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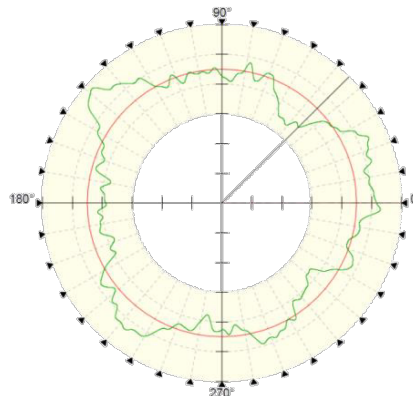
CASE STUDY #1025

Centreless Grinding Machine

Workpiece:	Engine Valve
Operation:	OD Stem Grinding (Plunge)
Machine:	Micromatic CLG 6020 – 3 Axis
Cycle Time:	11 secs
Stock Removal:	0.15 ~ 0.2mm
Dimensional Size:	Ø6.595 ± 0.010mm
Roundness:	1 µm
Cylindricity:	1.5 µm
Surface Roughness:	0.3 µm Ra
Dressing Skip:	50 components




Roundness Graph:



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