

Gear Hobbing Unit

High Productive Manufacturing of Gears
with CNC Turning Centers.

Maximum flexibility, high surface quality, easy handling.

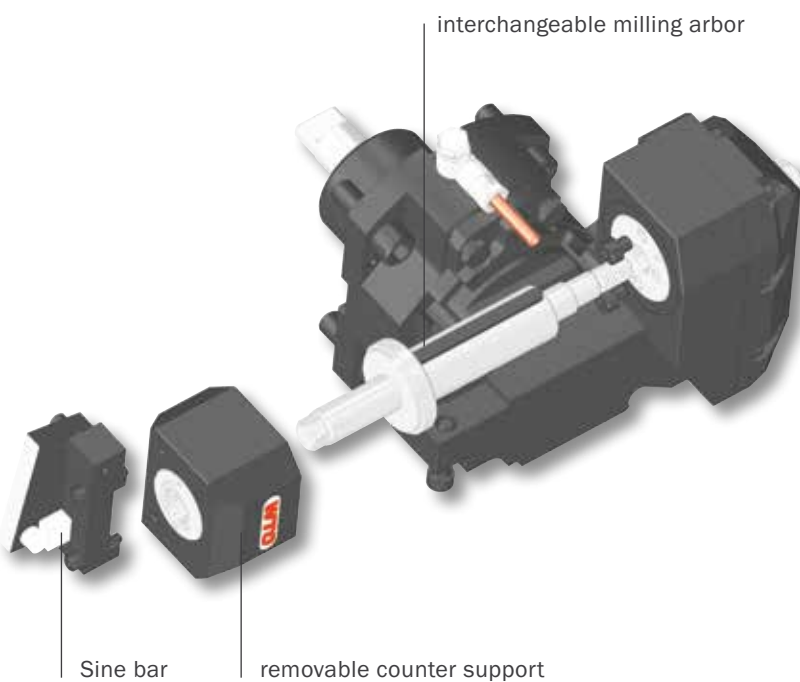


In operation:

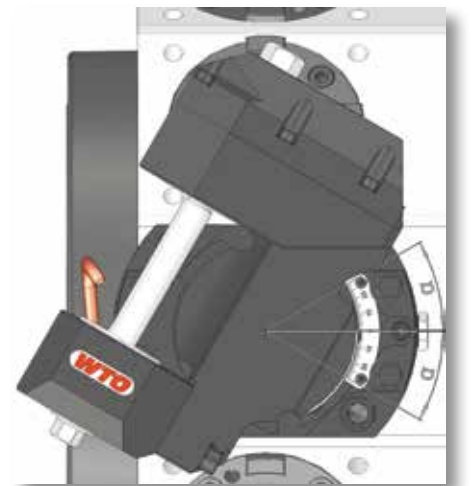


Gear Hobbing Unit for Turn/Mill Centers

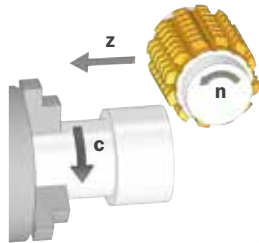
- | Usable for machining gear quality according to standard 8 ISO 1328, AGMA 8
- | Maximum scale swing of $\pm 30^\circ$
- | High stiffness and runout accuracy
- | Interchangeable milling arbor available in different sizes
- | Easy cutting tool change through removable counter support and withdrawal of the complete milling arbor
- | Cutting tools can be pre-set
- | Sine bar for high accurate angular adjustment



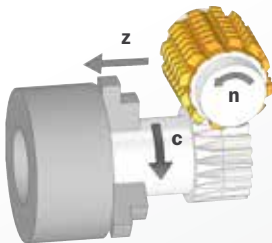
Maximum angular adjustment
 $\pm 30^\circ$ with scale and vernier



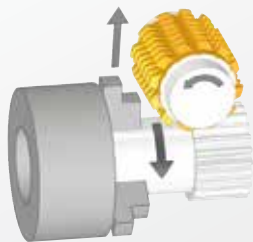
Operation principle: Gear hobbing



Synchronization of work piece and tool rotation.



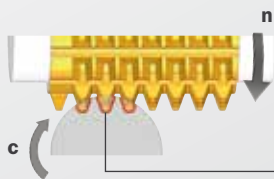
Feed movement in Z axis.



