

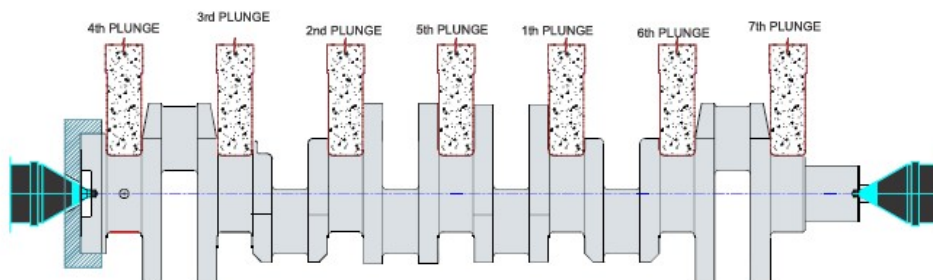
# MASTER ABRASIVES

CASE STUDY

#1035

## Special Purpose Grinding Machine

|                            |  |
|----------------------------|--|
| <b>Workpiece:</b>          | <b>Crank Shaft (6 Cylinder)</b>        |
| <b>Operation:</b>          | Journal Grinding                       |
| <b>Machine:</b>            | Micromatic RHINO-120                   |
| <b>Cycle Time:</b>         | 18 minutes 20 seconds                  |
| <b>Stock Removal:</b>      | 1.2mm on OD & 0.15mm on each Face      |
| <b>CpK:</b>                | 1.33                                   |
| <b>Roundness:</b>          | <5 $\mu\text{m}$                       |
| <b>Runout:</b>             | <60 $\mu\text{m}$                      |
| <b>Surface Roughness:</b>  | 0.5 ~ 0.6 $\mu\text{Ra}$               |
| <b>Dressing Frequency:</b> | Per journal simultaneous with grinding |



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