

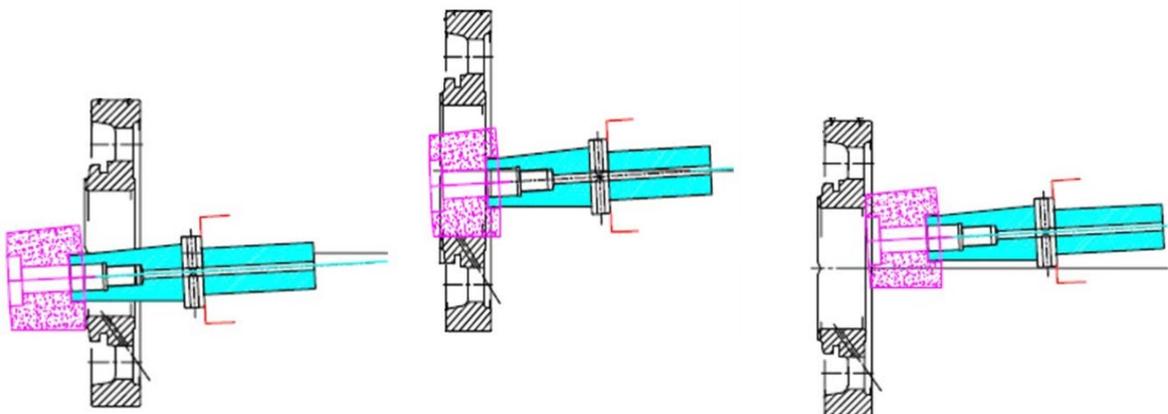
MASTER ABRASIVES

Internal Grinding Machine

CASE STUDY

#1050

Workpiece:	Gear Bore
Operation:	Bore, Front Face & Back in single set up
Material:	EN353,20MnCr5,
Component Diameter:	Max \varnothing 250mm
Bore Diameter:	\varnothing 75mm
Grinding Wheel:	Aluminium Oxide – supplied by Master Abrasives as a complete solution
Machine:	Micromatic IG 150 CNC
Cycle Time:	185 seconds
Stock Removal:	0.3mm in Bore and 0.15mm on Face
CpK:	2.36
Roundness:	Within $3\mu\text{m}$
Taper:	Within $4\mu\text{m}$
PCD Runout:	Within $30\mu\text{m}$



Copyright © 2020 Master Abrasives Ltd

CONTACT US FOR MORE INFORMATION

MASTER ABRASIVES

T:01327-703813

sales@master-abrasives.co.uk

www.master-abrasives.co.uk