

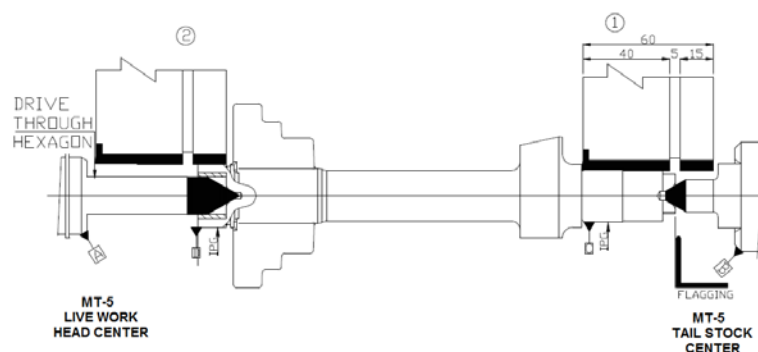
MASTER ABRASIVES

External Cylindrical Grinding Machine

CASE STUDY

#1019

Workpiece:	Balance Shaft
Operation:	Plunge Grinding
Machine:	Micromatic SH40 CNC / 60mps With CBN wheel
Cycle Time:	60 seconds (including dressing)
Stock Removal:	0.3mm on OD & 0.15mm on face
CpK:	3.36 (for tolerance of 13 μ m)
Hardness:	217~286 BHN
Roundness:	0.002mm on dia 30
Straightness:	0.003mm
Concentricity:	0.51 μ m
Surface Roughness:	<0.3 μ m Ra



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CONTACT US FOR MORE INFORMATION

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