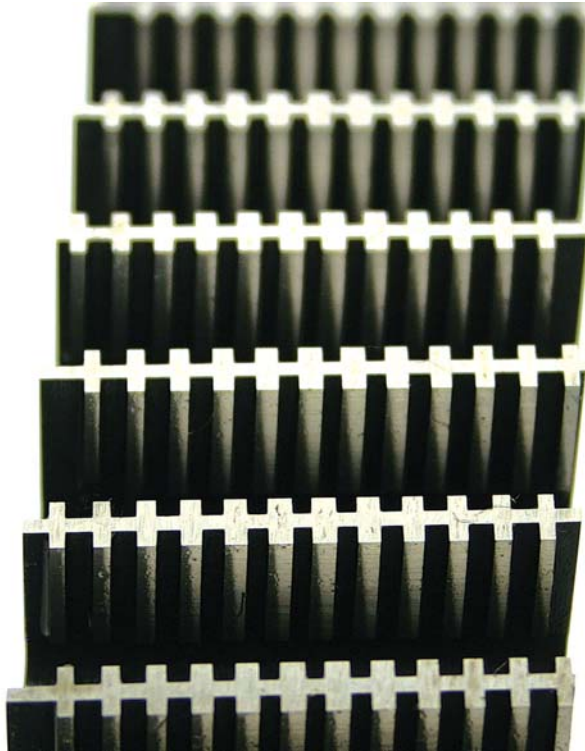


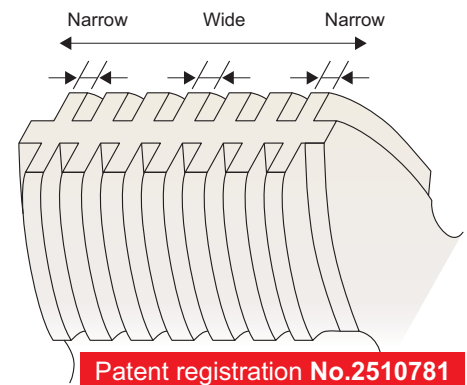
Gear Cutters

Variable Land Shaving Cutter



New shaving cutter to improve overall tooth profiles.

Detail of variable land serration



■ Features

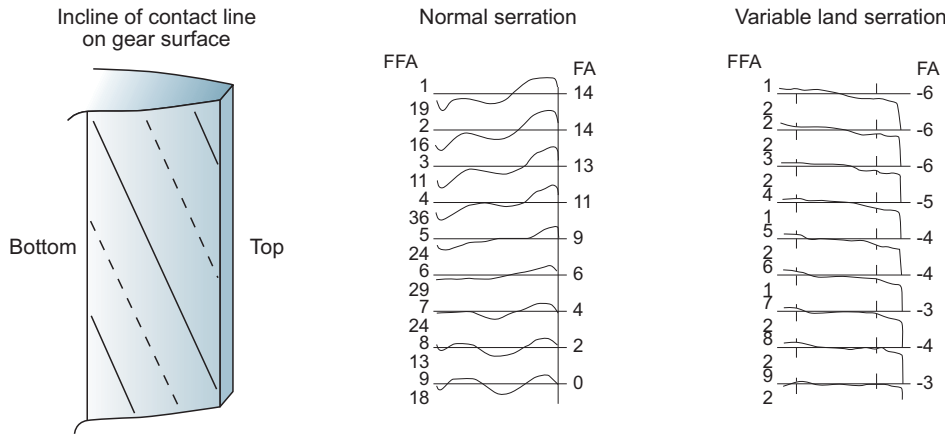
- In order to avoid the unevenness of the tooth profile, variable land serration is adapted to reduce the fluctuation of the cutting force.

Instruction for Use

There is no problem applying for the conventional process of plunge and under-pass shaving methods with the same cutting conditions.

Variable Land Shaving Cutter

Example 1

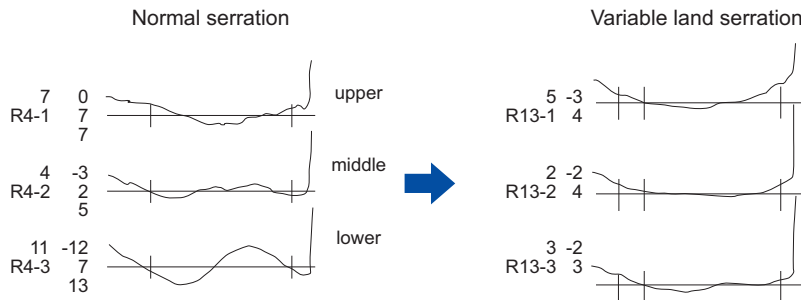


It is possible to recognize the effect of contact length fluctuation along the tooth profile wave of the gear surface with the previous serration shaving cutter. However, the waves are dissolved when using the new variable land shaving cutter.

Gear Dimension

Module	1.75
Pressure angle	17.5°
Number of teeth	18
Helix angle	36°RH
Crossed axis angle	10°
Contact ratio	2.32

Example 2



Just as the case above, the previous serration shaving cutter leaves a large wave on the upper and lower tooth profiles. However, all tooth profiles of upper, middle and lower sections leaves an even line when using the variable land shaving cutter.

Gear Dimension

Module	2.6
Pressure angle	20°
Number of teeth	15
Helix angle	20°RH
Crossed axis angle	10°
Contact ratio	1.496

For Your Safety

●Don't handle inserts and chips without gloves. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc. Ensure that the insert is correctly set in its location pocket. ●Before use, ensure that the tool setup and various settings (machining programme, etc) on the machine are suited to the tool specifications.

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(Tools specifications subject to change without notice.)