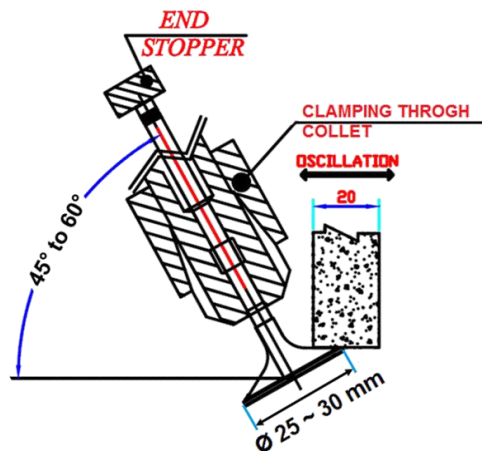


MASTER[®]

CASE STUDY #1036


Special Purpose Grinding Machine

Workpiece:	Engine Valve - Inlet
Operation:	Seat Angle Grinding
Machine:	Micromatic Valve Seat Grinder GVS CNC – 60mps
Grinding Wheel:	Conventional bonded wheel
Cycle Time:	7 secs (including load/unload; without dressing)
Stock Removal:	0.2mm
CpK (on Tip Height):	1.43 (tolerance $\pm 0.050\text{mm}$)
Roundness:	$\leq 0.003\text{mm}$
Runout:	0.015mm
Surface Roughness:	0.3 $\mu\text{m Ra}$
Seat Height Control:	Stem end or Valve face end – both options available
Dressing Skip:	25 components



SOLUTIONS FOR INDUSTRY

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