

# MASTER ABRASIVES

## Centreless Grinding Machine

CASE STUDY

#1024

<b>Workpiece:</b>	Torsion Bar
<b>Operation:</b>	OD Grinding (profile)
<b>Machine:</b>	Micromatic CLG 6020 – 3 axis CNC
<b>Cycle Time:</b>	22 seconds
<b>Stock Removal:</b>	0.25mm
<b>CpK:</b>	1.8 (for tolerance of 12 µm)
<b>Roundness:</b>	0.001mm
<b>Cylindricity:</b>	0.002mm / 120mm
<b>Straightness:</b>	0.002mm on each diameter
<b>Surface Roughness:</b>	0.2 µm Ra
<b>Dressing Skip:</b>	30 components



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CONTACT US FOR MORE INFORMATION

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