

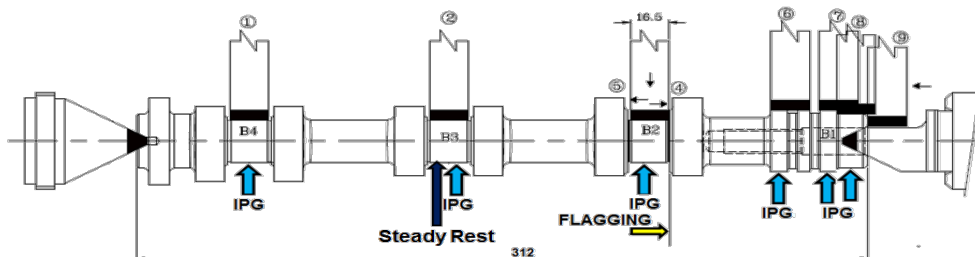
MASTER ABRASIVES

Special Purpose Cam Grinding Machine

CASE STUDY

#1038

Workpiece:	Camshaft – Journal & Face Grinding
Machine:	CBN 3263 / 80mps
Operation:	Journal Grinding & Two Faces
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 μ)
Cylindricity:	Within 2 μ
Taper:	Within 2 μ
Runout w.r.t Centre:	Within 4 μ on all ground diameters
Surface Roughness:	0.4 μ Ra on OD & 0.6 μ Ra on Face
Dressing Skip:	35 components



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