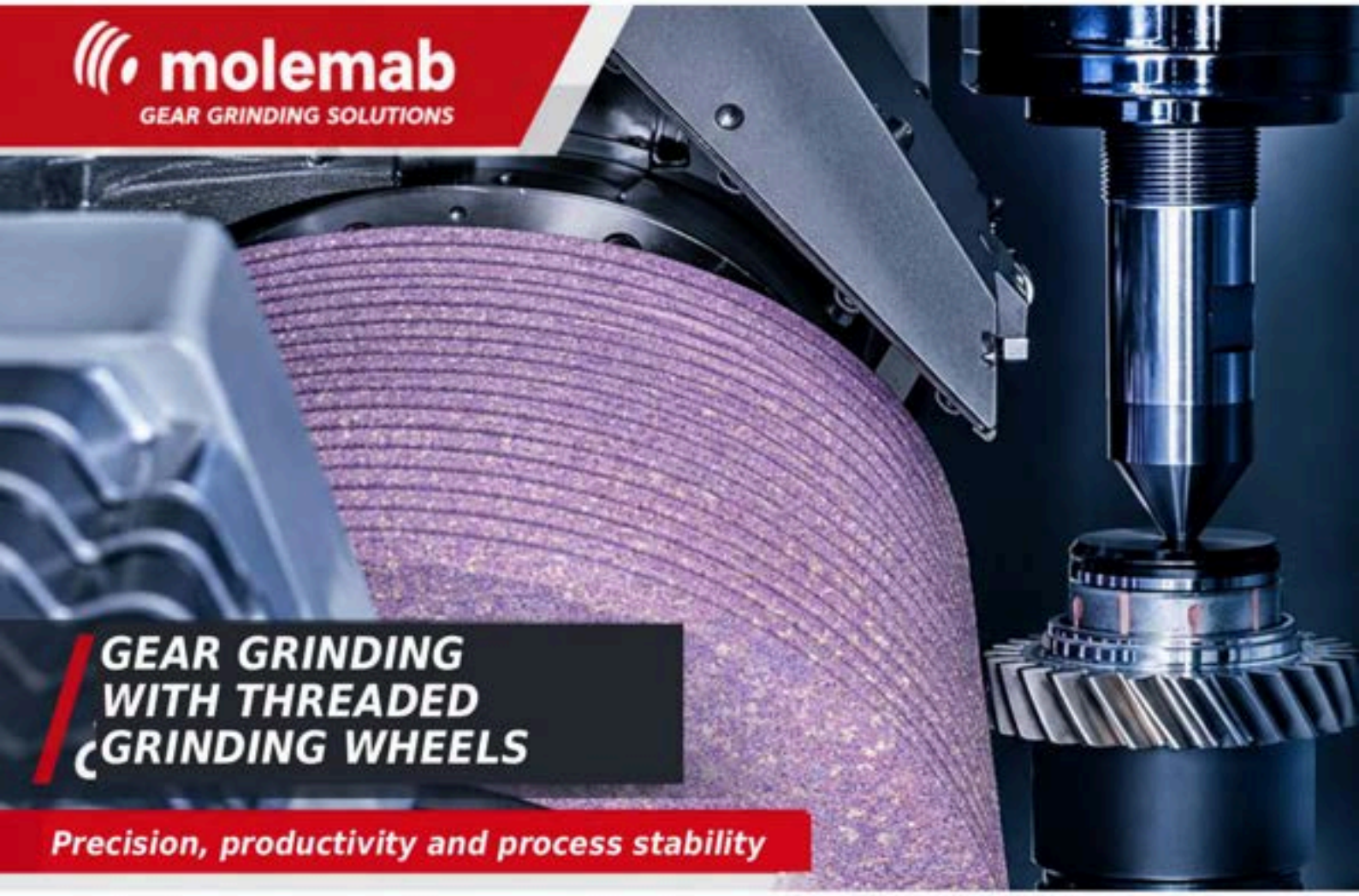
molemab
GEAR GRINDING SOLUTIONS



# GEAR GRINDING WITH THREADED GRINDING WHEELS

**Precision, productivity and process stability**

## APPLICATION

| | |
|---|---|
| Machine | KLINGELNBERG VIPER 500 |
| Material | 18NiCrMo5 |
| Hardness | 60-62 HRC |
| Module | 8 mm |
| Number of teeth | 22 |
| Pressure angle | 19° |
| Face width | 88 mm |

## GRINDING PARAMETERS

| | |
|---|---|
| Wheel speed | 42 m/s |
| Stock per flank | 0.210 mm |
| Number of passes | 4 |
| Cycle time | 7.10 min |
| Dressing frequency | 5 |

## MOLEMAB THREADED WHEEL




Wheel specification
**1AZ 80/2 I VDPA3 Makro**

Wheel diameter
**350 mm**

Number of starts
**3**

## RESULTS

| | |
|---|---|
| Gear quality | ISO 1328 grado 5 |
| Surface roughness | Ra 0,38 µm |
| No. of Pieces | 500 |

## RESULT

*Optimized cycle to complete all 500 gears unattended, with zero rejects.*