SOLID HOBS

Always on the edge in supplying top-quality high-performing tools for latest generation dry and wet hobbing machinery developed with state of the art machinery.

- SINGLE AND MULTI-THREAD INVOLUTE HOBS
- INVOLUTE SPLINE HOBS
- ROLLER CHAIN SPROCKET HOBS
- HELICAL WORM GEAR HOBS
- PULLEY HOBS

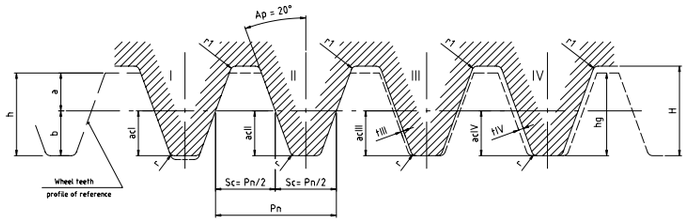
Optimised geometries based on apllication

From MODULE (DP) 0.3 (80) - MODULE 33 (0.75)
Diameter o 20-320 (.78" - 12.5")

QUALITY
- A DIN 3968
- AA DIN 3968
- AAA DIN FUBRI Standard
- AGMA Standard

MATERIAL
- HSS-PM steels
- Carbide

COATINGS
- TIN
- FUTURA NANO
- ALCRONA
- Other coatings available on request



a = sprocket-wheel addendum
b = sprocket-wheel dedendum
h = wheel tooth height
m = module
pn = normal pitch
t = machinable allowance
ac = tool addendum

H = tool tooth height
hg = penetration height of the tool in the sprocket-wheel
Sc = thickness of the tool tooth
Sr = thickness of the tooth of the gear to cut
Ap = pressure angle

ELEMENTS REFERRING TO THE TOOL TEETH

Profile	Type of tool	Addendum Ac	Tooth thickness Sc	Tooth height H
I	Finishing	1.167 m	0.5 pn	≥ 2.367 m
II	Finishing	1.25 m		≥ 2.450 m
III	Pre-grinding	1.25 m + 0.25 $\sqrt[3]{m}$		
	Pre-shaving			
IV	Roughing	1.25 m + 0.6 $\sqrt[3]{m}$		

VALUES IN mm REFERRING TO THE TOOL PROFILE 20°pa

MOD	pn	Sc	ac I	ac II	ac III	t III	ac IV	t IV
1	3.1416	1.57	1.17	1.25	1.50	0.09	1.85	0.21
1.25	3.9270	1.96	1.46	1.56	1.83	0.09	2.21	0.22
1.5	4.7124	2.36	1.75	1.88	2.16	0.10	2.56	0.23
1.75	5.4978	2.75	2.04	2.19	2.49	0.10	2.91	0.25
2	6.2832	3.14	2.33	2.50	2.81	0.11	3.26	0.26
2.25	7.0686	3.53	2.63	2.81	3.14	0.11	3.60	0.27
2.5	7.8540	3.93	2.92	3.13	3.46	0.12	3.94	0.28
2.75	8.6394	4.32	3.21	3.44	3.79	0.12	4.28	0.29
3	9.4248	4.71	3.50	3.75	4.11	0.12	4.62	0.30
3.25	10.2102	5.11	3.79	4.06	4.43	0.13	4.95	0.30
3.5	10.9956	5.50	4.08	4.38	4.75	0.13	5.29	0.31
3.75	11.7810	5.89	4.38	4.69	5.08	0.13	5.62	0.32
4	12.5664	6.28	4.67	5.00	5.40	0.14	5.95	0.33
4.5	14.1372	7.07	5.25	5.63	6.04	0.14	6.62	0.34
5	15.7080	7.85	5.84	6.25	6.68	0.15	7.28	0.35
5.5	17.2788	8.64	6.42	6.88	7.32	0.15	7.93	0.36
6	18.8496	9.42	7.00	7.50	7.95	0.16	8.59	0.37
6.5	20.4204	10.21	7.59	8.13	8.59	0.16	9.24	0.38
7	21.9911	11.00	8.17	8.75	9.23	0.16	9.90	0.39
8	25.1327	12.57	9.34	10.00	10.50	0.17	11.20	0.41
9	28.2743	14.14	10.50	11.25	11.77	0.18	12.50	0.43
10	31.4159	15.71	11.67	12.50	13.04	0.18	13.79	0.44
11	34.5575	17.28	12.84	13.75	14.31	0.19	15.08	0.46
12	37.6991	18.85	14.00	15.00	15.57	0.20	16.37	0.47
13	40.8407	20.42	15.17	16.25	16.84	0.20	17.66	0.48
14	43.9823	21.99	16.34	17.50	18.10	0.21	18.95	0.49
15	47.1239	23.56	17.51	18.75	19.37	0.21	20.23	0.51
16	50.2655	25.13	18.67	20.00	20.63	0.22	21.51	0.52

PRE-SHAVING ALLOWANCE ON TOOTH THICKNESS mm