

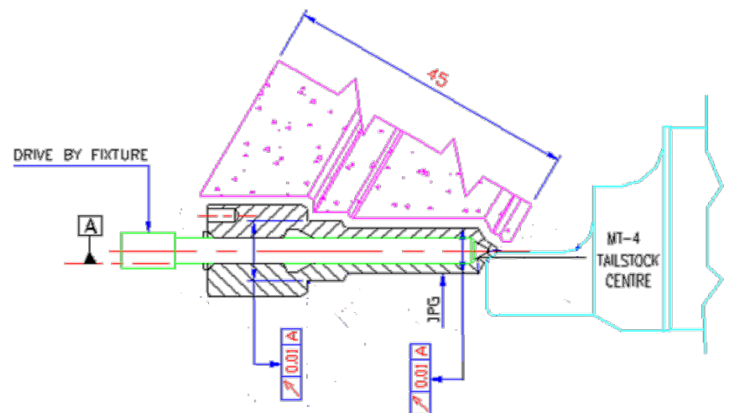
MASTER ABRASIVES

CASE STUDY

#1017

External Cylindrical Grinding Machine

Workpiece:	Injection Nozzle Body
Operation:	OD Grinding (Form)
Machine:	Micromatic GCE350 x 500 CNC
Cycle Time:	13 seconds
Stock Removal:	0.15 ~ 0.20mm
CpK:	11.71 (for tolerance of $\pm 0.01\text{mm}$)
Surface Roughness:	< 2.6 Rz
Concentricity:	< 0.01mm
Run out on ball:	< 4 μm



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