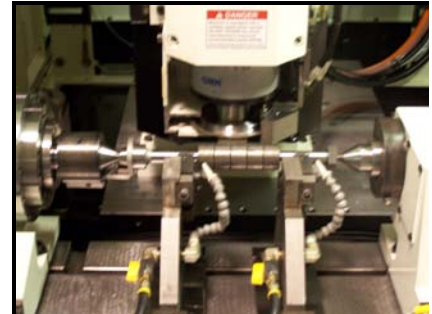




## Midas Slot Grinder Case Study, March '05



*Customer:* TRW Lafayette, IN      *Application:* Rotor Slot Grinding

*Configuration:* Straight wheel, vertical, vitrified CBN  
Custom 5-part arbor  
High-pressure wheel cleaner  
Universal electric rotary dresser  
GE Fanuc 18i TB CNC control

*Process:* Zero rotation traverse grind cycle  
Water-soluble oil coolant  
CBN wheel, 12,000 SFPM  
Dress every five cycles (500 slots)  
5.5 minute grind cycle to finish 5 parts (50 slots)

*Attributes:* Slot width tolerance      +/- .0002"  
Surface finish      5 Ra

*Notable:* Included off-line setting fixture for radial positioning slots

*Featuring:* **Dittel** acoustic sensor, **Barnes** filtration and coolant chiller, **Turmoil** spindle chiller, **Airflow** mist collector, **Vickers** power unit