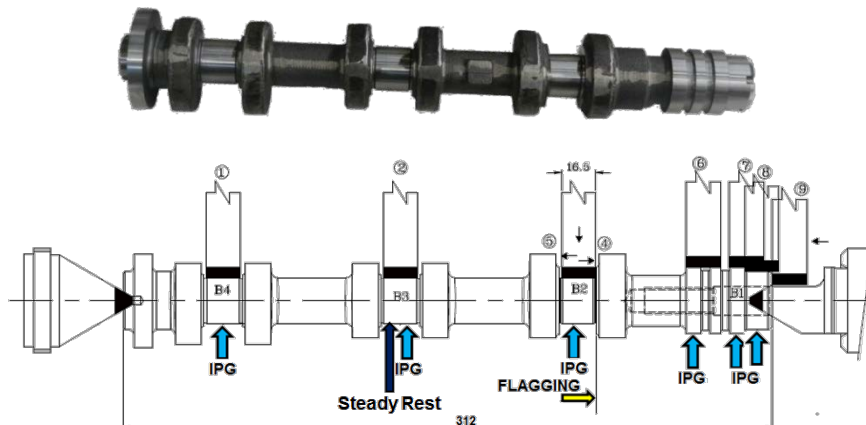


## CASE STUDY #1038

### Special Cam Grinding Machine

<b>Workpiece:</b>	Cam Shaft – Journal & Face Grinding
<b>Operation:</b>	Journal Grinding + Two Faces
<b>Machine:</b>	CBN 3263 / 80mps
<b>Stock Removal:</b>	0.6 to 0.7mm on dia. & 0.2mm on face
<b>Wheel type:</b>	Vitrified CBN
<b>Cycle Time:</b>	210 seconds
<b>CpK:</b>	≥ 1.67 for diameter (for tolerance of 13 µm)
<b>Cylindricity:</b>	<2 µm
<b>Taper:</b>	< 2 µm
<b>Runout w.r.t Centre:</b>	< 4 µm on all ground diameters
<b>Surface Roughness:</b>	0.4 µ Ra on OD grind and 0.6 µ Ra on Face
<b>Dressing Skip:</b>	35 components



**SOLUTIONS FOR INDUSTRY**