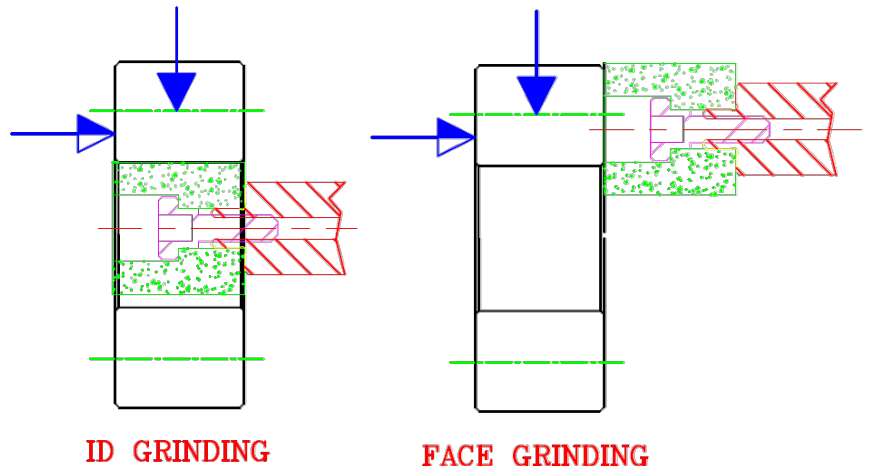


MASTER®

CASE STUDY #1033


Internal Grinding Machine

| | |
|---------------------------|-------------------------------|
| Workpiece: | Transmission Pump Gear |
| Operation: | Bore & Face Grinding |
| Machine: | Micromatic IG 50 CNC |
| Cycle Time: | 150 secs (including dressing) |
| Stock Removal: | 0.2mm in Bore & 0.1mm on Face |
| Hardness: | 25 HRC |
| CpK: | 1.85 (for tolerance of 10 µm) |
| Surface Roughness: | 0.2 µm Ra |



SOLUTIONS FOR INDUSTRY

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