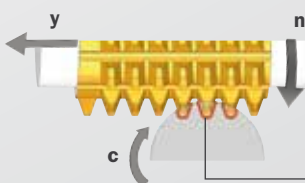
When hobbing is finished the hob has to move towards X.

Please consider:
At the end of the gear/spline there has to be sufficient clearance for the hob.

Shifting



Initial hob position after tool change with new cutting tool.



Hob position at end of cutting tool life.

To optimize the cutting tool life you can move the hob step by step in Y axis direction. This movement enables the usage of all cutting edges of the hob. This procedure is called shifting.

Sample workpieces



| **Splines**
e.g. DIN 5480, DIN 5482, TORX

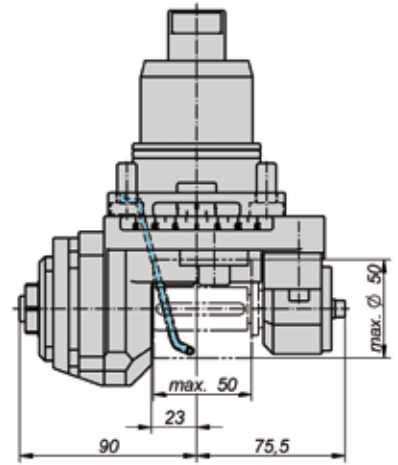
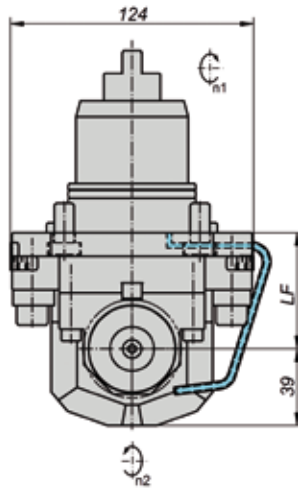


| **Spur gear**



| **Helical gear**

Gear Hobbing Unit type 1 (up to module 2)

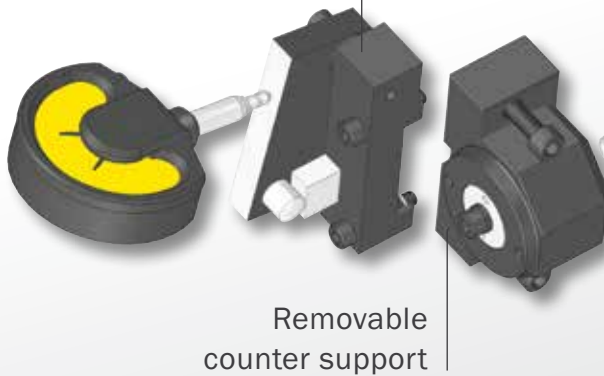


- | Max. cutting tool size $\varnothing 50 \times 50$ mm
- | Ratio i ($n_1:n_2$) 1:1
- | Max. RPM (n_2) 4,000
- | Max. torque M 32 Nm
- | Max. scale swing $\pm 30^\circ$

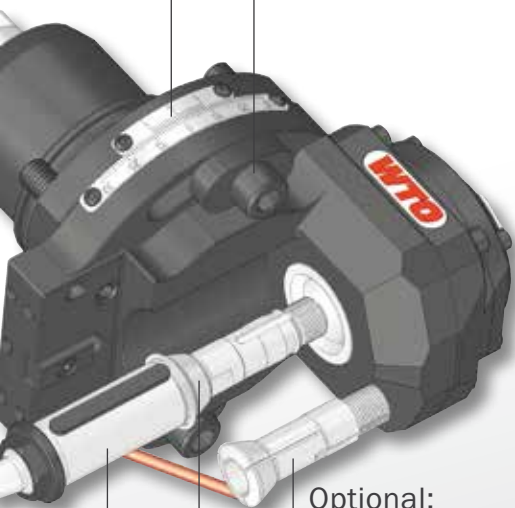
Maximum angular adjustment $\pm 30^\circ$ with scale and vernier

