examples include pyramidal-shaped particles, for example tetrahedral-shaped particles or particles as illustrated in Fig. 1A to 1C and Fig. 2A to 2C of WO 2011/068714. The thickness, t , of the shaped abrasive particles can be controlled to select an angle, β , between the first side and the sidewall (or facets). In various embodiments of the invention, the angle β between the first side and the sidewall (or facets) can be between 20 degrees
10 to about 50 degrees, or between about 10 degrees to about 60 degrees, or between about 5 degrees to about 65 degrees.

In typical embodiments the second side comprises a vertex and a sidewall comprising and more typically consisting of triangular facets forming a pyramid. The number of facets
15 comprised by the sidewall will depend on the number of edges present in the first geometric shape (defining the perimeter of the first face). For example, pyramidal shaped abrasive particles having a first side characterized by a trilateral first geometric shape will generally have three triangular facets meeting in the vertex thereby forming a pyramid, and pyramidal
20 shaped abrasive particles having a first side characterized by a quadrilateral first geometric shape will generally have four triangular facets meeting in the vertex thereby forming a pyramid, and so on.

In some embodiments, the second side comprises a vertex and four facets forming a pyramid. In exemplary embodiments, the first side of the shaped abrasive particle comprises
25 a quadrilateral first face having four edges and four vertices with the quadrilateral preferably being selected from the group consisting of a rhombus, a rhomboid, a kite, or a superellipse. The shape of the perimeter of the first face (i.e., the first geometric shape) can be preferably selected from the above groups since these shapes will result in a shaped abrasive particle with opposing major vertices along the longitudinal axis and in a shape that tapers from the
30 transverse axis toward each opposing major vertex.

The degree of taper can be controlled by selecting a specific aspect ratio for the particle as defined by the maximum length, L , along the longitudinal axis divided by the maximum

width, W, along the transverse axis that is perpendicular to the longitudinal axis. This aspect ratio (also referred to herein as "secondary aspect ratio") should be greater than 1.0 for the shaped abrasive particle to taper as may be desirable in some applications. In various embodiments of the invention, the secondary aspect ratio is between about 1.3 to about 10,
5 or between about 1.5 to about 8, or between about 1.7 to about 5. As the secondary aspect ratio becomes too large, the shaped abrasive particle can become too fragile.

In some embodiments, it is possible to slightly truncate one or more of the vertices as shown by dashed lines 42 in FIG. 1 of WO 2011/068714 and mold the shaped abrasive particles
10 into such a configuration. In these embodiments, if the edges where the truncation occurs can be extended to form one or more imaginary vertices that then completes the claimed quadrilateral, the first side is considered to be the claimed shape. For example, if both of the major opposing vertices were truncated, the resulting shape would still be considered to be a rhombus because when the edges are extended past the truncation they form two imaginary
15 vertices thereby completing the rhombus shape for the first side.

Another exemplary class of shaped abrasive particles having a second side comprising a vertex are tetrahedral shaped particles. A tetrahedral shape generally comprises four major sides joined by six common edges, wherein one of the four major sides contacts three other
20 of the four major sides, and wherein the six common edges have substantially the same length. According to the definitions used herein a tetrahedral shape can be characterized by a first side comprising an equilateral triangle as a first face and a second side comprising a vertex and a sidewall comprising three equilateral triangles as facets connecting the first face and the vertex, thereby forming a tetrahedron.

At least one of the four major sides (i.e. the group consisting of the first side and the three facets) can be substantially planar. At least one of the four major sides can be concave, or all the four major sides can be concave. At least one of the four major sides can be convex or all the four major sides can be convex.

The shaped particles of this embodiment typically have tetrahedral symmetry. The shaped abrasive particles of this embodiment are preferably substantially shaped as regular tetrahedrons.

5 It is preferred that the shaped abrasive particles comprise at least one shape feature selected from: an opening (preferably one extending or passing through the first and second side); at least one recessed (or concave) face or facet; at least one face or facet which is shaped outwardly (or convex); at least one side comprising a plurality of grooves; at least one fractured surface; a low roundness factor (as described later herein); a perimeter of the first face comprising one or more corner points having a sharp tip; a second side comprising a second face having a perimeter comprising one or more corner points having a sharp tip; or a combination of one or more of said shape features.

10 In preferred embodiments the shaped abrasive particles comprise at least one of the aforementioned shape features in combination with a substantially triangular shape of the perimeter of the first and optionally the second face.

15 in other preferred embodiments the shaped abrasive particles comprise at least one of the aforementioned shape features in combination with a substantially quadrilateral first geometric shape.

20 In other preferred embodiments, the shaped abrasive particle comprises a combination of two or more (for example, of three, four, five or more) of the recited shape features. For example, the abrasive particle can comprise an opening and a first face that is shaped outwardly (or convex) and a recessed (or concave) second face; a second face comprising a plurality of grooves and a low roundness factor; or an opening and a first face that is shaped outwardly (or convex) and a recessed (or concave) second face.

25 The shaped abrasive particles preferably have a perimeter of the first and optionally of the second face that comprises one or more corner points having a sharp tip. Preferably, all of the corner points comprised by the perimeter(s) have sharp tips. The shaped abrasive particles preferably also have sharp tips along any edges that may be present in a sidewall
30 (for example between two meeting facets comprised by a sidewall).

The sharpness of a corner point can be characterized by the radius of curvature along said corner point, wherein the radius extends to the interior side of the perimeter (as illustrated for the exemplary shaped abrasive particle shown in Fig. 6D).

5 In various embodiments of the invention, the radius of curvature (also referred to herein as average tip radius) can be less than 75 microns, or less than 50 microns, or less than 25 microns. It is believed that a sharper edge promotes more aggressive cutting and improved fi-acturing of the shaped abrasive particles during use.

10 A smaller radius of curvature means that the particle more perfectly replicates the edge or corner features of the mold used to prepare the particle (i.e. of the ideal shape of the particle), i.e. the shaped abrasive particles are much more precisely made. Typically, shaped abrasive articles (in particular, ceramic shaped abrasive particles) made by using a mold of the desired shape provide more precisely made particles than methods based on other
15 methods for preparing shaped abrasive particles, such as methods based on pressing, punching or extruding.

FIGS. 6C-6D show the radius of curvature 329a for sidewall edge 327a. In general, the smaller the radius of curvature, the sharper the sidewall edge will be.

20 The shaped abrasive particles may comprise an opening. The opening can pass completely through the first side and the second side. Alternatively, the opening can comprise a blind hole which may not pass completely through both sides.

25 In one embodiment, the size of the opening can be quite large relative to the area defined by the perimeter of the first face or the second face (if present).

The opening can comprise a geometric shape which may be the same or a different geometric shape than that of the first geometric shape and the second geometric shape.

30 An opening ratio of the opening area divided by the face area of the larger of either the first face or the second face can be between about 0.05 to about 0.95[^] or between about 0.1 to about 0.9, or between about 0.1 to about 0.7, between about 0:05 to about 0.5, or between

about 0.05 to about 0.3. For the purposes of this calculation, the face area is based on the area enclosed by the perimeter without subtracting any area due to the opening.

5 Shaped abrasive particles with an opening can have several benefits over solid, shaped abrasive particles without an opening. First, the shaped abrasive particles with an opening have an enhanced cut rate as compared to solid, shaped abrasive particles. Shaped abrasive particles having a larger opening relative to the face size may have enhanced grinding performance.

10 The inner surface of the opening can have varying contours. For example, the contour of the inner surface may be planar, convex, or concave depending on the shape of the upstanding mold element used for the manufacture of the shaped abrasive particle with an opening. Additionally, the inner surface can be tapered such that the size of the opening in each face is different. It is preferred that the inner surface is a tapered surface such that the opening is
15 narrower at the top of the mold cavity and wider at the bottom of the mold cavity for best release of the shaped abrasive particles from the mold and to prevent cracking of the shaped abrasive particles during drying.

20 The opening can be selected to have substantially the same shape as the first perimeter. The opening can also be selected to have substantially the same shape as the perimeter of the first face and of the perimeter of the second face. Thus, the shaped abrasive particles with an opening can comprise an integral connection of a plurality of bars joined at their respective ends to form a closed polygon as illustrated for example in Fig. 1A or Fig. 5A of US patent Application Publication 2010/0151201. Alternatively, the shape of the opening can be
25 selected to be different than the shape of the first and optionally of the second perimeter, as illustrated for example in Fig. 5B of US patent Application Publication 2010/0151201. The size and/or shape of the opening can be varied to perform different functions more effectively. In one embodiment, the shape of the opening comprises a substantially triangular shape, more preferably the shape of an equilateral triangle.

30 Another feature of the shaped abrasive particles with an opening can be an extremely low bulk density as tested by ANSI B74.4-1992 Procedure for Bulk Density of Abrasive Grains. Since the opening can significantly reduce the mass of the shaped abrasive particles without

reducing their overall size, the resulting bulk density can be extremely low. Moreover, the bulk density of the shaped abrasive particles can be readily changed and controlled by simply varying the size and shape of the opening in the particles. In various embodiments of the invention, the bulk density of the shaped abrasive particles with an opening can be less than 1.35 g/cm³, or less than 1.20 g/cm³, or less than 1.00 g/cm³, or less than 0.90 g/cm³.

The shaped abrasive particles may comprise at least one non-planar face. For example, the first face may be a non-planar face or both of the first face and the second face may be a non-planar face, or one or both of the first face and the second face could be shaped inwardly (for example recessed or concave) or shaped outwardly (for example convex).

For example, the first face can be shaped inwardly (for example be recessed or concave) and the second face can be substantially planar. Alternatively, the first face can be shaped outwardly (for example be convex) and the second face can be shaped inwardly (for example be recessed or concave), or, the first face can be shaped inwardly (for example be recessed or concave) and the second face can also be shaped inwardly (for example be recessed or concave).

A face which is shaped inwardly (for example a recessed face) may comprise a substantially planar center portion and a plurality of raised corners or upturned points. To further characterize such a face, the curvature of the first face of the shaped abrasive particles can be measured by fitting a sphere using a suitable image analysis program such as a non-linear regression curve-fitting program "NLREG", available from Phillip Sherrod, Brentwood, Tenn., obtained from www.NLREG.com. A recessed face may comprise a radius of a sphere curve fitted to the recessed face by image analysis. The radius can be between about 1 mm to about 25 mm, more preferably about 1 mm to about 14 mm or between about 2 mm to about 7 mm, when the center of the sphere is vertically aligned above the midpoint of the first face. In one embodiment, the radius of the fitted sphere to the dish-shaped abrasive particles measured 2.0 mm, in another embodiment 3.2 mm, in another embodiment 5.3 mm, and in another embodiment 13.7 mm.

In one embodiment, the abrasive particles may be described as dish-shaped abrasive particles. In general, the dish-shaped abrasive particles comprise typically thin bodies having a first face, and a second face separated by a sidewall having a varying thickness t . In

5 general, the sidewall thickness is greater at the points or corners of the dish-shaped abrasive particles and thinner at the midpoints of the edges. As such, T_m is less than T_c . In some embodiments, the sidewall is a sloping sidewall having a draft angle α greater than 90 degrees as discussed in more detail in the foregoing. More than one sloping sidewall can be present and the slope or draft angle for each sloping sidewall may be the same or different for each side of the dish-shaped abrasive particle, as discussed in the foregoing.

10 In some embodiments, the first face is shaped inwardly (for example recessed) and the second face and sidewall are substantially planar. By recessed it is meant that the thickness of the interior of the first face, T_i , is thinner than the thickness of the shaped abrasive particle at portions along the perimeter.

15 As mentioned, in some embodiments, the recessed face can have a substantially flat center portion and a plurality of upturned points or a plurality of raised comers. The perimeter of the dish-shaped abrasive particle can be flat or straight at portions between the upturned points or corners and the thickness T_c can be much greater than T_m .

20 In other embodiments, the recessed first face is substantially concave with three upturned points or corners and a substantially planar second face (the shaped abrasive particle is plano-concave). The difference between T_c and T_m is less and there can be a more gradual transition from the interior of the first face to each upturned point as compared to the embodiment wherein the first face is recessed and the second face and sidewall are substantially planar. A recessed face may be the result from the use of a manufacturing method involving sol-gel in a mold cavity and forming a meniscus leaving the first face recessed. As mentioned, the first face can be recessed such that the thickness, T_c , at the points or corners tends to be greater than the thickness, T_i , of the interior of the first face. As such, the points or comers are elevated higher than the interior of the first face.

25 In various embodiments of the invention, a thickness ratio of T_c/T_i can be between 1.25 to 5.00, or between 1.30 to 4.00, or between 1.30 to 3.00. The thickness ratio can be calculated as described in [0036] of US Patent Application Publication No. 2010/0151195. Triangular dish-shaped abrasive particles have been measured to have thickness ratios between 1.55 to 2.32 in some embodiments. Triangular shaped particles produced by the prior art method

disclosed in U.S. Pat. No. 5,366,523 (Rowenhorst et al.) have been measured to have thickness ratios between 0.94 to 1.15 meaning they are essentially flat and are just as likely to be slightly thicker in the middle as they are to be slightly thinner in the middle. Dish-shaped abrasive particles having a thickness ratio greater than 1.20 are statistically different
5 from the Rowenhorst particles at the 95% confidence interval.

One or more draft angle(s) α between the second face and the sidewall of the dish-shaped abrasive particle can be varied to change the relative sizes of each face as described in the foregoing.

10 A preferred embodiment of a dish-shaped abrasive particle is one with a recessed face. The draft angle α is approximately 98 degrees and the dish-shaped abrasive particle's perimeter comprises an equilateral triangle. The sides of each triangle measured approximately 1.4 mm long at the perimeter of the first face.

15 In one embodiment the thickness t can be more uniform. As such, T_m can be approximately equal to T_c .

20 In one embodiment, the first face is convex and the second face is concave (concavo-convex), for example such that the dish-shaped abrasive particle substantially comprises a triangular section of a spherical shell.

25 It is believed that the convex face is formed by the sol-gel in the mold cavity releasing from the bottom surface of the mold due to the presence of a mold release agent such as peanut oil during evaporative drying of the sol-gel. The rheology of the sol-gel then results in the convex/concave formation of the first and second face while the perimeter is formed into shape (preferably, a triangular shape) during evaporative drying.

30 In various embodiments of the invention, the radius of a sphere fitted to the concave second face can be between about 1 mm to about 25 mm, or between about 1 mm to about 14 mm, or between about 2 mm to about 7 mm, when the center of the sphere is vertically aligned above the midpoint of the second face.

In other embodiments of the invention, the first face and the second face of the dish-shaped abrasive particles can both be recessed. In some embodiments, the dish-shaped abrasive particles can be biconcave having a concave first face and a concave second face. Alternatively, other recessed structural geometries can be formed on the second face. For
5 example, a plurality of upturned points or a plurality of raised corners on the second face. In such embodiments, the degree of curvature or flatness of the first face can be controlled to some extent by how the dish-shaped abrasive particles are dried thereby resulting in a recessed or curved first face or a substantially planar first face.

10 The shaped abrasive particles can comprise a plurality of grooves on one or both of the first side and the second side. Preferably, the second side (i.e., one or more sidewalls, faces or facets comprised by the second side, and more preferably the second face) comprises a plurality of grooves.

15 The shaped abrasive particles can comprise a plurality of ridges on one or both of the first side and the second side. Preferably, the second side (i.e., one or more sidewalls, faces or facets comprised by the second side, and more preferably the second face) comprises a plurality of ridges.

20 The plurality of grooves (or ridges) can be formed by a plurality of ridges (or grooves) in the bottom surface of a mold cavity that have been found to make it easier to remove the precursor shaped abrasive particles from the mold.

The plurality of grooves (or ridges) is not particularly limited and can, for example,
25 comprise parallel lines which may or may not extend completely across the side. In terms of this aspect ratio, the shaped abrasive particles for use in the invention can be characterized as having a ratio of the length of the greatest cross-sectional dimension, of from about 2:1 to about 50:1 and more typically greater than about 5:1 to about 25:1. In one embodiment, the plurality of grooves (or ridges) comprises parallel lines extending completely across the
30 second side (preferably across the second face). Preferably, the parallel lines intersect with the perimeter along a first edge at a 90 degree angle. The cross sectional geometry of a groove or ridge can be a truncated triangle, triangle, or other geometry as further discussed in the following. In various embodiments of the invention, the depth, D, of the plurality of

grooves can be between about 1 micrometer to about 400 micrometers. Furthermore, a percentage ratio of the groove depth, D, to the dish-shaped abrasive particle's thickness, Tc, (D/Tc expressed as a percent) can be between about 0.1% to about 30%, or between about 0.1% to 20%, or between about 0.1% to 10%, or between about 0.5% to about 5%.

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in various embodiments of the invention, the spacing between each groove (or ridge) can be between about 1% to about 50%, or between about 1% to 40%, or between about 1% to 30%, or between about 1% to 20%, or between about 5% to 20% of a face dimension such as the length of one of the edges of the dish-shaped abrasive particle.

10

According to another embodiment the plurality of grooves comprises a cross hatch pattern of intersecting parallel lines which may or may not extend completely across the face. A first set of parallel lines intersects one edge of the perimeter at a 90 degree angle (having a percent spacing of for example 6.25%) of the edge length of the triangle, and a second set of parallel lines intersects a second edge of the perimeter at a 90 degree angle (having a percent spacing of for example 6.25%) creating the cross hatch pattern and forming a plurality of raised diamonds in the second face. In various embodiments, the cross hatch pattern can use intersecting parallel or non-parallel lines, various percent spacing between the lines, arcuate intersecting lines, or various cross-sectional geometries of the grooves.

15

20

In other embodiments of the invention the number of ridges (or grooves) in the bottom surface of each mold cavity can be between 1 and about 100, or between 2 to about 50, or between about 4 to about 25 and thus form a corresponding number of grooves (or ridges) in the shaped abrasive particles.

25

The shaped abrasive particles may have a low Average Roundness Factor. Such shaped abrasive particles comprise a longitudinal axis extending from a base to the grinding tip of the abrasive article (for example, as shown in Fig. 1 of US Patent Application Publication No. 2010/0319269). The Average Roundness Factor for the shaped abrasive particles can be between about 15% to 0%, or between about 13% to 0%, or between about 12% to 0%, or between about 12% to about 5%.

30

The geometric shape of the cross-sectional plane resulting from the transverse cut (i.e., the cut transversely at 90 degrees to the longitudinal axis, also simply referred to as cross-sectional shape) of the shaped abrasive particles is not particularly limited and can also vary. A non-circular cross-sectional shape is most preferably used. A circular cross-sectional shape is round, which is believed to be duller. It is believed that a non-circular cross-sectional shape has improved grinding performance since one or more sharp corners can be present and one or more sides could be generally linear similar to a chisel blade. Desirably, the cross-sectional shape is a polygonal shape, including but not limited to, a triangle, a rectangle, a trapezoid, or a pentagon.

In preferred embodiments (such as in the case of particles having a second face wherein at least one or preferably both of the first and second faces is/are shaped inwardly), the size of the cross-sectional shape diminishes from the perimeter of the second face towards the center of the second face. In this connection, the term "center" is not restricted to the exact geometric centre of the geometric shape of second face (i.e. the second geometric shape), although this option is also contemplated and may be preferred in some instances, but is intended to encompass an area generally located in the inside of the geometric shape of the second face as opposed to the boundaries of the second face as defined by the second geometric shape.

In one embodiment, the perimeter of the first and of the second side of the (and preferably of the first and of the second face) of the shaped abrasive particle is triangular and the cross-sectional shape is trapezoidal.

The shaped abrasive particles can also comprise at least one fractured surface (shaped abrasive particles having at least one fractured surface are also referred to herein as fractured shaped abrasive particle or abrasive shard). In other words, the abrasive particles can be shaped abrasive particles, as described in the foregoing, but wherein at least one surface is a fractured surface.

As compared to the same shaped abrasive particle without at least one fractured surface, the fractured abrasive particle can be considered to comprise the major part of the original shape of the comparison particle, such as for example, at least 60%, or 70% or 80% or 90% by

volume of the original shape. The term original shape means the same shape but without at least one fractured surface. Typically, the original shape will correspond to the shape of a mold cavity used to prepare the comparative ideally shaped abrasive particle.

5 Apart from the at least one fractured surface the fractured shaped abrasive particles comprise only precisely formed surfaces defining the major part of the original shape, and thus exclude particles obtained by a mechanical crushing operation.

10 In one embodiment, the fractured shaped abrasive particle does not comprise more than three, preferably more than two fractured surfaces. in another embodiment, the fractured shaped abrasive particle comprises one fractured surface.

15 The original shape is not particularly limited and can be selected from geometric shapes as defined in the foregoing with respect to abrasive particles which do not comprise at least one fractured surface.

20 Fractured shaped abrasive particles can be formed in a mold having the original shape, such as a triangular cavity. Typically, the mold has a plurality of cavities to economically produce the abrasive shards.

25 In one example, the shaped abrasive particles can comprise a first precisely formed surface, a second precisely formed surface intersecting with the first precisely formed surface at a predetermined angle α , a third surface opposite the first precisely formed surface, and a fractured surface.

30 The first precisely formed surface can be formed by contact with a bottom surface of a cavity in a mold (corresponding to the original shape). The first precisely formed surface substantially replicates the surface finish and shape of the bottom surface of the cavity. The second precisely formed surface of the abrasive shard can be formed by contact with a sidewall of the cavity in the mold. The sidewall is designed to intersect the bottom surface at a predetermined angle α (also referred to as draft angle α in the present invention). The second precisely formed surface substantially replicates the surface finish and shape of the sidewall of the cavity. The second precisely formed surface is molded by contact with the

sidewall of the cavity. As such, at least two surfaces of the resulting abrasive shard are precisely formed and the angle of intersection α between the two surfaces is a pre-determined angle based on the selected mold geometry. The third surface of the abrasive shard opposite the first precisely formed surface can be randomly wavy or undulating in appearance since it is in contact with the air after the cavity is filled with an abrasive dispersion. The third surface is not precisely formed since it is not molded by contact with the cavity. Often, the third surface is created by scraping or doctoring a top surface of the mold to remove excessive abrasive dispersion from the mold. The doctoring or scraping step results in a subtle waviness or irregularity of the third surface that is visible under magnification. As such, the third surface is similar to a surface created by extrusion, which is also not precisely formed. In the extrusion process, the sol-gel is forced out of a die. As such, the surfaces of the sol-gel exhibits scrape marks, gouges, and/or score lines as a result of the extrusion process. Such marks are created by the relative motion between the sol-gel and the die. Additionally, extruded surfaces from a die can be generally a smooth plane. In contrast, the precisely formed surfaces can replicate a sinusoidal or other more complex geometrical surface having significant variations in height along the length of the surface.

The fractured surface of the abrasive shard generally propagates between the first precisely formed surface and the opposing third surface and between opposing sidewalls of the cavity when the cavity depth is relatively small compared to the area of the bottom surface. The fractured surface is characterized by sharp, jagged points typical of a brittle fracture. The fractured surface can be created by a drying process that cracks or fractures at least the majority of the shaped abrasive particle precursors into at least two pieces while residing in the cavity. This produces abrasive shards having a smaller size than the mold cavity from which they were made. The abrasive shards, once formed, could be reassembled like jigsaw puzzle pieces to reproduce the original cavity shape of the mold from which they were made. The cracking or fracturing of the precursor abrasive particles is believed to occur by ensuring that the surface tension of the abrasive dispersion to the walls of the cavity is greater than the internal attractive forces of the abrasive dispersion as the abrasive dispersion is dried in the cavity.

Another embodiment is a shaped abrasive particle respectively bounded by a polygonal first face (or base), a polygonal second face (or top), and a plurality of sidewalls connecting the

base and the top, wherein adjacent sidewalls meet at respective sidewall edges having an average radius of curvature of less than 50 micrometers. For example, referring to FIGS. 6A-6B, exemplary shaped abrasive particle 320 is bounded by a trigonal base 321, a trigonal top 323, and plurality of sidewalls 325a, 325b, 325c connecting base 321 and top 323. Base 321 has sidewall edges 327a, 327b, 327c, having an average radius of curvature of less than 50 micrometers. FIGS. 6C-6D show radius of curvature 329a for sidewall edge 327a. In general, the smaller the radius of curvature, the sharper the sidewall edge will be. Typically, the base and the top of the shaped abrasive particles are substantially parallel, resulting in prismatic or truncated pyramidal (as shown in FIGS. 6A-6B) shapes, although this is not a requirement. As shown, sides 325a, 325b, 325c have equal dimensions and form dihedral angles with base 321 of about 82 degrees. However, it will be recognized that other dihedral angles (including 90 degrees) may also be used. For example, the dihedral angle between the base and each of the sidewalls may independently range from 45 to 90 degrees, typically 70 to 90 degrees, more typically 75 to 85 degrees.

According to particularly preferred embodiments, the shaped abrasive particles have a three-dimensional shape of flat triangular platelets or flat rectangular platelets, with flat triangular platelets being preferred. Such shaped abrasive particles may also be simply referred to as flat triangles or flat rectangles.

Hence, in particularly preferred embodiments, the shaped abrasive particles each comprise a first side and a second side separated by a thickness t , wherein said thickness t is preferably equal to or smaller than the length of the shortest side-related dimension of the particle, wherein said first side comprises (or preferably is) a first face having a perimeter of a first geometric shape, wherein said second side comprises (or preferably is) a second face having a perimeter of a second geometric shape, and wherein said second side is separated from said first side by thickness t and at least one sidewall connecting said second face and said first face, wherein said first geometric shape and said second geometric shapes have substantially identical geometric shapes which may or may not be different in size, wherein said identical geometric shapes are both selected either from triangular shapes or from quadrilateral shapes.

Said first geometric shape is preferably congruent to said second geometric shape, as described previously.

5 It is also preferred that the first and second face of such particles are substantially planar and substantially parallel to each other.

Preferred triangular and quadrilateral or rectangular shapes are as defined in the foregoing.

10 The sidewall can also be as defined in the foregoing. For example, the sidewall can be a non-sloping sidewall (i.e., the size of the first geometric shape is identical to the size of the second geometric shape; for example triangular or rectangular prisms) or a sloping sidewall (i.e., the size of the first geometric shape is not identical to and typically larger than the size of the second geometric shape; as, for example, in the case of particles having the shape of truncated triangular or rectangular pyramids, as described herein).

15 According to another particularly preferred embodiment, the shaped abrasive particles are flat triangular platelets (also simply referred to as flat triangles) or flat rectangular platelets (also simply referred to as flat rectangles), as described above, but wherein at least one of the first and the second face is shaped inwardly (for example recessed or concave).

20 For example, the first face can be shaped inwardly (for example be recessed or concave) and the second face can be substantially planar or shaped outwardly (for example be convex), or the second face can be shaped inwardly (for example be recessed or concave) and the first face can be substantially planar or shaped outwardly (for example be convex).

25 Alternatively and more preferably, the first face can be shaped inwardly (for example be recessed or concave) and the second face can also be shaped inwardly (for example be recessed or concave).

