The SK 204 is EMAG’s modular machine system for the grinding of cams. The SK 204 offers solutions for the internal and external out-of-round grinding of cams – from one-offs to large batch production grinding.
High performance grinding of internal and external contours.
The SK 204 modular machine system allows for the configuration of a large number of variants in order to accommodate individual production requirements. All modern grinding technologies can be realized with this machine. The machine can be equipped with different sizes of one, two or more grinding spindles for external and/or internal machining.

The available modules include dressing attachments for CBN and corundum wheels, touch-recognition during grinding and dressing, and workholding units. Workpieces are loaded and unloaded with an automatic workhandling system which includes a gantry loader and robots. This equipment is complemented by environmentally friendly coolant processing plants and exhaust systems.
The objective is to produce quality components.

Typical applications for the SK 204 Cam Grinder include the pre- and finish grinding of cam rings for vane and injection pumps and the grinding of external and internal polygons. The interpolation of C- and X-axis, axial grinding wheel oscillation with the Z-axis, the dressing of pre- and finish-grinding wheels with a diamond wheel ... all these are processes that offer outstanding grinding results.
### Technical Data.

#### Capacity

<table>
<thead>
<tr>
<th>SK 204</th>
<th>Workpiece diameter max.</th>
<th>mm</th>
<th>Workpiece length, max.</th>
<th>mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
</tr>
<tr>
<td></td>
<td>250</td>
<td>9.8</td>
<td>100</td>
<td>3.9</td>
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</tbody>
</table>

#### Grinding wheels

<table>
<thead>
<tr>
<th>SK 204</th>
<th>Grinding wheel dia., max.</th>
<th>mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>in</td>
</tr>
<tr>
<td></td>
<td>250</td>
<td>9.8</td>
</tr>
</tbody>
</table>

#### Feeds and speeds

<table>
<thead>
<tr>
<th>SK 204</th>
<th>X-axis travel</th>
<th>mm</th>
<th>Workpiece length, max.</th>
<th>mm</th>
<th>Z-axis travel</th>
<th>mm</th>
<th>X- and Z-axis speed</th>
<th>m/min</th>
<th>ipm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1,000</td>
<td>39.4</td>
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<td>3.9</td>
<td>360</td>
<td>14.2</td>
<td>30 / 30</td>
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#### Work head with motor spindle

<table>
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<tr>
<th>SK 204</th>
<th>Torque</th>
<th>Nm</th>
<th>ft-lb</th>
<th>Speed range</th>
<th>rpm</th>
<th>Receptor</th>
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</thead>
<tbody>
<tr>
<td></td>
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<td></td>
<td></td>
<td></td>
<td>KK</td>
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<tr>
<td></td>
<td></td>
<td>95</td>
<td>70</td>
<td>1 – 1,000</td>
<td>5</td>
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</tr>
</tbody>
</table>

#### Dimensions and weights

<table>
<thead>
<tr>
<th>SK 204</th>
<th>Length</th>
<th>mm</th>
<th>Workpiece length, max.</th>
<th>mm</th>
<th>Width</th>
<th>mm</th>
<th>Height</th>
<th>mm</th>
<th>Weight</th>
<th>approx. kg</th>
<th>approx. lb</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
<td></td>
<td>in</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td>3,410</td>
<td>134.3</td>
<td>100</td>
<td>3.9</td>
<td>2,400</td>
<td>94.5</td>
<td>2,490</td>
<td>98.0</td>
<td>11,000</td>
<td>24,251</td>
<td></td>
</tr>
</tbody>
</table>

### Floor plan SK 204

#### Dimensions in mm

Subject to technical changes
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EMAG
Gruppen-Vertriebs- und Service GmbH
Salach
Austrasse 24
73084 Salach
Germany
Phone: +49 7162 17-0
Fax: +49 7162 17-820
E-mail: info@salach.emag.com

Frankfurt
Martin-Beheim-Strasse 12
63263 Neu-Isenburg
Germany
Phone: +49 6102 88245-0
Fax: +49 6102 88245-412
E-mail: info@frankfurt.emag.com

Cologne
Robert-Perthel-Strasse 79
50739 Köln
Germany
Phone: +49 7162 17-0
Fax: +49 7162 17-820
E-mail: info@koeln.emag.com

Leipzig
Pitterstrasse 26
04159 Leipzig
Germany
Phone: +49 341 4666-0
Fax: +49 341 4666-014
E-mail: info@leipzig.emag.com