Clamping of angular position

Sine bar for high accurate angular adjustment



Removable counter support



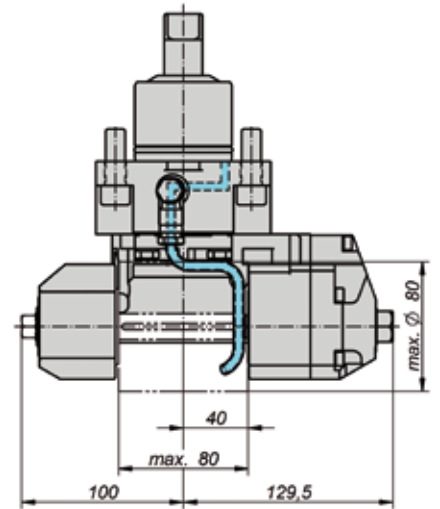
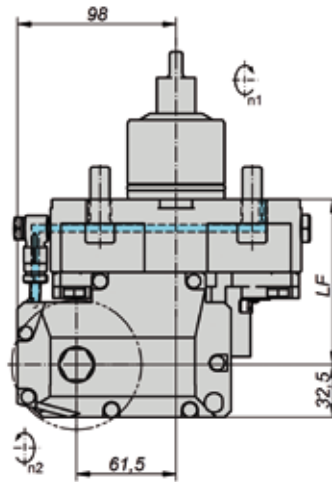
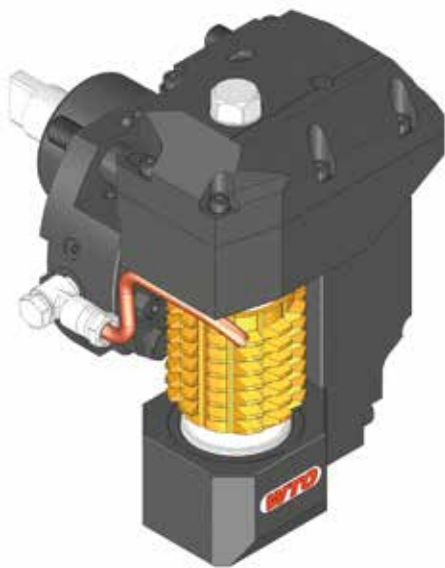
Optional: High precision collet

Taper connection for high accuracy runout

Interchangeable milling arbor

Taper support for high accuracy runout

Gear Hobbing Unit type 2 (up to module 3)



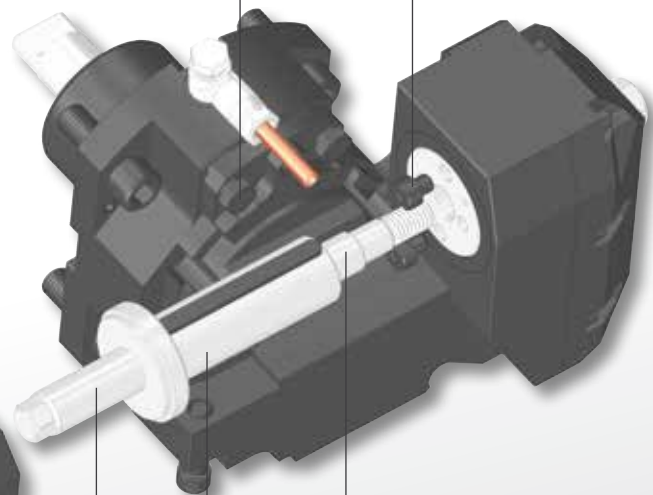
Max. cutting tool size	Ø80x80 mm	Ø80x80 mm
Ratio i (n1:n2)	1:1	2:1
Max. RPM (n2)	6,000	3,000
Max. torque M	60 Nm	80 Nm
Max. scale swing	±30°	±30°

Clamping of angular position

Removable face drive dogs



Maximum angular adjustment ±30° with scale and vernier



Precision interface for high accuracy runout

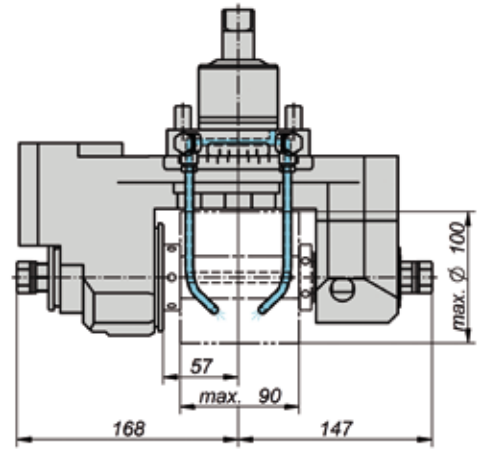
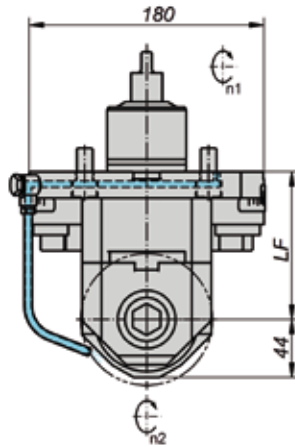
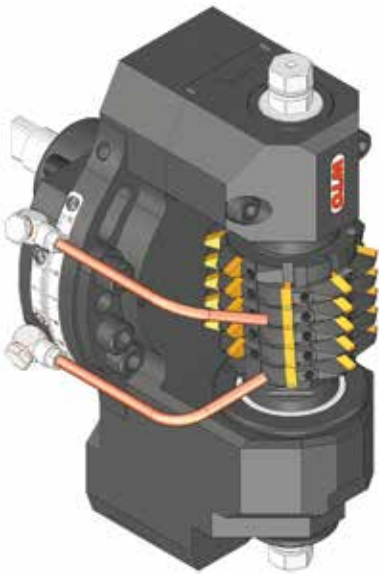
Interchangeable milling arbor

