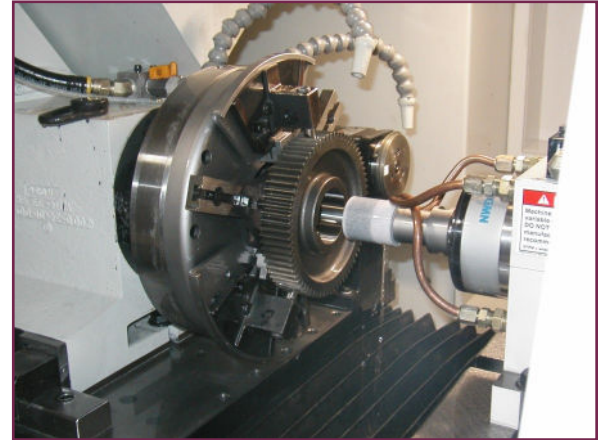




Phoenix Single Spindle ID Grinder



Customer:	Heavy Duty Automotive Supplier		
Application:	Truck transmission gears ID grind, straight bore with keyway		
Configuration:	GMN high precision spindle ~ 30,000 RPM ITW pitch-line chuck, pneumatically operated Universal electric rotary dresser and diamond roll FANUC 18i TB CNC control		
Process:	Plunge grind with chopping cycle Norton SG wheel ~ 8,000 SFPM Work speed at 100 SFPM Dress every (8) parts		
Attributes:	Diameter tolerance	+/- .0005"	1.89 Ppk
	Pitch diameter runout	.0022"	
	Bore finish	32 Ra	3.5 Ppk