30 For particles according to this embodiment, the thickness typically varies over the planar configuration of the particle and diminishes towards the "center of the particle".

Particles according to this embodiment are also typically characterized by a diminishing area of the cross-sectional shape (perpendicular to the length) towards the center of the particle.

5 The term "center of the particle" as used in this connection is to be understood in a general way and does not necessarily have to be the geometric center of the particle, although there might be cases where the minimum thickness or the minimum area of the cross-sectional shape can be found at the geometric center of the particle, as described previously.

10 The shaped abrasive particles used in the present invention can have an abrasives industry specified nominal grade or a nominal screened grade.

15 Abrasive particles are generally graded to a given particle size distribution before use. Such distributions typically have a range of particle sizes, from coarse particles to fine particles. In the abrasive art this range is sometimes referred to as a "coarse", "control", and "fine" fractions. Abrasive particles graded according to abrasive industry accepted grading standards specify the particle size distribution for each nominal grade within numerical limits. Such industry accepted grading standards (i.e., abrasive industry specified nominal grade) include those known as the American National Standards Institute, Inc. (ANSI) standards, Federation of European Producers of Abrasive Products (FEPA) standards, and
20 Japanese Industrial Standard (JIS) standards.

25 ANSI grade designations (i.e., specified nominal grades) include: ANSI 4, ANSI 6, ANSI 8, ANSI 16, ANSI 24, ANSI 36, ANSI 46, ANSI 54, ANSI 60, ANSI 70, ANSI 80, ANSI 90, ANSI 100, ANSI 120, ANSI 150, ANSI 180, ANSI 220, ANSI 240, ANSI 280, ANSI 320, ANSI 360, ANSI 400, and ANSI 600. FEPA grade designations include F4, F5, F6, F7, F8, F10, F12, F14, F16, F20, F22, F24, F30, F36, F40, F46, F54, F60, F70, F80, F90, F100, F120, F150, F180, F220, F230, F240, F280, F320, F360, F400, F500, F600, F800, F1000, F1200, F1500, and F2000. JIS grade designations include JIS8, JIS 12, JIS 16, JIS24, JIS36, JIS46, JIS54, JIS60, JIS80, JIS 100, JIS 150, JIS 180, JIS220, JIS240, JIS280, JIS320, JIS360,
30 JIS400, JIS600, JIS800, JIS1000, JIS1500, JIS2500, JIS4000, JIS6000, JIS8000, and JIS10,000.

Alternatively, the shaped abrasive particles can be graded to a nominal screened grade using U.S.A. Standard Test Sieves conforming to ASTM E-11 "Standard Specification for Wire Cloth and Sieves for Testing Purposes." ASTM E-11 proscribes the requirements for the design and construction of testing sieves using a medium of woven wire cloth mounted in a frame for the classification of materials according to a designated particle size. A typical designation may be represented as -18+20 meaning that the shaped abrasive particles pass through a test sieve meeting ASTM E-11 specifications for the number 18 sieve and are retained on a test sieve meeting ASTM E-11 specifications for the number 20 sieve. In one embodiment, the shaped abrasive particles have a particle size such that most of the particles pass through an 18 mesh test sieve and can be retained on a 20, 25, 30, 35, 40, 45, or 50 mesh test sieve. In various embodiments of the invention, the shaped abrasive particles can have a nominal screened grade comprising: -18+20, -20+25, -25+30, -30+35, -35+40, -40+45, -45+50, -50+60, -60+70, -70+80, -80+100, -100+120, -120+140, -140+170, -170+200, -200+230, -230+270, -270+325, -325+400, -400+450, -450+500, or -500+635.

The shaped abrasive particles in accordance with the present invention may be comprised in a fraction of abrasive particles (or abrasive fraction), also referred to as blend of abrasive particles in the present invention (for ease of reference the term "blend" as used herein is also intended to include the case that the fraction of abrasive particles comprises 100% by weight of shaped abrasive particles, based on the total amount of abrasive particles present in the fraction (or blend).

A blend can comprise one or more types of shaped abrasive particles in accordance with the present invention and optionally one or more types of abrasive particles which are generally referred to herein as "secondary abrasive particles" (abrasive particles which differ from the shaped abrasive particles to be used in accordance with the present invention). For example, abrasive particles having a shape not in accordance with the present invention (for example filamentary abrasive particles or elongated rods) or conventional non-shaped abrasive particles could be used as secondary abrasive particles.

A blend can comprise shaped abrasive particles in accordance with the present invention and secondary abrasive particles in any amount. Accordingly, the shaped abrasive particles and the secondary abrasive particles may be comprised in a blend, wherein the content of the

secondary abrasive particles may be up to 95% by weight based on the total amount of abrasive particles present in the blend or even higher. Thus, in other highly preferred embodiments, the article does not contain secondary abrasive particles.

5 In some embodiments, at least 5, 10, 15, 20, 25, 30, 35, 40, 45, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, or even 100 percent by weight of the blend are shaped abrasive particles according to the present invention, based on the total weight of the blend of abrasive particles.

10 The secondary abrasive particles may have any suitable particle form (as long as it is different from the shape of the abrasive particle for use in the invention). Exemplary particle forms include but are not limited to particle forms obtained by mechanical crushing operation, agglomerated forms and any other forms that differ from the specific abrasive particle shapes as defined herein.

15 The materials constituting the secondary abrasive particles are not particularly limited and include any suitable hard or superhard material known to be suitable for use as an abrasive particle. Accordingly, in one embodiment, the secondary abrasive particles comprise a major portion of a hard abrasive material. For example, at least 30%, or at least 50%, or 60% to 100%, or 90% or more, or 100% by weight of the total weight of the secondary abrasive
20 particles are comprised of a hard material. In another embodiment, the secondary abrasive particles comprise a major portion of a superhard abrasive material. For example, at least 30%, or at least 50%, or 60% to 100%, or 90% or more, or 100% by weight of the total weight of the secondary abrasive particles are comprised of a superhard material.

25 Examples of suitable abrasive materials of secondary abrasive particles include but are not limited to known ceramic materials, carbides, nitrides and other hard and superhard materials and include materials, as exemplified herein with respect to shaped abrasive particles, and the shaped abrasive particles of the invention and the secondary abrasive particles can be independently selected from particles of such exemplified materials or any combination
30 thereof.

Representative examples of materials of secondary abrasive particles include for example particles of fused aluminum oxide, e.g., white fused alumina, heat treated aluminum oxide,

ceramic aluminum oxide materials such as those commercially available under the trade designation 3M CERAMIC ABRASIVE GRAIN from 3M Company of St. Paul, Minnesota, sintered aluminum oxide, silicon carbide (including black silicon carbide and green silicon carbide), titanium diboride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride, garnet, fused alumina-zirconia, sol-gel derived abrasive particles (including sol-gel-derived aluminum oxide particles), cerium oxide, zirconium oxide, titanium oxide. Examples of sol-gel derived abrasive particles can be found in U.S. Patent Nos. 4,314,827 (Leitheiser et al.), 4,623,364 (Cottringer et al.); 4,744,802 (Schwabel), 4,770,671 (Monroe et al); and 4,881,951 (Monroe et al).

10

In a preferred embodiment, the secondary abrasive particles are selected from particles of fused oxide materials, including fused aluminum oxide materials or fused alumina-zirconia, preferably fused aluminum oxide.

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In another preferred embodiment, the secondary abrasive particles are selected from particles of superabrasive materials, for example cubic boron nitride and natural or synthetic diamond. Suitable diamond or cubic boron nitride materials can be crystalline or polycrystalline. A preferred superabrasive material for use as secondary abrasive particles is cubic boron nitride.

20

In yet another embodiment, the secondary abrasive particles are selected from particles of silicon carbide materials.

25

The secondary abrasives particles comprised in the blend may have an abrasives industry specified nominal grade or a nominal screened grade. As mentioned, the shaped abrasive particles may also have an abrasive industry specified nominal grade or a nominal screened grade and the grade(s) of the secondary abrasive particles and the grade(s) of the shaped abrasive particles of the present invention can be independently selected from any useful grade.

30

For example, the abrasive article may further comprise crushed abrasive particles (excluding abrasive shards as defined herein) which can optionally correspond to an abrasive industry specified nominal graded or combination thereof. The crushed abrasive particles can be of a

finer size grade or grades (e.g., if a plurality of size grades are used) than the shaped abrasive particles. In some embodiments, the crushed abrasive particles can be of a coarser size grade or grades (e.g., if a plurality of size grades are used) than the shaped abrasive particles.

5 Typically, conventional crushed abrasive particles are independently sized according to an abrasives industry recognized specified nominal grade. Exemplary abrasive industry recognized grading standards and grades for secondary abrasive particles include those as mentioned with respect to shaped abrasive particles.

10 Methods to provide shaped abrasive particles are known in the art and include technologies based on (1) fusion, (2) sintering, and (3) chemical ceramic. While preferred shaped abrasive particles can be obtained by using chemical ceramic technology, non-ceramic shaped abrasive particles are also included within the scope of the present invention. In the description of the invention, methods for preparing shaped abrasive particles may be
15 described with specific reference to ceramic shaped abrasive particles, particularly alumina based ceramic shaped abrasive particles. It is to be understood however that the invention is not limited to alumina but is capable of being adapted for use with a plurality of different hard and superhard materials.

20 The shaped abrasive particles used in the present invention can typically be made using tools (i.e., molds), cut using diamond tooling, which provides higher feature definition than other fabrication alternatives such as, for example, stamping or punching. Typically, the cavities in the tool surface have planar faces that meet along sharp edges, and form the sides and top of a truncated pyramid. The resultant shaped abrasive particles have a respective nominal
25 average shape that corresponds to the shape of cavities (e.g., truncated pyramid) in the tool surface; however, variations (e.g., random variations) from the nominal average shape may occur during manufacture, and shaped abrasive particles exhibiting such variations are included within the definition of shaped abrasive particles as used herein.

30 Shaped abrasive particles (for example alpha-alumina based ceramic particles) can be made according to a multistep process typically using a dimensionally stable dispersion of a suitable precursor (for example a ceramic precursor).

The dispersion that is typically employed in the process may be any dispersion of a suitable precursor and by this is intended a finely dispersed material that, after being subjected to a process suitable in the invention, is in the form of a shaped abrasive particle. The precursor may be chemically a precursor, as for example boehmite is a chemical precursor of alpha alumina; a morphological precursor as for example gamma alumina is a morphological precursor of alpha alumina; as well as (or alternatively), physically a precursor in the sense of that a finely divided form of alpha alumina can be formed into a shape and sintered to retain that shape. In typical cases, the dimensionally stable dispersion of a suitable precursor is a sol-gel.

Where the dispersion comprises a physical or morphological precursor as the term is used herein, the precursor is in the form of finely divided powder grains that, when sintered together, form an abrasive particle of utility in conventional bonded and coated abrasive applications. Such materials generally comprise powder grains with an average size of less than about 20 microns, preferably less than about 10 microns and most preferably less than about a micron. The solids content of a dispersion of a physical or a morphological precursor is preferably from about 40 to 65% though higher solids contents of up to about 80% can be used. An organic compound is frequently used along with the finely divided grains in such dispersions as a suspending agent or perhaps as a temporary binder until the particle has been dried sufficiently to maintain its shape. This can be any of those generally known for such purposes such as polyethylene glycol, sorbitan esters and the like.

The solids content of a chemical precursor that changes to its final stable (for example, ceramic) form upon heating may need to take into account water that may be liberated from the precursor during drying and firing to sinter the particles. In such cases the solids content is typically somewhat lower such as about 75% or lower and more preferably between about 30% and about 50%. With a boehmite gel a maximum solids content of about 60% or even 40% is preferred and a gel with a peptized minimum solids content of about 20% may also be used.

Particles made from physical precursors will typically need to be fired at higher temperatures than those formed from a seeded chemical precursor. For example, whereas particles of a seeded boehmite gel form an essentially fully densified alpha alumina at temperatures below

about 1250°C, particles made from alpha alumina gels require a firing temperature of above about 1400°C for full densification.

5 By way of example, a method suitable for use in the present invention comprises chemical ceramic technology involving converting a colloidal dispersion or hydrosol (sometimes called a sol), optionally in a mixture with solutions of other metal oxide precursors, to a gel or any other physical state that restrains the mobility of the components, drying, and firing to obtain a ceramic material. A sol can be prepared by any of several methods, including precipitation of a metal hydroxide from an aqueous solution followed by peptization, dialysis
10 of anions from a solution of metal salt, solvent extraction of an anion from a solution of a metal salt, hydrothermal decomposition of a solution of a metal salt having a volatile anion. The sol optionally contains metal oxide or precursor thereof and is transformed to a semi-rigid solid state of limited mobility such as a gel by, e.g., partial extraction of the solvent, e.g., water, the gel can be shaped by any convenient method such as pressing, molding, or
15 extruding, to provide a shaped abrasive grain.

An exemplary method involving chemical ceramic technology comprises the steps of making a dimensionally stable dispersion of a ceramic precursor (which may for example include either a seeded or non-seeded sol-gel alpha alumina precursor dispersion that can be
20 converted into alpha alumina); filling one or more mold cavities having the desired outer shape of the shaped abrasive particle with the dimensionally stable dispersion of a ceramic precursor, drying the stable dispersion of a ceramic precursor to form precursor ceramic shaped abrasive particles; removing the precursor ceramic shaped abrasive particles from the mold cavities; calcining the precursor ceramic shaped abrasive particles to form calcined,
25 precursor ceramic shaped abrasive particles, and then sintering the calcined, precursor ceramic shaped abrasive particles to form ceramic shaped abrasive particles. The process is described in more detail in U.S. Patent No. 5,201,916 (Berg et al.).

The materials that can be made into shaped particles of the invention include physical
30 precursors such as finely divided particles of known ceramic materials, carbides, nitrides such as alpha alumina, tungsten carbide, silicon carbide, titanium nitride, alumina/zirconia and cubic boron nitride (CBN). Also included are chemical and/or morphological precursors such as aluminum trihydrate, boehmite, gamma alumina and other transitional aluminas and

bauxite. The most useful of the above are typically based on alumina, and its physical or chemical precursors and in the specific descriptions that follow a method suitable for use in the invention is illustrated with specific reference to alumina.

5 Other components that have been found to be desirable in certain circumstances for the production of alumina-based particles include nucleating agents such as finely divided alpha alumina, ferric oxide, chromium oxide and other materials capable of nucleating the transformation of precursor forms to the alpha alumina form; oxides of magnesium; titanium; zirconium; yttrium; and other rare earth metal oxides. Such additives often act as
10 crystal growth limiters or boundary phase modifiers. The amount of such additives in the precursor is usually less than about 10% and often less than 5% by weight (solids basis).

It is also possible to use, instead of a chemical or morphological precursor of alpha alumina, a slip of finely divided alpha alumina itself together with an organic compound that will
15 maintain it in suspension and act as a temporary binder while the particle is being fired to essentially full densification. In such cases it is often possible to include in the suspension materials that will form a separate phase upon firing or that can act as an aid in maintaining the structural integrity of the shaped particles either during drying and firing, or after firing. Such materials may be present as impurities. If for example the precursor is finely divided
20 bauxite, there will be a small proportion of vitreous material present that will form a second phase after the powder grains are sintered together to form the shaped particle.

Ceramic shaped abrasive particles composed of crystallites of alpha alumina, magnesium alumina spinel, and a rare earth hexagonal aluminate may also be used. Such particles may
25 be prepared using sol-gel precursor alpha alumina particles according to methods described in, for example, U.S. Patent No. 5,213,591 (Celikkaya et al.) and U.S. Publ. Patent Appl. Nos. 2009/0165394 A1 (Culler et al.) and 2009/0169816 A1 (Erickson et al.).

In some embodiments, ceramic shaped abrasive particles can be made according to a
30 multistep process. The process will now be described in greater detail with specific reference to alumina. Generally, alpha alumina based shaped abrasive particles can be made from a dispersion of aluminum oxide monohydrate that is gelled, molded to shape, dried to retain

the shape, calcined, and sintered as is known in the art. The shaped abrasive particle's shape is retained without the need for a binder.

5 The first process step of the multi-step process involves providing either a seeded or non-seeded dispersion of an alpha alumina precursor that can be converted into alpha alumina. The alpha alumina precursor dispersion often comprises a liquid that is a volatile component. In one embodiment, the volatile component is water. The dispersion should comprise a sufficient amount of liquid for the viscosity of the dispersion to be sufficiently low to enable filling mold cavities and replicating the mold surfaces, but not so much liquid as to cause
10 subsequent removal of the liquid from the mold cavity to be prohibitively expensive. In one embodiment, the alpha alumina precursor dispersion comprises from 2 percent to 90 percent by weight of the particles that can be converted into alpha alumina, such as particles of aluminum oxide monohydrate (boehmite), and at least 10 percent by weight, or from 50 percent to 70 percent, or 50 percent to 60 percent, by weight of the volatile component such
15 as water. Conversely, the alpha alumina precursor dispersion in some embodiments contains from 30 percent to 50 percent, or 40 percent to 50 percent, by weight solids.

Aluminum oxide hydrates other than boehmite can also be used. Boehmite can be prepared by known techniques or can be obtained commercially. Examples of commercially available
20 boehmite include products having the trade designations "DISPERAL", and "DISPAL", both available from Sasol North America, Inc. of Houston, Texas, or "HiQ-40" available from BASF Corporation of Florham Park, New Jersey. These aluminum oxide monohydrates are relatively pure; that is, they include relatively little, if any, hydrate phases other than monohydrates, and have a high surface area.

25 The physical properties of the resulting ceramic shaped abrasive particles will generally depend upon the type of material used in the alpha alumina precursor dispersion. In one embodiment, the alpha alumina precursor dispersion is in a gel state. As used herein, a "gel" is a three-dimensional network of solids dispersed in a liquid.

30 The alpha alumina precursor dispersion may contain a modifying additive or precursor of a modifying additive. The modifying additive can function to enhance some desirable property of the abrasive particles or increase the effectiveness of the subsequent sintering step.

5 Modifying additives or precursors of modifying additives can be in the form of soluble salts, typically water soluble salts. They typically consist of a metal-containing compound and can be a precursor of oxide of magnesium, zinc, iron, silicon, cobalt, nickel, zirconium, hafnium, chromium, yttrium, praseodymium, samarium, ytterbium, neodymium, lanthanum, gadolinium, cerium, dysprosium, erbium, titanium, and mixtures thereof. The particular concentrations of these additives that can be present in the alpha alumina precursor dispersion can be varied based on skill in the art.

10 Typically, the introduction of a modifying additive or precursor of a modifying additive will cause the alpha alumina precursor dispersion to gel. The alpha alumina precursor dispersion can also be induced to gel by application of heat over a period of time. The alpha alumina precursor dispersion can also contain a nucleating agent (seeding) to enhance the transformation of hydrated or calcined aluminum oxide to alpha alumina. Nucleating agents suitable for this invention include fine particles of alpha alumina, alpha ferric oxide or its precursor, titanium oxides and titanates, chrome oxides, or any other material that will nucleate the transformation. The amount of nucleating agent, if used, should be sufficient to effect the transformation of alpha alumina. Nucleating such alpha alumina precursor dispersions is disclosed in U.S. Patent No. 4,744,802 (Schwabel).

20 A peptizing agent can be added to the alpha alumina precursor dispersion to produce a more stable hydrosol or colloidal alpha alumina precursor dispersion. Suitable peptizing agents are monoprotic acids or acid compounds such as acetic acid, hydrochloric acid, formic acid, and nitric acid. Multiprotic acids can also be used but they can rapidly gel the alpha alumina precursor dispersion, making it difficult to handle or to introduce additional components thereto. Some commercial sources of boehmite contain an acid titer (such as absorbed formic or nitric acid) that will assist in forming a stable alpha alumina precursor dispersion.

25 The alpha alumina precursor dispersion can be formed by any suitable means, such as, for example, by simply mixing aluminum oxide monohydrate with water containing a peptizing agent or by forming an aluminum oxide monohydrate slurry to which the peptizing agent is added.

Defoamers or other suitable chemicals can be added to reduce the tendency to form bubbles or entrain air while mixing. Additional chemicals such as wetting agents, alcohols, or coupling agents can be added if desired. The alpha alumina abrasive particles may contain silica and iron oxide as disclosed in U.S. Patent No. 5,645,619 (Erickson et al.). The alpha alumina abrasive particles may contain zirconia as disclosed in U.S. Patent No. 5,551,963 (Larmie). Alternatively, the alpha alumina abrasive particles can have a microstructure or additives as disclosed in U.S. Patent No. 6,277,161 (Castro).

The second process step involves providing a mold having at least one mold cavity, and preferably a plurality of cavities. The mold can have a generally planar bottom surface and a plurality of mold cavities. The plurality of cavities can be formed in a production tool. The production tool can be a belt, a sheet, a continuous web, a coating roll such as a rotogravure roll, a sleeve mounted on a coating roll, or die. In one embodiment, the production tool comprises polymeric material. Examples of suitable polymeric materials include thermoplastics such as polyesters, polycarbonates, poly(ether sulfone), poly(methyl methacrylate), polyurethanes, polyvinylchloride, polyolefin, polystyrene, polypropylene, polyethylene or combinations thereof, or thermosetting materials. In one embodiment, the entire tooling is made from a polymeric or thermoplastic material. In another embodiment, the surfaces of the tooling in contact with the sol-gel while drying, such as the surfaces of the plurality of cavities, comprises polymeric or thermoplastic materials and other portions of the tooling can be made from other materials. A suitable polymeric coating may be applied to a metal tooling to change its surface tension properties by way of example.

A polymeric or thermoplastic tool can be replicated off a metal master tool. The master tool will have the inverse pattern desired for the production tool. The master tool can be made in the same manner as the production tool. In one embodiment, the master tool is made out of metal, e.g., nickel and is diamond turned. The polymeric sheet material can be heated along with the master tool such that the polymeric material is embossed with the master tool pattern by pressing the two together. A polymeric or thermoplastic material can also be extruded or cast onto the master tool and then pressed. The thermoplastic material is cooled to solidify and produce the production tool. If a thermoplastic production tool is utilized, then care should be taken not to generate excessive heat that may distort the thermoplastic production tool limiting its life. More information concerning the design and fabrication of

production tooling or master tools can be found in U.S. Patent Nos. 5,152,917 (Pieper et al); 5,435,816 (Spurgeon et al.); 5,672,097 (Hoopman et al.); 5,946,991 (Hoopman et al.); 5,975,987 (Hoopman et al.); and 6,129,540 (Hoopman et al.).

5 Access to cavities can be from an opening in the top surface or bottom surface of the mold. In some instances, the cavities can extend for the entire thickness of the mold. Alternatively, the cavities can extend only for a portion of the thickness of the mold. In one embodiment, the top surface is substantially parallel to bottom surface of the mold with the cavities having a substantially uniform depth. At least one side of the mold, that is, the side in which the
10 cavities are formed, can remain exposed to the surrounding atmosphere during the step in which the volatile component is removed.

The cavities have a specified three-dimensional shape to make the ceramic shaped abrasive particles. The depth dimension is equal to the perpendicular distance from the top surface to
15 the lowermost point on the bottom surface. The depth of a given cavity can be uniform or can vary along its length and/or width. The cavities of a given mold can be of the same shape or of different shapes.

The third process step involves filling the cavities in the mold with the alpha alumina
20 precursor dispersion (e.g., by a conventional technique). In some embodiments, a knife roll coater or vacuum slot die coater can be used. A mold release can be used to aid in removing the particles from the mold if desired. Typical mold release agents include oils such as peanut oil or mineral oil, fish oil, silicones, polytetrafluoroethylene, zinc stearate, and graphite. In general, mold release agent such as peanut oil, in a liquid, such as water or
25 alcohol, is applied to the surfaces of the production tooling in contact with the sol-gel such that between about 0.1 mg/in^2 (0.02 mg/cm^2) to about 3.0 mg/in^2 (0.46 mg/cm^2) or between about 0.1 mg/in^2 (0.02 mg/cm^2) to about 5.0 mg/in^2 (0.78 mg/cm^2) of the mold release agent is present per unit area of the mold when a mold release is desired. In some
30 embodiments, the top surface of the mold is coated with the alpha alumina precursor dispersion. The alpha alumina precursor dispersion can be pumped onto the top surface.

Next, a scraper or leveler bar can be used to force the alpha alumina precursor dispersion fully into the cavity of the mold. The remaining portion of the alpha alumina precursor dispersion that does not enter cavity can be removed from top surface of the mold and recycled. In some embodiments, a small portion of the alpha alumina precursor dispersion
5 can remain on the top surface and in other embodiments the top surface is substantially free of the dispersion. The pressure applied by the scraper or leveler bar is typically less than 100 psi (0.7 MPa), less than 50 psi (0.3 MPa), or even less than 10 psi (69 kPa). In some embodiments, no exposed surface of the alpha alumina precursor dispersion extends substantially beyond the top surface to ensure uniformity in thickness of the resulting
10 ceramic shaped abrasive particles.

The fourth process step involves removing the volatile component to dry the dispersion. Desirably, the volatile component is removed by fast evaporation rates. In some
15 embodiments, removal of the volatile component by evaporation occurs at temperatures above the boiling point of the volatile component. An upper limit to the drying temperature often depends on the material the mold is made from. For polypropylene tooling the temperature should be less than the melting point of the plastic. In one embodiment, for a water dispersion of between about 40 to 50 percent solids and a polypropylene mold, the drying temperatures can be between about 90°C to about 165°C, or between about 105°C to
20 about 150°C, or between about 105°C to about 120°C. Higher temperatures can lead to improved production speeds but can also lead to degradation of the polypropylene tooling limiting its useful life as a mold.

The fifth process step involves removing resultant precursor ceramic shaped abrasive
25 particles from the mold cavities. The precursor ceramic shaped abrasive particles can be removed from the cavities by using the following processes alone or in combination on the mold: gravity, vibration, ultrasonic vibration, vacuum, or pressurized air to remove the particles from the mold cavities.

The precursor abrasive particles can be further dried outside of the mold. If the alpha alumina precursor dispersion is dried to the desired level in the mold, this additional drying
30 step is not necessary. However, in some instances it may be economical to employ this additional drying step to minimize the time that the alpha alumina precursor dispersion

resides in the mold. Typically, the precursor ceramic shaped abrasive particles will be dried from 10 to 480 minutes, or from 120 to 400 minutes, at a temperature from 50°C to 160°C, or at 120°C to 150°C.

5 The sixth process step involves calcining the precursor ceramic shaped abrasive particles. During calcining, essentially all the volatile material is removed, and the various components that were present in the alpha alumina precursor dispersion are transformed into metal oxides. The precursor ceramic shaped abrasive particles are generally heated to a temperature from 400°C to 800°C, and maintained within this temperature range until the
10 free water and over 90 percent by weight of any bound volatile material are removed. In an optional step, it may be desired to introduce the modifying additive by an impregnation process. A water-soluble salt can be introduced by impregnation into the pores of the calcined, precursor ceramic shaped abrasive particles. Then the precursor ceramic shaped abrasive particles are pre-fired again. This option is further described in U.S. Patent No.
15 5,164,348 (Wood).

