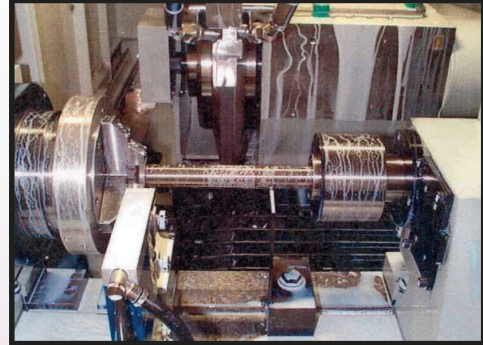




MIDAS 320S Peel Grinder Case Study, April, 2007



High production aerospace grade bolt grinding with a single vitrified CBN wheel configuration for all part sizes.

Customer:	Aerospace Fastener Manufacturer	Application:	Bolt Grind (Inconel 718)
Configuration:	Straight Wheel, CBN (vitrified) 3-Jaw chuck, pneumatic In-process sizing gage Hydraulically operated tailstock, live spindle High-pressure wheel cleaner		
Process:	High-speed “peel” grind: multi-pass. Grinds head-end shoulder, fillet radius, body diameter, transition angle, thread-roll diameter and nose-end angle		
Attributes:	Diameter tolerance	+/- .0002”	
	Surface finish	16 Ra	
Notable:	No wheel change required between part numbers		
Featuring:	<u>SBS</u> automatic wheel balancer, <u>GE Fanuc 18i</u> CNC control, <u>Movomatic</u> in-process gage, <u>Encyclon</u> cyclonic coolant filtration system, <u>Universal Superabrasives</u> vitrified CBN grinding wheel and rotary diamond dresser, <u>Dittel</u> acoustic sensor		