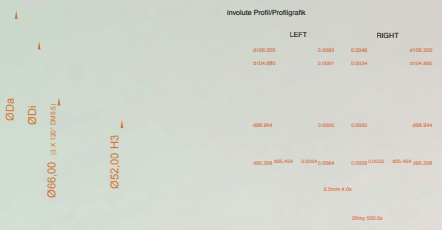
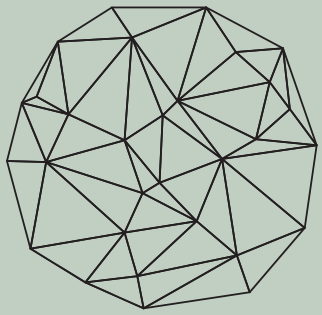
Engineering



Dressing Roll Data/Daten der Abrichtrolle

Dressing Roll/Abrichtrolle	BR1275.1.0005-0 / T-10635
Modul / Modul m	2.520
Pressure Angle / Eingriffswinkel Pa	L:14.55°/R:14.50°
Outside Da / Aussendurchmesser Da	123.000
Diameter Di / Durchmesser Di	96.000
Backlash/Spiel BL	0.000
Dedendum hfPo	3.650
Addendum haPo	4.850
Tip filet Radius / Kopradius pfPo	0.250
Root filet Radius / Fussradius paPo	0.750
Tooth Thickness / Zahndicke sPo	3.896
Profil / Profildaten	
Tip Relif Angle / Kopfrücknahme	-
Tip Relif Start / Start Kopfrücknahme	-
Tip Relif Radius / Balligkeitsr. KR	-
Root Relif Angle / Winkel Kopfrückn.	-
Crowning Radius / Balligkeitsradius	L:545.000/R:625.000
Grit Disc/ Korn Scheiben	D365N/c. CVD
Grit Tip Dresser / Korn Kopfabrichter	D251
CVD Reforced / CVD	YES / JA

GEARING



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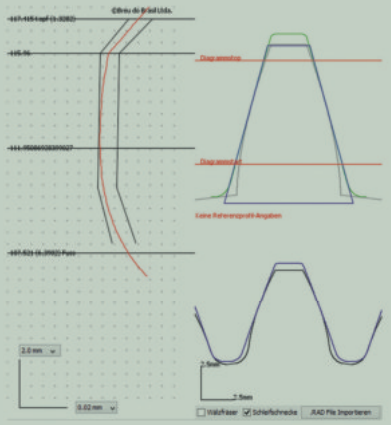
BREU Diamantwerkzeuge

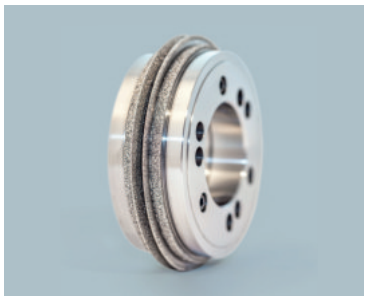
GEAR GRINDING

We manufacture the appropriate tools

With the specialized software we have developed we are able to support you in the setup of your complete project, starting from the layout of the tool, down to the manufacturing process of the gear wheel.

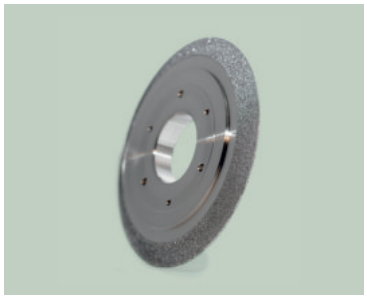
Profile design





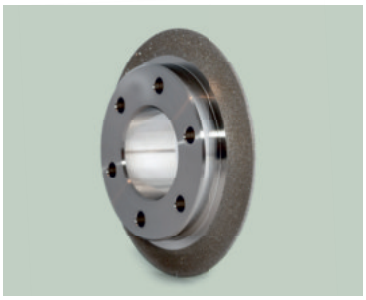
Diamond profile rollers for generating grinding

- For every generating grinding machine available on the tool market
- single- cone and twin-cone discs
- combined dressing rolls for the use in single- flank and dual- flank dressing



Diamond pre-profiling dresser

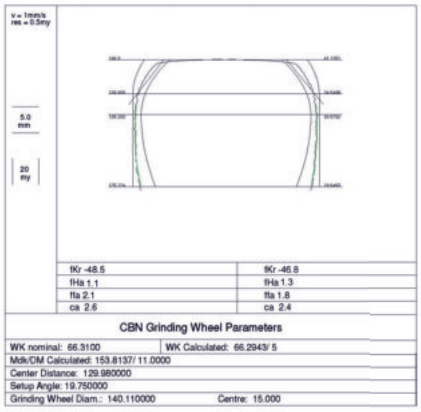
- for pre- profiling of ceramical worm wheels
- with CVD reinforcement of edges
- available in all common shapes and sizes up to Module 16 (special versions upon request)



CBN profile grinding discs

- ø30–300 mm (>300 mm upon request)
- external and internal toothing for use in passenger cars/ trucks/aviation and turbine industry
- for rough grinding and finishing operations up to M16

Measurement report



fKr -48.5	fKr -46.8
fHa 1.1	fHa 1.3
ffa 2.1	ffa 1.8
ca 2.6	ca 2.4

CBN Grinding Wheel Parameters

WK nominal: 66.3100	WK Calculated: 66.2943/ 5
Mdk/DM Calculated: 153.8137/ 11.0000	
Center Distance: 129.980000	
Setup Angle: 19.750000	
Grinding Wheel Diam.: 140.110000	Centre: 15.000