

Process Cycle Chart for Grooves of Single and Double Angular Contact Ball Bearing  
Model STK-200WT

1st Groove or Single Groove		2nd Groove	
1	1st Groove Position INDEX	5	2nd Groove Position INDEX center angle is moved to 2nd groove setting position at 2nd groove position index.
2	1st Groove Position Approach	6	2nd Groove Position Approach
3	1st Groove Oscillation	7	2nd Groove Oscillation
	<p>Angle center at 1st groove</p>		<p>Angle center at 2nd groove</p>
4	1st Groove Position Retract	8	2nd Groove Position Retract
	<p>* Tool out (completion of machining) when machining of single groove is selected.</p>		
		9	Tool Out (machining completed)

**SEIBU**

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