

## BURKA-KOSMOS Grinding Wheel Worksheet for Reishauer Gear Grinding Machine Type RZ 400

Customer :

Machine Type :

Date :

**1. Workpiece Data:**

Norm. - Modul m =	mm	Number of Teeth =		Material =		Hardness=	HRC
Outside Diameter =	mm	Helix Angle =		Stock Rem- Base Tan Lgth	mm	Number of Gears	
Face Width =	mm	Pressure Angle =		Stock per Flank =	mm	DIN - Quality =	

**2. Process Data with Competitors Wheel**

**Competitor:**

**Wheel Size:**

**Wheel Spec.:**

	Step 1	Step 2	Step 3	Step 4	Step 5	Step 6
Active step	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Number Strokes						
Wheel Shift	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Direction Starting Stroke	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Grinding Wheel RPM 1/min						
Infeed per Stroke mm						
Z - Feed mm / U						
Y - Feed mm / mm Stroke						
Infeed Speed mm / min						
Shift Amount mm						
Direction last Stroke <input type="checkbox"/>	Shift Direction <input type="checkbox"/>		Grind Time min			

**3. Results of B-K Grinding Test:**

**BK-Nr.:**

**Wheel Size:**

**BK-Spec.:**

	Step 1	Step 2	Step 3	Step 4	Step 5	Step 6
Active step	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Number Strokes						
Wheel Shift	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Direction Starting Stroke	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Grinding Wheel RPM 1/min						
Infeed per Stroke mm						
Z - Feed mm / U						
Y - Feed mm / mm Stroke						
Infeed Speed mm / min						
Shift Amount mm						
Direction last Stroke <input type="checkbox"/>	Shift Direction <input type="checkbox"/>		Grind Time min			

**3. Dressing Data**

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Technolog. Step	Number Active Strokes	Wheel Shift	Dress Interval Index	RPM Wheel U/min	RPM Workpiece U/min	Infeed mm	Infeed Accum mm	Direction last Stroke	Technolog. Step	Number Active Strokes	Wheel Shift	Dress Interval Index	RPM Wheel U/min	RPM Workpiece U/min	Infeed mm	Infeed Accum mm	Direction last Stroke
Step 1	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						Step 1	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
Step 2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						Step 2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
Step 3	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						Step 3	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
Step 4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						Step 4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					

**Comments: (Inspection Diagram; Quality Achieved; Test for Burns; etc.)**

**Remarks:**