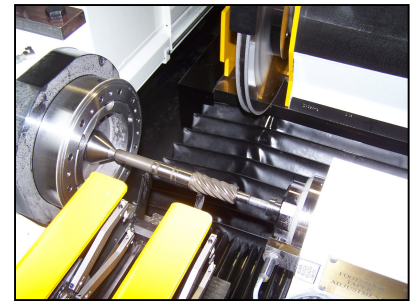
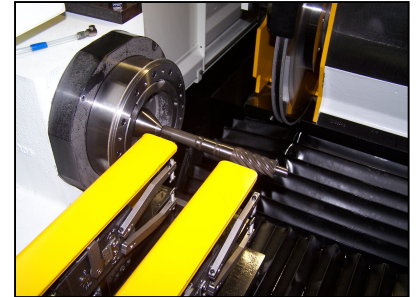




320S Midas CBN Peel Grinder Case Study, May 2006



Customer: ACH, Indianapolis, IN *Application:* Power Steering Pinion Shafts

Configuration: Straight wheel slide
CBN OD wheels
Workhead spindle dresser ring
Friction drive
Dual post-process gaging
2-axis gantry loader
Loop conveyor

Process: Fully automatic high-speed peel grind multiple diameters, shoulders, and blend angle.

Attributes: OD size +/- .0045 mm (2.0 Cpk)
Surface finish .4 Ra (max)

Notable: Three-machine cell, dual wheel set-up, peel grinding four diameters and two shoulders (left and right hand side) in a floor-to-floor cycle time less than 40 seconds.

Featuring: **SBS** wheel balancer, **CGI** post-process gage, **GE Fanuc 18i** CNC control, **Universal Superabrasive** CBN wheels and diamond dresser roll, **Dittel** acoustic emissions sensor, EWAB loop conveyor.