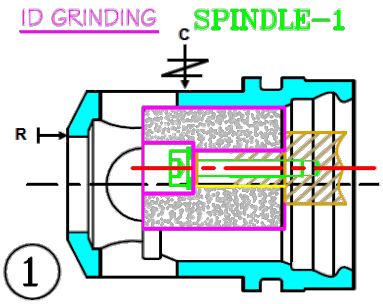
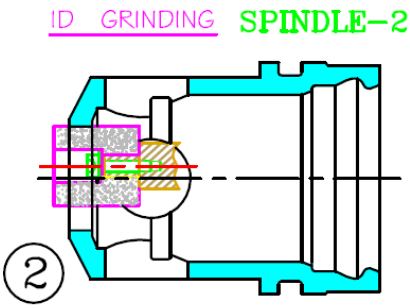
MASTER®

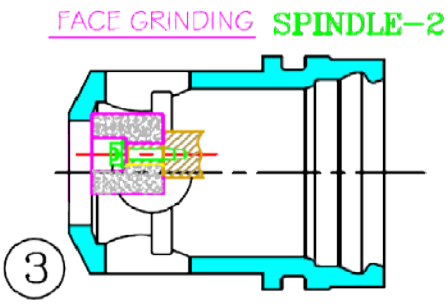
CASE STUDY #1030

Internal Grinding Machine

Workpiece:	**Cylindrical Valve**
Operation:	Bore & Face Grinding
Machine:	Micromatic IG 50 SPM with CBN Wheel
Cycle Time:	110 secs
Stock Removal:	0.3mm
CpK:	2.7 (for tolerance of 6 µm)
Roundness:	0.0015mm
Cylindricity:	0.002mm / 11mm
Surface Roughness:	0.4 µm Ra
Dressing Skip:	20 components







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