

Product note

Gear cutting unit, adjustable angle

Face contact flat

Note on applicability

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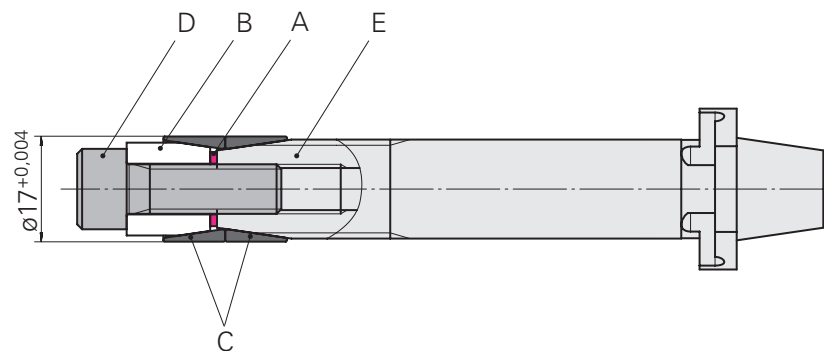
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Presetting

- Presetting is done outside the tool holder, to achieve a play-free fit in the bearings
- Assemble ring (A), taper (B) and clamping sleeves (C)
- Use cylinder head screw (D) to tighten the mounting arbor (E)
- Adjust the required outside diameter $17\text{mm}+0.004$ by grinding the ring (A)
- Disassemble again for installation in the gear cutting unit



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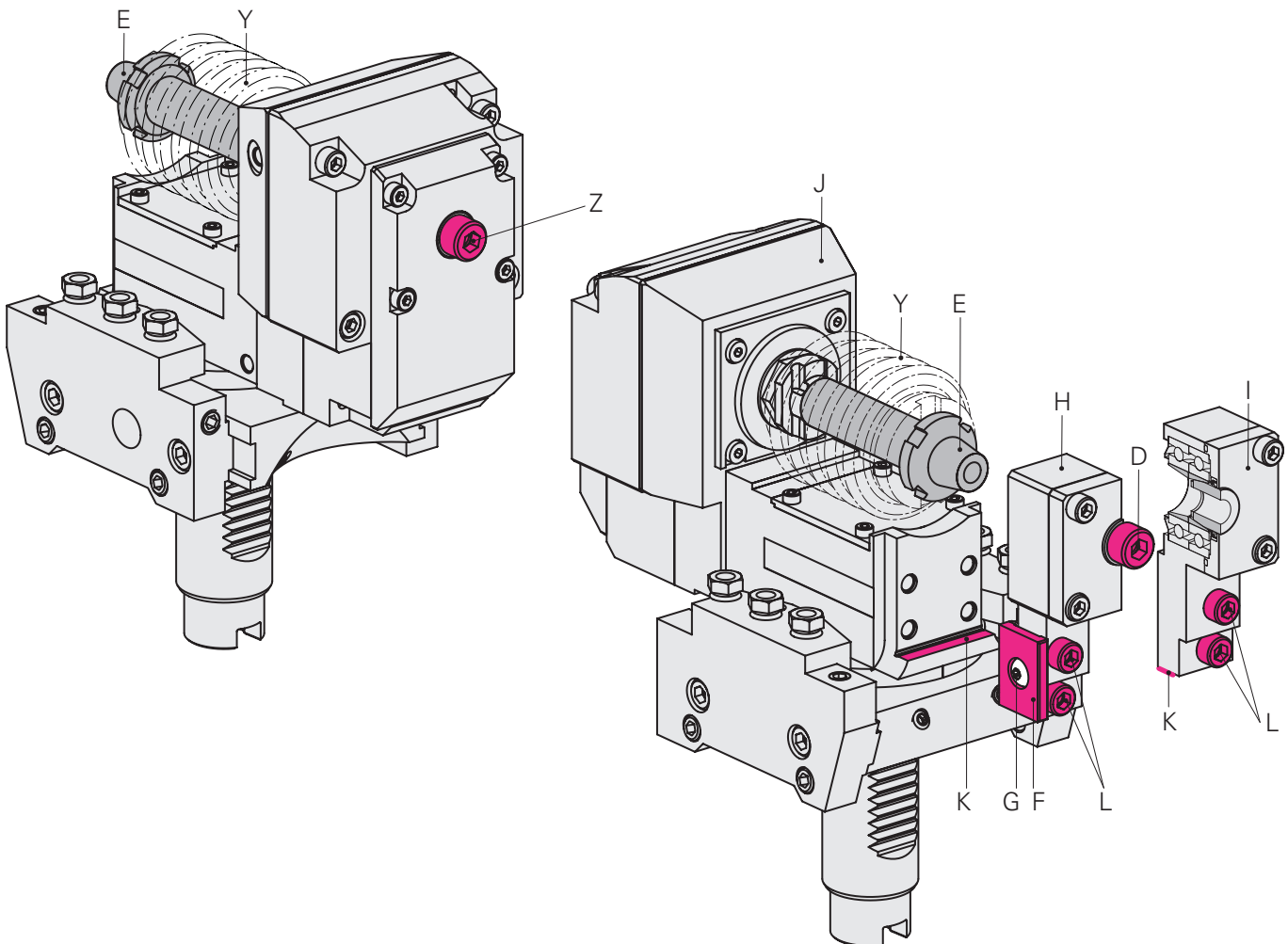
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Installation