The seventh process step involves sintering the calcined, precursor ceramic shaped abrasive particles to form alpha alumina particles. Prior to sintering, the calcined, precursor ceramic shaped abrasive particles are not completely densified and thus lack the desired hardness to
20 be used as ceramic shaped abrasive particles. Sintering takes place by heating the calcined, precursor ceramic shaped abrasive particles to a temperature of from 1000°C to 1650°C and maintaining them within this temperature range until substantially all of the alpha alumina monohydrate (or equivalent) is converted to alpha alumina and the porosity is reduced to less than 15 percent by volume. The length of time to which the calcined, precursor ceramic
25 shaped abrasive particles must be exposed to the sintering temperature to achieve this level of conversion depends upon various factors but usually from five seconds to 48 hours is typical.

In another embodiment, the duration for the sintering step ranges from one minute to 90
30 minutes. After sintering, the ceramic shaped abrasive particles can have a Vickers hardness of 10 GPa, 16 GPa, 18 GPa, 20 GPa, or greater.

Other steps can be used to modify the described process such as, for example, rapidly heating the material from the calcining temperature to the sintering temperature, centrifuging the alpha alumina precursor dispersion to remove sludge and/or waste. Moreover, the process can be modified by combining two or more of the process steps if desired.

5 Conventional process steps that can be used to modify the process of this disclosure are more fully described in U.S. Patent No. 4,314,827 (Leitheiser). More information concerning methods to make ceramic shaped abrasive particles is disclosed in US Patent Application Publication No. 2009/0165394 A1 (Culler et al).

10 Methods for making shaped abrasive particles having at least one sloping sidewall are for example described in US Patent Application Publication Nos. 2010/0151196 and 2009/0165394. Methods for making shaped abrasive particles having an opening are for example described in US Patent Application Publication No. 2010/0151201 and 2009/0165394. Methods for making shaped abrasive particles having grooves on at least one
15 side are for example described in US Patent Application Publication No. 2010/0146867. Methods for making dish-shaped abrasive particles are for example described in US Patent Application Publication Nos. 2010/0151195 and 2009/0165394. Methods for making shaped abrasive particles with low Roundness Factor are for example described in US Patent Application Publication No. 2010/0319269. Methods for making shaped abrasive particles
20 with at least one fractured surface are for example described in US Patent Application Publication Nos. 2009/0169816 and 2009/0165394. Methods for making abrasive particles wherein the second side comprises a vertex (for example, dual tapered abrasive particles) or a ridge line (for example, roof shaped particles) are for example described in WO 2011/068714.

25 The bonding medium of a bonded abrasive article serves to retain the shaped abrasive particles (and any optional components, such as secondary abrasive particles, fillers and additives) in the abrasive article. According to the present invention, the bonding medium comprises a vitreous (also referred to as vitrified) bond phase. In a preferred embodiment,
30 the bonding medium is a vitreous bond (phase). The vitreous bond serves to retain the shaped abrasive particles (and any optional secondary abrasive particles as described herein) in the article. The vitreous bond phase which binds together the abrasive particles (shaped

abrasive particle and any optional secondary abrasive particles) can be of any suitable composition.

5 The vitreous bond phase, also known in the art as a "vitrified bond", "vitreous bond", "ceramic bond" or "glass bond", may be produced from a vitreous bond precursor composition comprising a mixture or combination of one or more raw materials that when heated to a high temperature melt and/or fuse to form an integral vitreous matrix phase.

10 Typical raw materials for forming a vitreous bond phase can be selected from metal oxides (including metalloid oxides), non-metal oxides, non-metal compounds, silicates and naturally occurring and synthetic minerals, and combinations of one or more of these raw materials.

15 Metal oxides can for example be selected from silicon oxide, aluminium oxide, magnesium oxide, calcium oxide, barium oxide, lithium oxide, sodium oxide, potassium oxide, iron oxide, titanium oxide, manganese oxide, zinc oxide, and metal oxides that can be characterized as pigments such as cobalt oxide, chromium oxide, or iron oxide, and combinations thereof.

20 Non-metal oxides can for example be selected from boron oxide or phosphorous oxide and combinations thereof.

Suitable examples for non-metal compounds include boric acid.

25 Silicates can for example be selected from aluminum silicates, borosilicates, calcium silicates, magnesium silicates, sodium silicates, magnesium silicates, lithium silicates, and combinations thereof.

Minerals can for example be selected from clay, feldspar, kaolin, wollastonite, borax, quartz, soda ash, limestone, dolomite, chalk, and combinations thereof.

30 In the present invention, the vitreous bond phase may also be formed from a frit, i.e. a composition that has been prefired prior to its employment in a vitreous bond precursor composition for forming the vitreous bond phase of a bonded abrasive article. As used herein, the term "frit" is a generic term for a material that is formed by thoroughly blending a

5 mixture comprising one or more frit forming components, followed by heating (also referred to as prefiring) the mixture to a temperature at least high enough to melt it; cooling the glass and pulverizing it. The frit forming components are usually mixed together as powders, fired to fuse the mixture and then the fused mixture is cooled. The cooled mixture is crushed and
10 screened to a fine powder to then be used as a frit bond. The fineness of the powder is not particularly limited. Examples of illustrative particle sizes include but are not limited to particle sizes of $\leq 35 \mu\text{m}$ or $\leq 63 \mu\text{m}$. It is this final powder that may be used in a vitreous bond precursor composition to prepare the vitreous bond of a bonded abrasive article of the invention, such as a grinding wheel.

15 Frits, their sources and compositions are well known in the art. Frit forming components include materials which have been previously referred to as raw materials for forming a vitreous bond. Frits are well known materials and have been used for many years as enamels for coating, for example, porcelain, metals and jewellery, but also for vitreous bonds of
20 technical ceramics and grinding wheels. Frits as well as ceramic bonds for vitrified bonded abrasive articles are commercially available from suppliers such as Ferro Corporation, 1000 Lakeside Avenue, Cleveland, Ohio, USA 441 14-7000 and Reimbold & Strick, Cologne, Germany. Frits for the use in vitrified bonded abrasive articles typically show melting temperatures in the range of 500 to 1300°C.

25 In accordance with the present invention, frits may be used in addition to the raw materials or in lieu of the raw materials. Alternatively, the vitreous bond may be derived from a non-frit containing composition.

30 For example, a vitreous bond can be formed from a vitreous bond precursor composition comprising from more than 0 to 100% by weight frit, although more typically the composition comprises 3 to 70% frit. The remaining portion of the vitreous bond precursor composition can be a non-frit material.

Suitable ranges for vitrified bond compositions can be specified as follows: 25 to 90% by weight, preferably 35 to 85% by weight, based on the total weight of the vitreous bond, of SiO_2 ; 0 to 40% by weight, preferably 0 to 30% by weight, based on the total weight of the vitreous bond, of B_2O_3 ; 0 to 40% by weight, preferably 5 to 30% by weight, based on the

total weight of the vitreous bond, of Al_2O_3 ; 0 to 5% by weight, preferably 0 to 3% by weight, based on the total weight of the vitreous bond, of Fe_2O_3 , 0 to 5% by weight, preferably 0 to 3% by weight, based on the total weight of the vitreous bond, of TiO_2 , 0 to 20% by weight, preferably 0 to 10% by weight, based on the total weight of the vitreous bond, of CaO ; 0 to 20% by weight, preferably 0 to 10% by weight, based on the total weight of the vitreous bond, of MgO ; 0 to 20% by weight, preferably 0 to 10% by weight, based on the total weight of the vitreous bond, of K_2O ; 0 to 25% by weight, preferably 0 to 15% by weight, based on the total weight of the vitreous bond, of Na_2O ; 0 to 20% by weight, preferably 0 to 12% by weight, based on the total weight of the vitreous bond, of Li_2O ; 0 to 10% by weight, preferably 0 to 3% by weight, based on the total weight of the vitreous bond, of ZnO ; 0 to 10% by weight, preferably 0 to 3% by weight, based on the total weight of the vitreous bond, of BaO ; and 0 to 5% by weight, preferably 0 to 3% by weight, based on the total weight of the vitreous bond, of metallic oxides [e.g. CoO , Cr_2O_3 (pigments)].

It is known in the art to use various additives in the making of vitreous bonded abrasive articles both to assist in the making of the abrasive article and/or improve the performance of such articles. Such conventional additives which may also be used in the practice of this invention include but are not limited to lubricants, fillers, temporary binders and processing aids.

Organic binders are preferably used as temporary binders. Typical temporary binders are dextrans, urea resins (including urea formaldehyde resins), polysaccharides, polyethylene glycol, polyacrylates, and any other types of glue etc. These binders may also include a liquid component, such as water or polyethylene glycol, viscosity or pH modifiers and mixing aids. The use of temporary binders may improve homogeneity and the structural quality of the pre-fired or green pressed body as well as of the fired article. Because the binders are burned out during firing, they do not become part of the finished bond or abrasive article.

Bonded abrasive articles according to the present invention can be made according to any suitable method. Procedures and conditions well known in the art for producing vitrified bonded abrasive articles (e.g., grinding wheels) and especially procedures and conditions for producing vitreous bonded sol-gel alumina-based abrasive articles may be used to make the

abrasive article of this invention. These procedures may employ conventional and well known equipment in the art.

5 An exemplary method for manufacturing a bonded abrasive article of the invention comprises the steps of:

- 10 (a) providing a precursor composition comprising shaped abrasive particles in accordance with the present invention and a vitreous bond precursor composition and optionally one or more components selected from a temporary binder composition (including for example one or more components selected from one or more temporary binder(s) and pore inducing agent(s)) and secondary abrasive particles;
- 15 (b) forming the precursor composition to a desired shape so as to obtain a green structure;
- (c) optionally, drying the green structure;
- 20 (d) firing the green structure obtained in step (b) or (c) at temperatures suitable to produce a vitreous bond (for example at temperatures selected from about 700°C to about 1500°C) so as to obtain a vitrified bonded abrasive article having a first shape (for example a straight wheel shape, e.g., T1 type);
- 25 (e) optionally, further altering the first shape in one or more shape features (for example bore, diameter, thickness, face profile) so as to obtain a bonded abrasive article having a second shape (for example a shape resulting from customer needs).

30 For example, during manufacture of a vitrified bonded abrasive article, the vitreous bond precursor composition, in a powder form, may be mixed with a temporary binder (typically an organic binder) which does not form part of the fired vitrified bonding medium. Bonded abrasive articles are typically prepared by forming a green structure comprised of abrasive grain, the vitreous bond precursor composition, and optionally, a temporary binder and other optional additives and fillers. Forming can for example be accomplished by molding with or without pressing. Typical forming pressures can vary within wide ranges and may be

selected from pressures ranging from 0 to 400 kg/cm², depending on the composition of the green structure. The green structure is then fired. The vitreous bond phase is usually produced in the firing step, typically at a temperature(s) in the range from about 700 °C to about 1500 °C, preferably in the range from about 750°C to about 1350°C and most preferably in the range from about 800°C to about 1300°C. Good results may be also obtained at temperatures of about 1000°C or less, or from about 1100 to about 1200°C. The actual temperature at which the vitreous bond phase is formed depends, for example, on the particular bond chemistry. Firing of the vitreous bond precursor composition is typically accomplished by raising the temperature from room temperature to the maximum temperature over a prolonged period of time (e.g., about 10-130 hours), holding at the maximum temperature, e.g., for 1-20 hours, and then cooling the fired article to room temperature over an extended period of time, e.g., 10-140 hours. It should be understood that the temperature selected for the firing step and the composition of the vitreous bond phase must be chosen so as to not have a detrimental effect on the physical properties and/or composition of the abrasive particles (shaped and optional secondary particles) contained in the abrasive article.

A bonded abrasive article according to the present invention comprises shaped abrasive particles (as defined in accordance with the present invention) and a bonding medium comprising a vitreous bond. In addition, the bonded abrasive article may comprise one or more optional components selected from secondary abrasive particles, fillers and additives.

The amounts of abrasive particles (which may be comprised in a blend including one or more secondary abrasive particles) may vary widely and can range for example from 10 to 80 %, more preferably from 25 to 60 % by volume.

While the invention has a most pronounced effect when the abrasive fraction (or blend) includes 100% by weight of shaped abrasive particles in accordance with the present invention based on the total weight of abrasive particles present in the abrasive fraction (or blend), it is also effective when the article contains for example as little as 5% by weight of shaped abrasive particles in accordance with the present invention and up to 95% by weight of secondary abrasive particles, based on the total weight of abrasive particles present in the abrasive fraction. Hence, the abrasive article can contain a total amount of abrasive particles

of up to 100% by weight of the abrasive particles according to this invention, based on the total weight of abrasive particles. In some embodiments, the bonded abrasive article can include from about 5 to 100, preferably 10 to 80 percent by weight of shaped abrasive particles; typically 20 to 60 percent by weight, and more typically 30 to 50 percent by weight, based on the total weight of abrasive particles. In some grinding applications the addition of a secondary abrasive particle is for the purpose of reducing the cost of the abrasive article by reducing the amount of premium priced shaped abrasive particles. In other applications a mixture with a secondary abrasive particle may have a synergistic effect.

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The amount of bonding medium may also vary widely and can range for example from 1 to 60 % by volume, more preferably 2.5 to 40% by volume.

Optionally, the bonded abrasive article can comprise porosity. Bonded abrasive articles containing porosity have an open structure (interlinked or interconnected porosity) which can provide chip clearance for high material removal, transport more coolant into the contact area while decreasing friction, and optimizes the self-sharpening process. Porosity enables the bonded abrasive article to shed used or worn abrasive particles to expose new cutting edges or fresh abrasive particles.

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Bonded abrasive articles according to the present invention can have any useful range of porosity; such as from about 5 to about 80 % by volume, preferably from about 20 to about 70 % by volume.

Preferably, the bonded abrasive article according to the present invention contains porosity.

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The porosity can be formed by the natural spacing provided by the packing density of the materials comprised in the bonded abrasive articles and by pore inducing components, as known in the art, or by both.

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Pore inducing components can be selected from temporary components (i.e. components not present in the final article) non-temporary components (i.e. (components present in the final article) and combinations thereof. Preferred pore inducing components should not leave any chemical traces in a finished abrasive article (i.e. be temporary components), do not expand upon removal, mix well with the abrasive particles and can provide the desired type (e.g.

interconnected) and extent of porosity. Pore inducing components are typically used in amounts ranging from 0-40 Vol.-% of the total article. Typical non-temporary pore inducing components may be selected from materials such as hollow spheres made of materials such as glass, ceramic (aluminium oxide) and glass particles. Typical temporary pore inducing components may be selected from materials such as polymeric materials (including foamed polymeric materials) cork, ground walnut shells, wood particles, organic compounds (such as naphthalene or paradichlorbenzene) and combinations thereof. In a preferred embodiment, the abrasive article contains porosity induced by using naphthalene (as a temporary pore inducing component).

Bonded abrasive articles according to the present invention may contain additional components such as, for example, fillers and additives, as is known in the art. Examples of optional additives contained in the bonded abrasive article include non-temporary pore inducing agents, as described in the foregoing, and any components used when making the vitreous bond, including but not limited to lubricants, fillers, temporary binders and processing aids.

Bonded abrasive articles in accordance with the present invention have a three-dimensional shape, which is not particularly limited. Typically, the shape of a bonded abrasive article according to the invention is selected depending on factors such as the intended grinding application (including grinding method, grinding conditions and workpiece) as well as customer needs.

By way of exemplification, International Standard ISO 603:1999 lists suitable shapes of bonded abrasive articles all of which are useful in the present invention. Standard types according to standards of FEPA (Federation of European Producers of Abrasives) or other standards as well as non-standard types can also be used.

By way of illustration, typical shapes can for example include but are not limited to the shape of a wheel, honing stone, grinding segment, mounted point or other types according to standard forms of FEPA or ISO 603:1999 and other standards as well as non-standard individual types.

A preferred bonded abrasive article is a vitrified bonded abrasive wheel, in particular, a vitrified bonded grinding wheel.

5 The diameter of abrasive wheels in accordance with the present invention is not particularly limited and can for example be selected to range from 1 mm to 2000 mm, or from 10 mm to 1200 mm or from 100 mm to 750 mm, although other dimensions may also be used. Likewise, the thickness of abrasive (grinding) wheels is not particularly limited. For example, the thickness can typically be selected to range from 2 to 600 mm, or from 5 to 350 mm, or from 10 mm to 300 mm, although other dimensions may also be used. For example,
10 a bore diameter may range from 0 mm to 800 mm, more typically from 4 mm to 400 or from 8 mm to 350 mm.

The particular design of the abrasive article (preferably grinding wheel) is not limited and can be selected from "monolithic" designs and "zonal" design (such as segmented and
15 layered designs). Both designs can include the reinforcement of the bore by using glues such as thermosetting resins, for example resins selected from epoxy resins, polycondensates, and phenolic resins.

20 The abrasive particles (i.e. one or more type of shaped abrasive particles and optionally one or more types of secondary abrasive particles) may be homogeneously or non-homogeneously distributed in the abrasive article, for example be distributed or concentrated in selected areas, layers, segments or portions of the abrasive article. Homogeneous or non-homogeneous distribution may be either as a homogeneous blend or in a way that different types of abrasive particles are located and distributed only in selected areas, layers, segments
25 or portions of the abrasive article.

For example, a bonded abrasive wheel, may comprise at least two distinct sections, including an outer zone (also often referred to as rim or periphery) and an inner zone (also often referred to as core or center portion). The distinct sections may be provided based on
30 differences in one or more aspects selected from the composition of the bond (for example the type of bonding material or the amount of porosity present), the shape of abrasive particles (for example shaped versus crushed or first shape versus second shape), the grit size of abrasive particle (for example, finer versus coarser) and the amount of abrasive particles

(for example presence or absence of abrasive particles or first (for example high) amount versus second (for example low) amount).

5 In some embodiments the outer zone comprises shaped abrasive particles according to the present invention whereas the inner zone does not.

In other embodiments, the inner zone comprises shaped abrasive particles according to the present invention whereas the outer zone does not.

10 An abrasive wheel may also contain an inner zone made of a non-vitreous bonding material (such as plastics etc.).

15 If the bonded abrasive article is an abrasive wheel, such as a grinding wheel, the abrasive particles may be concentrated towards the middle, or only in the outer zone, i.e., the periphery, of the wheel. The center portion may contain a different (higher or lower) amount of abrasive particles.

20 Another example for a zonal design is an abrasive wheel, such as a grinding wheel, having a rim containing shaped abrasive particles in accordance with the present invention and an inner zone optionally containing and preferably not containing shaped abrasive particles in accordance with the present invention. The inner zone of this design may optionally contain secondary abrasive particles (e.g, fused alumina, sintered alumina) that may have the same or different grit size. This design is also referred to as special centre design which is intended to minimize the grinding wheel costs due to the lack of shaped abrasive particles and at the same time to increase the bursting speed.

25 In another variation, an abrasive wheel may include two or more types of abrasive particles positioned on different sides of the abrasive wheel. For example, first abrasive particles may be on one side of the wheel with different abrasive particles on the opposite side. Either the first or the second abrasive particles or both are selected from shaped abrasive particles in accordance with the present invention. However, typically all the abrasive particles are homogenously distributed among each other, because the manufacture of the wheels is

easier, and the grinding effect is optimized when the abrasive particles or the two or more types thereof are closely positioned to each other.

5 In one embodiment, abrasive particles according to the present invention are homogeneously distributed throughout the bonded abrasive article.

10 The present invention also relates to a method for abrading a workpiece, the method comprising frictionally contacting at least a portion of an abrasive article in accordance with the invention with a surface of a workpiece; and moving (for example rotating) at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.

15 The bonded abrasive articles of this invention can be advantageously used in a wide range of grinding applications.

Beneficial effects may be in particular achieved in grinding applications which involve high material removal rates, in particular grinding applications selected from roughing and semi-roughing operations, i.e. applications typically involving high material removal rates.

20 The present invention is however not limited to grinding applications which involve high material removal rates but may also be beneficially used in grinding applications which do not involve high material removal rates, such as finishing operations.

25 Hence, the bonded abrasive articles of this invention can be suitably used in a wide range of grinding applications ranging from roughing operations via semi-roughing to finishing operations.

Exemplary grinding applications include but are not limited to standardized and non-standardized grinding applications, for example methods according to DiN-8589:2003.

30 The bonded abrasive articles of this invention are particularly suitable for applications including but not limited to cylindrical grinding (outer diameter or OD grinding as well as internal diameter or ID grinding), centerless grinding, gear grinding, generating gear

grinding, surface and profile grinding, reciprocating grinding, creep-feed grinding, grinding in generating method as well as by other methods of gears, threads, tools, camshafts, crankshafts, bearings, guard rails, etc. Cut-off operations are less preferred but included within the scope of the present invention. Preferred applications include gear grinding, creep-feed grinding, surface grinding, profile grinding, reciprocating grinding, grinding in generating method, cylindrical grinding (OD and ID grinding) and centerless grinding, and particularly preferred applications include cylindrical grinding applications, gear grinding applications, surface grinding applications and particularly creep-feed-grinding applications. The applied force during abrading is not particularly limited and can be selected on the basis of the grinding application.

During use, the bonded abrasive article can be used dry or wet. During wet grinding, the bonded abrasive article is typically used in conjunction with a grinding fluid which may for example contain water or commercially available lubricants (also referred to as coolants). During wet grinding lubricants are commonly used to cool the workpiece and wheel, lubricate the interface, remove swarf (chips), and clean the wheel. The lubricant is typically applied directly to the grinding area to ensure that the fluid is not carried away by the grinding wheel. The type of lubrication used depends on the workpiece material and can be selected as is known in the art.

Common lubricants can be classified based on their ability to mix with water. A first class suitable for use in the present invention includes oils, such as mineral oils (typically petroleum based oils) and plant oils. A second class suitably for use in the present invention includes emulsions of lubricants (for example mineral oil based lubricants; plant oil based lubricants and semi-synthetic lubricants) and solutions of lubricants (typically semi-synthetic and synthetic lubricants) with water.

Abrasive articles in accordance with the present invention can be used on any grinding machine specific for the grinding method. The grinding machine can be electrically, hydraulically or pneumatically driven, at any suitable speed, generally at speeds from about 10 to 250 *mis*.

Bonded abrasive articles according to the present invention are useful, for example, for abrading a workpiece. The bonded abrasive article can be particularly suitable for use on workpieces made of metal, such as steel (including powder metallurgical steel and steel alloys, carbon steels, mild steels, tool steels, stainless steel, hardened steel, ball bearing steel, cold working steel, cast iron), non-ferrous metals and alloys (such as aluminum, titanium, bronze, etc.), hard metals (such as tungsten carbide, titanium carbide, titanium nitride, cermets, etc), ceramics (technical ceramics such as oxide ceramics, silicate ceramics, non-oxide ceramics), and glasses. The use of the bonded abrasive articles is however not restricted to the use on these exemplified workpiece materials.

Preferred grinding methods according to the present invention include but are not limited to cylindrical grinding applications, gear grinding applications and surface grinding applications including creep feed grinding applications.

Gear Grinding

The term gear grinding as used in the present invention generally refers to a method of generative grinding and profile grinding of gears. Gear wheels determine the transmission ratios of gearboxes; according to the second fundamental law of gearing, this ratio will only remain constant if the next tooth is already engaged before the previous tooth disengages. The more perfectly ground the surface of the tooth flanks, the better is the form fit, and the more smoothly and quietly the gearbox runs. The process of machining the tooth flanks brings with it tough demands in terms of dimensional accuracy and shape accuracy – and also places tough demands particularly on the edge zone properties of the component. Whereas very slight deviations in terms of the macro and micro-geometry - which influence the amount and type of noise generated by the teeth – may be tolerable within strict limits depending on the quality requirements, a "zero tolerance" policy applies to the edge zone of the tooth flank. Damage to the edge zone as a result of influence on the structure will contribute to faster wear of the teeth and can, in extreme cases, cause the tooth to fracture and break off. In the context of these requirements, different techniques may be useful all of which are included within the scope of the present invention.

Exemplary gear grinding techniques include:

- 5 - Gear grinding with the continuous generative grinding technique using grinding worms: The bonded abrasive article (typically a grinding wheel) has a shape that corresponds to a grinding worm, the basic tooth profile of which should always be seen as a rack profile. The involute form is generated through continuous generative grinding of the grinding worm and the gearing). The process lends itself very well to the series production of gear wheels.

- 10 - Gear grinding with globoidal grinding worms (continuous profile grinding): unlike the continuous generative grinding technique, the shape of the bonded abrasive article in this case does not correspond to a grinding worm with a rack profile as the basic tooth profile. Instead, a globoidal grinding worm maps the contour of the tooth flank. During the grinding process the tooth form is produced through virtually linear engagement of the tool in the tooth gap. This method is predestined for grinding
15 bevel gears which are used primarily in differential gears and can optionally be combined with a subsequent honing step.

- 20 - Single flank generating grinding: The involute shape is produced in a generative grinding process in which the grinding wheel only machines a single flank in the direction of grinding per tooth gap. This method allows the machining of different moduli with an unchanged wheel width and allows different infeeds for the left or right-hand tooth flank.

- 25 - Form or profile grinding with radial infeed: The involute form is transferred to the bonded abrasive article (most typically a grinding wheel), which then generates the form in the tooth gap of the workpiece.

- 30 - Form or profile grinding with rotative infeed: The involute form is transferred to the bonded abrasive article (typically a grinding wheel), which then generates the form in the tooth gap of the workpiece.

Bonded abrasive articles for use in the gear grinding applications are not particularly limited and as described in the foregoing. In preferred embodiments, the bonded abrasive articles for

use in gear grinding applications may be characterized by a particle shape selected from flat triangles or flat rectangles wherein optionally at least one face is shaped inwardly, as described in the foregoing with respect to particularly preferred particle shapes.

5 Creep-feed grinding

Creep-feed grinding can be considered as a specific case of surface grinding. However, in contrast to surface grinding with a reciprocating linear cutting motion, creep-feed grinding uses relatively large cutting depths but comparatively low feed rates. The total grinding allowance is generally achieved in a few passes. With creep-feed grinding, a distinction is made between surface grinding and cylindrical grinding operations. One special form of creep-feed grinding is outside-diameter longitudinal grinding (peel grinding).

Creep-feed grinding typically uses rotating dressing devices and is typically operated wet. With creep-feed grinding, the workpiece form can be produced with large infeeds of up to 15 mm in a single grinding pass. As with increasing infeed the length of contact between the workpiece and the bonded abrasive article increases significantly, the processes of transporting the grinding fluid and carrying away the grinding detritus is made more difficult. As a result, creep-feed grinding requires open-pored abrasive articles with a low hardness and a continuous supply of grinding fluid in large quantities. This method is particularly well suited to the final cutting of high-precision profiles like guideways and clamping profiles of turbine vanes.

Bonded abrasive articles for use in creep-feed grinding applications are not particularly limited and as described in the foregoing. In preferred embodiments, the bonded abrasive articles for use in creep-feed grinding applications may be characterized by a particle shape selected from flat triangles or flat rectangles wherein optionally at least one face is shaped inwardly, as described in the foregoing with respect to particularly preferred particle shapes.

30 Surface grinding (except creep-feed grinding)

Surface grinding or face grinding techniques are commonly divided into peripheral-longitudinal surface grinding (surface grinding, face grinding of large surfaces) and peripheral-transverse surface grinding (flute grinding, profile grinding).

5 In the case of peripheral-longitudinal grinding, the grinding wheel engages at right angles and advances by the selected feed increment into the workpiece, which is moved by the machine table. In the process, the infeed and feed rate define the grinding result.

10 Peripheral-transverse surface grinding is ideally suited to producing large, flat surfaces. With this method, the bonded abrasive article is also positioned at right angles to the workpiece, but it is fed in by the amount which exactly corresponds to the width of the bonded abrasive article. Both methods can be used for reciprocating grinding and creep-feed grinding.

15 With reciprocating grinding, the bonded abrasive article moves over the workpiece "backwards and forwards" at right angles to the reference edge - the resulting motion is described as being "reciprocating". This method is seen as the oldest variant of surface grinding and is characterised by low cutting depths (for example as low as 0.005 to 0.2 mm) and high table speeds (for example ranging from 15 to 30 m/min). The technique is particularly useful for materials which are easy to grind, small batch sizes and low amounts
20 of material removal, as well in cases of relatively low machine investment.

Bonded abrasive articles for use in surface grinding applications are not particularly limited and as described in the foregoing. In preferred embodiments, the bonded abrasive articles for use in surface grinding applications may be characterized by a particle shape selected from
25 flat triangles or flat rectangles wherein optionally at least one face is shaped inwardly, as described in the foregoing with respect to particularly preferred particle shapes

Cylindrical Grinding

30 Cylindrical grinding is a grinding technique which is commonly characterized by having one or more and preferably all of the following four features:

(1) The workpiece is constantly rotating; (2) The grinding wheel is constantly rotating; (3) The grinding wheel is fed towards and away from the work; (4) Either the work or the grinding wheel is traversed with the respect to the other.

5 While the majority of cylindrical grinding applications employ all four movements, there are applications that only employ three of the four actions. Three main types of cylindrical grinding are outside diameter (OD) grinding, inside diameter (ID) grinding, and centerless grinding and any one of these techniques can be suitably used in the present invention:

10 - Outside diameter (OD) grinding is one of the most frequently used grinding techniques - for example in the automotive industry, where it is used in the grinding of camshafts and crankshafts. During the course of industrial development and in response to the requirements which have emerged as a result, outside diameter grinding has been divided into different variants of the technique which differ
15 depending on the way in which the workpiece is mounted and according to the principle feed direction.

- o Peripheral-transverse outer diameter (OD) grinding between centers (also known as plunge grinding)
- 20 o Centerless peripheral-transverse outer diameter (OD) grinding
- o Peripheral-longitudinal outer diameter (OD) grinding between centers (also known as throughfeed grinding)
- o Centerless peripheral-longitudinal outer diameter (OD) grinding

25 In processes of grinding between centers, the workpiece is clamped firmly between two centers in centering fixtures on its end faces, and in this position the workpiece is driven by the grinding machine. Depending on the principle feed direction of the wheel - right-angled plunge feed or parallel movement along the workpiece - this is referred to as transverse or longitudinal grinding.

30 In the process of peripheral-transverse outer diameter grinding, the grinding wheel is generally at right angles to the workpiece. This technique is generally used to machine bearing seats, shoulders and grooves using straight plunge grinding. Often

the cut-in is divided into several process steps which are performed in sequence with ever decreasing chip removal rates. Depending on the particular task and the size of the batch, angle plunge grinding is another variant which may be more productive.

5 The process of peripheral-longitudinal outer diameter grinding is particularly suitable for applications requiring cylindrical or conical workpieces which are significantly longer than the width of the grinding wheel. Examples include but are not limited to the machining of press cylinders and rollers for paper production, as well as rollers for use in rolling mills in the steel industry. In this technique the grinding wheel
10 moves parallel to the workpiece and is fed in at the reversal point at right angles to the workpiece. The required finished dimension can either be attained in several passes or in just a single pass – the latter being referred to as peel grinding. These methods are comparable to creep-feed grinding and reciprocating grinding. In the automotive industry, peel grinding is used for example in the production of drive
15 shafts.

- Centerless grinding: If the challenge is to machine large quantities of long and/or thin, round components made of pliable or brittle materials, centerless grinding might be the solution. In addition, centerless grinding is a technique which can allow
20 multiple tasks – e.g. roughing and finishing - to be performed in a single pass. The machining process itself corresponds to the other cylindrical grinding techniques like the ones previously mentioned with respect to "Outside diameter grinding" - even without centers the process still involves plunge grinding and through feeding techniques.

25 - Internal diameter (ID) grinding provides perfect functional surfaces in components which need to establish a non-positive connection with an axle or shaft. Similarly to outer diameter (OD) grinding, this method is split into two different techniques according to the direction of grinding:

- 30
- o Peripheral-transverse internal diameter (ID) grinding (plunge grinding)
 - o Peripheral-longitudinal internal diameter (ID) grinding

In terms of the behaviour of the grinding wheel and the workpiece, both techniques display virtually identical properties to outer diameter (OD) grinding between centres. Application examples where ID grinding is commonly used include but are not limited to the refining of bores with a high-precision fit; for the machining of
5 hard and super-hard materials, to machine different diameters in a single pass as well as to produce tapered fits and in situations where the grinding wheel needs to be narrower than the surface which is to be machined and a combination of longitudinal and plunge grinding is required. In typical cases the grinding wheel diameter should not exceed 2/3 or a maximum of 4/5 of the bore diameter.

10 Bonded abrasive articles for use in cylindrical grinding applications are not particularly limited and as described in the foregoing. In preferred embodiments, the bonded abrasive articles for use in cylindrical grinding applications may be characterized by a particle shape selected from flat triangles or flat rectangles wherein optionally at least one face is shaped
15 inwardly, as described in the foregoing with respect to particularly preferred particle shapes.

Surprisingly, bonded abrasive articles in accordance with the present invention have been found to provide excellent results in a wide range of grinding applications and in particular in high performance grinding applications.

20 For the purposes of the present invention, the term high performance grinding application is intended to refer to higher material removal rates than is commonly possible with present day conventional abrasives. Conventional abrasives encompass all types of aluminium oxide including so-called ceramic abrasives, and silicon carbide.

25 High performance grinding can be established for a specific grinding application based on the knowledge of sound grinding engineering and adequate modern CNC (Computerized Numerical Control) machinery. One parameter to define high performance grinding could be the specific material removal rate QV also called Q -prime. Q'_w indicates how many mm^3 of workpiece material one mm wheel width removes per second ($\text{mm}^3/\text{mm}/\text{sec}$). Q'_w can be
30 calculated based on two parameters, namely the depth of cut a_e and the feed rate v_w , according to the formula $Q'_w = [a_e \times v_w]/60$. The specific material removal rate Q'_w can be increased by increasing the feed rate v_w and/or the depth of cut a_e . [The peripheral speed v_c

does not have an influence on QV] Values for Q'_w are typically indicated by using the unit $\text{mm}^3/\text{mm}^2\cdot\text{s}$ or $\text{mm}^3/(\text{mm}^2\cdot\text{s})$.

Typical ranges for Q'_w for exemplary high performance grinding applications can be specified as follows: Inner diameter (ID-) grinding 1-15, preferably 2-12, most preferably 4-11 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; outer diameter (OD-) grinding 1.5-25, preferably 3-22, most preferably 4-20 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; surface grinding 1.5-20, preferably 2-17, most preferably 4-19 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; profile grinding 3-60, for example 3-50, preferably 5-45, most preferably 7-50 or 7-40 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; profile grinding with generating method 8-60, preferably 10-55, most preferably 14-50 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; creep-feed grinding 4-100, preferably 6-90, most preferably 9-80 $\text{mm}^3/\text{mm}^2\cdot\text{s}$; and camshaft grinding 8-100, preferably 12-95, most preferably 15-90 $\text{mm}^3/\text{mm}^2\cdot\text{s}$.

While the values mentioned above refer to roughing and semi-roughing operations, in finishing operations the Q'_w values may be $<1 \text{ mm}^3/\text{mm}^2\cdot\text{s}$.

Bonded abrasive articles of the present invention have been found to provide constant grinding results over a long period of time and particularly under severe grinding conditions (for example at high specific material removal rates).

In addition, bonded abrasive articles in accordance with the present invention can provide a better surface finish (decreased surface roughness R_a) on the workpiece used in a wide range of grinding applications ranging from roughing via semi-roughing to finishing operations. In some instances, bonded abrasive articles incorporating a coarser particle size of shaped abrasive particles may surprisingly provide better surface quality as compared to a finer particle size.

During use the bonded abrasive articles can also ensure a reduced risk of damaging the workpiece (such as by workpiece burning or discoloration) while at the same time minimizing the clogging of the bonded abrasive article during use.

Bonded abrasive articles of the present invention are characterized by long dressing cycles thus allowing more workpiece parts to be finalized between dressing cycles as well as a long total serve life of the bonded abrasive article.

5 Due to the high material removal rates which can be realized using bonded abrasive articles of the present invention, shorter grinding times can be accomplished contributing to a higher workpiece flow in overall.

10 Another parameter which is often used to characterize the performance of a grinding application is the specific chip volume V'_w . V'_w indicates the total amount of workpiece material [mm^3] that is removed in a grinding application before dressing has to be set up (i.e. during one grinding cycle). The time after which dressing has to be set up (i.e., the end of the grinding cycle) can be easily recognized by a person skilled in the art of grinding. By way of example, the end of a grinding cycle is typically indicated by a somewhat prominent drop in
15 the power drawn by the grinding machine. Other factors which can be used as additional or alternative indicators for recognizing the end of a grinding cycle include but are not limited to the loss of the form and profile holding of the bonded abrasive article, decrease of workpiece quality, for example burning or discoloration of the workpiece, or worse surface finish indicated by an increased surface roughness R_a .

20 At the end of a grinding cycle, the specific chip volume can be easily calculated by a skilled person, as is known in the art. For the purpose of determining the specific chip volume, the actual start of grinding is taken as the starting point of the grinding cycle. For evaluating the performance of a specific grinding application, the specific material removal rate Q'_w is
25 typically set constant and the performance of the grinding application is evaluated with respect to the specific chip volume V'_w .

In practice, the specific chip volume is commonly based on the effective width of the active abrasive article's profile used in the grinding application (i.e. the specific chip volume
30 indicates the total volume of workpiece material removed per 1 mm of width of the bonded abrasive article, for example 1 mm wheel width during one grinding cycle).

Bonded abrasive articles in accordance with the present invention have surprisingly been found to provide excellent results with respect to the specific chip volume V'_w , in particular in applications such as gear grinding, thus for example leading into higher set limits for redressing. It is to be emphasized that such excellent results with respect to the chip volume surprisingly can also be achieved at high material removal rates i.e., when using a high constant value of Q'_w during the grinding cycle, for example when using gear grinding (such as single rib ear grinding) with a specific material removal rate Q'_w of at least 5 mmVmm/s, typically of at least 10 mmVmm/s, more typically of at least 14 mmVmm/s or at least 16 mmVmm/s and even more typically of at least 20 mmVmm/s, preferably of at least 25 mmVmm/s and more preferably of at least 30 mm³/mm/s. Typically, abrasive articles based on conventional abrasive particles show lower specific chip volumes V'_w at a higher specific material removal rate Q'_w as compared to the same grinding application at a lower specific material removal rate Q'_w and typically show adverse effects with respect to the workpiece such as burning or discoloration when used at higher specific material removal rates. Even under these severe grinding conditions no workpiece burning or discoloration was observed when using bonded abrasive articles in accordance with the present invention.

While in particular grinding applications such as gear grinding applications have been found to provide such excellent results with respect to the specific chip volume, other grinding applications are expected to provide similar pronounced effects.

Bonded abrasive articles in accordance with the present invention incorporating shaped abrasive particles as defined herein can provide specific chip volumes that are substantially higher than those commonly achieved with present day conventional abrasives (as defined with respect to high performance grinding applications). In other words, using a given set of grinding conditions [given workpiece, given grinding application at constant Q'_w ; for example 17CrNiMo6, gear grinding at a constant specific material removal rate Q'_w of 14 mm³/mm/s (or even with a specific material removal rate Q'_w as high as 30 mm³/mm/s)], a bonded abrasive article in accordance with the present invention typically provides a specific chip volume that is at least 20% higher, more typically at least 50%, higher, even more typically at least 100% higher, even more typically at least 200% higher and most typically at least 300% higher than the specific chip volume achieved when using a comparable

bonded abrasive article using the same set of grinding conditions (in particular the same specific material removal rate Q_v)-

5 A person skilled in the art of grinding can easily ascertain an appropriate comparable bonded abrasive article. A bonded abrasive article suitable for use as a comparable bonded abrasive article can for example be based on the same abrasive material but with the only difference that the abrasive particles are not shaped. For example, the same bonded abrasive article but wherein the shaped abrasive particles according to the invention are replaced with the same nominal size and weight of crushed abrasive particles having the same chemical composition
10 could be used as a comparable bonded abrasive article. A comparable bonded abrasive article should also contain the same nominal size(s) and weight(s) of any optional secondary abrasive particles having the same chemical compositions) as used in the bonded abrasive article to be evaluated. Hence, the shaped abrasive particles as defined herein contained in the bonded abrasive article to be evaluated preferably represent the only difference to the
15 comparable bonded abrasive article used when evaluating the specific chip volume V'_w . That means that the same type (particularly with respect to the chemical composition) and volume amount of bonding medium (and optionally the same volume amount of porosity, if any) is preferably used for the bonded abrasive article to be evaluated and the comparable bonded abrasive article.

20 By way of illustration, specific chip volumes as achievable in the present invention are typically higher by factor 2, or 5, or 10, or 15 and even 20 than what is commonly achieved with a comparable bonded abrasive article based on such present day conventional abrasives.

25 For example, using a bonded abrasive article of the present invention, a grinding application [such as gear grinding (particularly single rib gear grinding) a workpiece made of for example 17CrMMo6 with a specific material removal rate Q'_w of for example 14 $\text{mm}^3/\text{mm/s}$] can easily provide specific chip volumes of at least 850 mm^3/mm , particularly of at least 1500 mm^3/mm , greater, more particularly of at least 2500 mm^3/mm , even more
30 particularly of at least 10000 mm^3/mm and even more particularly of 15 000 mm^3/mm or greater or of even 30 000 mm^3/mm or greater.

The present invention thus also relates to a method of grinding (in particular, a method of gear grinding, more particularly single rib gear grinding) characterized by using a bonded abrasive article according to the present invention, wherein the specific chip volume V'_w is at least 20% higher, preferably at least 50% higher, more typically at least 100% higher, even more typically at least 200% higher and most typically at least 300% higher than the specific chip volume achieved when using a comparable bonded abrasive article under the same set of grinding conditions, in particular at the same specific material removal rate Q'_w .

The present invention also relates to a method of grinding (in particular, a method of single rib gear grinding at a specific material removal rate of Q'_w of 14) characterized by using a bonded abrasive article according to the present invention, wherein the specific chip volume is at least 850 mm³/mm, particularly at least 1 500 mm³/mm greater, preferably at least 2 500 mmVmm, more preferably at least 10 000 mmVmm and even more preferably 15 000 mmVmm or greater or at least 30 000 mmVmm or greater. In other preferred embodiments, the present invention relates to a method of grinding (in particular, a method of single rib gear grinding at a specific material removal rate of Q'_w of 16) characterized by using a bonded abrasive article according to the present invention, wherein the specific chip volume is at least 850 mmVmm, particularly at least 1 500 mmVmm greater, preferably at least 2500 mmVmm, more preferably at least 10 000 mm³/mm and even more preferably 15 000 mmVmm or greater or at least 30 000 mmVmm or greater, and in other preferred embodiments is more than 10 000 mmVmm, preferably at least 11 000, even more preferably 15 000 mmVmm or greater and most preferably 30 000 mmVmm or greater.

Other effects achieved in the present invention are high form or profile holding of the bonded abrasive article. This translates into less dressing, and therefore better process and tool consumption economics.

The use of shaped abrasive particles (such as flat triangles and flat rectangles as described herein, optionally having one or more faces shaped inwardly), in vitrified bonded abrasive articles allows these beneficial effects to be achieved for a wide range of different compositions of the bonded abrasive article as well as for a wide variety of applications. Although in some applications a most pronounced effect might be achieved when the abrasive article comprises 100% shaped abrasive particles in accordance with the present

invention based on the total amount of abrasive particles present in the article, articles containing for example as little as 5% by weight of shaped abrasive particles in accordance with the present invention and up to 95% by weight of secondary abrasive particles, based on the total amount of abrasive particles present in the article, have also been shown to provide excellent performance over a wide range of applications.

The effects achieved in the present invention are also unexpected in view of the fact that the bonded abrasive article typically does not have to comprise the shaped abrasive in any specific orientation. Unlike the situation in comparatively thin coated abrasive articles where orientation may be of advantage, the bonded abrasive article (for example, wheel, segment, layer or part thereof) typically comprises the shaped abrasive particles in a random orientation, although orientation of the particles is not excluded from the scope of the present invention.

In embodiments, the present invention relates to the following items:

1. A bonded abrasive article comprising shaped abrasive particles and a bonding medium comprising a vitreous bond, said shaped abrasive particles each comprising a first side and a second side separated by a thickness t , wherein said first side comprises a first face having a perimeter of a first geometric shape.
2. The article of item 1, wherein the thickness t is equal to or smaller than the length of the shortest side-related dimension of the particle.
3. The article according to items 1 or 2, wherein the shaped abrasive particles are ceramic shaped abrasive particles.
4. The article according to any of items 1 to 3, wherein the shaped abrasive particles comprise alpha alumina.
5. The article according to any of items 1 to 4, wherein the shaped abrasive particles comprise non-seeded sol-gel derived alpha alumina.

6. The article according to any of items 1 to 4, wherein the shaped abrasive particles comprise seeded sol-gel derived alpha alumina.
7. The article according to any of items 1 to 6, further comprising secondary abrasive particles.
8. The article according to item 1, wherein the shaped and secondary abrasive particles are independently selected from particles of fused aluminum oxide materials, heat treated aluminum oxide materials, ceramic aluminum oxide materials, sintered aluminum oxide materials, silicon carbide materials, titanium diboride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride, garnet, fused alumina-zirconia, sol-gel derived abrasive particles, cerium oxide, zirconium oxide, titanium oxide or a combination thereof.
9. The article according to item 7 or 8, wherein the secondary abrasive particles are selected from crushed abrasive particles having a specified nominal grade.
10. The article according to item 9, wherein the crushed abrasive particles are of a smaller size than the shaped abrasive particles.
11. The article according to any of items 1 to 10 comprising 10 to 80 % by volume of said shaped abrasive particles.
12. The article according to any of items 1 to 11 comprising 1 to 60 % by volume of said bonding medium.
13. The article according to any of items 1 to 12, wherein said vitreous bond comprises, based on the total weight of the vitreous bond, 25 to 90% by weight of SiO_2 ; 0 to 40% by weight of B_2O_3 ; 0 to 40% by weight of Al_2O_3 ; 0 to 5% by weight of Fe_2O_3 ; 0 to 5% by weight of TiO_2 ; 0 to 20% by weight of CaO ; 0 to 20% by weight of MgO ; 0 to 20% by weight of K_2O ; 0 to 25% by weight of Na_2O ; 0 to 20% by weight of Li_2O ; 0 to 10% by weight of ZnO ; 0 to 10% by weight of BaO ; and 0 to 5% by weight of metallic oxides.

14. The article according to any of items 1 to 13, wherein the vitreous bond is obtainable from a vitreous bond precursor composition comprising frit.
- 5 15. The article according to any of item 14, wherein the vitreous bond precursor composition comprises 3 to 70 % by weight of a frit based on the total weight of the vitreous bond precursor composition.
16. The article according to any of items 1 to 15, comprising porosity.
- 10 17. The article according to any of items 1 to 16 comprising, based on the volume of the article, 1 to 60 % by volume of a vitreous bond, 10 to 80 % by volume of shaped abrasive particles and 5 to 80 % by volume of porosity.
- 15 18. The article according to any of items 7 to 17 wherein the shaped abrasive particles and the secondary abrasive particles are comprised in a blend, wherein the content of the secondary abrasive particles is up to 95% by weight based on the total weight of abrasive particles present in the blend.
- 20 19. The article according to any of items 1 to 18, wherein the ratio of the length of the shortest side-related dimension to the thickness of said particle is at least 1:1.
- 25 20. The article according to any of items 1 to 19, wherein said first geometric shape is selected from polygonal shapes, lense-shapes, lune-shapes, circular shapes, semicircular shapes, oval shapes, circular sectors, circular segments, drop-shapes and hypocycloids.
- 30 21. The article according to any of items 1 to 20 wherein said first geometric shape is selected from triangular shapes and quadrilateral shapes.
22. The article according to any of items 1 to 21 wherein said first geometric shape is a quadrilateral shape selected from a rectangle, a rhombus, a rhomboid, a kite, or a superellipse.

23. The article according to any of items 1 to 21 wherein said first geometric shape is a triangular shape selected from isosceles triangular shapes and equilateral triangular shapes.
- 5
24. The article according to any of items 1 to 23, wherein the shaped abrasive particles have a volumetric aspect ratio and the volumetric aspect ratio is greater than about 1.15.
- 10
25. The article according to any of items 1 to 24, comprising at least one sidewall.
26. The article according to item 25, wherein the sidewall comprises one or more facets.
27. The article according to item 26, wherein the one or more facets have a shape independently selected from triangular and quadrilateral geometric shapes and combinations thereof.
- 15
28. The article according to any of items 25 to 27, wherein the at least one sidewall is a sloping sidewall.
- 20
29. The article according to any of items 25 to 28, further comprising a draft angle alpha between the second face and the sidewall, the draft angle alpha being greater than 90 degrees.
- 25
30. The article of item 29, wherein the draft angle alpha is between about 95 to about 135 degrees.
31. The article according to any of items 25 to 28, wherein the sidewall intersects the first side at an angle beta of between 5 to about 65 degrees.
- 30
32. The article according to any of items 1 to 31, wherein said shaped abrasive particles each comprise at least one shape feature selected from: an opening, at least one recessed (or concave) face; at least one face which is shaped outwardly (or convex);

at least one side having a plurality of grooves or ridges; at least one fractured surface; a low roundness factor; a perimeter of the first face comprising one or more corner points having a sharp tip; a second side comprising a second face having a perimeter comprising one or more corner points having a sharp tip; or a combination of one or more of said shape features.

5

33. The article according to any of items 1 to 32, wherein the shaped abrasive particles each have an opening.

10

34. The article according to any of item 33, wherein the opening passes through the first side and the second side.

35. The article according to any of items 1 to 34, wherein the shaped abrasive particles further comprise a plurality of grooves and/or ridges on the second side.

15

36. The article according to any of items 1 to 35 wherein the second side comprises a vertex or a ridge line or a second face.

20

37. The article according to item 36, wherein the second side comprises a second face separated from the first side by thickness t and at least one sidewall connecting the second face and the first face.

38. The article according to item 37, wherein the thickness is equal to or smaller than the length of the shortest facial dimension of the particle.

25

39. The article according to item 37 or 38, wherein the second face has a perimeter of a second geometric shape which may be the same or different to the first geometric shape.

30

40. The article according to item 39, wherein said first and second geometric shapes are independently selected from regular polygons, irregular polygons, lenses, lunes, circulars, semicirculars, ovals, circular sectors, circular segments, drop-shapes and hypocycloids.

41. The article according to items 39 or 40, wherein the first and second geometric shapes have identical geometric shapes which may or may not be different in size.
- 5 42. The article according to item 41, wherein the first and second geometric shapes are selected from substantially triangular shapes.
43. The article according to item 42, wherein the substantially triangular shape comprise the shape of an equilateral triangle.
- 10 44. The article according to any of items 37 to 43, wherein the first face and the second face are substantially parallel to each other.
45. The article according to any of items 37 to 44, wherein the first face and the second face are nonparallel to each other.
- 15 46. The article according to any of items 37 to 45, wherein the sidewall is a sloping sidewall.
- 20 47. The article according to any of items 37 to 46, further comprising a draft angle alpha between the second face and the sidewall, and the draft angle alpha is greater than 90 degrees.
- 25 48. The article according to item any of items 37 to 47 comprising a first sloping sidewall having a first draft angle, a second sloping sidewall having a second draft angle, and a third sloping sidewall having a third draft angle.
49. The article according to item 48, wherein the first draft angle, and the second draft angle, and the third draft angle have different values from each other.
- 30 50. The article according to item 48, wherein the first draft angle, the second draft angle, and the third draft angle are equal.

51. The article according to any of items 37 to 50, wherein the first and the second face are substantially planar.
52. The article according to any of items 37 to 50, wherein at least one of the first and second face is a non-planar face.
53. The article according to item 52, wherein the first face is recessed or concave and the second face is substantially planar.
54. The articles according to item 52, wherein the first face is convex and the second face is recessed or concave.
55. The article according to item 52, wherein the first face is recessed or concave and the second face is recessed or concave.
56. The article according to item 52, wherein the particles are dish-shaped abrasive particles each having a sidewall and a varying thickness t , wherein the first face is recessed and a thickness ratio of T_c/T_i for the dish-shaped abrasive particles is between 1.25 to 5.00.
57. The article according to item 52 or 56, wherein the first face comprises a substantially planar center portion and a plurality of raised corners.
58. The article according to any of items 37 to 57, wherein the second side comprises a second face and four facets intersecting the second face at a draft angle α forming a truncated pyramid.
59. The article of item 58, wherein the draft angle α is between about 95 to about 135 degrees.
60. The article according to item 36, wherein the second side comprises a vertex separated from the first side by thickness t and at least one sidewall connecting the vertex and the perimeter of the first face.

61. The article according to item 60, wherein the sidewall comprises one or more facets connecting the vertex and the perimeter of the first face.
- 5 62. The article according to item 60 or 61, wherein the perimeter of the first face is trilateral, quadrilateral or higher polygonal and wherein the second side comprises a vertex and the corresponding number of facets for forming a pyramid.
- 10 63. The article according to any of items 60 to 62, wherein the first side comprises a quadrilateral having four edges and four vertices with the quadrilateral being selected from the group consisting of a rectangle, rhombus, a rhomboid, a kite, or a superellipse.
- 15 64. The article according to any of items 60 to 62, wherein the first side comprises a trilateral having three edges and three vertices and the second side comprise a vertex and three triangular facets forming a pyramid.
- 20 65. The article according to item 64, wherein the trilateral is an equilateral triangle.
- 25 66. The article according to any of items item 60 to 65, wherein the sidewall and/or or facets intersect the first side at an angle beta of between about 5 to about 65 degrees.
- 30 67. The article according to item 64, wherein the shaped abrasive particles have four major sides joined by six common edges, wherein each one of the four major sides contacts three other of the four major sides, and wherein the six common edges have substantially the same length.
68. The article according to item 67, wherein at least one of the four major sides is substantially planar.
69. The article according to item 67 or 68, wherein at least one of the four major sides is concave.

