

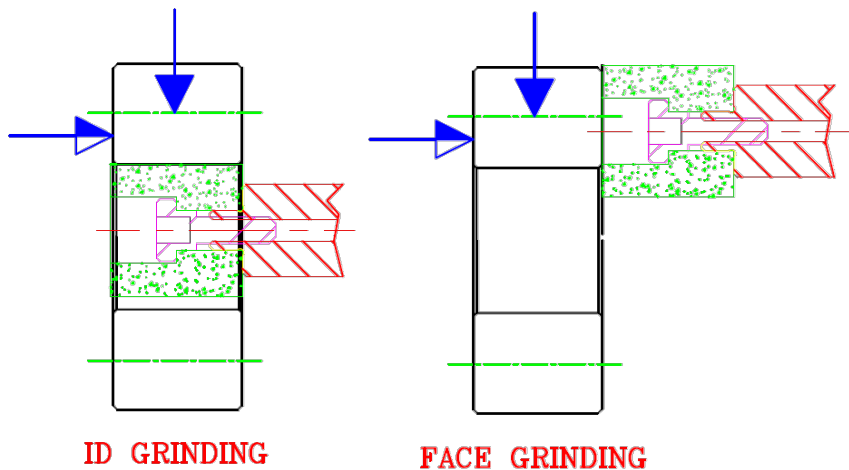
MASTER ABRASIVES

Internal Grinding Machine

CASE STUDY

#1033

Workpiece:	Transmission Pump Gear
Operation:	Bore & Face Grinding
Machine:	Micromatic IG 50 CNC
Cycle Time:	150 seconds (including dressing)
Stock Removal:	0.2mm in Bore & 0.1mm on Face
Hardness:	25 HRC
CpK:	1.85 (for tolerance of 10 µm)
Surface Roughness:	0.2 µm Ra



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