

# Product note

## **Gear cutting unit, adjustable angle**

Face contact cupped

## **Note on applicability**

Illustrations in this publication may deviate from the product supplied. Errors and omissions due to technical progress expected.

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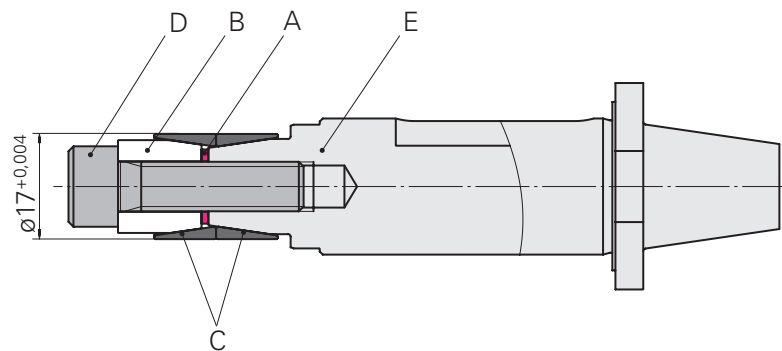
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### Presetting

- 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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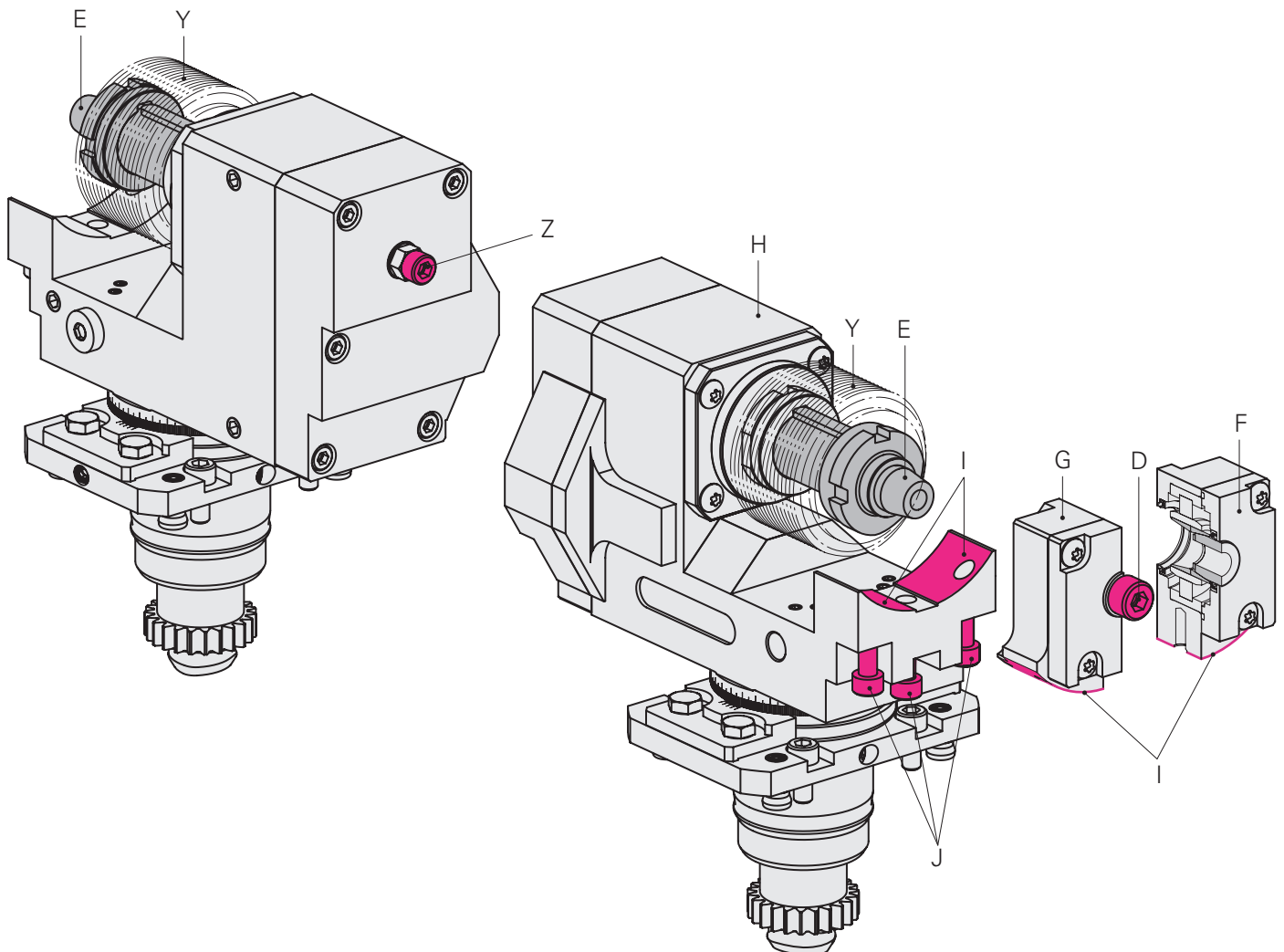
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### Installation

