SEIBU AEROLIDE®
SEIBU JIDO KIKI CO., LTD.
1-23-2 Nanko-kita, Suminoe-ku, Osaka 559-0034 JAPAN
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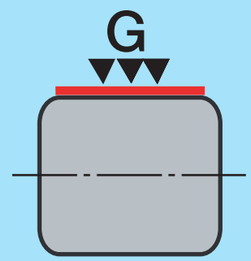
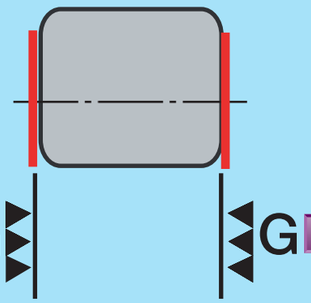
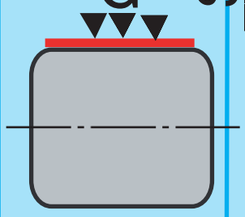
URL: http://www.seibu-jk.co.jp

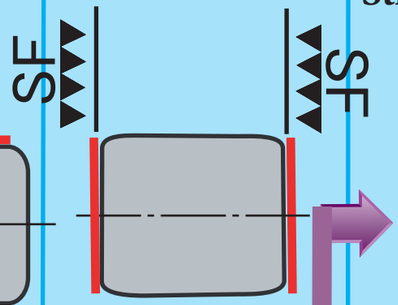
Cylindrical roller machining process

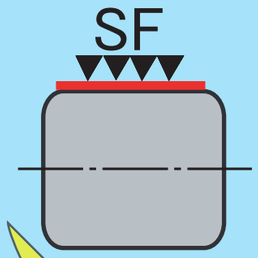
	1	2	3	4	5	6	7
			Seibu TSG-455NC		Seibu STK-50FSD -TZB or -20FSD	Seibu ASM-500ZR Straight stone lapping	Seibu ASM-500ZR
(Cold) Forging							
	Quenching & Barrel Grinding	Roundness: less than 2 μm Profile straightness: less than 0.5 μm					
Turning							











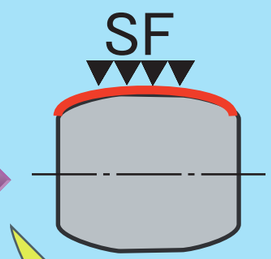
Cycle time: 1.5 mtr/min.

Rough Grinding:
Face run-out: less than 5 μm
Stock removal - 0.4 mm
Cycle time - 95 pcs/min

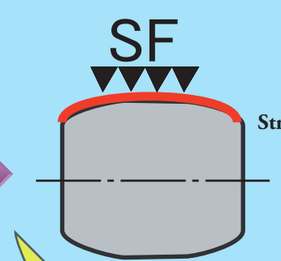
Fine Grinding:
Face run-out: less than 3 μm
Parallelism: less than 3 μm
Roughness: less than 3 μm
Stock removal - 0.06 mm
Cycle time - 120 pcs/min

Length variation: ±1.5 μm
Face run-out: 1 μm
Roughness:
Ra 0.05 ~ 0.09 μm
Cycle time: 10 sec/pc
Stock removal:
0.035 ~ 0.045mm/side

Full crowning stone lapping



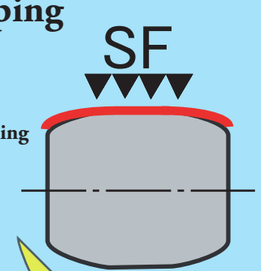
Cycle time: 0.5 mtr/min.



Cycle time: 0.5 mtr/min.

Straight stone lapping

Partial crowning stone lapping



Cycle time: 0.5 mtr/min.