

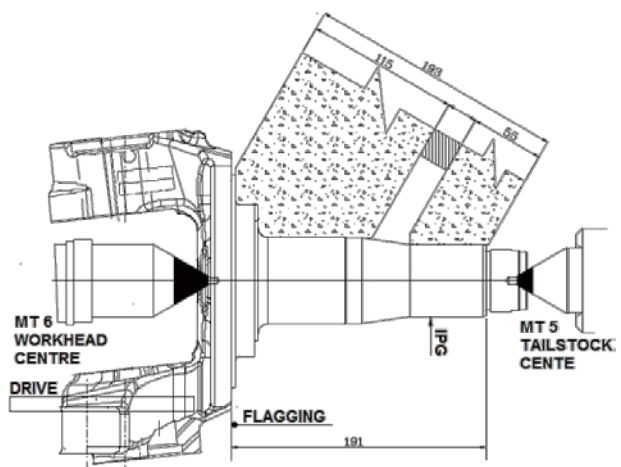
# MASTER ABRASIVES

## Cylindrical Grinding Machine

CASE STUDY

#1041

<b>Workpiece:</b>	<b>Stub Axle</b>
<b>Operation:</b>	OD & Face Grinding – Angle Approach
<b>Machine:</b>	Micromatic SH 63 CNC / 45 mps
<b>Cycle Time:</b>	125 seconds
<b>Stock Removal:</b>	0.4mm on OD & 0.1mm on face
<b>Hardness:</b>	300 BHN
<b>Run out w.r.t Centre:</b>	Within 5µm
<b>Surface Roughness:</b>	On OD within 0.45 µ Ra On face within 0.5 µ Ra
<b>Dressing Skip:</b>	4 Components



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