

CASE STUDY 32

(HONING OIL FOR USE IN BEARING INDUSTRY)



CUSTOMER DETAILS :

A leading automotive bearing manufacturer in East India having manufacturing capacity of 30 Million Bearing per month.



OBJECTIVES FOR CONDUCTING THE TRIAL

- To lower copper staining in used oil
- No EHS Issues - Operator & Environmental Friendly.
- To reduce the cost of oil.

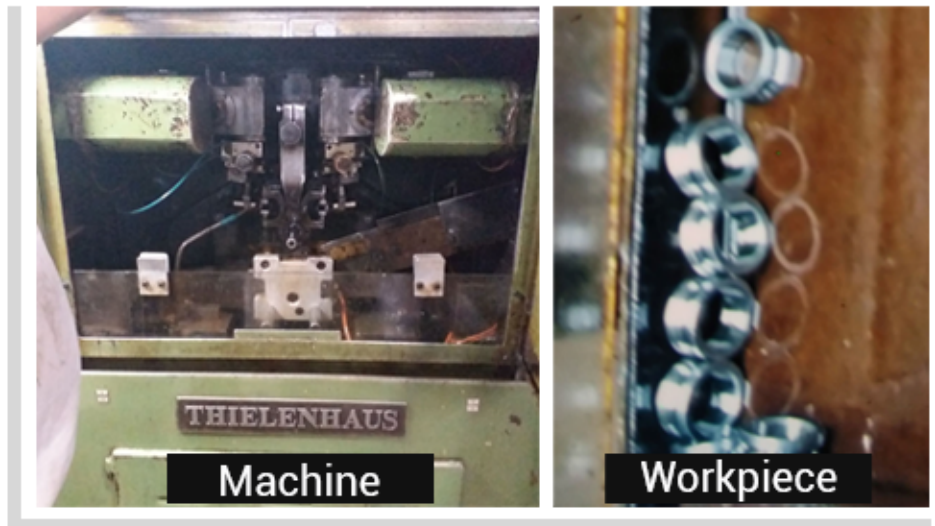


OPERATING / APPLICATION DETAILS:

- Machine : Make: Thielenhaus, Machine No.4
- Application : Honing
- Tank Capacity : 160 Ltrs
- Part : Inner Bearing race (Part No.6004 IR)
- Desired Ra value : 0.02 to 0,04 Micron
- Cycle time : 40 Secs (Rough + Finish)
- Tool – Honing Stone (Stick type)
- Tool Movement - Vibratory
- Filtration : Magnetic + Cloth
- Ambient Temp : 30°C average
- Trial period : 3 Months
- Production capacity : 9000 pcs per day (in three shifts)
- Present Product : Indian Oil Servohone 7 XL (T)



COMPONENT VIEW



PRODUCT RECOMMENDED: HICUT HONE CSF

TRIAL RESULTS



Lower temperature rise resulting in longer sump life



Dirt Content : 0.011 gm/ Ltr after 4 days in operation (Within limit)



Operator & Environmental Friendly



Copper corrosion after 8 days – 1b (Better than the existing oil)



Achieved average Ra value of 0.0257 Micron



Reduction in direct cost