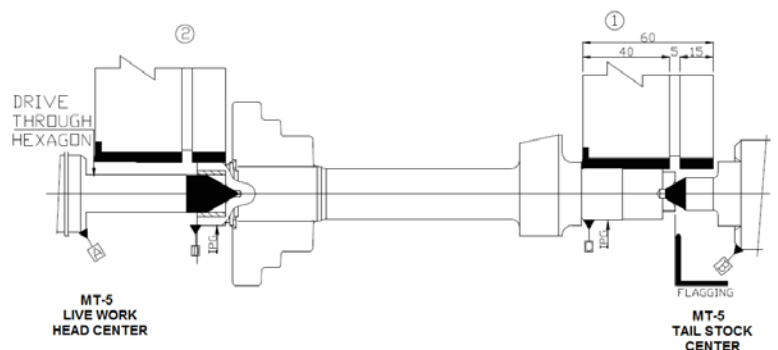


MASTER®

CASE STUDY #1019


External Cylindrical Grinding Machine

| | |
|---------------------------|---|
| Workpiece: | Balance Shaft |
| Operation: | Plunge Grinding |
| Machine: | Micromatic SH40 CNC / 60mps With CBN Wheel |
| Cycle Time: | 60 secs (including dressing) |
| Stock Removal: | 0.3mm on OD & 0.15mm on Face |
| CpK: | 3.36 (for tolerance of 13 µm) |
| Hardness: | 217~286 BHN |
| Roundness: | 0.002mm on dia 30 |
| Straightness: | 0.003mm |
| Concentricity: | 0.51 µm |
| Surface Roughness: | <0.3 µm Ra |



SOLUTIONS FOR INDUSTRY

T: 01327 703813
sales@master-abrasives.co.uk

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www.master-abrasives.co.uk