

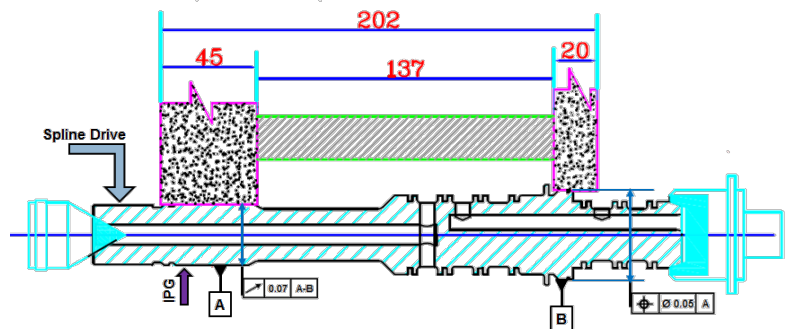
MASTER ABRASIVES

External Cylindrical Grinding Machine

CASE STUDY

#1016

Workpiece:	Turbine Shaft
Operation:	OD Grinding
Machine:	Micromatic SH-40 CNC
Cycle Time:	38 seconds (includes load/unload)
Stock Removal:	0.3mm on OD
CpK:	2.2 (for tolerance of 8 µm)
Surface Roughness:	< 0.3 µm Ra
TP:	40%
Dressing Skip:	10 components



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