



GEAR GRINDING wheels

+ Gear grinding is a finishing process to remove considerable amount of metal after heat-treatment operation to obtain a predetermined quality. Gear grinding is done to meet the exact requirement of form, dimension and surface texture. Gear grinding gives a very high degree of dimensional accuracy.

Methods of Gear grinding

- Generating type method - In this process, the wheel progressively approaches the root of the gear from the tip of the gear tooth. Suitable for Machines like Maag & Hoffler.
- Form/ Profile grinding - In this process the wheel is in constant touch with the work piece. Suitable for Machines like Reishauer & Csepel.

Recommendation

Size	Conventional Grading	Ceramic (CG) Grading
280 x 33 x 90	AA46 I5 V15	3CG46 I5 VC8
307 x 38 x 127	AA36 I5 VI8N	3CG36 I8 VC8
350 x 25 x 127	PAA46 H8 VP7	3CG46 H8 VSC
350 x 25 x 127	AA46 I16 V18N	2CG46 I10 VSC
350 x 84 x 160	AA100 K6 VSC	3CG100 K6 VSC
400 x 35 x 127	PAA46 I10 VP7	3CG46 I10 VP7
450 x 29 x 127	PAA46 I7 VP7	3CG46 I8 VSC
450 x 104 x 160	PA100 K5 V18N	3CG100 K6 VSC

Product Range

Abrasive	Diameter	Thickness	Grit	Hardness	Structure
PAA , AA , CG	280-500	25-104	36-220	G - K	5 - 7 - 8 - 16