70. The article according to item 67, wherein all of the four major sides are concave.
71. The article according to item 67 or 68, wherein at least one of the four major sides is convex.
- 5
72. The article according to any of items 67 to 71, wherein the shaped abrasive particles have tetrahedral symmetry.
73. The article according to any of items 67 to 72, wherein the shaped particles are substantially shaped as regular tetrahedrons.
- 10
74. The article according to item 36, wherein the second side comprises a ridge line separated from the first side by thickness t and at least one sidewall connecting the ridge line and the perimeter of the first face.
- 15
75. The article according to item 74, wherein the sidewall comprises one or more facets connecting the ridge line and the perimeter of the first face.
76. The article according to any of item 74 or 75 wherein the sidewall and/or facets intersect the first side at an angle β of between about 5 to about 65 degrees.
- 20
77. The article according to any of items 74 to 76, wherein the first geometric shape is selected from quadrilateral geometric shapes and the sidewall comprises four facets forming a roof-shaped particle.
- 25
78. The article according to item 77 wherein the quadrilateral shape is selected from the group consisting of a rectangle, a rhombus, a rhomboid, a kite, or a superellipse.
79. The articles according to any of items 1 to 78, wherein the abrasive particles have an average tip radius and the average tip radius is less than 75 microns.
- 30
80. The article according to any of items 1 to 79, wherein the shaped abrasive particles each have a cross-sectional shape along a longitudinal axis of the shaped abrasive

particles, the cross-sectional shape comprising a non-circular cross-sectional plane, and the shaped abrasive particles comprise an Average Roundness Factor of between about 15% to 0%.

- 5 81. The article according to any of items 1 to 80 having a three-dimensional shape selected from the shape of a wheel, honing stone, grinding segment, mounted points or other shapes.
82. The article according to any of items 1 to 81, wherein the article comprises a wheel.
- 10 83. The article according to any of items 1 to 82, wherein the article is a wheel.
84. The article according to any of items 82 or 83, wherein the wheel is selected from grinding wheels for cylindrical grinding, centerless grinding, surface and profile grinding, reciprocating grinding, creep-feed grinding, grinding in generating methods of gears, threads, tools, camshafts, crankshafts bearings, and guard rails.
- 15 85. The article according to any of items 1 to 84, wherein the shaped abrasive particles are homogeneously distributed in the abrasive article.
- 20 86. The article according to any of items 1 to 84, wherein the shaped abrasive particles are non-homogeneously distributed in the abrasive article.
- 25 87. The article according to item 86, which is or comprises a bonded abrasive wheel, the wheel comprising an outer zone and an inner zone, wherein the compositions of the inner and outer zone differ in one or more aspects selected from the composition of the bond, the shape of abrasive particles, the grit size of abrasive particle, and the amount of abrasive particles.
- 30 88. Use of an article according to any of items 1 to 87 in high performance grinding applications.

89. Use according to claim 88 for outer diameter grinding with a Q'_w of at least 1.5 mm³/mm/sec, inner diameter grinding with a Q'_w of at least 1 mm³/mm/sec, surface grinding with a Q'_w of at least 1.5 mm³/mm/sec, profile grinding with a Q'_w of at least 3 mm³/mm/sec, profile grinding with generating method with a Q'_w of at least 8 mm³/mm/sec, creep-feed grinding with a Q'_w of at least 4 mm³/mm/sec, and camshaft grinding with a Q'_w of at least 8 mm³/mm/sec.

90. Use of an article according to any of claims 1 to 87 for abrading a workpiece material selected from steels, non-ferrous metals, alloys, hard metals, ceramics and glasses.

91. Method for abrading a workpiece, the method comprising frictionally contacting at least a portion of the abrasive article according to any of items 1 to 87 with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.

92. A method of grinding characterized by using a bonded abrasive article according to any of items 1 to 87, wherein the specific chip volume V'_w is at least 20% higher, than the specific chip volume achieved when using a comparable bonded abrasive article at the same specific material removal rate Q'_w .

In particularly preferred embodiments, the present invention relates to the following items:

1. A bonded abrasive article comprising shaped abrasive particles and a bonding medium comprising a vitreous bond, said shaped abrasive particles each comprising a first side and a second side separated by a thickness t , wherein said first side comprises (or preferably is) a first face having a perimeter of a first geometric shape, wherein the thickness t is equal to or smaller than the length of the shortest side-related dimension of the particle, wherein said second side comprises (or preferably is) a second face having a perimeter of a second geometric shape, said second side being separated from said first side by thickness t and at least one sidewall connecting said second face and said first face, said first geometric shape and said second geometric shapes having substantially identical geometric shapes which may

or may not be different in size, wherein said identical geometric shapes are both selected either from triangular shapes or from quadrilateral shapes.

- 5
2. The article according to item 1, wherein said identical geometric shapes are both selected from triangular shapes.
 3. The article according to any of items 1 or 2, wherein the first face and the second face are substantially parallel or non-parallel to each other.
 - 10 4. The article according to any of items 1 to 3, wherein the first and/or the second face are substantially planar.
 5. The article according to any of items 1 to 4, wherein at least one of the first and second face is a non-planar face.
 - 15 6. The article according to item 5, wherein at least one of the first and the second face is shaped inwardly.
 - 20 7. The article according to item 6, wherein the first face is shaped inwardly and the second face is substantially planar or the first face is shaped outwardly and the second face is shaped inwardly or the first face is shaped inwardly and the second face is shaped inwardly.
 - 25 8. The article according to any of items 1 to 7, wherein the second side comprises a second face and four facets intersecting the second face at a draft angle α forming a truncated pyramid.
 9. The article according to any of items 1 to 8, wherein the shaped abrasive particles are ceramic shaped abrasive particles.
 - 30 10. The article according to any of items 1 to 9, wherein the shaped abrasive particles comprise alpha alumina.

11. The article according to any of items 1 to 10, wherein the shaped abrasive particles comprise seeded or non-seeded sol-gel derived alpha alumina.
- 5 12. The article according to any of items 1 to 7, wherein said shaped abrasive particles comprise a major portion of aluminum oxide.
13. The article according to item 12, wherein said aluminum oxide is fused aluminum oxide.
- 10 14. The article according to any of items 1 to 13, further comprising secondary abrasive particles.
- 15 15. The article according to item 14, wherein the shaped and secondary abrasive particles are independently selected from particles of fused aluminum oxide materials, heat treated aluminum oxide materials, ceramic aluminum oxide materials, sintered aluminum oxide materials, silicon carbide materials, titanium diboride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride, garnet, fused alumina-zirconia, sol-gel derived abrasive particles, cerium oxide, zirconium oxide, titanium oxide or a combination thereof.
- 20 16. The article according to item 14 or 15, wherein the secondary abrasive particles are selected from crushed abrasive particles having a specified nominal grade.
- 25 17. The article according to item 16, wherein the crushed abrasive particles are of a smaller size than the shaped abrasive particles.
- 30 18. The article according to any of items 14 to 17 wherein said secondary abrasive particles are selected from particles of fused aluminum oxide materials, particles of superabrasive materials or particles of silicon carbide materials.
19. The article according to any of items I to 18 comprising 10 to 80 % by volume of said shaped abrasive particles and 1 to 60 % by volume of said bonding medium.

20. The article according to any of items 1 to 19, wherein said vitreous bond comprises, based on the total weight of the vitreous bond, 25 to 90% by weight of SiO_2 ; 0 to 40% by weight of B_2O_3 ; 0 to 40% by weight of Al_2O_3 ; 0 to 5% by weight of Fe_2O_3 , 0 to 5% by weight of TiO_2 , 0 to 20% by weight of CaO ; 0 to 20% by weight of MgO ; 0 to 20% by weight of K_2O ; 0 to 25% by weight of Na_2O ; 0 to 20% by weight of Li_2O ; 0 to 10% by weight of ZnO ; 0 to 10% by weight of BaO ; and 0 to 5% by weight of metallic oxides.
21. The article according to any of items 1 to 21, wherein the vitreous bond is obtainable from a vitreous bond precursor composition comprising frit.
22. The article according to any of items 1 to 22, comprising porosity.
23. The article according to any of items 14 to 22 wherein the shaped abrasive particles and the secondary abrasive particles are comprised in a blend, wherein the content of the secondary abrasive particles is up to 95% by weight based on the total amount of abrasive particles present in the blend.
24. The article according to item 1, wherein the at least one sidewall is a sloping sidewall.
25. The article according to any of items 1 to 24, wherein said shaped abrasive particles each comprise at least one shape feature selected from: an opening, at least one recessed (or concave) face; at least one face which is shaped outwardly (or convex); at least one side having a plurality of grooves or ridges; at least one fractured surface; a low roundness factor; a perimeter of the first face comprising one or more corner points having a sharp tip; a second side comprising a second face having a perimeter comprising one or more corner points having a sharp tip; or a combination of one or more of said shape features.
26. The article according to any of items 1 to 25, wherein the shaped abrasive particles each have an opening.

27. The article according to any of items 1 to 26, wherein the shaped abrasive particles further comprise a plurality of grooves and/or ridges on the second side.
- 5 28. The article according to any of items 1 to 27 having a three-dimensional shape selected from the shape of a wheel, honing stone, grinding segment, mounted points, or other shapes.
29. The article according to any of items 1 to 28, wherein the article comprises a wheel.
- 10 30. The article according to any of item 29, wherein the wheel is selected from grinding wheels for cylindrical grinding, centerless grinding, surface and profile grinding, reciprocating grinding, creep-feed grinding, grinding in generating methods of gears, threads, tools, camshafts, crankshafts bearings, and guard rails.
- 15 31. The article according to any of items 1 to 30, wherein the shaped abrasive particles are homogeneously distributed in the abrasive article.
32. The article according to any of items 1 to 31, wherein the shaped abrasive particles are non-homogeneous]y distributed in the abrasive article.
- 20 33. The article according to item 32, which is or comprises a bonded abrasive wheel, the wheel comprising an outer zone and an inner zone, wherein the compositions of the inner and outer zone differ in one or more aspects selected from the composition of the bond, the shape of abrasive particles, the grit size of abrasive particle, and the amount of abrasive particles.
- 25 34. Use of an article according to any of items 1 to 32 in high performance grinding applications.
- 30 35. Use according to item 34 for outer diameter grinding with a Q'_w of at least 1.5 mm³/mm/sec, inner diameter grinding with a Q'_w of at least 1 mm³/mm/sec, surface grinding with a Q'_w of at least 1.5 mm³/mm/sec, profile grinding with a Q'_w of at least 3 mm³/mm/sec, profile grinding with generating method with a Q'_w of at least 8

mm³/sec, creep-feed grinding with a Q'_w of at least 4 mm³/sec, and camshaft grinding with a Q'_w of at least 8 mm³/sec.

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36. Use of an article according to any of items 1 to 32 for abrading a workpiece material selected from steels, non-ferrous metals, alloys, hard metals, ceramics and glasses.

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37. Method for abrading a workpiece, the method comprising frictionally contacting at least a portion of the abrasive article according to any of items 1 to 32 with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.

38. Method of gear grinding characterized by using a bonded abrasive article according to any of items 1 to 32.

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39. Method of creep-feed grinding characterized by using a bonded abrasive article according to any of items 1 to 32.

40. Method of surface grinding characterized by using a bonded abrasive article according to any of items 1 to 32.

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41. Method of cylindrical grinding characterized by using a bonded abrasive article according to any of items 1 to 32.

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42. A method of grinding characterized by using a bonded abrasive article according to any of items 1 to 32, wherein the specific chip volume V'_w is at least 20% higher, than the specific chip volume achieved when using a comparable bonded abrasive article at the same specific material removal rate Q'_w .

Determination of particle dimensions

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The dimensions of the shaped abrasive particle (such as length, width and thickness) can be determined using methods known in the art, for example, by using conventional measuring

tools such as rulers, vernier callipers, micrometers, or microscopy measurement techniques and typically calculating the average of a suitable number of measurements.

5 For example, a measuring microscope such as a Nikon MM-40 obtained from Nikon
Americas Inc. in Melville, NY according to the following test method can be used: One or
more shaped abrasive particles are supported on a glass slide preferably by its largest
substantially planar surface (if it has one) in contact with the glass slide (dished or concave
10 surface up if the particle has one.) The glass slide is then placed on the Nikon MM-40
microscope stage. The stage has the ability to move in the X and Y direction and it is also
equipped with counters for the X-Y distance travelled. The crosshair is aligned with one of
the exterior vertices of the shaped abrasive particle. For example, a thin triangular particle
would use one of the three vertices; a rectangular base pyramid would use one of the four
15 rectangular base vertices of the pyramid. The X and Y counters are then reset to zero. The
crosshair is then moved clockwise to the next exterior vertex of the geometry being
measured and the X and Y readings are recorded. The remaining exterior vertices moving in
a clockwise direction are then sequentially measured. The X and Y coordinates of each
exterior vertex can then be placed into a spreadsheet and the maximum dimension between
any two of the vertices calculated using Pythagoras' theorem.

20 For a triangle the length is maximum distance between any two adjacent vertices of the three
vertices. For a rectangle, the length is the maximum dimension between adjacent vertices.
For an elongated parallelogram, the length is the maximum dimension between adjacent
vertices. For a kite or a rhombus, the length is the maximum dimension between opposing
vertices. The maximum dimension to determine length for alternative geometries can be
25 determined by those of skill in the art when looking at the geometry in the microscope. The
width can then be determined perpendicular to the length by using the coordinates of
selected vertices or by rotating the stage or slide such that the length dimension is parallel to
the X-axis. For a triangle the width is the maximum distance between the side with the
longest adjacent vertices and the opposing vertex. For a rectangle, the width is the largest
30 dimension between the two pairs of shorter opposing vertices. For an elongated
parallelogram, the width is the maximum dimension between the side with the longest
adjacent vertices and the opposing side. For a kite or a rhombus, the width is the shorter
dimension between opposing vertices. The maximum dimension to determine width for

alternative geometries can be determined by those of skill in the art when looking at the geometry in the microscope.

5 The Nikon MM-40 microscope is also equipped with a Z-axis scale with a counter. To measure thickness, t , (height from glass slide) the viewfield is first focused on the upper surface of the glass slide using the 100x objective for maximum accuracy. The Z counter is then reset to zero. The viewfield is then moved to the highest possible point of the shaped abrasive particle that can be observed (a lower magnification may be needed to find the highest point) and the microscope refocused at that the highest point at the 100x
10 magnification. The particle's thickness is determined by the Z reading after refocusing.

At least 20 shaped abrasive particles are measured for the dimension of interest (individual length, individual width, individual thickness). The averages of the dimension of interest (individual lengths, widths, thickness dimensions) are determined to define the dimension
15 (length, width, thickness) for the measured shaped abrasive particles respectively.

For the purposes of this measurement, the thickness of a particle having an opening is measured at the site of the actual maximum thickness of the particle (i.e. typically not within the opening). The shortest side related dimension, the width and the length of a particle
20 having an opening are typically measured without subtracting the length of overlap of the opening with any one of these dimensions (if any). For example, the width and length of an equilateral, prismatic particle having an opening extending between the first and the second side of uniform thickness t can be measured based on the perimeter of the first face (or the second face) without taking into account the opening.

25 The volumetric aspect ratio can be determined using methods known in the art, for example by using the actual maximum and minimum cross sectional areas of the particle, and/or exterior dimensions determined by microscopy measurement techniques as previously described and calculating the average of a suitable number (for example 20 or more) of
30 individual particle determinations. For an equilateral triangular shaped abrasive particle, the thickness and side length can be measured by microscopic techniques discussed above and the volumetric aspect ratio determined.

5 The radius of curvature can be measured by using image analysis for example, using a CLEMEX VISION PE image analysis program available from Clemex Technologies, Inc. of Longueuil, Quebec, Canada, interfaced with an inverted light microscope, or other suitable image analysis software/equipment. Using a suitable polished cross-section taken between the first face and the second face may help in microscopic examination of the edge or corner point of a sidewall. The radius of curvature of each point of the shaped abrasive article can be determined by defining three points at the tip of each point (when viewed e.g. at 100X magnification). A point is placed at the start of the tip's curve where there is a transition from the straight edge to the start of a curve, at the apex of the tip, and at the transition from the curved tip back to a straight edge. The image analysis software then draws an arc defined by the three points (start, middle, and end of the curve) and calculates a radius of curvature. The radius of curvature for at least 30 apexes are measured and averaged to determine the average tip radius.

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15 The Average Roundness Factor can be determined as described in [0029] to [0033] of US Patent Application Publication No. 2010/0319269 by using a transverse cut C, as defined in [0029] of said patent application publication.

20 Objectives and advantages of this disclosure are further illustrated by the following non-limiting examples, but the particular materials and amounts thereof recited in these examples, as well as other conditions and details, should not be construed to unduly limit this disclosure.

25 EXAMPLES

Unless otherwise noted, all parts, percentages, ratios, etc. in the Examples and the rest of the specification are by weight. Unless otherwise noted, grinding was performed wet using lubricants common for the grinding application, such as a 3 to 5% emulsion (v/v) of oil or synthetic lubricant (for example Castrol Syntilo 81 E, available from Castrol LTd. or Castrol Group, or Cimtech® D18, available from Cimcool® Fluid Technology, LLC) in water.

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Materials used in the Examples

80+	Shaped abrasive particles with the composition of 3M™ Ceramic Abrasive Grain 321 with each abrasive particle shaped as a triangular prism with sloping side walls (side wall draft angle 98 degrees) with two substantially parallel faces, wherein the first face comprises an equilateral triangle with a median dimension of 0.49 mm and the second face also comprises an equilateral triangle of median edge length of 0.415 mm. The average distance between the faces was 0.095 mm.
60+	Shaped abrasive particles with the composition of 3M™ Ceramic Abrasive Grain 321 with each abrasive particle shaped as a triangular prism with sloping side walls (side wall draft angle 98 degrees) with two substantially parallel faces, wherein the first face comprises an equilateral triangle with a median dimension of 0.63 mm and the second face also comprises an equilateral triangle of median edge length of 0.540 mm. The average distance between the faces was 0.120 mm
T	Shaped abrasive particles with the composition of 3M™ Ceramic Abrasive Grain 321 with each abrasive particle shaped as a tetrahedron with a median edge length of 0.510 mm
White fused aluminium oxide	available as Alodur® WSK from Treibacher Schleifmittel AG, Austria in grit size F24, F30, F40, F46, F54, F60, F70, F80, and F100 according to FEPA-Standard 44-1:2006
Monocrystalline aluminium oxide	available as Alodur® SCTSK from Treibacher Schleifmittel AG, Austria in grit size F80 according to FEPA-Standard 44-

	1:2006										
3M™ Ceramic Abrasive Grain 321	<p>crushed non-seeded sol-gel derived ceramic alpha alumina based abrasive particles having the same chemical composition:</p> <table border="1"> <tr> <td>Al₂O₃</td> <td>94 – 96%</td> </tr> <tr> <td>MgO</td> <td>1.2% +/- 0.3%</td> </tr> <tr> <td>Y₂O₃</td> <td>1.2% +/- 0.3%</td> </tr> <tr> <td>La₂O₃ + Nd₂O₃</td> <td>2.4% +/- 0.5%</td> </tr> <tr> <td colspan="2">Traces of : TiO₂, SiO₂, CaO, and CoO and Fe</td> </tr> </table> <p>and having grit size ANSI 46, ANSI 60, ANSI 80 and ANSI 90, available from 3M, USA</p>	Al₂O₃	94 – 96%	MgO	1.2% +/- 0.3%	Y₂O₃	1.2% +/- 0.3%	La₂O₃ + Nd₂O₃	2.4% +/- 0.5%	Traces of : TiO₂, SiO₂, CaO, and CoO and Fe	
Al₂O₃	94 – 96%										
MgO	1.2% +/- 0.3%										
Y₂O₃	1.2% +/- 0.3%										
La₂O₃ + Nd₂O₃	2.4% +/- 0.5%										
Traces of : TiO₂, SiO₂, CaO, and CoO and Fe											
Cerpass TGE®, Code TGE-0557	<p>Extruded abrasive rods composed of seeded gel product; containing >99.6% alpha aluminium oxide in grit size grit size 36 with an aspect ratio [the ratio of the length to the greatest cross-sectional dimension (the greatest dimension perpendicular to the length)] in the range of 2.9-4.5 and a side dimension of the cross-sectional area of 474-546 μm, and in grit size 100 with an aspect ratio [the ratio of the length to the greatest cross-sectional dimension (the greatest dimension perpendicular to the length)] in the range of 3.3-5.1 and a side dimension of the cross-sectional area of 140-152 μm, Saint-Gobain Grains & Powders, Worcester, USA</p>										
Cerpass XTL®, Code XTL-0560	<p>Crushed seeded gel product, containing ≥ 99.6% alpha aluminium oxide in grit size 90 according to ANSI available from Saint-Gobain Grains & Powders</p>										
Mix 1 - Comparative Example Ref. 1A-2	<p>100% by weight white fused aluminium oxide based on the total weight of abrasive grain, consisting of 20% by weight of FEPA grade F70, 50% by weight of FEPA grade F80, and 30% by weight of FEPA grade F100</p>										
Mix 2 - Comparative	<p>30% by weight 3M™ Ceramic Abrasive Grain 321 and 70%</p>										

<p>Example Comparative Ref. IX-3</p> <p>Ref. 2A-1, Example</p>	<p>by weight of white fused aluminium oxide based on the total weight of abrasive grain</p> <p>the 3M™ Ceramic Abrasive Grain 321 portion consists of each 50% by weight of ANSI grade 80 and ANSI grade 90. The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70 and F100, and 42.8% by weight of FEPA grade F80.</p>
<p>Mix 3 - Examples 1A-1, and IB-1, Example IX-1</p> <p>Example V-4,</p>	<p>30% by weight 80+ and 70% by weight white fused alumina by weight based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70 and F100, and 42.8% by weight of FEPA grade F80</p>
<p>Mix 4 - Examples 2A-1, and 2B-1</p>	<p>30% by weight 60+ and 70% by weight of white fused alumina based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70 and F100, and 42.8% by weight of FEPA grade F80</p>
<p>Mix 5 - Examples 3A-1, and 3B-1</p>	<p>30% by weight T and 70% by weight of white fused aluminium oxide based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70 and F100, and 42.8% by weight of FEPA grade F80</p>
<p>Mix 6 - Examples 1A-2, and 1B-2, II-1, IV-1, V-3, IX-2</p>	<p>100% by weight 80+ based on the total weight of abrasive grain</p>
<p>Mix 7 - Comparative Example Ref. 3A-1</p>	<p>30% by weight Cerpass TGE®, code TGE-0557, grit size 100 and 70% by weight of white fused aluminium oxide based on the total weight of abrasive grain</p>

	The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70
Mix 8 - Comparative Example Ref. 3A-2	100% by weight Cerpass TGE®, code TGE-0557, grit size 100 based on the total weight of abrasive grain
Mix 9 - Example II-1, Comparative Example Ref. 11-2, Example IV-1, Comparative Example IV-2, Comparative Example Ref. V-5	100% by weight white fused aluminium oxide based on the total weight of abrasive grain, consisting of 20% by weight of FEPA grade F54, 50% by weight of FEPA grade F60, and 30% by weight of FEPA grade F70
Mix 10 - Comparative Example Ref. II-2, Comparative Example Ref. V-5	30% by weight 3M™ Ceramic Abrasive Grain 321 and 70% by weight of white fused aluminium oxide based on the total weight of abrasive grain The 3M™ Ceramic Abrasive Grain 321 portion consists of 100% by weight of ANSI grade 60. The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F54 and F60, and 42.8% by weight of FEPA grade F70.
Mix 11 - Example III-1, VI-1, VII-1, VIII-1	100% by weight 60+ based on the total weight of abrasive grain
Mix 12 - Comparative Example Ref. III-2, Comparative Example Ref. VIII-2	30% by weight 3M™ Ceramic Abrasive Grain 321 and 70% by weight of white fused aluminium oxide based on the total weight of abrasive grain The 3M™ Ceramic Abrasive Grain 321 portion consists of 100% by weight of ANSI grade 46. The portion of white fused aluminium oxide consists of each 42.9% by weight of FEPA grade F40 and F54, and 14.2% by weight of FEPA grade F46.

