

Machine:
S31

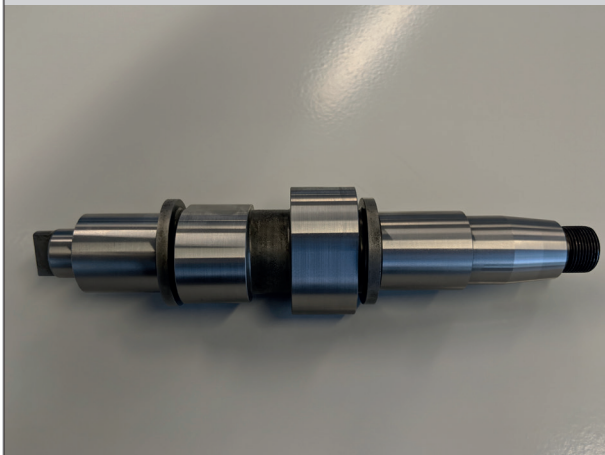
Machining procedure:
Complete machining of outside diameters, shoulders and form grinding of cams with StuderFormHSM in 2 set-ups with ceramic bonded corundum grinding wheels



Application:
Automotive

Workpiece	Cam shaft
Material	16MnCr5
Hardness	HRV 770 +/- 70
Dimension	dia. max. 66 x 280 mm
Stock allowance	0,2 mm
Shape deviation of cam form	< 4 μm
Straightness dia. / taper	< 1 μm
Roundness	< 1 μm
Surface finish	Ra 0,3 μm (twist-free)
Cooling lubricant	Emulsion

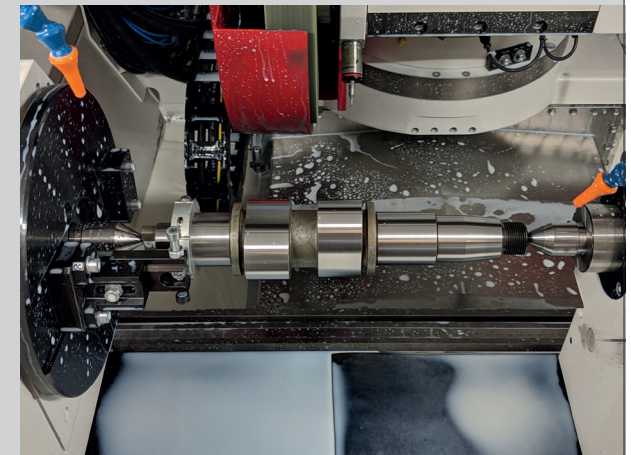
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Grinding example: 088



Cam shaft



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