

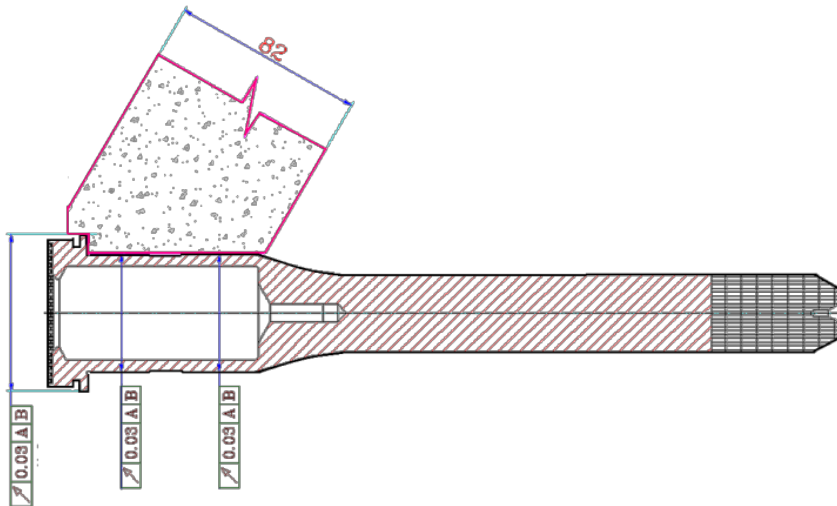
MASTER ABRASIVES

CASE STUDY

#1015

External Cylindrical Grinding Machine

Workpiece:	Output Shaft
Operation:	OD & Face Grinding
Machine:	Micromatic SH-40 CNC
Cycle Time:	60 seconds
Stock Removal:	0.3mm on OD & 0.15mm on face
CpK:	1.66 (for tolerance of 10 µm)
Surface Roughness:	02 ~ 0.3 µm Ra 1.65 ~ 2.67 Rz 0.5 ~ 1.25 Rpm
Lead Angle:	0± 0.05° as per SAEJ946
Dressing Skip:	5 components



Copyright © 2020 Master Abrasives Ltd

CONTACT US FOR MORE INFORMATION

**MASTER
ABRASIVES**

T:01327-703813

sales@master-abrasives.co.uk

www.master-abrasives.co.uk