

Jig Grinder Application Study

Roll Die

450 CP Jig Grinder with CNC Rotary Table

- | Roll die with 1080 0.095 diameter holes with draft
- | Material: A2 tool steel
- | Outside diameter 5.910
- | Material removed on diameter 0.012 and 0.015
- | Finishing size ± 0.0001
- | 175K Grinding Head
- | CBN Metal Bond grinding wheel 0.051
- | Work piece mounted to CNC rotary table
- | Roughing: Autosize every 15 holes, 3 minutes a hole
- | Finishing: Autosize every 8 holes, 4 minutes a hole

*Continuous Operation: Approximately 126 Hours
5 Days @ 24 Hours/Day - Unattended*

