

CBN camshaft grinding - required information

for determination of the appropriate specification

In order to determine the proper specification for a highly complex such as camshaft grinding, a number of inform is required. Please complete all fields of this form in as much detail as possible. The more information being prov better. If more information is available than can fit into the fields (i.e. drawings), please attach them on a separati

General information

Customer

(address, contact person, phone)

Annual demand of the grinding wheel

(value or number of wheels)

Technical information

Shape, dimensions and maximum speed of the grinding wheel

(please attach a drawing if possible)

Workpiece description

(please attach a drawing if possible)

Workpiece material and hardness --> influences the selection of CBN type

(different hardnesses on bearing area, radius and shoulder?)

Required surface of these parts --> needed for the selection of grit size

(Ra, Rz or Rt in μinch or μm)

Grinding machine

(Manufacturer, type)

Competitors name and specification --> Might indicate the need for special considerations

Target of optimization

(i.e. reduction of grinding time, improving surface quality, be 2nd supplier, increasing tool life)

Process information

The information in this section indicate what forces the grinding wheel is subjected to and will highly impact the d grinding wheel as well as the specification.

Can the machine parameters directly be changed? --> important for possible grinding parameter adjustments

Coolant --> important for the structure of the specification

(Type, brand, concentration)

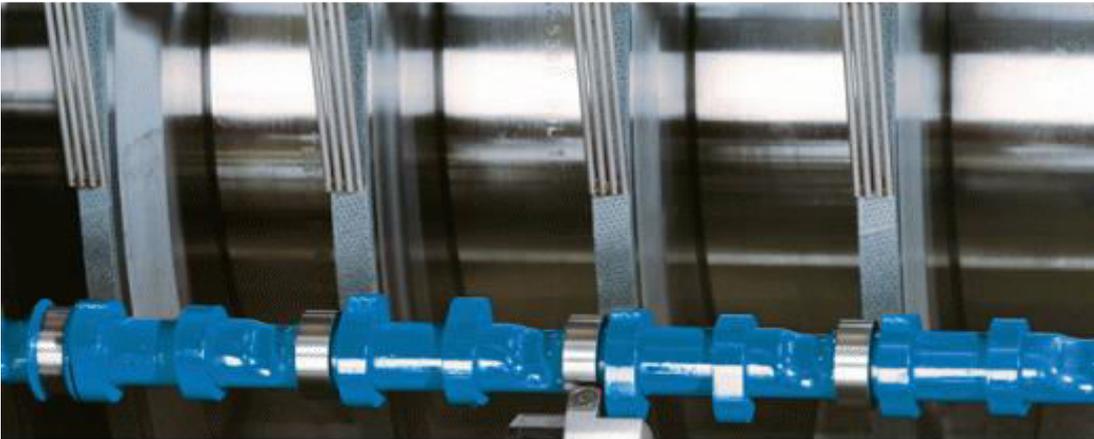
Pre-machining --> important for grade of the specification
(Type, roughness)

Grinding

allowance feed rate radial wheel speed rpm workpiece
rough pre-finish finish rough pre-finish finish rough pre-finish finish rough pre-finish finish

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