

CASE STUDY 107

(PRE-MIXED PASTE FOR LAPPING APPLICATION)



PROFILE OF COMPANY:

One of the largest Tractor manufacturer in South India doing machining of Tractors parts -gears, pinions, etc.



TRIAL CRITERIA

1. Easy handling – Avoid the manual mixing
2. Easy clean ability
3. No EHS Issues (Skin & eye irritation)
4. Need to achieve the required finish- Visual finish
5. Reduce the overall cost.



OPERATING/ APPLICATION DETAILS :

1. Machine Make : Gleason Hypoid Lapper
2. Component : Gears & Pinions
3. Material : Steel
4. Cycle time: Depend on parts
5. Operation : Lapping
6. Tank capacity : 15 Ltrs
7. RPM : Upto 800 , Depends on model
8. Existing product : XXXX 500 + Grit (Grit Size 280)
9. Mixing ratio : Manual Mix @ 1: 4 ratio
10. Cycle time: 3 mins



COMPONENT DETAILS



PRODUCT RECOMMENDED: HIGRIND LAP 2

TRIAL CONCLUSION



Achieved required finish,
Good visual finish. No line
marks as compare to earlier



No EHS
Issues observed



Grit settling not
observed- even mixing
during machining



Ease of cleaning with
alkaline cleaner



Overall Cost reduced
by 3-4 %