

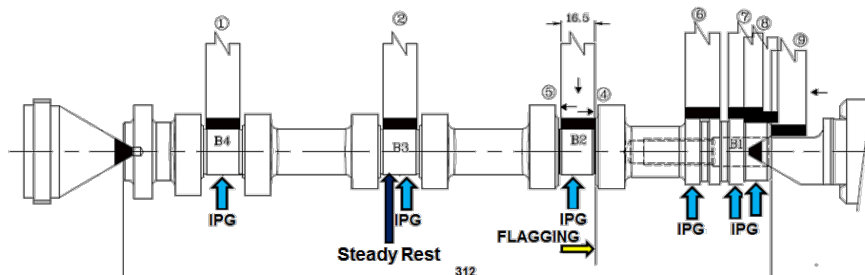
MASTER ABRASIVES

Special Cam Grinding Machine

CASE STUDY

#1028

Workpiece:	Camshaft - Journal & Face Grinding
Operation:	Journal Grinding + Two Faces
Machine:	CBN 3263 / 80mps
Stock Removal:	0.6 to 0.7mm on dia. & 0.2mm on face
Wheel type:	Vitrified CBN
Cycle Time:	210 seconds
CpK:	≥ 1.67 for diameter (for tolerance of 13 μm)
Cylindricity:	<2 μm
Taper:	< 2 μm
Runout w.r.t Centre:	< 4 μm on all ground diameters
Surface Roughness:	0.4 μ Ra on OD grind and 0.6 μ Ra on Face
Dressing Skip:	35 components



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CONTACT US FOR MORE INFORMATION

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