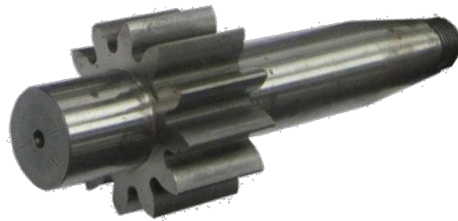


MASTER®

CASE STUDY #1018


External Cylindrical Grinding Machine

Workpiece:	Geared Shaft
Operation:	OD and Face Grinding in single setup
Machine:	Micromatic SH40 SPM / 60mps Twin Wheel Head
Cycle Time:	129 secs
Stock Removal:	0.25mm
CpK:	0.67 (for tolerance of 11 µm)
Hardness:	50~55 HRC
Concentricity Ø:	0.002mm
Cylindricity:	0.002mm / 50mm length
Run out major Ø:	0.002mm
Gear Width Measurement:	0.002 ~ 0.003mm
Axial Runout (short/long):	< 0.002mm
Flatness on Face (short/long):	< 0.002mm
Surface Finish – OD Face:	0.2 ~ 0.3 µm Ra
Dressing Skip:	20 components



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