- Tighten mounting arbor (E) and inserted gear cutter (Y) with cylinder head screw (Z) to 14 Nm
- Assemble cover (F) and housing (G)
- Insert into gear cutting unit (H)
- Observe face contact (I) of the housing (G) during installation
- Tighten cylinder head screw (D)
- Tighten cylinder head screws (J)

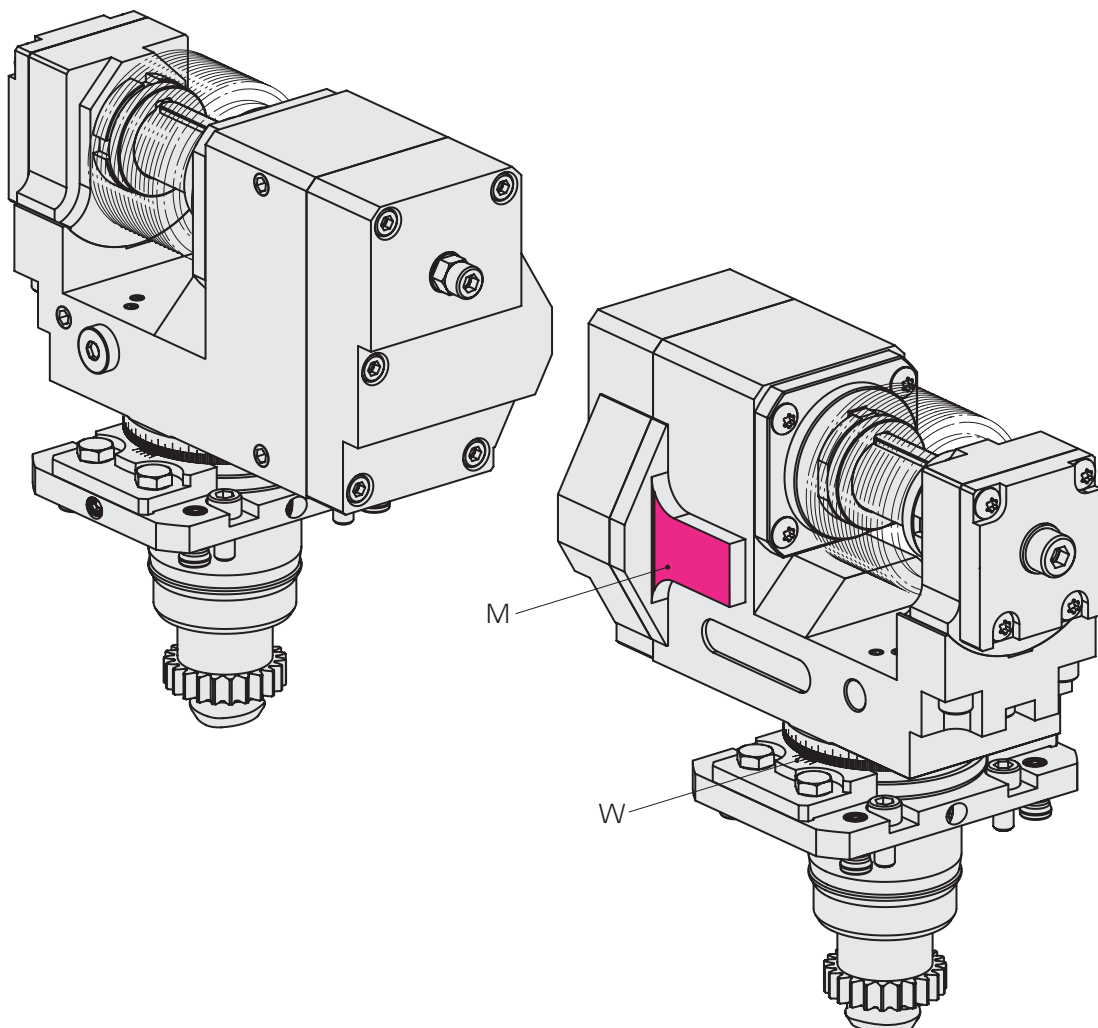


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### Angle adjustment

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



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