

MASTER ABRASIVES

Centreless Grinding Machine

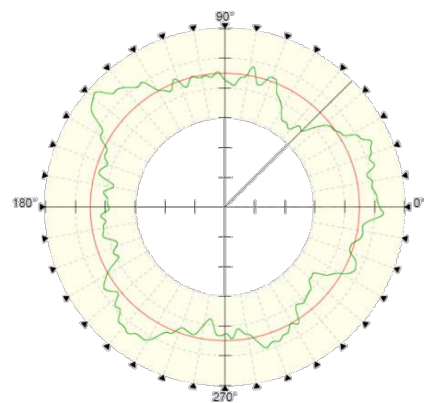
CASE STUDY

#1025

Workpiece:	Engine Valve
Operation:	OD Stem Grinding (Plunge)
Machine:	Micromatic CLG 6020 – 3 Axis
Cycle Time:	11 seconds
Stock Removal:	0.15 ~ 0.2mm
Dimensional Size:	$\varnothing 6.595 \pm 0.010\text{mm}$
Roundness:	1 μm
Cylindricity:	1.5 μm
Surface Roughness:	0.3 $\mu\text{m Ra}$
Dressing Skip:	50 components



Roundness graph:



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CONTACT US FOR MORE INFORMATION

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