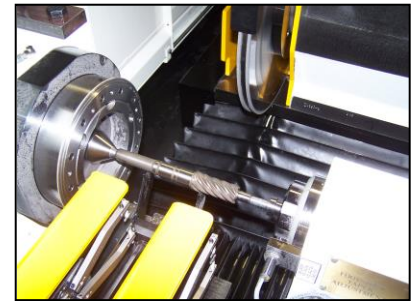
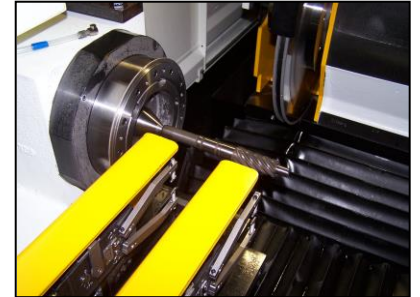




MIDAS 320S - CBN Peel Grinder Case Study



<i>Customer:</i>	ACH, Indianapolis, IN	<i>Application:</i>	Power Steering Pinion Shafts
<i>Configuration:</i>	Straight wheel slide CBN OD wheels Workhead spindle dresser ring Friction drive Dual post-process gaging 2-axis gantry loader Loop conveyor		
<i>Process:</i>	Fully automatic high-speed peel grind multiple diameters, shoulders, and blend angle.		
<i>Attributes:</i>	OD size	+/- .0045 mm (2.0 Cpk)	
	Surface finish	.4 Ra (max)	
<i>Notable:</i>	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.		
<i>Featuring:</i>	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.		