

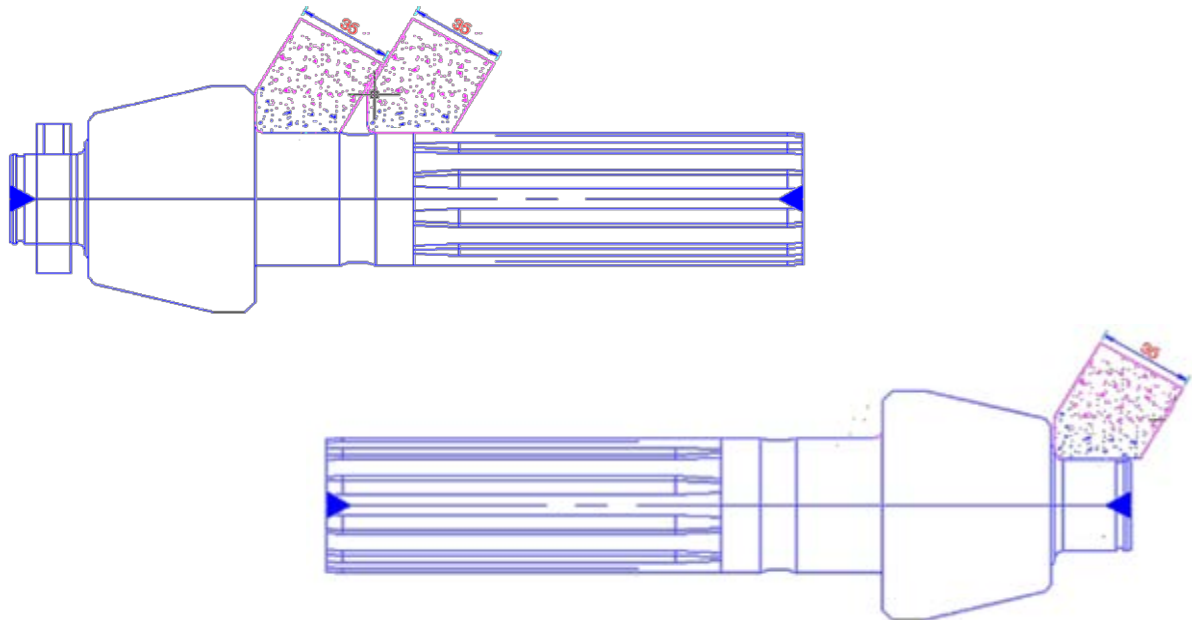
MASTER ABRASIVES

External Cylindrical Grinding Machine

CASE STUDY

#1022

Workpiece:	Drive Pinion
Operation:	OD Grinding in 2 setups
Machine:	Micromatic e-grind 200 CNC
Cycle Time:	205 seconds including reverse loading & dressing
Stock Removal:	0.35 ~ 0.4mm
Hardness:	58 ~ 60 HRC
CpK:	3.33 (for tolerance of 0.014mm)
Ovality:	<0.003mm
Surface Finish:	0.4 Ra
Dressing Skip:	Every component



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