<p>Mix 13 - Comparative Example IV-2</p>	<p>20% by weight 3M™ Ceramic Abrasive Grain 321 and 80% by weight of white fused aluminium oxide based on the total weight of abrasive grain</p> <p>The 3M™ Ceramic Abrasive Grain 321 portion consists of 100% by weight of ANSI grade 60. The portion of white fused aluminium oxide consists of 25% by weight of FEPA grade F54, and of each 37.5% by weight of FEPA grade F60 and F70.</p>
<p>Mix 14 - Example V-1</p>	<p>30% by weight 80+ and 70% by weight white fused alumina by weight based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of each 50% by weight of FEPA grade F46 and F60</p>
<p>Mix 15 - Example V-1, Example V-2, Example V-3</p>	<p>100% by weight white fused aluminium oxide based on the total weight of abrasive grain, consisting of each 35% by weight of FEPA grade F46 and F60, and 30% by weight of FEPA grade F54.</p>
<p>Mix 16 - Example V-2</p>	<p>50% by weight 80+ and 50% by weight white fused alumina by weight based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of 40% by weight of FEPA grade F46, and 60% by weight of FEPA grade F60</p>
<p>Mix 17 - Example V-4, Comparative Example Ref. V-6, Example IX-1, Example IX-2, Comparative Example Ref. IX-3</p>	<p>100%, by weight white fused aluminium oxide based on the total weight of abrasive grain, consisting of each 20% by weight of FEPA grade F70 and F100, and 60% by weight of FEPA grade F80.</p>
<p>Mix 18 - Comparative</p>	<p>30% by weight 3M™ Ceramic Abrasive Grain 321 and 70%</p>

<p>Example Ref. V-6</p>	<p>by weight of white fused aluminium oxide based on the total weight of abrasive grain</p> <p>The 3M™ Ceramic Abrasive Grain 321 portion consists of 100% by weight of ANSI grade 80. The portion of white fused aluminium oxide consists of each 28.6% by weight of FEPA grade F70 and F100, and 42.8% by weight of FEPA grade F80.</p>
<p>Mix 19 - Comparative Example Ref. VI-2</p>	<p>5% by weight 3M™ Ceramic Abrasive Grain 321, 25% by weight of Cerpass XTL® code XTL-0560, 50% by weight of monocrystalline aluminium oxide, and 20% by weight of white fused aluminium oxide based on the total weight of abrasive grain</p> <p>The 3M™ Ceramic Abrasive Grain 321 portion consists of 100% by weight of ANSI grade 90. The Cerpass XTL® code XTL-0560 portion consists of 100% by weight of ANSI grade 90. The monocrystalline aluminium oxide portion consists of 100% by weight of FEPA grade F80. The white fused aluminium oxide portion consists of 100% by weight of FEPA grade F70.</p>
<p>Mix 20 - Example VII-2</p>	<p>30% by weight 60+ and 70% by weight white fused alumina by weight based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of 42.9% by weight of FEPA grade F24, and 57.1% by weight of FEPA grade F30</p>
<p>Mix 21 - Comparative Example VII-3</p>	<p>30% by weight Cerpass TGE®, code TGE-0557, grit size 36 and 70% by weight white fused alumina by weight based on the total weight of abrasive grain</p> <p>The portion of white fused aluminium oxide consists of 42.9% by weight of FEPA grade F24, and 57.1% by weight</p>

	of FEPA grade F30
Mix 22 - Example VIII-1, Comparative Example kef. VIII-2	100% by weight white fused aluminium oxide based- on the total weight of abrasive grain, consisting of each 30% by weight of FEPA grade F40 and F54, and 40% by weight of FEPA grade F46.
Vitrified bond precursor mix	Mix of 98.5% by weight vitrified bond having a grain size of $97\% < 63 \mu\text{m}$ and a composition consisting of Na_2O , Al_2O_3 , B_2O_3 , and SiO_2 , commercially available as vitrified bond VO 82069 from Reibold & Strick, Germany and 1.5% by weight of blue pigment, cobalt blue colour stain for glazes consisting of CoAl_2O_4 , commercially available as K90084 from Reibold & Strick, Germany
Temporary binder	Consisting of Liquid temporary binder mix and solid temporary binder
Liquid temporary binder mix	Urea formaldehyde resin*, for example PA1 175G available from PA resins AB, Sweden, now Chemoplastica AB, Sweden
Solid temporary binder	Potato starch*, for example Dextrin 20.912 available from Agrana Starke GmbH, Austria
Pore inducing agent	Naphthalene*, for example available from Sintal SA, Belgium, in crystalline and sifted form; depending on the grain size distribution herein later referred to as Type A (212-500 μm) and Type B (300-1190 μm)

* not present in the final product

EXAMPLE I – Outer Diameter (OD) GrindingA. Manufacturing process of abrasive grinding wheels

Vitrified bonded abrasive grinding wheels having the same bond and wheel dimension of 500 x 25 x 304.8 mm (wheel diameter x thickness x bore diameter) and T1 shape (according to DINTSO 603:1999), i.e. a straight grinding wheel, were prepared according to the following manufacturing process:

(i) Mixing

The abrasive grain/grain mix as specified with respect to the examples was put into a mixing aggregate and the liquid temporary binder was poured onto it while mixing. After stirring for about 3-5 minutes, a mixture consisting of the vitrified bond precursor mix and the solid temporary binder was added and the mixing was continued thoroughly for about 1.0 minutes.

(ii) Sieving

With reference to the examples given, the mixture obtained in step (i) is screened with a sieve 16 mesh (mesh size 1.18 mm).

(iii) Moulding

The mixture obtained in step (ii) is put into a mould and formed by pressing to give green bodies. Typical forming pressures were 126-150 kg/cm² for green bodies with an abrasive mix containing 100% 80+ and 21-51 kg/cm² for green bodies with an abrasive mix containing 30% 80, 60+ or T shaped abrasive grain.

(iv) Heat treatment

With reference to the examples given, the achieved green bodies are dried at a temperature of 130°C and sintered at a temperature of 930°C.

(vii) Finishing

The finishing operation comprises the grinding of the bore, the lateral surfaces, and the peripheral surface.

Table 1: Characteristics of the test wheels of Example I

Amounts [wt. %]*	Example 1A-1	Example 2A-1	Example 3A-1	Example 1A-2	Comparative Example Ref. 2A-1	Comparative Example Ref. 3A-1	Comparative Example Ref. 3A-2
Green Structure							
Abrasive Grain	Mix 3	Mix 4	Mix 5	Mix 1	Mix 2	Mix 7	Mix 8
shaped abrasive grain	26.55 80+	26.55 60+	26.55 T	88.50 80+			
3M™ Ceramic Abrasive Grain 321					26.55 grit 80, 90		
Cerpass TGE®, code TGE-0557						26.55 grit 100	88.50 grit 100
White fused aluminium oxide	61.95 F70, 80, 100	61.95 F70, 80, 100	61.95 F70, 80, 100	88.50 F70, 80, 100	61.95 F70, 80, 100	61.95 F70, 80, 100	-
Vitreous bond	11.50	11.50	11.50	11.50	11.50	11.50	11.50

Temporary binder												
Starch	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50
Liquid temporary binder mix	4.20	4.20	4.20	4.20	4.20	4.20	4.20	4.20	4.20	4.20	4.20	4.20
Moulding density [g/cm ³]	2.110	2.110	2.110	2.110	2.110	2.110	2.110	2.110	2.110	2.110	2.110	2.110
Wheel												
Type**	Type III											
Shape	T1											
Dimension	500x25x304.8											

** Here and in the following the Wheel Type (or the abrasive article or tool type) relates to the hardness/structure of the test abrasive tools and had been classified as a type ranging from Type I (lower volume percentage of bond and abrasive grain, and higher volume percentage of porosity) to Type XI (higher volume percentage of bond and abrasive grain, and lower volume percentage of porosity) based on the percentage of bond and porosity in the abrasive tools (for example wheels or segments), with a higher volume percentage of bond corresponding to a higher type and a more rigid or hard abrasive tool.

For example with specific reference to Example I, i.e. Type 0 1 or Type VII, , test wheels of Type VII can be considered as acting harder or more rigid under the grinding conditions used as compared to test wheels of Type III because of the higher volume percentage of bond and less porosity present in wheels of Type VII.

* weight amounts of the green wheels before firing

Table 1 (continued)

Amounts [wt. %]*	Example 1B- 1	Example 2B- 1	Example 3B- 1	Example 1B- 2
Green Structure				
Abrasive Grain	Mix 3	Mix 4	Mix 5	Mix 6
shaped abrasive grain	25.97 80+	25.97 60+	25.97 T	86.58 80+
3M TM Ceramic Abrasive Grain 321				
White fused aluminium oxide	60.61 F70, 80, 100	60.61 F70, 80, 100	60.61 F70, 80, 100	
Vitreous bond	13.42	13.42	13.42	13.42
Temporary binder				
Starch	0.85	0.85	0.85	0.85
Liquid temporary binder mix	3.30	3.30	3.30	3.30
Moulding density [g/cm ³]	2.150	2.150	2.150	2.150
Wheel				
Type**	Type VII	Type VII	Type VII	Type VII
Shape	T1	T1	T1	T1
Dimension	500x25x304.8	500x25x304.8	500x25x304.8	500x25x304.8

* weight amounts of the green wheels before firing

B. Testing procedure

The grinding wheels prepared as in Example I were tested in a cylindrical grinding application in order to establish the grinding performance of the wheels. The grinding tests were performed using the following grinding conditions:

Grinding Process: outer diameter (OD-) grinding
 Machine: UVA Johansson 10MD; 18.5 kW, year of construction 1979 (rebuilt)
 Workpiece: bearing steel; Ovako 824, Ovako Hofors AB, Sweden 1.3537
 (100CrMo7) according to EN ISO 683-17: 1999, 62-64 HRc, diameter
 100 mm, length 20 mm
 Parameters: operating speed of grinding wheel: 45 m/s; wet grinding using
 Cimtech® D18 (3%) as a lubricant/coolant
 Dressing: Multi-point diamond dresser, V448-0,8x4-4 bars, Kucher GmbH,
 Germany, synthetic diamond, width 15 mm, length 28 mm, traverse
 speed 350 mm/min

Using the grinding wheels of Example I, three sets of grinding tests were performed.

Test Series (I) used a specific material removal rate of Q'_w 2.5 mm³/mm/s (infeed: 0.006 mm/turn of work piece; peripheral speed of work piece: 25 m/min).

Test Series (II) used more severe grinding conditions by applying a specific material removal rate of Q'_w 5 mm³/mm/s (infeed: 0.010 mm/turn of work piece; peripheral speed of work piece: 30 m/min).

Test series (III), using a specific material removal rate of Q'_w 2.5 mm³/mm/s (infeed: 0.006 mm/turn of work piece; peripheral speed of work piece: 25 m/min) to remove 1.2 mm of work piece in radius following by 5 s of outspark was chosen to characterise the surface quality of the work piece.

The power drawn was recorded as a function of the grinding time. The results of Test Series (I) are shown in Fig. 1 and Fig. 2. The results of Test Series (II) are shown in Fig. 3 and Fig. 4.

5 Typically grinding curves of this type are cyclical: The power drawn (kilowatts) increases over time as the grinding forces increase. When the forces get high enough the wheel breaks down, breaking and ejecting grit particles and then the grinding power consumption (grinding force) decreases. At this point dressing of the grinding wheel has to be set up in order to avoid defects at the workpiece to be abraded and, in order to provide for constant
10 abrading performance of the grinding wheel. Then the grinding cycle has to be started again. What is desired is a grinding wheel having a long cycle period (in terms of constant power drawn), indicating good form holding and long total service life of the wheel.

For each wheel the grinding test was operated until the power consumption fell below the
15 power consumption at the initial grinding level. This was considered the test endpoint. Due to their long service life the tests of Test Series (I) using the wheels of all examples excluding Example Ref. 1A-2 and Ref. 2A-1, and the tests of Test Series (II) using the grinding wheels of Examples 1A-2 and 1B-2 (100% 80+) were ended before reaching this point.

20 In addition, the mean value of surface roughness R_a of the workpiece after the grinding according to Test Series III has been determined with a device of type SURFTEST SJ-210 of Mitutojo. The results of the Type III-wheels are summarized in Fig. 5.

25 C. Results

A comparison of the results obtained under Test Series I and II shows the higher grinding performance of the examples given by increasing the specific material removal rate (Fig. 1-4). While in Test Series I (Q'_w 2.5 mm³/mm/s) all variants comprising non-seeded sol-gel derived aluminium oxide refer to a long service life (Fig. 1 and Fig. 2, examples excluding
30 the Comparative Examples Ref. 1A-2, Ref. 2A-1, Ref. 3A-1, and Ref. 3A-2), differences in the power drawn can be seen in Fig. 3 and Fig. 4 when applying the grinding conditions of Test Series II comprising a specific material removal rate Q'_w of 5 mm³/mm/s.

Fig. 3 and Fig. 4 illustrate a marked increase in the period of the grinding cycle when using grinding wheels containing shaped abrasive particles in accordance with the present invention in comparison to the variants comprising white fused aluminium oxide or 3M™ Ceramic Abrasive Grain 321 or extruded Cerpass TGE® (Comparative Examples Ref. 1A-2 or Ref. 2A-1, or Ref. 3A-1) respectively, and confirm the increase in the service life. For example, the period for the grinding cycle of Example 1A-1 in comparison to Ref. 2A-1 is nearly doubled, thus resulting in a longer dressing interval. Considering grinding wheels with abrasive mixes consisting of 100% shaped abrasive particles in accordance with the present invention (Example 1A-2) as well as 100% extruded Cerpass TGE® (Comparative Example Ref. 3A-2) Example 1A-2 shows a marked increase in service life. The testing of Example 1A-2 was terminated artificially because of the constant power drawn during a certain grinding duration.

With reference to the examples comprising shaped abrasive particles in accordance with the present invention an influence of the abrasive grain size and the amount of the abrasive grain portion can be seen. Increasing the abrasive grain portion effects longer service life. This can be seen from Examples 1A-2 and 1B-2 in comparison to examples 1A-1 and 1B-1, each containing shaped abrasive particles 80+. Using the same portion of the shaped abrasive particle of the invention, examples 2A-1 and 2B-1, containing shaped abrasive particles 60+, show the influence of the grain size and an increase of the service life by reducing the wear of the shaped abrasive particles in comparison to the Examples 1A-1 and 1B-1, comprising shaped abrasive particles 80+.

In sum, the use of shaped abrasive grains in a vitrified bond can provide abrasive grinding wheels exhibiting a long and stable grinding curve in grinding applications, particularly under more severe grinding conditions, as for example shown in Test Series II. Surprisingly, the service life of the wheels increased when tested using a higher specific removal rate ($Q'_w = 5.0 \text{ mm}^3/\text{mm/s}$). Increasing the amount of shaped abrasive particles according to the present invention can provide an extremely long grinding cycle.

In addition, the use of shaped abrasive grains has been found to provide improved surface finish as evident from a comparison of the examples for wheels of Type III given and shown

in Fig. 5. With respect to the grinding practice, it has to be stated that deviation of the results is low. Because of its narrow range the results of the mean value of surface roughness R_a are not described in detail.

5 With respect to the results obtained it is also to be noted that the grinding tests involved a specific grinding machine built in 1979. The use of a more recently constructed machine is expected to provide even better results since higher values for $Q'w$ could be accomplished.

EXAMPLE II - Outer Diameter (OO) Grinding

10

A. Manufacturing process of abrasive grinding tools

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 2 were prepared as described in Example I.

15

Table 2: Characteristics of Grinding Wheels used in Example II

Green Structure	Example II-1		Comparative Example Ref. II-2	
	Rim	Center	Rim	Center
Abrasive Grain	Mix 6	Mix 9	Mix 10	Mix 9
Shaped abrasive grain	88.50 80+			
3M™ Ceramic Abrasive Grain 321			26.55 Grit 60	
White fused alumina		88.50 F54, 60, 70	61.95 F54, 60, 70	88.50 F54, 60, 70
Vitreous bond	11.50	11.50	11.50	11.50
Starch	1.50	1.50	1.00	1.00
Liquid temporary binder mix	4.24	4.24	3.89	3.89
Pore inducing agent	13.27 (Type A)	13.27 (Type A)	13.27 (Type A)	13.27 (Type A)
Moulding density [g/cm ³]	2.100	2.100	2.010	2.010
Wheel				
Wheel Type **	Type IV		Type V	

Shape	T5	T5
Dimension	750x100x304.8-1-420x30	750x100x304.8-1-420x30

** (see Table 1)

B. Testing Procedure

5 The grinding wheels prepared as in Example II were tested in an outer diameter (OD) grinding application in order to establish the grinding performance of the wheels.

Using the grinding wheels of Example II, grinding tests were performed using the following grinding conditions:

10

Grinding Process: outer diameter (OD-) grinding

Machine: HOL-MONTA 2000CNC (22kW)

Workpiece: pressure cylinder, diameter 620 mm, length 1110 mm, hard-chrome plated; required surface roughness $R_z < 4 \mu\text{m}$ (R_z describing the average roughness depth)

15

Parameters: Roughing via plunge grinding; 10 plunges, speed ratio q_s 67 and finishing via traverse grinding, speed ratio q_s 67, speed of fiunge speed rate v_f 700 mm/min

Dressing: Multi-point diamond dresser MKD4x0,8

20

C. Results

Table 3: Results of Example II

		grinding stock [mm]	v_w [rpm/min]	v_c [m/s]	Q_w Roughing [mm ³ /mm/s]	Q_w Semi-roughing [mm ³ /mm/s]	Q_w Finishing [mm ³ /mm/s]	Dressing
Comparative Example Ref. II-2	Roughing	0.5	11	25	1.8	0.9	0.25	after each plunge, 4x0.02 mm
	Finishing	0.04	11	25	2	2	0.2	1x before grinding, 4x0.02 mm
Example II-1: Test 1	Roughing	0.5	11	25	1.8	0.9	0.25	after each plunge, 4x0.02 mm
	Finishing	0.04	11	25	2	2	0.2	1x before grinding, 4x0.02 mm
Example II-1: Test 2	Roughing	0.5	12	27	2.3	1.3	0.6	after each 2 nd plunge 4x0.01 mm
	Finishing	0.04	11	25	2	2	0.2	1x before grinding 4x0.01 mm
Example II-1: Test 3	Roughing	0.9	12	27	2.9	1.5	0.8	after each 2 nd plunge 4x0.01 mm
	Finishing	0.04	11	25	2	2	0.2	1x before grinding 4x0.01 mm

The grinding tests were performed in test series using three different parameter sets for the roughing and the same parameter sets for the finishing process. The parameter sets are summarized in Table 3. The results show an increase in the performance thus reflected by the specific material removal rate Q'_w and the total grinding time for the test wheel as well as an improvement in the dressing process by reducing the dressing amounts by 50%. Considering the total grinding time the reference wheel as well as the test wheel using the parameter set of Test 1 show total grinding times of 270 minutes. Using parameter set of Test 2 enables to reduce the grinding time to 190 minutes (-30%) and to increase the infeed by 29% in comparison to the reference wheel and Test 1. Test 3 comprised a 80% higher grinding stock and a 40% higher infeed. Even with these more severe conditions present the grinding time was increased by only 10% (210 minutes) than in Test 2 and still was ca. 20% shorter than in Test 1. In all test series the test wheel met the required surface quality and gained a silk-mat surface quality.

EXAMPLE III - Outer Diameter (O D) Grinding

A. Manufacturing process of abrasive grinding tools

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 4 were prepared as described in Example I.

Table 4: Characteristics of Grinding Wheels used in Example III

	Example III-1	Comparative Example Ref. III-2
Green Structure		
Abrasive Grain	Mix 11	Mix 12
Shaped abrasive grain	85.10 60+	
3M™ Ceramic Abrasive Grain 321		25.53 Grit 46
White fused alumina		59.57 F40, 46, 54
Vitreous bond	14.90	14.90
Starch	1.50	1.50
Liquid temporary binder mix	4.92	4.92

Pore inducing agent	12.77 (Type A)	12.77 (Type A)
Wheel		
Moulding density [g/cm ³]	2.450	2.360
Wheel Type **	Type X	Type XI
Shape	T1	T1
Dimension	250x9x85	250x9x85

** (see Table 1)

B. Testing Procedure

- 5 The grinding wheels prepared as in Example III were tested in an outer diameter (OD) grinding application in order to establish the grinding performance of the wheels.

Using the wheels of Example III, grinding tests were performed using the following grinding conditions:

10

Grinding Process: outer diameter (OD-) grinding; semi-finish sidegrinding of chrome plated slots

Machine: Chris Marie, adopted to customer needs

Workpiece: vessel engine piston with diameter 460 mm, 4 slots per piston

15

Parameters: semi finish side-grinding of chrome plated slots, 4 slots per piston; stock removal : 0,3-0,5 mm per side

Dressing: Multi-point diamond dresser MKD4x0,8

C. Results

20

Table 5: Results of Example III

	Comparative Example Ref. III-2	Example III-1
Total infeed [mm]	0.43	0.30
Effective take of material per slot [mm]	0.23	0.25
Dressing	9 times 0.01 mm	2 times 0.01 mm
Dressing without infeed, to open the wheel again	6 times	4 times
Grinding time per side [min]	20	11

Using the same parameter sets the test wheel gains improvements with regard to the grinding time as well as to the dressing process as follows:

5 The grinding time was reduced by 9 minutes per side, each slot showing two sides this results in a 72 minutes decrease of the grinding time per piston (4 slots per piston). In comparison to the reference wheel the grinding time can be reduced almost by 50%.

10 Considering the dressing process 7 dressing cycles less were necessary for the test wheel. Calculating the total dressing amount for both sides of all slots (2 sides each slot, 4 slots) leads to 0.56 mm less wheel usage.

EXAMPLE IV - Outer Diameter (OP) Grinding

A. Manufacturing process of abrasive grinding tools

15 Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 6 were prepared as described in Example I.

20 Table 6: Characteristics of Grinding Wheels used in Example IV

Green Structure	Example IV-1		Comparative Example Ref. IV-2	
	Rim	Center	Rim	Center
Abrasive Grain	Mix 6	Mix 9	Mix 13	Mix 9
Shaped abrasive grain	87.72 80+			
3M™ Ceramic Abrasive Grain 321			17.54 Grit 60	
White fused alumina		87.72 F54, 60, 70	70.18 F54, 60, 70	87.72 F54, 60, 70
Vitreous bond	12.28	12.28	12.28	12.28
Starch	0.80	0.80	0.80	0.80
Liquid	3.12	3.12	3.12	3.12

temporary binder mix				
Moulding density [g/cm ³]	2.300	2.300	2.190	2.190
Wheel				
Wheel Type **	Type IX		Type VII	
Shape	T5N		T5N	
Dimension	610x100x304,8-1-390x50		610x100x304,8-1-390x50	

** (see Table 1)

B. Testing Procedure

5 The grinding wheels prepared as in Example IV were tested in an outer diameter (OD) grinding application in order to establish the grinding performance of the wheels.

Using the wheels of Example IV, grinding tests were performed using the following grinding conditions:

10

Grinding Process: outer diameter (OD-) grinding

Machine: Schaudt FlexGrind M

Workpiece: drive shaft showing diameter 170 mm, 140 mm, and 160 mm, case hardened to 60-62 HRC; material: 17CrNiMo6; required surface quality R_a 0.8 μ m

15

Parameters: see Table 7; grinding stock 1 mm; dressing every 2 parts one stroke

Dressing: Diamond dresser CVD 1.0x1.0x4D (one rod)

C. Results

Table 7: Results of Example IV

		v_c [m/s]	Infeed roughing [mm/min]	Infeed semi- roughing [mm/min]	Infeed finishing [mm/min]	Speed ratio q_s	Grinding time roughing [min:sec]	Q'_w [mm ³ /mm/s]	R_a [μ m]
Comparative Example Ref. IV-2	Ref. Mix f2	45	0.2584	0.0861	0.0215	92	05:08	2.2	0.647
	Ref. Mix f2	45	0.3137	0.1046	0.0261	95		2.3	
	Ref. Mix f2	45	0.2628	0.1314	0.0788	90		2.3	
Example IV-1: Test 1	Mix fl	45	0.2584	0.0861	0.0215	92	05:08	2.2	0.602
	Mix fl	45	0.3137	0.1046	0.0261	95		2.3	
	Mix fl	45	0.2628	0.1314	0.0788	90		2.3	
Example IV-1: Test 2	Mix fl	63	0.5610	0.1350	0.0330	60	01:32	5	0.466
	Mix fl	63	0.6820	0.1600	0.0400	60		5	0.38
	Mix fl	63	0.5960	0.1430	0.0788	60		5	0.337
Example IV-1: Test 3	Mix fl	63	0.8988	0.1350	0.0330	60		8	
	Mix fl	63	1.0913	0.1600	0.0400	60		8	
	Mix fl	63	0.9549	0.1430	0.0788	60		8	

The tests were performed in three test series using different parameter sets. Test 1 applying the same parameter set as for the reference results in a better surface quality represented by the mean value of surface roughness R_a . The results of Test 2 and Test 3 show that the test wheel enables an increase in the operating speed v_c as well as higher infeed rates for each machining step thus resulting in a marked increase in the specific material removal rate $Q'w$ and in ca. 70% shorter grinding times as described for the roughing. The surface quality generally improves using the test specification and results in a reduction of the mean surface roughness R_a by 50%.

10 EXAMPLE V – Single Rib Gear Grinding

A. Manufacturing process of abrasive grinding wheels

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 8 were prepared as described in Example I:

B. Testing Procedure

20 The grinding wheels prepared as in Example V were tested in a single rib gear grinding application in order to establish the grinding performance of the wheels.

Using the wheels of Example V, two sets of grinding tests were performed using the following grinding conditions:

25

Test 1:

Grinding Process: single rib gear grinding

Grinding tool: T1ESP 400x60x127 V=50°, U=15

30 Machine: Hofier Rapid 2500 (37kW)

Workpiece: Planet gear, normal module 13.5 mm, pressure angle: 20°, helix angle: 7.25°, number of teeth: 50, face width 380 mm; Material: 18CrNiMo7-6 case hardened to 62 HRc

Parameters: operating speed v_c of grinding wheel: 30 m/s

Test 2:

- 5 Grinding Process: single rib gear grinding
Grinding Tool: T1ESP 400x50x127 V-65° U=12
Machine used: Hofler Rapid 1250 (24kW)
Workpiece: Planet gear, nonmai module 13,5 mm, pressure angle: 20°, helix angle: 7°, number of teeth: 43, face width 250 mm; Material: 17CrNi.Mo6
- 10 Planet gear, normal module 16 mm, pressure angle: 20°, helix angle: 6,25°, number of teeth: 31, face width 371,2 mm; Material: 18CrNiMo7-6 case hardened to 62 HRc,
required mean value of surface roughness R_a 0,4 μm (both workpieces)
- 15 Parameters: operating speed v_c of grinding wheel: 30 m/s

Table 8: Characteristics of the test wheels of Example V

	Example V-1		Example V-2		Example V-3		Example V-4		Comparative Example Ref. V-5		Comparative Example Ref. V-6	
	Rim	Center	Rim	Center	Rim	Center	Rim	Center	Rim	Center	Rim	Center
Green Structure	Mix 14	Mix 15	Mix 16	Mix 15	Mix 6	Mix 15	Mix 3	Mix 17	Mix 10	Mix 9	Mix 18	Mix 17
Abrasive Grain	27.52 80+		45.87 80+		91.74 80+		27.40 80+					
Shaped abrasive grain												
3M TM Ceramic Abrasive Grain 321									27.52 Grit 60		27.3 Grit 80	
White fused alumina	64.22 F46, 60	91.74 F46, 54, 60	45.87 F46, 60	91.74 F46, 54, 60		91.74 F46, 54, 60	63.92 F70, F80, F100	91.32 F70, 80, 100	64.22 F54, 60, 70	91.74 F54, 60, 70	63.92 F70, 80, 100	91.32 F70, 80, 100
Vitreous bond	8.26	8.26	8.26	8.26	8.26	8.26	8.68	8.68	8.26	8.26	8.68	8.68
Starch	2.10	2.10	2.10	2.10	2.10	2.10	1.62	1.62	1.60	1.60	1.62	1.62
Liquid temporary binder mix	3.37	3.37	3.37	3.37	3.37	3.37	3.01	3.01	3.49	3.49	3.01	3.01
Pore inducing agent	9.17 (Type A)	9.17 (Type A)	9.17 (Type A)	9.17 (Type A)	9.17 (Type A)	9.17 (Type A)	18.26 (Type B)	18.26 (Type B)	18.35 (Type B)	18.35 (Type B)	18.26 (Type B)	18.26 (Type B)

C. Results

Table 9A: Results of Test 1 - Test series A

	Comparative Example Ref. V-5	Example V-4	Example V-3
Specific material removal rate Q'_w [mm ³ /mm/s]	16	24	30
Specific chip volume V'_w [mm ³ /mm]	10.000	15.000	18.000
Mean value of surface roughness R_a [μm]	0.40	0.30	0.30

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Table 9B: Results of Test 1 - Test series B showing a specific material removal rate Q'_w of 16 mm³/mm/s

	Comparative Example Ref. V-5	Example V-4	Example V-3
Specific material removal rate Q'_w [mm ³ /mm/s]	16	16	16
Specific chip volume V'_w [mm ³ /mm]	10.000	18.000	30.000

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Table 9C: Results of Test 2

	Comparative Example Ref. V-6	Example V-1	Example V-2	Example V-3
Specific material removal rate Q'_w [mm ³ /mm/s]	14	24	30	30
Specific chip volume V'_w [mm ³ /mm]	800	1500	2500	2500
Comment:				Too less machine power

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The test series show an increase in the specific material removal rate Q'_w as well as in the specific chip volume V'_w for the test wheels in comparison to the reference wheels independent from the workplace material type and dimensions. In Test 2 the machine used had too less machine power to increase both parameters for Example V-3. In general it can

be seen that the increase depends on the amount of shaped abrasive particles resulting in the highest values for an abrasive fraction entirely consisting of shaped abrasive particles (Example V-3). Using an amount of 30% of shaped abrasive grain (Example V-1 and Example V-4) results in an increase in the specific chip volume V'_w in the range of 50-90% and an increase of the specific material removal rate Q'_w in the range of 50-70%. Increasing the amount of shaped abrasive grain to 50% (Example V-2) gains an increase by ca. 210% for the specific chip volume and ca. 115% for the specific material removal rate. Keeping the specific material removal rate Q'_w constant, in comparison to the reference grinding wheel Comparative Example Ref. V-5 Test Series B of Test 1 shows an increase in the specific chip removal V'_w of 80% for Example V-4 and of 200% for Example V-3, thus resulting in longer dressing cycles, less redressing and proving the excellent form and profile holding of the test grinding wheels. Even under these severe grinding conditions no workpiece burning or discoloration was observed. Considering the surface quality of the workpieces an improvement can be seen related to the test wheels of Test 1 (Test Series A) thus reflected by the mean value of the surface roughness R_a and its decrease by 25% with regard to the reference wheel. The test series document the beneficial effects of abrasive tools consisting of shaped abrasive grain referring to high performance grinding and combined with highly efficient process and tool economics.

