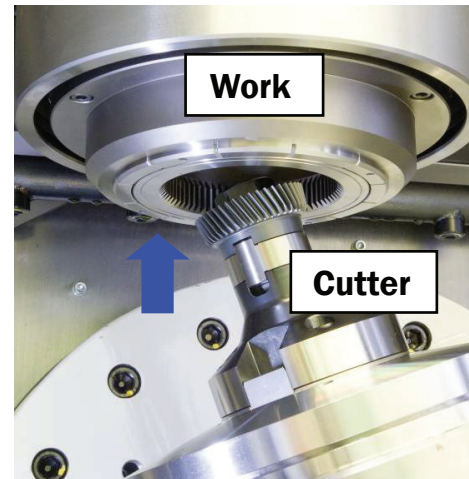


Skiving Cutter

Suitable for Internal Gear Machining in Small-Scale Line

Features

- Machining efficiency is more than double the amount of shaper cutters.
- By analyzing our machining process using our latest gear cutting technology, we have achieved the highest combination of the longest tool life and the most precise work piece.



- Small and large quantity production
- Low initial costs
- Allows processing for internal blind gear
- Tooth profile, tooth lead adjustments are possible



- Feature comparison of the internal gear processing method

	Item	Broaching Process	Shaper Cutter	Skiving Process
Process	Productivity	◎	△	○
	Processing accuracy	◎	○	○
	Set-up performance	△	◎	◎
Equipment	Initial investment	△	○	○
Tool cost	Initial	×	◎	◎
	Running	○	△	(△)
Workpiece	Blind hole gear	×	○	○
	Tooth profile, lead adjust	×	×	○
Method	Hard processing after HT	×	×	○

◎ Excellent ○ Good △ Not Ideal × Not Recommended

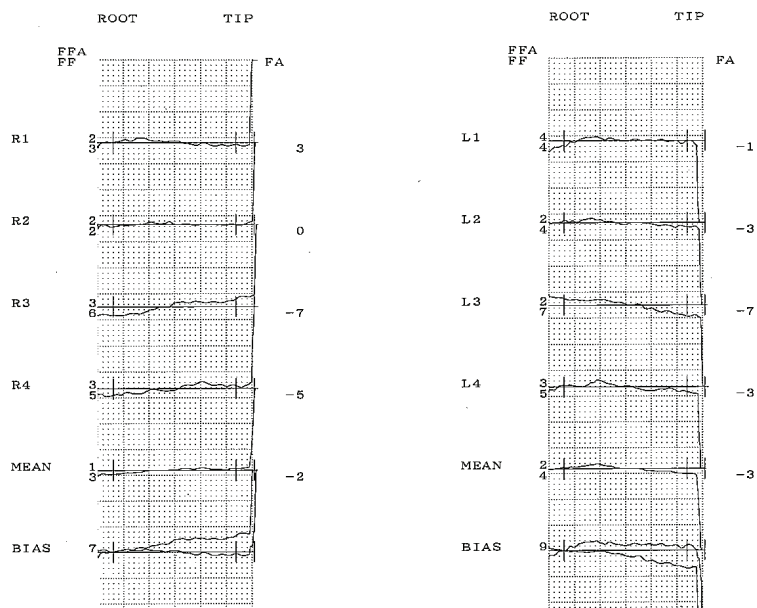
Application Examples

Work Details		Cutter Details		Cutting Condition	
MxPA	m1.5xPA20°	No. of Teeth	30	Rotation	1600/1600 rpm
No. of Teeth	内 70	Helix Angle	SPUR	Slide Speed	148/148 m/min
Helix Angle	20°RH	Material	FAX55	Feed	0.05/0.05 mm/rev
Material	SCM420	Coating	Hyper DuAl GP	Coolant	Oil
Tooth Width	25mm	(on cutting face)	Yes	No. of Workpieces	

• ACCURACY

Tooth Profile

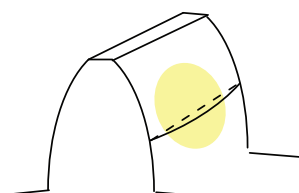
500x 4.0x $\frac{2.0\mu m}{0.25mm}$



• ACCURACY

Lead Crowning

500x 2.0x $\frac{2.0\mu m}{0.50mm}$



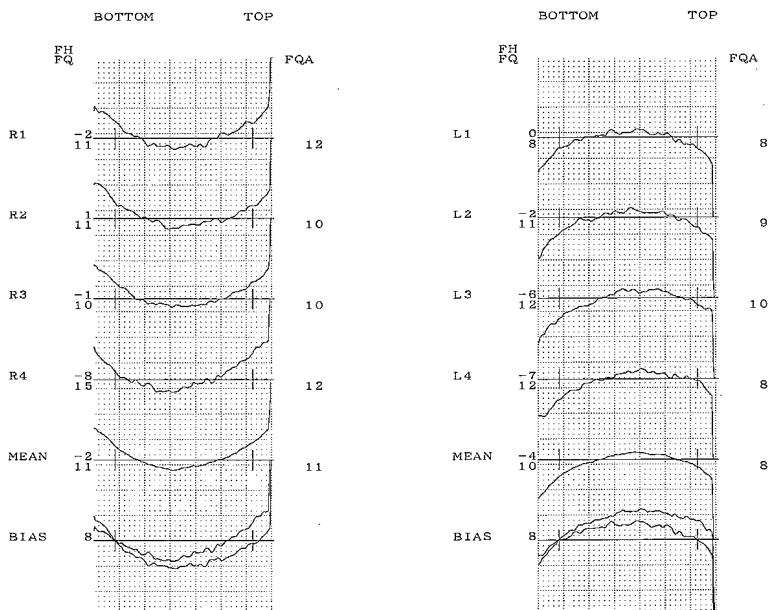
Lead modification is possible



Adjust tooth contact



Improve gear performance



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