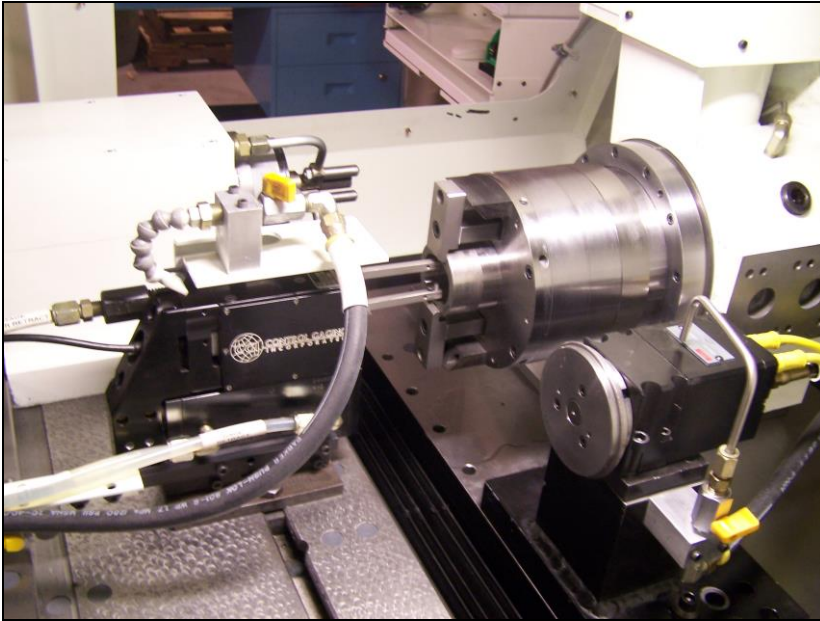




Phoenix Single Spindle CBN ID Cam Grinder Case Study



Application: Truck steering – Pump Cams

Configuration: Grinding wheel, vitrified CBN
Custom work holding, face clamp
FANUC 180i TB CNC control
High torque gear drive workhead

Process: Plunge / oscillate grind cycle (ID)
Water-soluble coolant (high-pressure wheel scrubber)
CBN wheel ~ 35,000 RPM (8,000 SFPM)
Work speed (in-process variable)
Dress every thirty-five (35) parts
53-second total cycle (floor to floor)
.014" stock removal per side

Attributes: True-to-form tolerance +/- .0002" 1.67 CPk
Surface finish 10 Ra

Featuring: **Universal** electric rotary dresser, **GMN** high frequency grinding spindle, **Spindel** variable speed drive, **Turmoil** spindle and coolant chillers, **CGI** in-cycle post process gage, **Airflow** mist collector, **Heidenhain** linear & rotary glass scales, **Northfield** pull-back pneumatic chuck