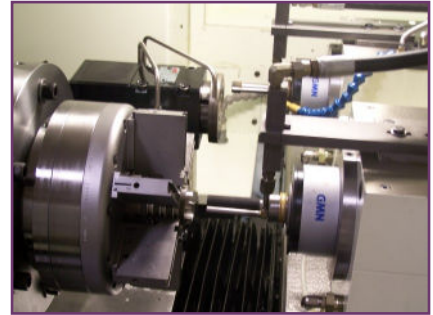


Phoenix Dual Spindle CBN ID Grinder



<i>Customer:</i>	Steering component supplier	
<i>Application:</i>	Truck steering - rotary valves	
<i>Configuration:</i>	Dual wheel, vitrified CBN Custom work holding Central coolant connections	
<i>Process:</i>	FANUC 18i TB CNC control 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 (10) parts 76-second total cycle (floor to floor)	
<i>Attributes:</i>	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"
<i>Featuring:</i>	Dittel acoustic sensor, Universal electric dresser, GMN high frequency grinding spindles, Spindel variable speed drives, Turmoil spindle chiller	



Weldon Solutions offers a full line of CNC OD, ID, and combination grinders. As a FANUC Robotics integrator, Weldon can also address your machine tending, material removal, material handling, and packaging/palletizing needs.

QUALITY, Over and Over Again.

www.weldonsolutions.com - info@weldonsolutions.com
425 East Berlin Road, York, PA 17408 - 717-846-4000

Contact Weldon today to find out how a new CNC grinder can enhance your manufacturing operation, and increase efficiency and profitability