

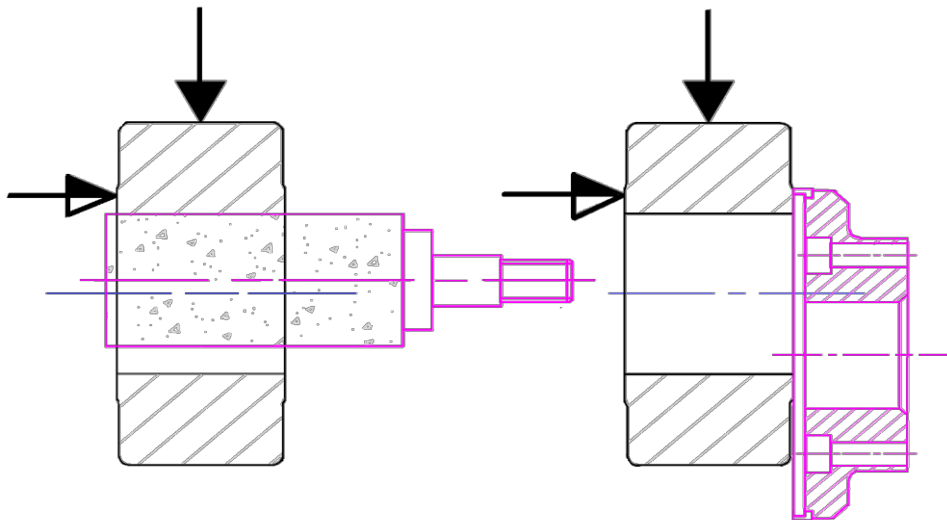
MASTER ABRASIVES

Internal Grinding Machine

CASE STUDY

#1032

Workpiece:	Roller Cam Follower
Operation:	Bore & Face Grinding
Machine:	Micromatic IG 50
Cycle Time:	65 seconds with automation
Stock Removal:	0.2mm in Bore & 0.1mm on Face
Hardness:	60-64 HRC
Roundness:	0.0015mm
Straightness:	< 0.001mm
Surface Roughness:	0.4 μm Ra
Dressing Skip:	Bore – after 15 components Face – after 30 components



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