EXAMPLE VI - Generating gear grinding

A. Manufacturing process of abrasive grinding tools

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 10 were prepared as described in Example I.

Table 10: Characteristics of Grinding Wheels used in Example VI

	Example VI-1	Comparative Example Ref. VI-2
Green Structure		
Abrasive Grain	Mix 11	Mix 19
Shaped abrasive grain	86.58 60+	
3M™ Ceramic Abrasive Grain 321		4.45 grit 90
Cerpass XTL®, code 0560		22.25 Grit 90
Single crystal alumina		44.5 F80
White fused alumina		17.8 F70
Vitreous bond	13.42	11.00
Starch	1.20	0.96
Liquid temporary binder mix	4.56	3.29
Pore inducing agent	12.99 (Type A)	6.05 (Type A)
Moulding density [g/cm ³]	2,040	2.125
Wheel		
Wheel Type **	Type IX	Type VII
Shape	T1SP	T1SP
Dimension	320x230x110mm modulus 9.0mm, pressure angle 20°, 2 starts	320x230x110mm modulus 9.0mm, pressure angle 20°, 2 starts

** (see Table 1)

5 B. Testing Procedure

The grinding wheels prepared as in Example VI were tested in a generating gear grinding application in order to establish the grinding performance of the wheels. Using the wheels of Example VI, grinding tests were performed using the following grinding conditions:

Grinding Process: Generating gear grinding using so-called grinding worms

Machine used: Liebherr LCS 1200 (35 kW)

Work piece: Helical gear, normal module 9 mm, pressure angle: 20°, helix angle: 10°, number of teeth: 65, face width 153 mm; Material: 18CrNiMo6-7, case hardened to 58 HRc

Parameters: operating speed v_c of grinding wheel: 59 m/s

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C. Results

Table 11: Results of Example VI

	Infeed roughing radial [mm]	Feed rate roughing [mm/rpm]	Shifting	Material removal rate Q_{max} [mm ³ /s]	Specific material removal rate $Q'w$ [mm ³ /mm/s]
Comparative Example Ref. VI-2	0.34	0.45	diagonal	267	6.5
Example VI-1: Test 1	0.34	0.45	diagonal	269	6.5
Example VI-1: Test 2	0.34	0.75	diagonal	475	10.2
Example VI-1: Test 3	0.34	1.00	diagonal	502	13.6
Example VI-1: Test 4	0.34	1.30	diagonal	772	17.7
Example VI-1: Test 5	0.45	1.20	diagonal	883	21.0

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The tests were performed in five test series using different grinding parameters thus described by the infeed and the feed rate for the roughing process. Varying the feed rate shows an increase in the specific material removal rate $Q'w$ in the range of 55-170%. Increasing the feed rate as well as the infeed results in a marked increase in the specific material removal rate $Q'w$ with regard to the reference wheel thereby reducing the process consisting of three roughing steps by one roughing step thus effecting the total grinding time. Even under these severe conditions the test wheel showed no clogging.

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EXAMPLE VII - Surface grinding with segmentsA. Manufacturing process of abrasive grinding tools

- 5 Vitrified bonded abrasive grinding segments having composition, type, dimension (segment width B x thickness C x length L), shape and bond as described in Table 12 were prepared as described in Example I.

Table 12: Characteristics of Grinding Segments used in Example VII

	Example VII-1	Example VII-2	Comparative Example Ref. VII-3
Green Structure			
Abrasive Grain	Mix 11	Mix 20	Mix 21
Shaped abrasive grain	91.74 60+	27.52 60+	
Cerpass TGE®, code 0557			27.3 Grit 36
White fused alumina		64.22 F24, F30	63.7 F24, F30
Vitreous bond	8.26	8.26	9.00
Starch	1.50	1.50	1.74
Liquid temporary binder mix	3.85	3.85	3.67
Pore inducing agent	13.76 (Type B)	13.76 (Type B)	15.00 (Type B)
Moulding density [g/cm ³]	2.080	2.080	2.070
Segments			
Abrasive tool Type **	Type II	Type II	Type II
Shape	T3101	T3101	T3101
Dimension	120x40x200	120x40x200	120x40x200

** (see Table 1)

B. Testing Procedure

The segments prepared as in Example VII were tested in surface grinding application in order to establish the grinding performance of the segments. Using the segments of Example VII, grinding tests were performed using the following grinding conditions:

- Grinding Process: surface grinding
- Machine: Kehren D15CNC (110 kW), Table diameter 1500 mm, grinding head diameter 800 mm (applying 14 segments T310I-120x40x200)
- Workpiece: Die plate, 546x696x66.95 mm. Material: 1.2085 (soft, high chrome content 16-17%)
- Parameters: operating speed v_c 800 rpm, feed rate v_w 15 rpm, grinding stock, 0.3 mm, traverse speed v_f (see Table 13)
- Dressing: Multipoint diamond dresser, 16 mm

C. Results

Table 13: Results of Example VII

	v_{f1} [mm/min]	v_{f2} [mm/min]	v_{f3} [mm/min]	R_a [μ m]	Wear [mm]	Total Grinding time [min:sec]
Example VII-1						
Test 1	0.15	0.15	0.10	0.97	0.28	07:10
Test 2	0.30	0.30	0.10	1.1	0.33	05:45
Test 3	0.30	0.30	0.10	1.0	0.39	06:15
Test 4	0.50	0.50	0.10	0.97	0.36	06:05
Example VII-2						
Test 1	0.15	0.15	0.10	1.9	0.35	07:45
Test 2	0.30	0.30	0.10	1.4	0.50	07:30
Test 3	0.15	0.15	0.10	1.3	0.28	07:30
Test 4	0.15	0.15	0.10		0.25	08:00

The tests were performed in comparison to a reference segment comprising extruded abrasive rods using different parameter sets. For the reference conditions as in Test 1 were

chosen. In general the traverse speed was increased from 0.15 to 0.30, and 0.50 mm/min, respectively. With the machine table present the reference set of segments was able to grind two die plates simultaneously in a total grinding time of 10-12 minutes. Considering the corresponding set of test segments four die plates could be ground simultaneously in ca. 6 minutes (Mix fl, ca. -50%) and ca. 7.5-8 minutes (Mix £2, ca. -30%). The wear of the tests segments was reduced to 0.3-0.4 mm (ca. -35%) in comparison to the reference segments showing a wear of 0.4-0.7 mm. In comparison to the reference segments no clogging of the test segments was observed. The workpiece showed silk-mat surface quality. In general the test series resulted in a marked improvement with regard to the efficiency of the entire grinding process.

EXAMPLE VIII – Surface grinding - reciprocating method

A. Manufacturing process of abrasive grinding tools

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 14 were prepared as described in Example I.

Table 14: Characteristics of Grinding Wheels used in Example VIII

	Example VIII-1		Comparative Example Ref. VIII-2	
	Rim	Center	Rim	Center
Green Structure				
Abrasive Grain	Mix 11	Mix 22	Mix 12	Mix 22
Shaped abrasive grain	92.17 60+			
3M TM Ceramic Abrasive Grain 321			26.79 grit 46	
White fused alumina		92.17 F40, 46, 54	62.51 F40, 46, 54	89.30 F40, 46, 54
Vitreous bond	7.83	7.83	10.70	10.70

Starch	2.10	2.10	1.25	1.25
Liquid temporary binder mix	3.57	3.57	3.86	3.86
Pore inducing agent	13.82 (Type A)	13.82 (Type A)	17.86 (Type B)	17.86 (Type B)
Moulding density [g/cm ³]	2.240	2.240	2,050	2,050
Wheel				
Wheel Type **	Type I		Type IV	
Shape	T26		T26	
Dimension	400x100/6x127-2-200x25/11 A=2		400x100/6x127-2-200x25/11 A=2	

** (see Table 1)

B. Testing Procedure

5 The grinding wheels prepared as in Example VIII were tested in a reciprocating grinding application in order to establish the grinding performance of the wheels. Using the wheels of Example VIII, grinding tests were performed using the following grinding conditions:

10 Grinding Process: reciprocating grinding
Machine: Rosa Linea Avion 13.7 P (17 kW)
Workpiece: customer-specific component; type of material: GGG60; required mean value of surface roughness R_a 1.8 mm
Parameters: Roughing via plunge grinding and finishing via reciprocating grinding; operating speed v_c and other grinding parameters (see Table 14)
Dressing: multipoint diamond dresser

C. Results

Table 15: Results for Example VIII

	Process	Counts of passes	v_c [m/s]	Infeed [mm/min]	Grinding stock [mm]	Infeed/pass [mm]	Speed ratio q_s	Specific material removal rate Q'_w [$\text{mm}^3/\text{mm/s}$]	Surface Roughness R_z [μm]
Comparative Example Ref. VIII-2	Roughing	3x	32	16000	0.8	0.007	120	2	
Example VIII-1: Test 1	Finishing	1x	32	16000	0.03	0.005	120	1.4	6.33
	Roughing	3x	32	16000	0.8	0.007	100	2	
Example VIII-1: Test 2	Finishing	1x	32	16000	0.03	0.005	100	1.4	3.94
	Roughing	3x	32	16000	0.8	0.014	100	4	
Example VIII-1: Test 3	Finishing	1x	27	16000	0.03	0.005	100	1.4	3.33
	Roughing	3x	27	16000	0.8	0.020	100	5.3	
	Finishing	1x	27	16000	0.03	0.005	100	1.4	5.64

The results are shown for the roughing as well as for the finishing process. The roughing process was investigated by three test series using different grinding parameters. The parameter set for the finishing process was kept as for the reference wheel. Performing the tests with the same parameter set as for the reference wheel gains a higher surface quality as for the reference, represented by a lower value for the average roughness depth R_z which means a mean value for the surface roughness of $0.64 \mu\text{m}$ for Test 1. In Test 2 and Test 3 the infeed per pass was increased by 100-185% resulting in 100-165% higher specific material removal rates Q_w and for Test 2 in a further improvement of the surface quality of the workpiece (R_a $0.49 \mu\text{m}$) in comparison to the reference test. Even under the grinding conditions of Test 3 a better surface quality (R_a $0.88 \mu\text{m}$) was obtained than with the reference wheel. Additionally it was observed that the reference wheel showed clogging and the workpiece became unusually warm during grinding. Considering all test series the test wheel does not show this behavior. The dressing after each plunge of the roughing process was reduced to dressing after the third plunge thus leading to an increase in efficiency of the entire grinding process.

EXAMPLE IX – Surface grinding – creep-feed grinding

A. Manufacturing process of abrasive grinding tools

Vitrified bonded abrasive grinding wheels having composition, type, dimension (wheel diameter x thickness x bore diameter), shape and bond as described in Table 16 were prepared as described in Example L

Table 16: Characteristics of Grinding Wheels used in Example IX

Green Structure	Example IX-1			Example IX-2			Comparative Example Ref. IX-3		
	Rim	Center		Rim	Center		Rim	Center	
Abrasive Grain	Mix 3	Mix 17		Mix 6	Mix 17		Mix 2	Mix 17	
Shaped abrasive grain	26.32 80+			87.72 80+					
3M™ Ceramic Abrasive Grain 321							26.32 Grit 80, 90		
White fused alumina	61.40 F70, 80, 100	87.72 F70, 80, 100			87.72 F70, 80, 100		61.40 F70, 80, 100	87.72 F70, 80, 100	
Vitreous bond	12.28	12.28		12.28	12.28		12.28	12.28	
Starch	1.10	1.10		1.50	1.50		1.10	1.10	
Liquid temporary binder mix	3.93	3.93		4.74	4.74		3.93	3.93	
Pore inducing agent	21.93 (Type A)	21.93 (Type A)		13.82 (Type B)	13.82 (Type B)		21.93 (Type A)	21.93 (Type A)	
Moulding density [g/cm ³]	1.870	1.870		2.020	2.020		1.870	1.870	
Wheel									
Wheel Type **	Type VI			Type IV			Type VI		
Shape	T1MSP			T1MSP			T1MSP		
Dimension	600x65x203,2 V=20°, U=1			600x65x203,2 V=20°, U=1			600x65x203,2 V=20°, U=1		

** (see Table 1)

B. Testing Procedure

The grinding wheels prepared as in Example IX were tested in a creep-feed grinding application in order to establish the grinding performance of the wheels. Using the wheels of Example IX, grinding tests were performed using the following grinding conditions:

Grinding Process: creep-feed grinding
 Machine: Magerle MGC
 Workpiece: saw blades, to be ground: 2x 100x10 mm, tooth depth 3 mm
 Parameters: see Table 17, two wheels in a set for grinding both sides of workpiece
 Dressing: diamond rotary dressing tool, synchronous dressing, ratio of surface speeds of grinding wheel and dressing roll 0.75

C. ResultsTable 17: Results for Example IX

	Comparative Example Ref. IX-3	Example IX-1	Example IX-2-
Operating speed v_c [m/s]	45	49	40
Feed rate v_w [mm/min]	550	1200	800
Dressing	2x 0.03 mm	1x 0.03 mm	1x 0.02 mm

The main improvements of the test specifications can be referred to an increase in the feed rate and to the dressing process. The dressing process was improved by reducing the number of dressing cycles by 50%. For Example IX-1 the dressing amount was kept constant but in total was reduced by 50% (0.03 mm instead of 0.06 mm). For Example IX-2 the dressing amount was decreased to 0.02 mm this in total reflecting an improvement by ca. 65%. Due to the machine settings no further variation of the grinding parameters could not be tested. Even with this restriction an increase of the feed rate by 45-120% was obtained. Additionally considering the dressing process the efficiency of the entire grinding process was improved.

CLAIMS

1. A bonded abrasive article comprising shaped abrasive particles and a bonding medium comprising a vitreous bond, said shaped abrasive particles each comprising a first side and a second side separated by a thickness t , wherein said first side comprises a first face having a perimeter of a first geometric shape, wherein the thickness t is equal to or smaller than the length of the shortest side-related dimension of the particle.
2. The article according to claim 1, wherein the shaped abrasive particles are ceramic shaped abrasive particles.
3. The article according to claim 1 or 2, wherein the shaped abrasive particles comprise alpha alumina.
4. The article according to any of claims 1 to 3, wherein the shaped abrasive particles comprise seeded or non-seeded sol-gel derived alpha alumina.
5. The article according to claim 1, wherein said shaped abrasive particles comprise a major portion of aluminum oxide.
6. The article according to claim 5, wherein said aluminum oxide is fused aluminum oxide.
7. The article according to any of claims 1 to 6, further comprising secondary abrasive particles.
8. The article according to claim 7, wherein the shaped and secondary abrasive particles are independently selected from particles of fused aluminum oxide materials, heat treated aluminum oxide materials, ceramic aluminum oxide materials, sintered

aluminum oxide materials, silicon carbide materials, titanium diboride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride, garnet, fused alumina-zirconia, sol-gel derived abrasive particles, cerium oxide, zirconium oxide, titanium oxide or a combination thereof.

9. The article according to claim 7 or 8, wherein the secondary abrasive particles are selected from crushed abrasive particles having a specified nominal grade.
10. The article according to claim 9, wherein the crushed abrasive particles are of a smaller size than the shaped abrasive particles.
11. The article according to any of claims 7 to 10 wherein said secondary abrasive particles are selected from particles of fused aluminum oxide materials, particles of superabrasive materials or particles of silicon carbide materials.
12. The article according to any of claims 1 to 11 comprising 10 to 80 % by volume of said shaped abrasive particles and 1 to 60 % by volume of said bonding medium.
13. The article according to any of claims 1 to 12, wherein said vitreous bond comprises, based on the total weight of the vitreous bond, 25 to 90% by weight of SiO_2 ; 0 to 40% by weight of B_2O_3 ; 0 to 40% by weight of Al_2O_3 ; 0 to 5% by weight of Fe_2O_3 ; 0 to 5% by weight of TiO_2 ; 0 to 20% by weight of CaO ; 0 to 20% by weight of MgO ; 0 to 20% by weight of K_2O ; 0 to 25% by weight of Na_2O ; 0 to 20% by weight of Li_2O ; 0 to 10% by weight of ZnO ; 0 to 10% by weight of BaO ; and 0 to 5% by weight of metallic oxides.
14. The article according to any of claims 1 to 13, wherein the vitreous bond is obtainable from a vitreous bond precursor composition comprising frit.
15. The article according to any of claims 1 to 14, comprising porosity.
16. The article according to any of claims 7 to 15 wherein the shaped abrasive particles and the secondary abrasive particles are comprised in a blend, wherein the content of

the secondary abrasive particles is up to 95% by weight based on the total amount of abrasive particles present in the blend.

17. The article according to any of claims 1 to 16, wherein said first geometric shape is selected from polygonal shapes, lense-shapes, lune-shapes, circular shapes, semicircular shapes, oval shapes, circular sectors, circular segments, drop-shapes and hypocycloids.
18. The article according to any of claims 1 to 17 wherein said first geometric shape is selected from triangular shapes and quadrilateral shapes
19. The article according to any of claims 1 to 18, comprising at least one sidewall.
20. The article according to claim 19, wherein the at least one sidewall is a sloping sidewall.
21. The article according to any of claims 1 to 20, wherein said shaped abrasive particles each comprise at least one shape feature selected from: an opening, at least one recessed (or concave) face; at least one face which is shaped outwardly (or convex); at least one side having a plurality of grooves or ridges; at least one fractured surface; a low roundness factor; a perimeter of the first face comprising one or more corner points having a sharp tip; a second side comprising a second face having a perimeter comprising one or more corner points having a sharp tip; or a combination of one or more of said shape features.
22. The article according to any of claims 1 to 21, wherein the shaped abrasive particles each have an opening.
23. The article according to any of claims 1 to 22, wherein the shaped abrasive particles further comprise a plurality of grooves and/or ridges on the second side.
24. The article according to any of claims 1 to 23 wherein the second side comprises a vertex or a ridge line or a second face.

25. The article according to claim 24, wherein the second side comprises a second face separated from the first side by thickness t and at least one sidewall connecting the second face and the first face.
26. The article according to claim 25, wherein the second face has a perimeter of a second geometric shape which may be the same or different to the first geometric shape.
27. The article according to claim 26 wherein said first and second geometric shapes are independently selected from regular polygons, irregular polygons, lenses, lunes, circulars, semicirculars, ovals, circular sectors, circular segments, drop-shapes and hypocycloids.
28. The article according to claims 26 or 27 wherein the first and second geometric shapes have identical geometric shapes which may or may not be different in size.
29. The article according to claim 28, wherein said identical geometric shapes are both selected either from triangular shapes or from quadrilateral shapes.
30. The article according to any of claims 25 to 29, wherein the first face and the second face are substantially parallel or non-parallel to each other.
31. The article according to any of claims 25 to 30, wherein the first and/or the second face are substantially planar.
32. The article according to any of claims 25 to 31, wherein at least one of the first and second face is a non-planar face.
33. The article according to claim 32, wherein at least one of the first and the second face is shaped inwardly.
34. The article according to claim 33, wherein the first face is shaped inwardly and the second face is substantially planar or the first face is shaped outwardly and the

second face is shaped inwardly or the first face is shaped inwardly and the second face is shaped inwardly.

35. The article according to any of claims 25 to 34, wherein the second side comprises a second face and four facets intersecting the second face at a draft angle α forming a truncated pyramid.
36. The article according to claim 24, wherein the second side comprises a vertex separated from the first side by thickness t and at least one sidewall connecting the vertex and the perimeter of the first face.
37. The article according to claim 36, wherein the perimeter of the first face is trilateral, quadrilateral or higher polygonal and wherein the second side comprises a vertex and the corresponding number of facets for forming a pyramid.
38. The article according to claim 37, wherein the perimeter of the first face is trilateral and wherein the shaped abrasive particles have four major sides joined by six common edges, wherein each one of the four major sides contacts three other of the four major sides, and wherein the six common edges have substantially the same length.
39. The article according to claim 24, wherein the second side comprises a ridge line separated from the first side by thickness t and at least one sidewall connecting the ridge line and the perimeter of the first face.
40. The article according to claim 39, wherein the sidewall comprises one or more facets connecting the ridge line and the perimeter of the first face.
41. The article according to claim 39 or 40, wherein the first geometric shape is selected from quadrilateral geometric shapes and the sidewall comprises four facets forming a roof-shaped particle.

- 42.** The article according to any of claims 1 to 42 having a three-dimensional shape selected from the shape of a wheel, honing stone, grinding segment, mounted points, or other shapes.
- 43.** The article according to any of claims 1 to 42, wherein the article comprises a wheel.
- 44.** The article according to any of claims 43, wherein the wheel is selected from grinding wheels for cylindrical grinding, centerless grinding, surface and profile grinding, reciprocating grinding, creep-feed grinding, grinding in generating methods of gears, threads, tools, camshafts, crankshafts bearings, and guard rails.
- 45.** The article according to any of claims 1 to 44, wherein the shaped abrasive particles are homogeneously distributed in the abrasive article.
- 46.** The article according to any of claims 1 to 44, wherein the shaped abrasive particles are non-homogeneously distributed in the abrasive article.
- 47.** The article according to claim 46, which is or comprises a bonded abrasive wheel, the wheel comprising an outer zone and an inner zone, wherein the compositions of the inner and outer zone differ in one or more aspects selected from the composition of the bond, the shape of abrasive particles, the grit size of abrasive particle, and the amount of abrasive particles.
- 48.** Use of an article according to any of claims 1 to 47 in high performance grinding applications.
- 49.** Use according to claim 48 for outer diameter grinding with a Q'_w of at least 1.5 mm³/mm/sec, inner diameter grinding with a Q'_w of at least 1 mm³/mm/sec, surface grinding with a Q'_w of at least 1.5 mm³/mm/sec, profile grinding with a Q'_w of at least 3 mm³/mm/sec, profile grinding with generating method with a Q'_w of at least 8 mm³/mm/sec, creep-feed grinding with a Q'_w of at least 4 mm³/mm/sec, and camshaft grinding with a Q'_w of at least 8 mm³/mm/sec.

50. Use of an article according to any of claims 1 to 47 for abrading a workpiece material selected from steels, non-ferrous metals, alloys, hard metals, ceramics and glasses.
51. Method for abrading a workpiece, the method comprising frictionally contacting at least a portion of the abrasive article according to any of claims 1 to 42 with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.
52. Method of gear grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
53. Method of creep-feed grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
54. Method of surface grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
55. Method of cylindrical grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
56. A method of grinding characterized by using a bonded abrasive article according to any of claims 1 to 47, wherein the specific chip volume V'_w is at least 20% higher, than the specific chip volume achieved when using a comparable bonded abrasive article at the same specific material removal rate Q'_w .

AMENDED CLAIMS
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1. A bonded abrasive article comprising shaped abrasive particles and a bonding medium comprising a vitreous bond, said shaped abrasive particles each comprising a first side and a second side separated by a thickness t , wherein said first side comprises a first face having a perimeter of a first geometric shape, wherein the thickness t is equal to or smaller than the length of the shortest side-related dimension of the particle.
2. The article according to claim 1, wherein the shaped abrasive particles are ceramic shaped abrasive particles.
3. The article according to claim 1 or 2, wherein the shaped abrasive particles comprise alpha alumina.
4. The article according to any of claims 1 to 3, wherein the shaped abrasive particles comprise seeded or non-seeded sol-gel derived alpha alumina.
5. The article according to claim 1, wherein said shaped abrasive particles comprise a major portion of aluminum oxide.
6. The article according to claim 5, wherein said aluminum oxide is fused aluminum oxide.
7. The article according to any of claims 1 to 6, further comprising secondary abrasive particles.
8. The article according to claim 7, wherein the shaped and secondary abrasive particles are independently selected from particles of fused aluminum oxide materials, heat treated aluminum oxide materials, ceramic aluminum oxide materials, sintered

aluminum oxide materials, silicon carbide materials, titanium diboride, boron carbide, tungsten carbide, titanium carbide, diamond, cubic boron nitride, garnet, fused alumina-zirconia, sol-gel derived abrasive particles, cerium oxide, zirconium oxide, titanium oxide or a combination thereof.

9. The article according to claim 7 or 8, wherein the secondary abrasive particles are selected from crushed abrasive particles having a specified nominal grade.
10. The article according to claim 9, wherein the crushed abrasive particles are of a smaller size than the shaped abrasive particles.
11. The article according to any of claims 7 to 10 wherein said secondary abrasive particles are selected from particles of fused aluminum oxide materials, particles of superabrasive materials or particles of silicon carbide materials.
12. The article according to any of claims 1 to 11 comprising 10 to 80 % by volume of said shaped abrasive particles and 1 to 60 % by volume of said bonding medium.
13. The article according to any of claims 1 to 12, wherein said vitreous bond comprises, based on the total weight of the vitreous bond, 25 to 90% by weight of SiO_2 ; 0 to 40% by weight of B_2O_3 ; 0 to 40% by weight of Al_2O_3 ; 0 to 5% by weight of Fe_2O_3 ; 0 to 5% by weight of TiO_2 ; 0 to 20% by weight of CaO ; 0 to 20% by weight of MgO ; 0 to 20% by weight of K_2O ; 0 to 25% by weight of Na_2O ; 0 to 20% by weight of Li_2O ; 0 to 10% by weight of ZnO ; 0 to 10% by weight of BaO ; and 0 to 5% by weight of metallic oxides.
14. The article according to any of claims 1 to 13, wherein the vitreous bond is obtainable from a vitreous bond precursor composition comprising frit.
15. The article according to any of claims 1 to 14, comprising porosity.
16. The article according to any of claims 7 to 15 wherein the shaped abrasive particles and the secondary abrasive particles are comprised in a blend, wherein the content of

the secondary abrasive particles is up to 95% by weight based on the total amount of abrasive particles present in the blend.

