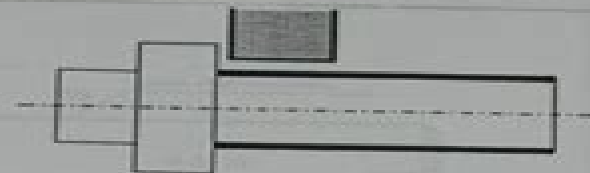


3. GRINDING OPERATIONS ON THE HTG 410/610 420/620

In this chapter we describe the different ways of using the machine for grinding workpieces. To avoid giving too much confusing detail we have based the instructions on a simple workpiece: this part does not need the whole range of possible grinding operations, but those described are the operations which will mostly be used in everyday grinding.

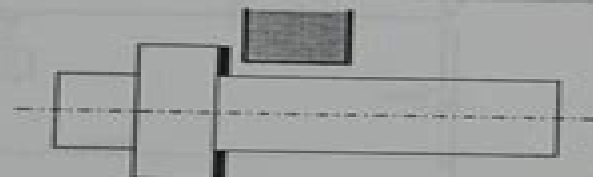
TRAVERSE GRINDING

- For grinding a long shaft diameter
- Table slide oscillation
 - Stepwise infeed of wheelhead



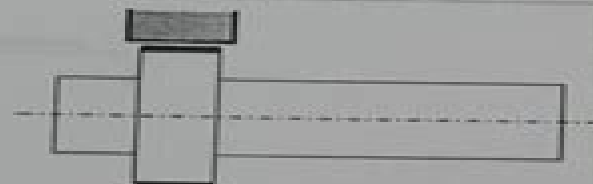
FACE GRINDING

- For grinding the face of a shoulder
- Side infeed by manual table slide traversing



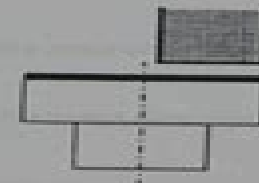
PLUNGE GRINDING

- For grinding a short shaft diameter
- Continuous wheelhead infeed
 - Short table slide oscillations, according to the relative widths of the wheel and the diameter being machined



FLAT GRINDING

- For grinding a complete face parallel to the wheel axis
- Workhead swivelled 90°
 - Table slide oscillation
 - Stepwise wheelhead infeed



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