Munich
Zamorforsterstrasse 100
81677 München
Germany
Phone: +49 89 99886-250
Fax: +49 89 99886-160
E-mail: info@munchen.emag.com

Austria
Glaneckerweg 1
5400 Hallein
Austria
Phone: +43 6245 76023-0
Fax: +43 6245 76023-20
E-mail: info@austria.emag.com

Denmark
Horsvangen 31
7120 Vejle Ø
Denmark
Phone: +45 75 854854
Fax: +45 75 816276
E-mail: info@daenemark.emag.com

Sweden
Glaspagan 19B
73130 Köping
Sweden
Phone: +46 221 40305
Fax: +46 221 40305
E-mail: info@sweden.emag.com

Russia
ul. Akademika Chelomeya 3/2
117630 Moscow
Russia
Phone: +7 495 287 0960
Fax: +7 495 287 0961
E-mail: info@russia.emag.com

Belarus
ul. Timiriazeva, 65 B, Office 1101
220035 Minsk
Belarus
Phone: +375 17 2547730
Fax: +375 17 2547730
E-mail: info@emag.by

Contact us. Now.

NODIER EMAG INDUSTRIE
2, Parc des Fontenelles
78870 Bailly
France
Phone: +33 130 8047-70
Fax: +33 130 8047-69
E-mail: info@nodier.emag.com

EMAG MAQUINAS HERRAMIENTA S.L.
Pasaje Arrahona, nº 1B
Polígono Industrial Santiga
08210 Barberà del Vallés (Barcelona)
Spain
Phone: +34 93 7195080
Fax: +34 93 7227107
E-mail: info@emh.emag.com

ZETA EMAG Srl
Viale Longarone 41/A
20080 Zibido S.Giacomo (MI)
Italy
Phone: +39 02 905942-1
Fax: +39 02 905942-22
E-mail: info@zeta.emag.com

EMAG (UK) Ltd.
Chestrut House,
Kingswood Business Park
Holyhead Road
Albrighton
Wolverhampton WV7 3AU
Great Britain
Phone: +44 1902 37609-0
Fax: +44 1902 37609-1
E-mail: info@uk.emag.com

EMAG L.L.C. USA
38800 Grand River Avenue
Farmington Hills, MI 48335
USA
Phone: +1 248 477-7440
Fax: +1 248 477-7784
E-mail: info@usa.emag.com

EMAG MEXICO
Colina de la Umbria 10
53140 Boulevares
Naucalpan Edo. de México
Mexico
Phone: +52 55 5374266-5
Fax: +52 55 5374266-4
E-mail: info@mexico.emag.com

EMAG DO BRASIL Ltda.
Rua Schilling, 413
Vila Leopoldina
05302-001 São Paulo
Brazil
Phone: +55 11 38370145
Fax: +55 11 38370145
E-mail: info@brasil.emag.com

EMAG INDIA Pvt. Ltd.
Technology Centre
No. 17/G/46-3, Industrial Suburb,
2nd Stage, Yeshwantpur,
Bangaluru – 560 022.
India
Phone: +91 80 42544400
Fax: +91 80 42544440
E-mail: info@india.emag.com

EMAG SOUTH AFRICA
PO. Box 2900
Kempton Park 1620
Rep. South Africa
Phone: +27 11 39350-70
Fax: +27 11 39350-64
E-mail: info@southafrica.emag.com

EMAG MACHINE TOOLS (Taicang) Co., Ltd.
Building 3, Cang Neng
Europe & American Technology Park
No. 8 Lou Jiang Rd. (N.)
215400 Taicang
PR. China
Phone: +86 512 5357-6065
Fax: +86 512 5357-5399
E-mail: info@china.emag.com

EMAG KOREA Ltd.
Rm204, Biz center,
SKn Technopark, 124 Sagimakgol-ro,
Sangdaewon-dong, Joongwon-gu,
Seongnam City,
Gyeonggi-do, 462-721,
South Korea
Phone: +82 31 776-4415
Fax: +82 31 776-4419
E-mail: info@korea.emag.com

TAKAMAZ EMAG Ltd.
1-8 Asahigaoka Hakusan-City
Ishikawa Japan, 924-0004
Japan
Phone: +81 76 274-1409
Fax: +81 76 274-5830
E-mail: info@takamaz.emag.com

www.emag.com

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