Precision interface for high accuracy runout

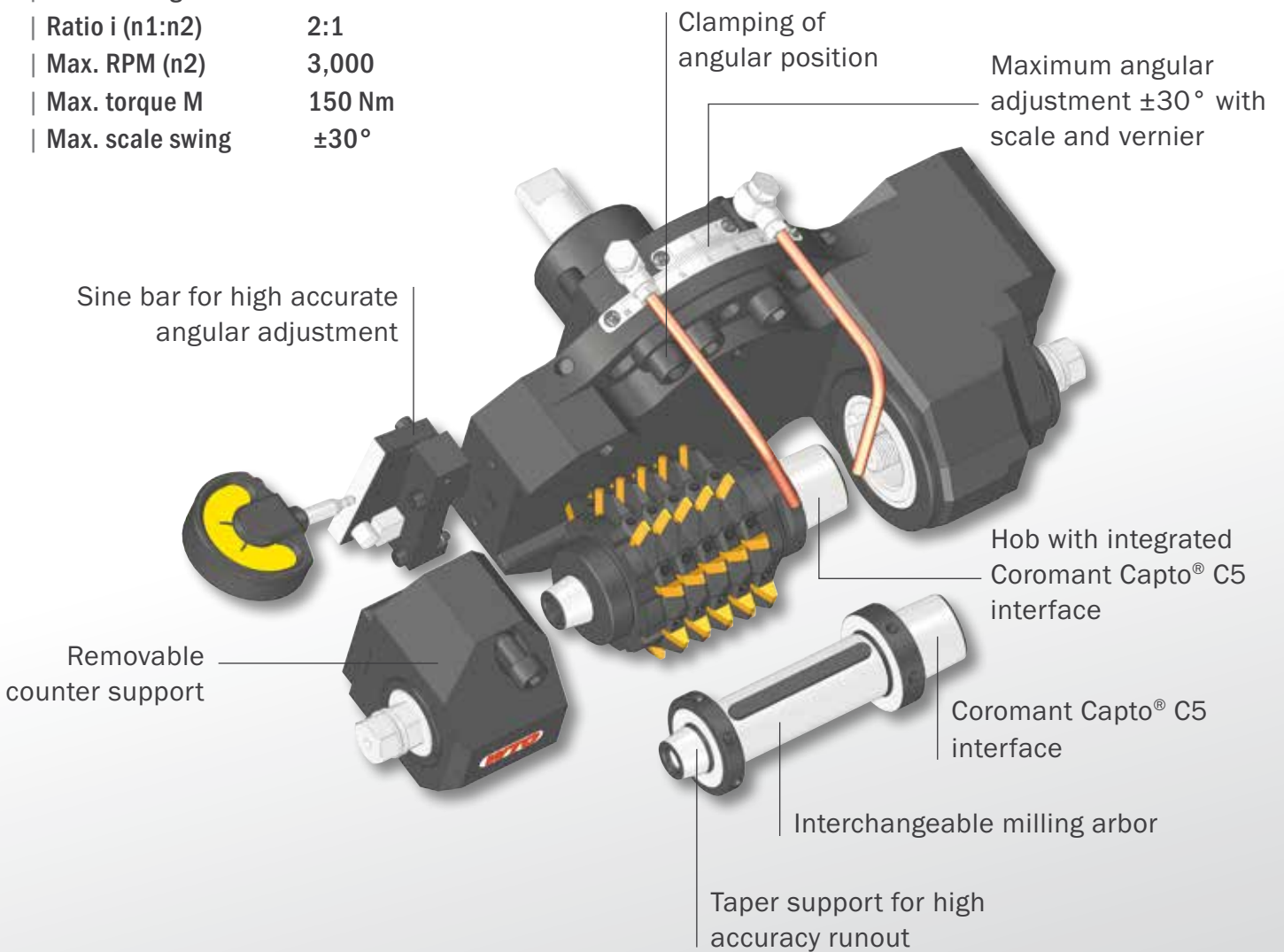
Removable counter support

Sine bar for high accurate angular adjustment

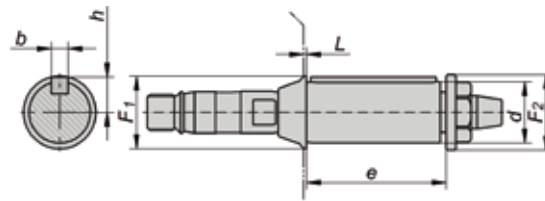
Gear Hobbing Unit type 3 (up to module 6)



- | Max. cutting tool size $\varnothing 100 \times 90$ mm
- | Ratio $i (n_1:n_2)$ 2:1
- | Max. RPM (n_2) 3,000
- | Max. torque M 150 Nm
- | Max. scale swing $\pm 30^\circ$



Milling arbor type 1



Collet for type 1 (324E-UP)

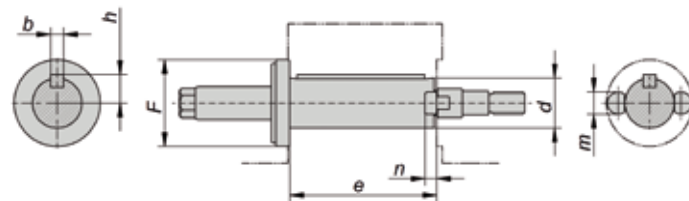




Item No.	Ø
199015130	13
199015050-in	1/2"

Item No.	d	e	b	h	L	F ₁	F ₂		
160008152	8	35	2	4.7	14	14.0	15.0	104271	98852
160010152	10	40	3	6.20	7	16.0	21.5	20588	86055
160013152	13	50	3	7.70	1	26.0	20.0	87770	86054
