

# CASE STUDY 105

## (JUNKER APPROVED OIL FOR CAMSHAFT GRINDING)



### PROFILE OF COMPANY:

A reputed manufacturer, supplier and exporter of a broad range of Cylinder Camshaft, Injection Pump Camshafts, Single Cylinder to 16 Cylinder Camshafts, Railway Camshafts, established in 2004 in MP



### TRIAL CRITERIA

1. To develop alternative Junker approved source of OIL
2. Cost Saving
3. NO EHS issue



### OPERATING/ APPLICATION DETAILS :

1. Machine : Junker 3643 ,80162 (Twin cam )
2. Application : Camshaft Grinding
3. Material : EN 43 C Forged steel
4. Customers : Ashok Leyland and VECV
5. Oil Sump : 2000 ltr
6. Filter : 10 Micron paper
7. Oil Temp : 24-28 Deg C
8. Oil Pressure : Min 8 bar, Max 15 bar
9. CBN Wheel details : Diamond wheel, 200 MM ,400 MM, ASAI Japan
10. Material removal rate 1mm/30 sec
11. Feed : 22000 mm/min
12. RPM : 6685
13. Depth : 0.15 mm 5 cuts and 0.05mm in 3 cuts
14. Cycle time 2 min -5 min , according to components
15. Wheel Life : 9000 camshaft / 72000 camlobe
16. Tank cleaning frequency -6 months
17. Earlier grade : XXXX XXXX 7009



### COMPONENT DETAILS



**PRODUCT RECOMMENDED: ISOCUT R 10 HM**

## TRIAL CONCLUSION



Product is running from last 8 months with satisfactory performance , meeting all desired objectives. Achieved 20 % direct cost saving.