

MASTER ABRASIVES

External Cylindrical Grinding Machine

CASE STUDY

#1045

Workpiece	Rocker Arm
Operation	OD and 2 face grinding in single plunge
Machine	e-Grind 200 CNC
Cycle Time	55 seconds
Stock Removal	0.25 on OD and 0.15 on both faces
CpK	>1.4 (for tolerance of 8 µm on diameter)
Width Control	Within 80% of tolerance
Cylindricity	Within 2 µm
Surface Roughness	Within 0.35 µ Ra
Benefits	<ul style="list-style-type: none">• Productivity increased by 25% through optimisation of grinding cycle• Grinding wheel utilisation increased by 50% through optimised dressing skips• Consistency in geometrical parameters during production run



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CONTACT US FOR MORE INFORMATION

MASTER
ABRASIVES

T:01327-703813

sales@master-abrasives.co.uk

www.master-abrasives.co.uk