BURKA-KOSMOS Grinding Wheel Worksheet for Samputensili Profile Grinding Machine

Customer : Machine Type Date :

1. Workpiece Data:

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

2.Dress and Grind Parameters w/ Competitors Grinding Wheel

Wheel Size: **Spec.:**

Competitor:	Cycle 1	Cycle 2	Cycle 3	Cycle 4
Cycle Type				
Number of Passes				
Number of First Profile				
Dressing Amount (mm)				
Dressing Speed				
Rotation of Dressing Roll (0=ccw /1=cw)				
Number of Passes per Gap				
Infeed in start (mm)				
Feed in start (m / min)				
Infeed return (mm)				
Feed return (m/min)				
Cutting Speed (m / sec)				
Intermediate Profile of Tooth				
Tooth Placement				
Profile Speed of the Disc (m / s)				
Dressing Roll Speed (U / min)				
Load Meter % =				
Grind Time min=	Q ´ w =			

3. Results with B-K Grinding Wheel **BK-Nr.**

Wheel Size: **Spec.:**

	Cycle 1	Cycle 2	Cycle 3
Cycle Type			
Number of Passes			
Number of First Profile			
Dressing Amount (mm)			
Dressing Speed			
Rotaion of Dressing Roll (0=ccw /1=cw)			
Number of Passes per Gap			
Indeed in start {mm}			
Feed in start (m / min)			
Infeed return (mm)			
Feed return (m/min)			
Cutting Speed (m / sec)			
Intermediate Profile of Tooth			
Tooth Placement			
Profile Speed of the Disc (m / s)			
Dressing Roll Speed (U / min)			
Load Meter % =			
Grind Time min=	Q ´ w =		

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

Remarks: