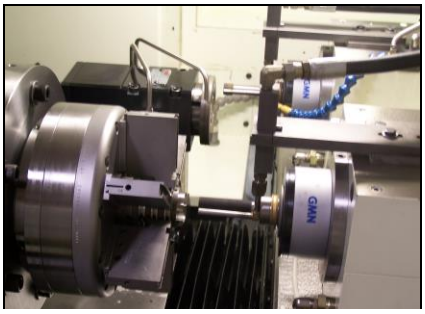
Phoenix Dual Spindle CBN ID Grinder
Case Study



Customer: Major component supplier *Application:* Truck steering - rotary valves

Configuration:
Dual wheel, vitrified CBN
Custom work holding
Central coolant connections
FANUC 18i TB CNC control

Process:
Rough plunge / finish traverse grind cycle (ID)
Water-soluble coolant
CBN wheel ~ rough at 40,000 RPM, finish at 30,000 RPM
Work speed at 150 SFPM
Dress every ten (10) parts
76-second total cycle (floor to floor)

Attributes:

Diameter tolerance	+/- .00015”	1.67 CPk
Surface finish	10 Ra	
Taper tolerance	.0001”	1.67 CPk
Roundness tolerance	.0001”	1.00 CPk
Total deviation tolerance	.00015”	

Featuring: **Dittel** acoustic sensor, **Universal** electric dresser, **GMN** high frequency grinding spindles, **Spindel** variable speed drives, **Turmoil** spindle chiller