



COMPONENT APPLICATION SHEET

Ultramat CNC - 12 - 0602



MACHINE

Ultramat CNC - Universal Wheelhead Production Cylindrical Grinder

COMPONENT

Aerospace Seal Adaptor

SIZE

Ø 72 x 125mm (Ø 2.834" x 4.921")

TOLERANCE

Concentricity 0,005mm (0.00019") TIR

MATERIAL

Unspecified

OPERATION

Dress double sided facing wheel using standard dress cycle
Plunge and face grind front Ø 56mm (Ø 2.204")
Plunge and face grind second Ø 56mm (Ø 2.204")
Shoulder grind front face of component
Plunge and face grind front Ø 54mm (Ø 2.125")
Step over 2 plunges & traverse grind to finish Ø 54mm (Ø 2.125")
Plunge grind with oscillation Ø 72 x 6mm (Ø 2.834 x 0.236")
Radius & diameter dress internal wheel
Internal grind Ø 50mm (Ø 1.968") bore and internal radius
Traverse grind Ø 40 x 10mm (Ø 1.574" x 0.393") bore

