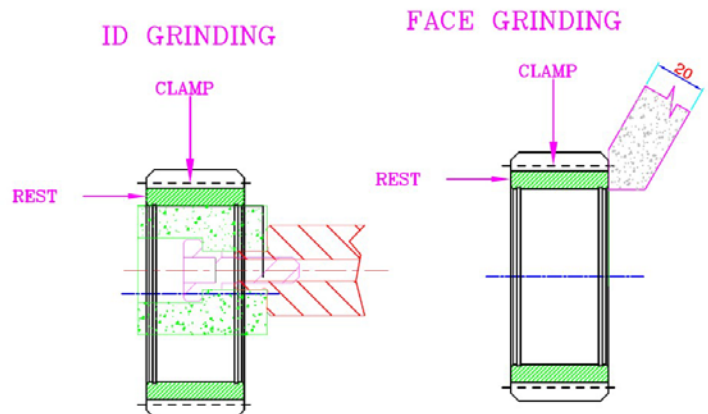


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Internal Grinding Machine

CASE STUDY
#1029

Workpiece:	Planetary Gear
Operation:	Bore & Face by OD Grinding
Machine:	Micromatic IG 150 U
Cycle Time:	95 seconds
Stock Removal:	0.3mm in Bore and 0.15mm on Face
CpK:	2.03 (for tolerance of 20 µm)
Roundness:	0.001mm
Cylindricity:	0.003mm / 40mm
Runout on face W.R.T. ID:	0.01mm
Surface Roughness:	0.4 µm Ra



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