160016152	16	50	4	9.20	1	26.0	27.0	20642	97265
160022152	22	50	6	12.60	1	26.0	27.0	20804	97265
160015152	5/8"	50	1/8"	9.52	1	26.0	27.0	44683	97265
160019152	3/4"	50	1/8"	11.11	1	26.0	27.0	44683	97265

Dimensions in mm

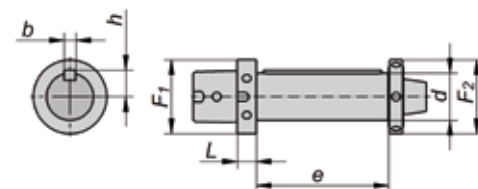
Milling arbor type 2





Item No.	d	e	b	h	m	n	F		
160016161	16	80	4	9.2	8	4.5	47	104358	45988
160022161	22	80	6	12.6	10	5.6	47	80120	45151
160027161	27	80	7	15.5	12	6.3	47	77856	77558
160015161	5/8"	80	1/8"	9.51	7.94	4.5	47	77705	77704
160019161	3/4"	80	1/8"	11.11	7.94	4.5	47	77706	77704
160023161	7/8"	80	1/8"	12.69	7.94	4.5	47	77705	91840
160025161	1"	80	1/4"	15.07	9.53	5.0	47	77870	85352
160031161	1 1/4"	80	1/4"	18.26	-	-	47	77870	-

