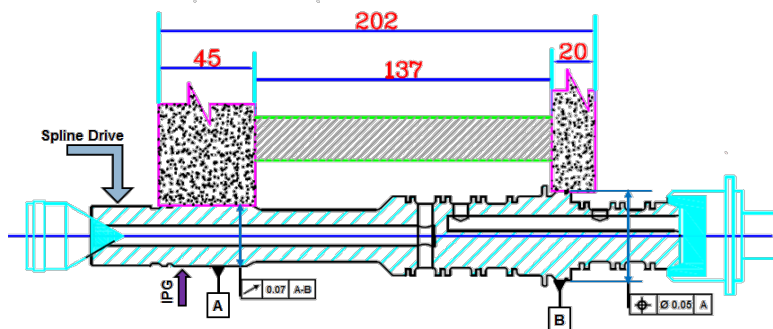


# MASTER®

## CASE STUDY #1016

### External Cylindrical Grinding Machine

<b>Workpiece:</b>	Turbine Shaft
<b>Operation:</b>	OD Grinding
<b>Machine:</b>	Micromatic SH-40 CNC
<b>Cycle Time:</b>	38 secs (includes load/unload)
<b>Stock Removal:</b>	0.3mm on OD
<b>CpK:</b>	2.2 (for tolerance of 8 µm)
<b>Surface Roughness:</b>	< 0.3 µm Ra
<b>TP:</b>	40%
<b>Dressing Skip:</b>	10 components



SOLUTIONS FOR INDUSTRY

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