



Phoenix Dual Spindle CBN ID Grinder



Customer:	Steering Component Manufacturer		
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 (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:	<u>ITW</u> diaphragm chuck, <u>Dittel</u> acoustic sensor, <u>Universal</u> electric dresser, <u>GMN</u> high frequency grinding spindles, <u>Spindel</u> variable speed drives, <u>Turmoil</u> spindle chiller		