17. The article according to any of claims 1 to 16, wherein said first geometric shape is selected from polygonal shapes, lense-shapes, lune-shapes, circular shapes, semicircular shapes, oval shapes, circular sectors, circular segments, drop-shapes and hypocycloids.
18. The article according to any of claims 1 to 17 wherein said first geometric shape is selected from triangular shapes and quadrilateral shapes
19. The article according to any of claims 1 to 18, comprising at least one sidewall.
20. The article according to claim 19, wherein the at least one sidewall is a sloping sidewall.
21. The article according to any of claims 1 to 20, wherein said shaped abrasive particles each comprise at least one shape feature selected from: an opening, at least one recessed (or concave) face; at least one face which is shaped outwardly (or convex); at least one side having a plurality of grooves or ridges; at least one fractured surface; a low roundness factor; a perimeter of the first face comprising one or more corner points having a sharp tip; a second side comprising a second face having a perimeter comprising one or more corner points having a sharp tip; or a combination of one or more of said shape features.
22. The article according to any of claims 1 to 21, wherein the shaped abrasive particles each have an opening.
23. The article according to any of claims 1 to 22, wherein the shaped abrasive particles further comprise a plurality of grooves and/or ridges on the second side.
24. The article according to any of claims 1 to 23 wherein the second side comprises a vertex or a ridge line or a second face.

25. The article according to claim 24, wherein the second side comprises a second face separated from the first side by thickness t and at least one sidewall connecting the second face and the first face.
26. The article according to claim 25, wherein the second face has a perimeter of a second geometric shape which may be the same or different to the first geometric shape.
27. The article according to claim 26 wherein said first and second geometric shapes are independently selected from regular polygons, irregular polygons, lenses, lunes, circulars, semicirculars, ovals, circular sectors, circular segments, drop-shapes and hypocycloids.
28. The article according to claims 26 or 27 wherein the first and second geometric shapes have identical geometric shapes which may or may not be different in size.
29. The article according to claim 28, wherein said identical geometric shapes are both selected either from triangular shapes or from quadrilateral shapes.
30. The article according to any of claims 25 to 29, wherein the first face and the second face are substantially parallel or non-parallel to each other.
31. The article according to any of claims 25 to 30, wherein the first and/or the second face are substantially planar.
32. The article according to any of claims 25 to 31, wherein at least one of the first and second face is a non-planar face.
33. The article according to claim 32, wherein at least one of the first and the second face is shaped inwardly.
34. The article according to claim 33, wherein the first face is shaped inwardly and the second face is substantially planar or the first face is shaped outwardly and the

second face is shaped inwardly or the first face is shaped inwardly and the second face is shaped inwardly.

35. The article according to any of claims 25 to 34, wherein the second side comprises a second face and four facets intersecting the second face at a draft angle α forming a truncated pyramid.
36. The article according to claim 24, wherein the second side comprises a vertex separated from the first side by thickness t and at least one sidewall connecting the vertex and the perimeter of the first face.
37. The article according to claim 36, wherein the perimeter of the first face is trilateral, quadrilateral or higher polygonal and wherein the second side comprises a vertex and the corresponding number of facets for forming a pyramid.
38. The article according to claim 37, wherein the perimeter of the first face is trilateral and wherein the shaped abrasive particles have four major sides joined by six common edges, wherein each one of the four major sides contacts three other of the four major sides, and wherein the six common edges have substantially the same length.
39. The article according to claim 24, wherein the second side comprises a ridge line separated from the first side by thickness t and at least one sidewall connecting the ridge line and the perimeter of the first face.
40. The article according to claim 39, wherein the sidewall comprises one or more facets connecting the ridge line and the perimeter of the first face.
41. The article according to claim 39 or 40, wherein the first geometric shape is selected from quadrilateral geometric shapes and the sidewall comprises four facets forming a roof-shaped particle.

42. The article according to any of claims 1 to 42 having a three-dimensional shape selected from the shape of a wheel, honing stone, grinding segment, mounted points, or other shapes.
43. The article according to any of claims 1 to 42, wherein the article comprises a wheel.
44. The article according to claim 43, wherein the wheel is selected from grinding wheels for cylindrical grinding, centerless grinding, surface and profile grinding, reciprocating grinding, creep-feed grinding, grinding in generating methods of gears, threads, tools, camshafts, crankshafts bearings, and guard rails.
45. The article according to any of claims 1 to 44, wherein the shaped abrasive particles are homogeneously distributed in the abrasive article.
46. The article according to any of claims 1 to 44, wherein the shaped abrasive particles are non-homogeneously distributed in the abrasive article.
47. The article according to claim 46, which is or comprises a bonded abrasive wheel, the wheel comprising an outer zone and an inner zone, wherein the compositions of the inner and outer zone differ in one or more aspects selected from the composition of the bond, the shape of abrasive particles, the grit size of abrasive particle, and the amount of abrasive particles.
48. A bonded abrasive article according to any of claims 1 to 47, wherein the article comprises a blend of said shaped abrasive particles and secondary abrasive particles, wherein the amount of shaped abrasive particles ranges from 20 to 60% by weight, based on the total weight of abrasive particles in the blend.
49. A bonded abrasive article according to any of claims 1 to 47, wherein the article is an article for gear grinding.
50. Use of an article according to any of claims 1 to 49 in high performance grinding applications.

51. Use according to claim 50 for outer diameter grinding with a Q'_w of at least 1.5 mm³/mm/sec, inner diameter grinding with a Q'_w of at least 1 mm³/mm/sec, surface grinding with a Q'_w of at least 1.5 mm³/mm/sec, profile grinding with a Q'_w of at least 3 mm³/mm/sec, profile grinding with generating method with a Q'_w of at least 8 mm³/mm/sec, creep-feed grinding with a Q'_w of at least 4 mm³/mm/sec, and camshaft grinding with a Q'_w of at least 8 mm³/mm/sec.
52. Use of an article according to any of claims 1 to 49 for abrading a workpiece material selected from steels, non-ferrous metals, alloys, hard metals, ceramics and glasses.
53. Method for abrading a workpiece, the method comprising frictionally contacting at least a portion of the abrasive article according to any of claims 1 to 42 with a surface of a workpiece; and moving at least one of the workpiece or the abrasive article to abrade at least a portion of the surface of the workpiece.
54. Method of gear grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
55. Method of creep-feed grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
56. Method of surface grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
57. Method of cylindrical grinding characterized by using a bonded abrasive article according to any of claims 1 to 47.
58. A method of grinding characterized by using a bonded abrasive article according to any of claims 1 to 49, wherein the specific chip volume V'_w is at least 20% higher, than the specific chip volume achieved when using a comparable bonded abrasive article at the same specific material removal rate Q'_w .

Fig. 1: Example I - Q'w 2,5 mm³/mm/s -- Type III Wheels

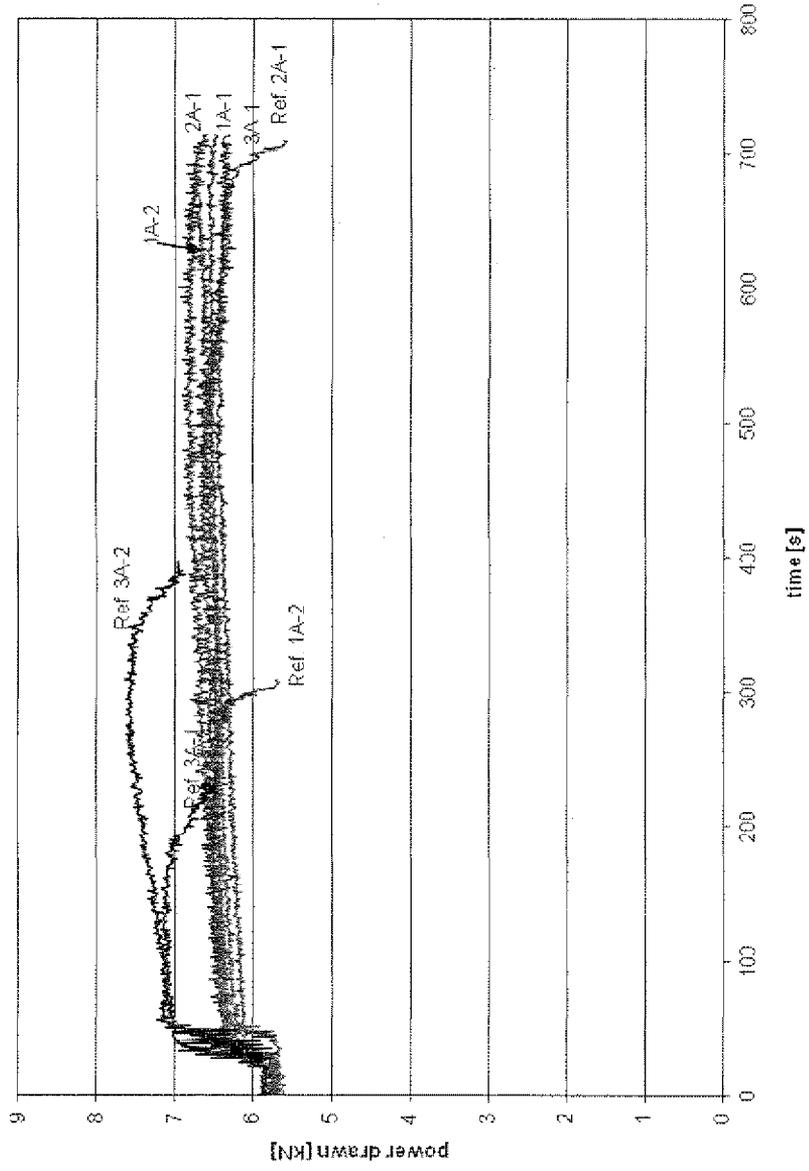


Fig. 2: Example 1 - Q'w 2,5 mm³/mm/s - Type VII Wheels

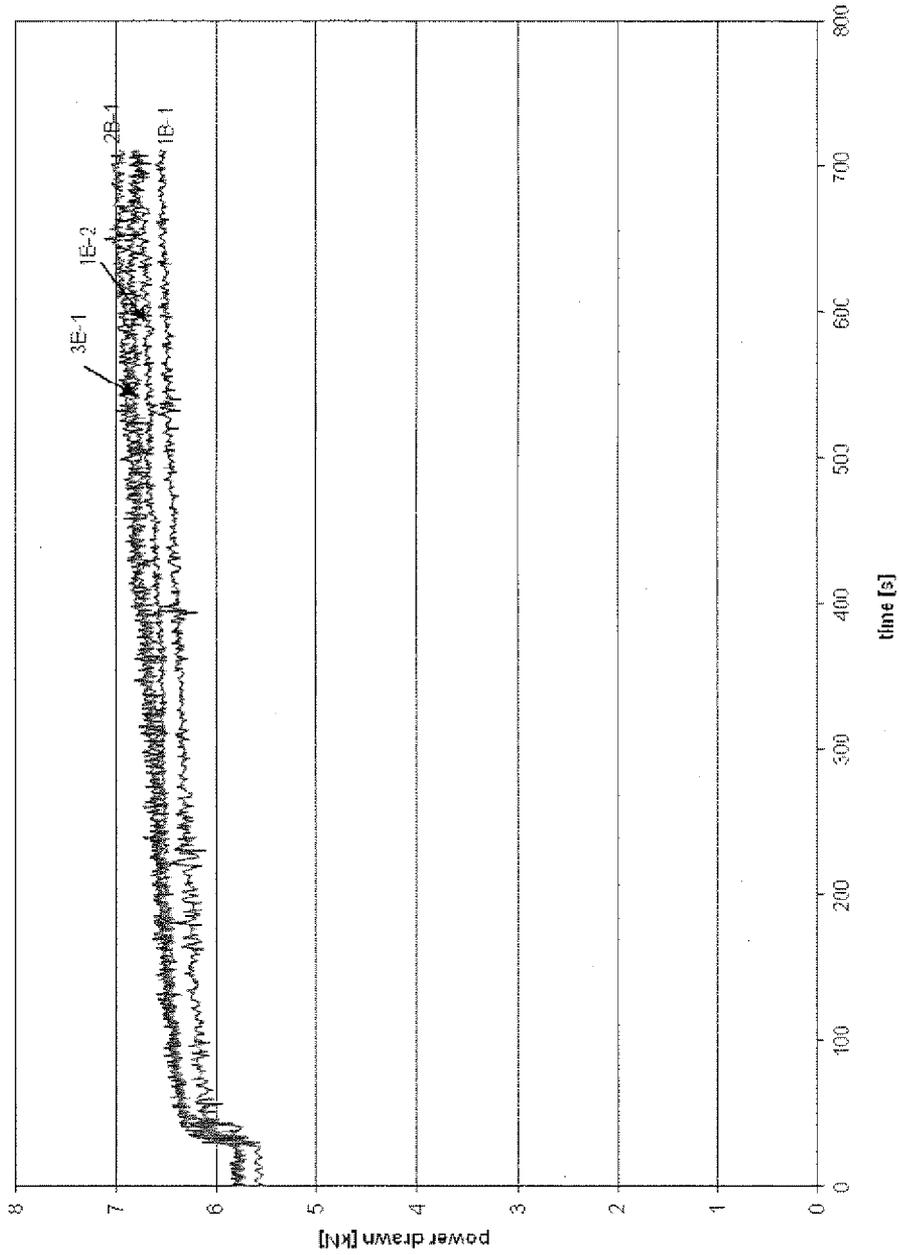


Fig. 3: Example I - Q'w 5 mm³/mm/s - Type III Wheels

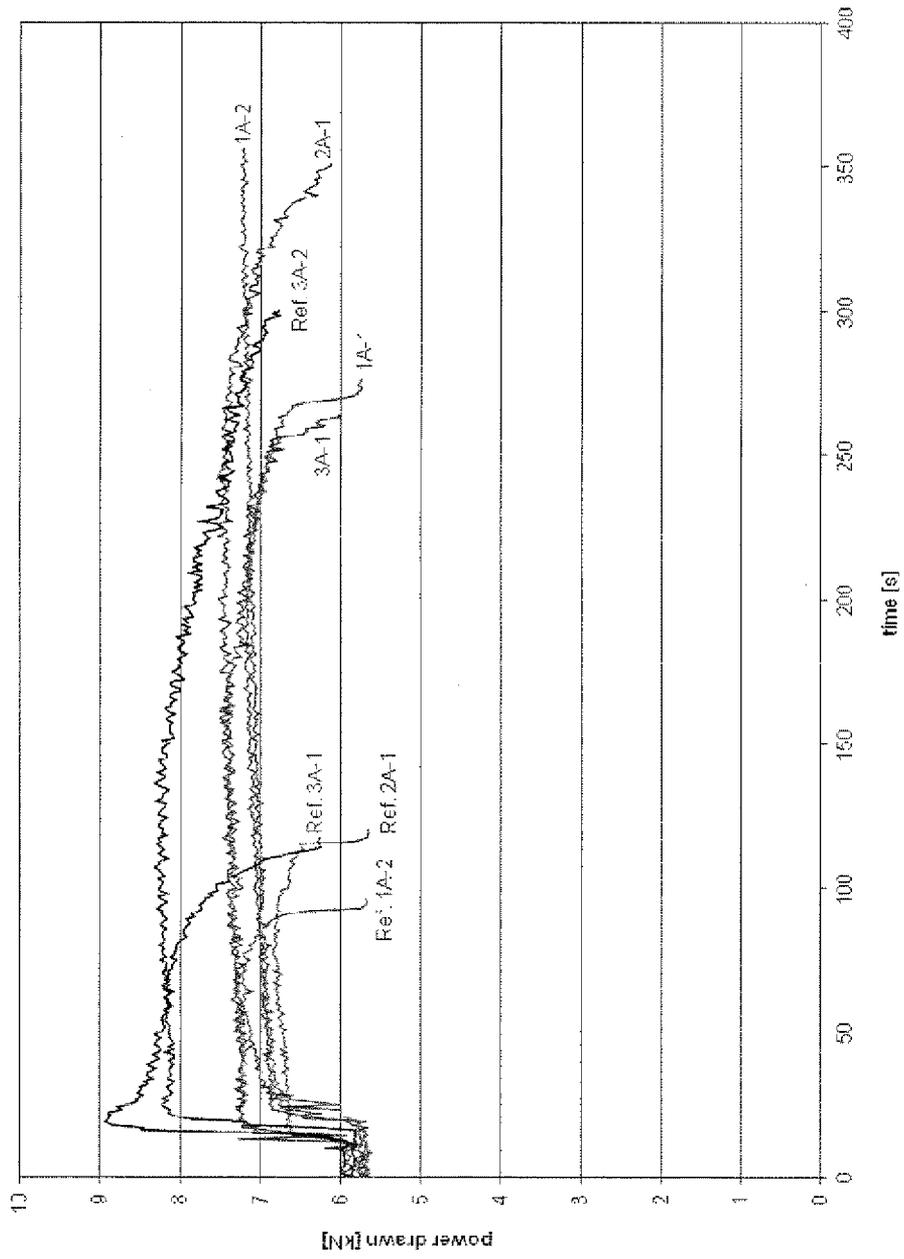


Fig. 4: Example I - Q'w 5 mm³/mm/s - Type VII Wheels

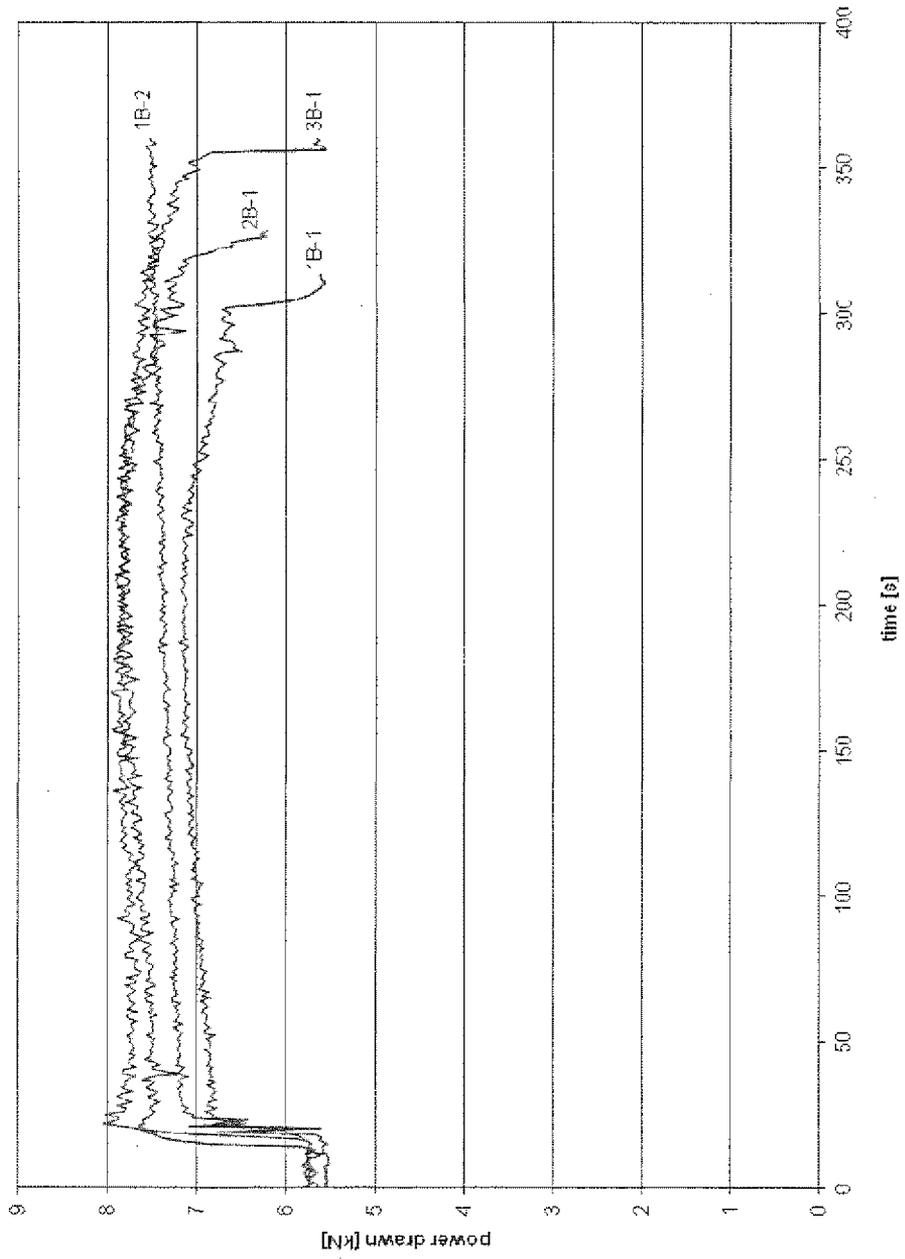


Fig. 5: Example I - Surface Roughness R_a – Type III Wheels

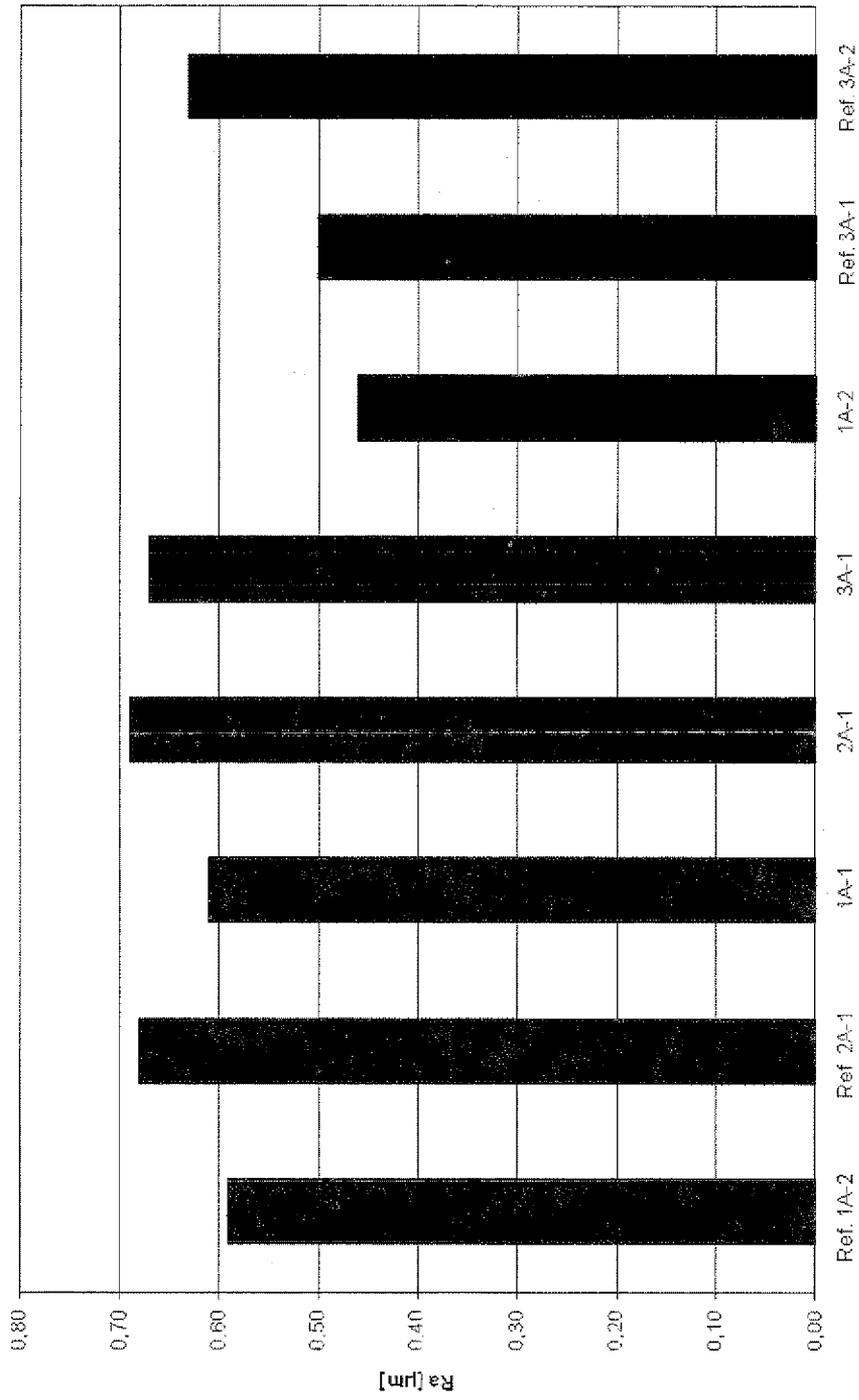


Fig. 6:

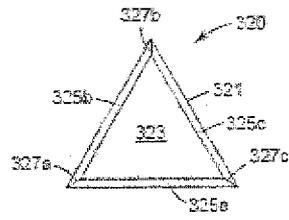


Fig. 6A

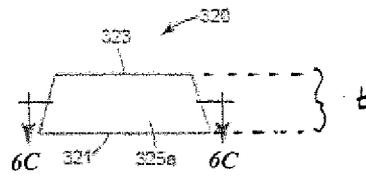


Fig. 6B

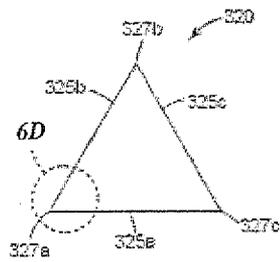


Fig. 6C

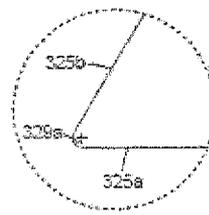


Fig. 6D

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2012/067426

A. CLASSIFICATION OF SUBJECT MATTER
INV. B24D3/14 C09K3/14
ADD.
According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
Minimum documentation searched (classification system followed by classification symbols)
B24D C09K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	wo 2011/068714 A2 (3M INNOVATIVE PROPERTIES CO [US] ; ADEFRIS NEGUS B [US] ; BRAUNSCHWEIG E) 9 June 2011 (2011-06-09) cited in the application	I - 6, II- 56
Y	page 5, line 15 - page 21, line 23 -----	7-10
Y	wo 2007/040865 AI (SAINT GOBAIN ABRASIVES INC [US]) 12 April 2007 (2007-04-12) paragraph [0017] -----	7-10

Further documents are listed in the continuation of Box C. See patent family annex.

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"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

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"&" document member of the same patent family

Date of the actual completion of the international search 3 December 2012	Date of mailing of the international search report 17/12/2012
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer Gel der, Kl aus
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/EP2012/067426

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