

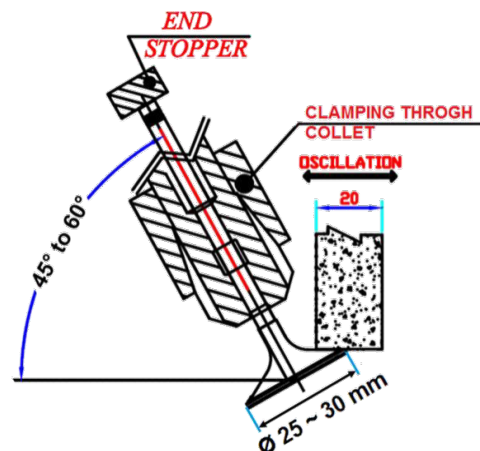
MASTER ABRASIVES

Special Purpose Grinding Machine

CASE STUDY

#1036

Workpiece:	Engine Valve - Inlet
Operation:	Seat Angle Grinding
Machine:	Micromatic Valve Seat Grinder GVS CNC – 60mps
Grinding Wheel:	Conventional bonded wheel
Cycle Time:	7 seconds (including load/unload; without dressing)
Stock Removal:	0.2mm
CpK (on Tip Height):	1.43 (tolerance $\pm 0.050\text{mm}$)
Roundness:	$\leq 0.003\text{mm}$
Runout:	0.015mm
Surface Roughness:	0.3 $\mu\text{m Ra}$
Seat Height Control:	Stem end or Valve face end – both options available
Dressing Skip:	25 components



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