



Grinder System Application

Root Form Cutters

Description

Regrinding of high speed steel root form cutters.

Application

Root form cutters for the aerospace industries and power generation.
Tooth profiles and flute faces.

Process

Resharpen the flute face or regrind the tooth profile and flute face.

Material

High speed steel.

Machine Features and Benefits

Root form cutters are ground using the HS-150, HS-190 and HS-200 Series grinders.

Automatic wheel truing with wheel wear compensation is an integral part of the software.

An automatic wheel dressing (stick feed) system is available for opening the grinding wheel bond.

Integrated to a CAD/CAM system or Huffman's APT programming language for profile grinding.

Tolerances between pressure lands are held less than 0.0002" (0.0051mm) for profile grinding.

For profile grinding, a diamond truing nib is used to form a conventional abrasive wheel. The program compensates for any form distortion generated by axial or radial rake on the flute face.

Wheel diameters for profile grinding are a function of tooth spacing; typically 6"-8" (152-203mm).

The formed wheel grinds a cam relief on the profile.

Tooling is available for securing both tapered and straight shank cutters.

