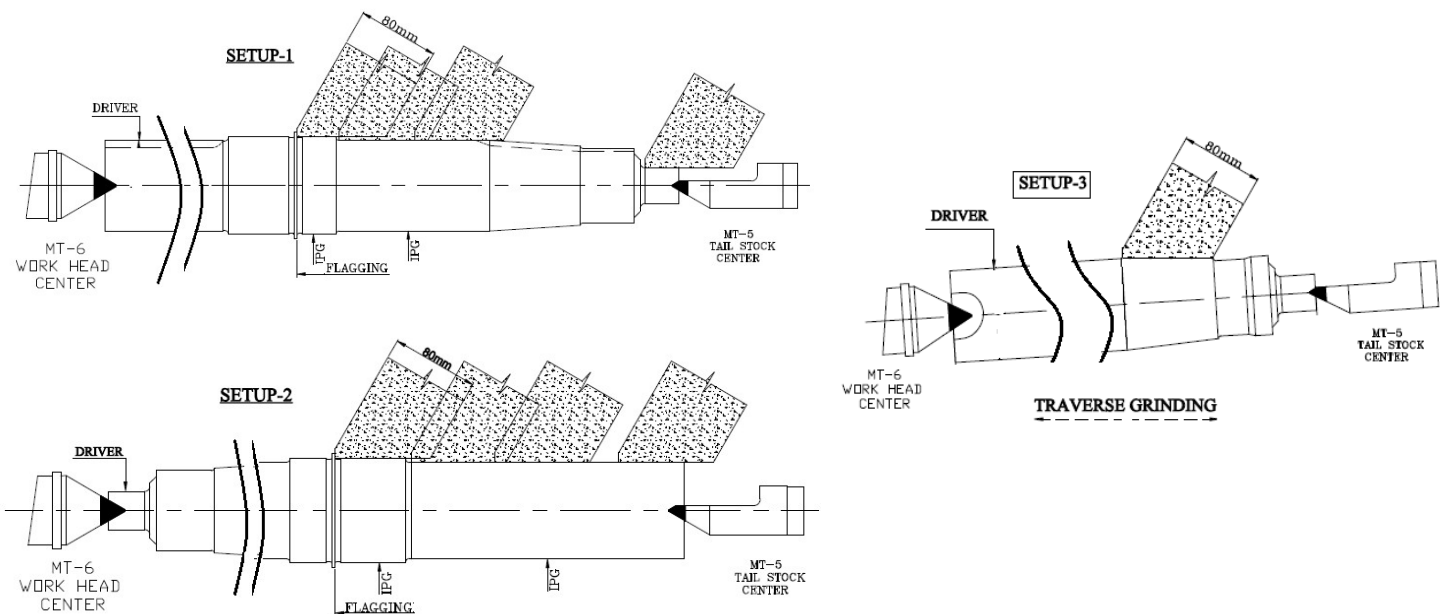


MASTER®

CASE STUDY #1020

External Cylindrical Grinding Machine

Workpiece:	Shaft Clutch
Operation:	OD Grinding (3 setups)
Machine:	Micromatic SH100 CNC / 45mps
Cycle Time -1st setup:	300 secs
Cycle Time -2nd setup:	310 secs
Cycle Time -3rd setup:	94 secs
Stock Removal:	0.3mm
Taper (3rd setup):	< 0.002°
Runout on W.R.T Centre:	0.003mm
Surface Roughness:	0.4 µm Ra



SOLUTIONS FOR INDUSTRY

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