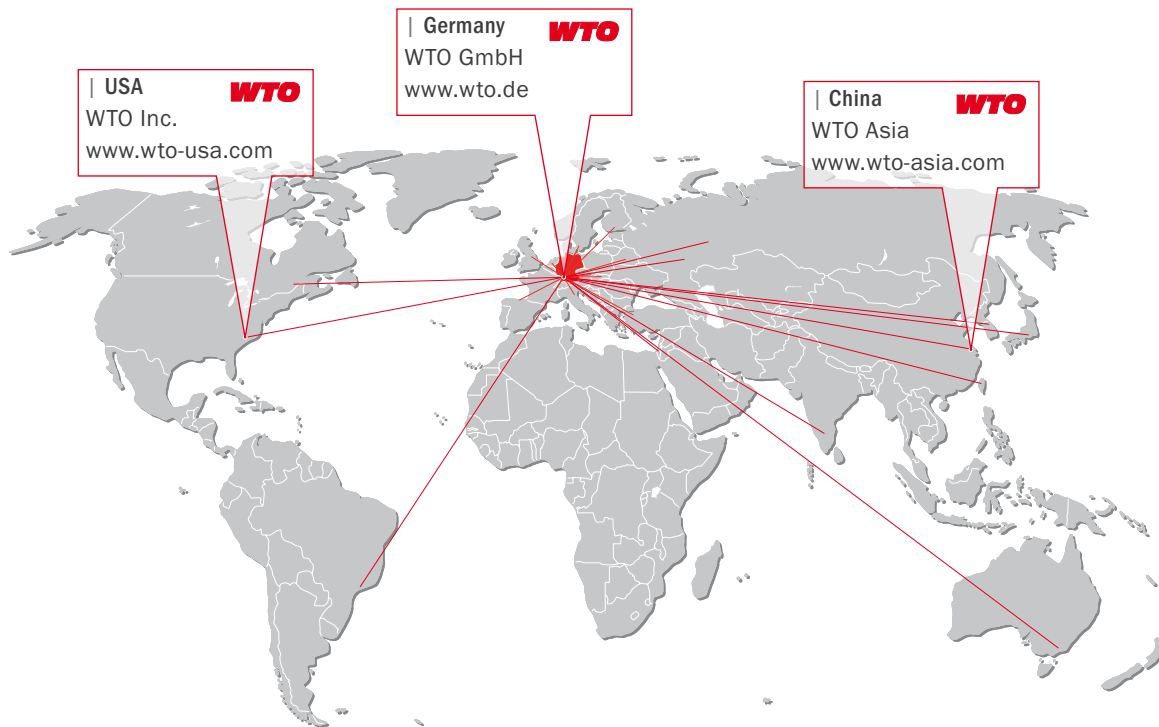
Dimensions in mm

Milling arbor type 3



Item No.	d	e	b	h	L	F ₁	F ₂		
160027C51	27	90	7	15.50	13	50	50	100091	99760
160032C51	32	90	8	18.00	13	50	50	20870	99760
160025C51	1"	90	1/4"	15.07	13	50	50	99761	99760
160031C51	1 1/4"	90	5/16"	19.05	13	50	50	100090	99760

Dimensions in mm



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WTO GmbH
www.wto.de

| China
WTO Asia
www.wto-asia.com

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Auf der oberen Au 45
77797 Ohlsbach
Germany

WTO USA
13900 S Lakes Dr Ste F
Charlotte NC 28273-7119
USA

WTO Asia
Room 109-110, Building 2
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Dimac Tooling Ltd.
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pta@wto.de

| Mexico
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info@wem.com.mx

| Spain
ITALMATIC, S.A.
italmatic@italmatic.es

| Brazil
TF2
tfdois@tfdois.com.br

| Great Britain
Cutwel Ltd.
sales@cutwel.net

| Netherlands
Klein Tooling B.V.
verkoop@kleintooling.nl

| Sweden
Komet Scandinavia AB
scandinavia@kometgroup.com

| Canada
Mittmann Industrial Inc.
info@mittmann.com

| India
A.H. Rao
ahr.rao@gmail.com

| Norway
Helge Karlsen Verktøy og Maskin AS
hkvm@hkvm.no

| Switzerland
Utilis AG
info@utilis.com

| China
Shanghai Gangde
wtocando@aliyun.com

| Israel
E.Y.A.R. Ltd.
yehoshua@eyar.co.il

| Poland
ARCO Andrzej Rudenko
info@arcotools.pl

| Taiwan
Kaiko Co., Ltd.
info@kaiko.com.tw

| Czech Republic
ALBA precision, spol. s.r.o.
info@albaprecision.cz

| Italy
Prymark srl
commerciale@prymark.it

| Romania
SC Elif Trading SRL
bulent.ozkan@eliftrading.com

| Turkey
MYK CNC MAKINA SAN. VE
huseyin.tatlidil@mykcnc.com.tr

| Denmark
Tool-part
cj@tool-part.dk

| Japan
NK Works Co. Ltd.
k_samba@nk-works.co.jp

| Russia
WTO Office Russia
office@wto-russia.com

| Ukraine
„LLC“ SPA Stankopromimport
info@phoenix-ua.com