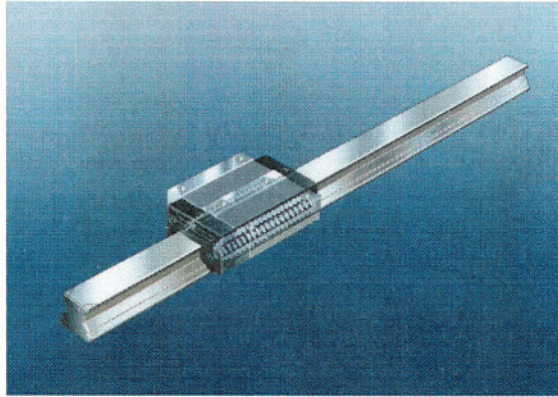


Reciprocating Profile Grinding of Precision Guide Ways



Part Data

Work Piece: Precision machine guide way
Operation: Reciprocating profile grinding
Material: 52100, 4140 @ 60 HRc
Surface Finish: 16 RMS

Wheel Data

Size: 16" x 2 1/4" x 5" Type 01
Hermes Spec: ERT 80 F 16 V62 Z P44
Competitors Spec: 9RA 60/2 F 802F VOS

Truing Data

Dressing Device: Rotary diamond disk
Dressing Method: 2 axes contour dressing
Dressing Ratio: Unidirectional 0.8

Machine Data

Blohm 3 axes Planomat 408
25 horsepower

Process Parameters:

The clients cycle time was 25 minutes to process precision guide ways. Using Hermes products and CNC optimization methods the cycle time was reduced by 10 minutes. A real time cycle for grinding and wheel dressing combined of 15 minutes was achieved.

BCH06



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