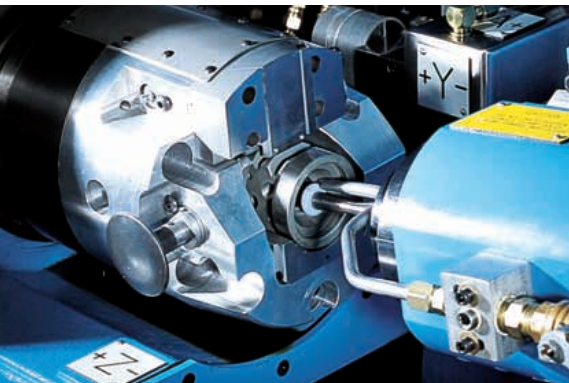


INTRODUCING ...

# **DRAKE** **GS:TI**<sup>TM</sup>

## Grinding System: Thread Internal



*Complex internal threads are ground with consistent precision.*



*The Drake GS:TI reduces set-up time, raises productivity.*

**You get the precision and productivity of CNC, the simplicity and economy of a proven design and quality parts from day one.**

Drake GS:TI grinders give you repeatable precision over the length of the run on ball nuts, gages, power steering nuts, molds and entire families of internal threaded parts. For optimum performance, many Drake customers install internal and external grinders in pairs, to get matching precision on mating parts.

Your productivity is increased with such features as variable speed work and wheel drives for constant surface speed and an advanced diamond roll system for CNC-controlled contour dressing.

### ***Superior control for superior results.***

Precision is ensured through the use of the latest components and systems

to control machine motion and repeatability. These include precision ball screws, digital AC servo motors and exact linear scales with 0.000,004" resolution. Together, they allow the Drake GS:TI to grind aggressively and still offer size control within  $\pm 0.0002$ ".

### ***Menu-driven software speeds set-up and assures accuracy.***

Your Drake GS:TI is completely customized to your specific manufacturing environment. To set up for a given part, all you have to do is enter the workpiece parameters, and the menu-driven programs take it from there. Since the program is designed for your exact parts, such factors as truing forms, grind paths and spindle and

work SFM are easily entered, giving you complete control over the process without requiring programming.

### ***Simplified operation raises productivity.***

The menu-driven software is very easy to use. Complete processing conditions are displayed in clear text form, prompting your operators quickly through the entire cycle. You reduce set-up times, minimize operator error and increase the utilization of your machine.

ISO 9001 Certified Quality System

**Drake**  
MANUFACTURING

# DRAKE GS:TI™

## Grinding System: Thread Internal Specifications

AXIS DEFINITIONS				
Axis	Description	Standard	Optional	Speed
C	Work Rotation	Direct Drive	Cone Drive	0 to 1000 RPM 0 to 200 RPM
X	Wheel Feed	9"		0 to 400 IPM
Y	Dresser Cross	1-1/4"		0 to 200 IPM
Z	Table Travel	9"	12"	0 to 400 IPM
A	Dresser Helix	± 10°		60 DPM
Spindle		11 kW 5 kW		20K or 40K RPM 60K RPM

CAPACITIES		
	Part Size	Thread
Standard	15" Length 10" Diameter	9" Length 8" ID
Optional	45" Length 10" Diameter	12" Length 8" ID

DIMENSIONS	
Overall Machine Std.	87" L x 78" D (2210 mm x 1980 mm)
Overall Machine Opt.	100" L x 78" D (2540 mm x 1980 mm)
Coolant Discharge Height	20" above bottom of base
Part Loading Height	46" above bottom of base

### Typical Menu Entries

NUMBER OF STARTS	00	THREAD LENGTH	00.00
THREAD HAND	L/R	SIZE COMP	0.00000
LEAD	00.00000	TAPER COMP	0.00000
WHEEL DIA	00.00	FIN STOCK	0.0000
RUF PASSES	00	FIN PASSES	00
RUF WHEEL SFM	00000	FIN WHEEL SFM	00000
RUF WORK SFM	000	FIN WORK SFM	00
DRESS COUNT	00	DRESS WHEEL SFM	0000
DRESS AMOUNT	0.0000	DRESS FEED IPM	00
BALL RADIUS	0.000	CROSS OVER SHIFT	0.000
GOTHIC RADIUS	0.000		



Smart Spindle technology enhances the performance of the Drake GS:TI.



The latest Fanuc controls assure easy set-up.

### Performance warranty.

In term, the Drake warranty is a full year, with no limit on hours. In nature, it's basic: You expect performance—we deliver it.

### See the Drake GS:TI at work.

Give us a call to discuss your exact internal threading challenges. We will arrange a working demonstration of the GS:TI solutions.

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ISO 9001 Certified Quality System



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