- Tighten mounting arbor (E) and inserted gear cutter (Y) with cylinder head screw (Z) to 20Nm
- Secure plate (F) with oval head screw (G) to housing (H)
- Assemble cover (I) and housing (H)
- Insert into gear cutting unit (J)
- Observe face contact (K) of the housing (H) during installation
- Use plate (F) as lateral stop
- Tighten cylinder head screw (D)
- Tighten cylinder head screws (L)

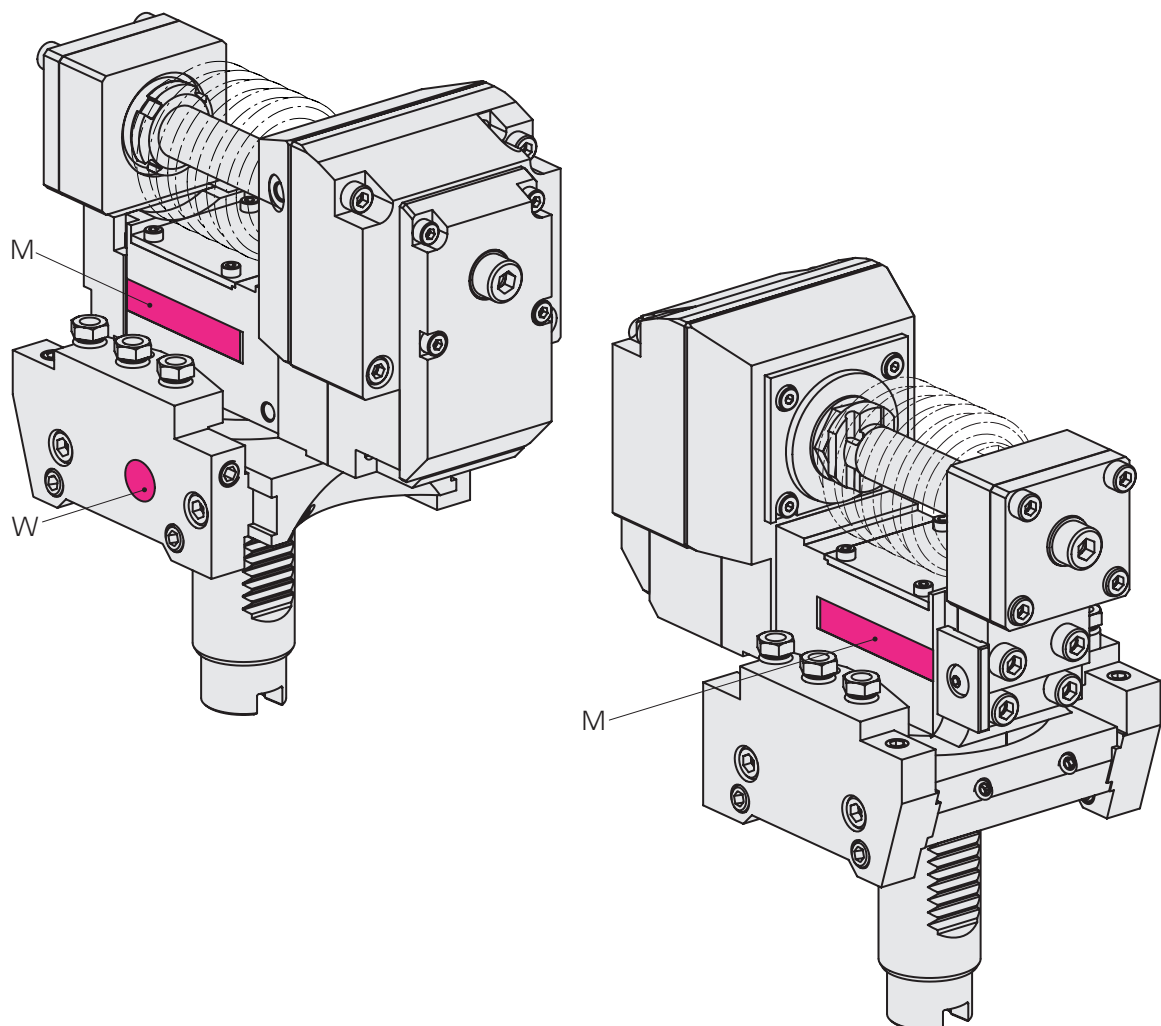


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Angle adjustment

- Adjust the angle and speed as instructed by the manufacturer of the gear cutters
- Angle adjusting screw (W) is used for coarse adjustment
- Angle is adjusted when installed in the machine on the ground measuring surface (M)



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