

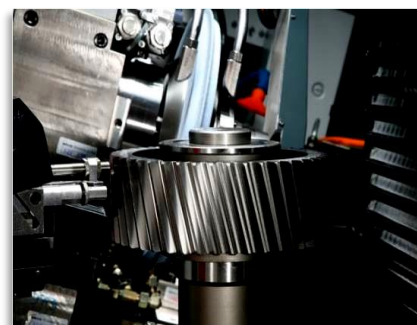
**VITRIFIED
GEAR
GRINDING WHEELS**

Anchor provides straight wheel for profile grinding and worm wheel, small module gear grinding) with excellent form holding ability for gear industry.

■ **Material of Gear**

Regular material of gear:

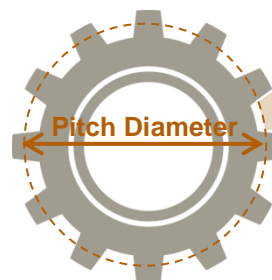
Work-piece	Material	Hardness	Treatment
Gear	S45C	HRC 28	HRC 48-55
	SCM415 420	HRC 22-24	HRC 48-55
	SCM440	HRC 30-38	HRC 57-61
	SNCM220	HRC 25-37	HRC 57-61
	17CrNiMo6	-	HRC 59-64



■ **Module and Grit size**

Comparison table of gear modulus and grit size:

Module	Grit size	Roughness
M1 ↓	#100 - #120	Ra 0.4
M1.2 – M1.8	#80 - #100	Ra 0.5
M2 – M3	#60 - #80	Ra 0.6
M3 ↑	#46 - #60	Ra 0.6-0.8



M = D/T
M = Module
D = Pitch Diameter
T = Number of Teeth

WHEEL SIZE

Regular wheel size of straight and worm wheels:

Type	Diameter	Thickness	Hole size	Shape	Machine
Straight wheel	300	20 -80	100		KAPP-NILES Gleason HÖFLER LUREN
	350		127 130		
	400		127 160		
	450		127 160		
Worm wheel	280	84 104 160	115 160		REISHAUER Okamoto Mitsubishi
	300	84 104	160		
	350	84 104	160		

■ For further inquiry, please contact us via the company information below.

CASE STUDY

Economic type

Work-piece and operating parameters

Machine	KAPP-NILES ZP1200
Wheel speed	50 m/s
Module	M3 – M20
Material	SCM415 420、SNCM220
Hardness	HRC 58-60
Gear grade	DIN 2.3.4
Infeed (Ae)	Double-sided 0.06 x 2=0.12 mm
Cross feed (Vw)	3500 mm / min
Qw value	7.0 mm ³ / s
Dressing infeed	0.05-0.06 mm
Dressing frequency	20 teeth / time

Specification and Size

Specification	87A60I8VHB4A
Wheel size	400 mm X 32 mm X 127 mm

Efficient type

Work-piece and operating parameters

Machine	KAPP-NILES ZP1200
Wheel speed	50 m/s
Module	M3 – M20
Material	SCM415 420、SNCM220
Hardness	HRC 58-60
Gear grade	DIN 2.3.4
Infeed (Ae)	Double-sided 0.15 x 2=0.3 mm
Cross feed (Vw)	3500 mm / min
Qw value	17.5 mm ³ / s
Dressing infeed	0.03 mm
Dressing frequency	30 teeth / time

Specification and Size

Specification	3CX60H9VLL4A
Wheel size	400 mm X 32 mm X 127 mm

Company Information

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■ While using grinding wheels, it is essential that you observe correct procedures to protect yourself.