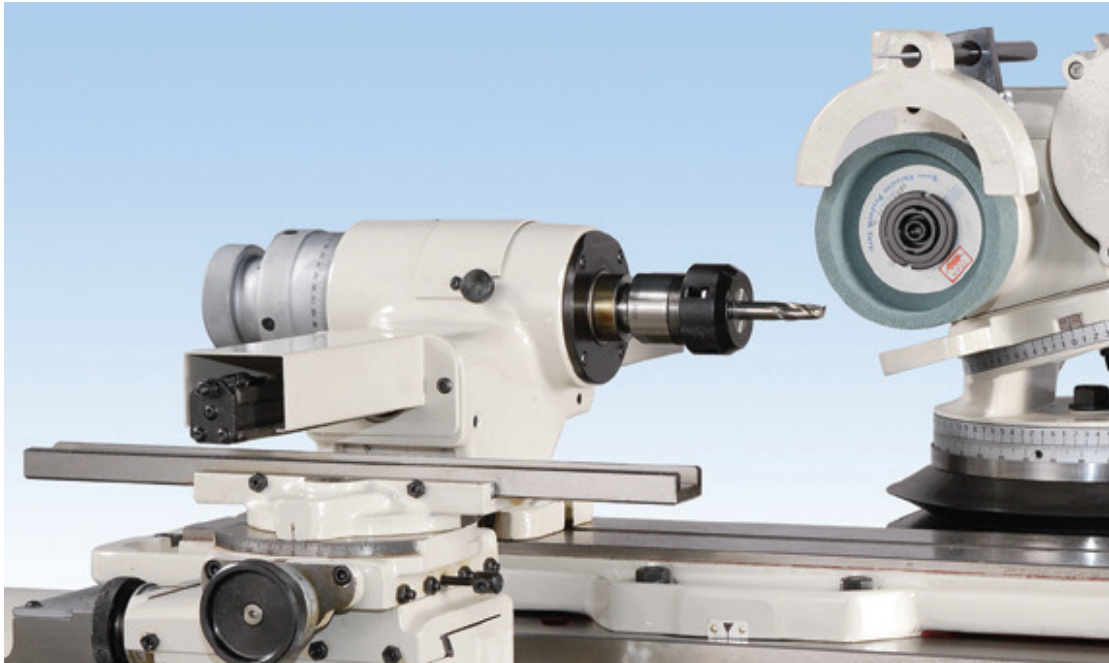


8.4 Helix Angle Grinding Device



1. Introduction

The device is suitable for grinding spiral cutter escape angle and tilt or roll cutter, cutter and center drill, the work head Spindles taper hole M.T.#4.

2. Product Specifications

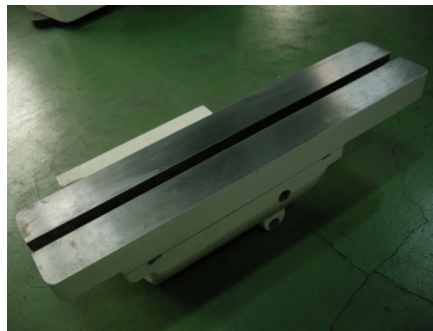
Spindle taper of work head	M.T.#4
Indexing plate	24 (Standard)
The maximum diameter of the bed platform to	125 mm (5")
The maximum length of the bed platform	320 mm (12 1/2") (When Spiral angle = 0)
Max. Module of Hob to be ground	8 (3 Diametral pitch)
Max. Helix Angle of. Hob to be ground	±8°
Dia. of Arbor for mounting Hob	1" (Standard)

3. Installation

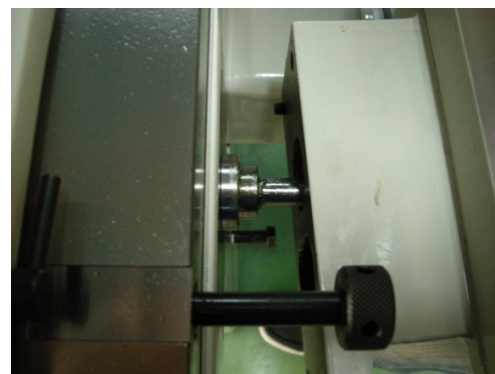
(a) First, the first machine to remove the handle down.



(b) Then this accessory to the device up.



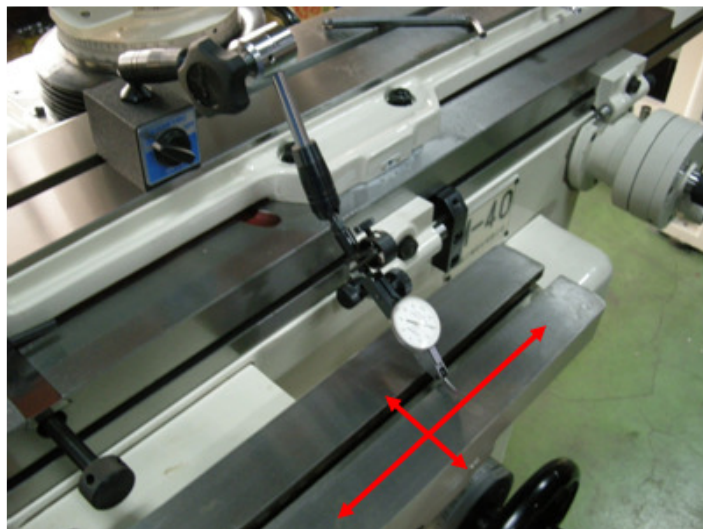
(c) Install with the machine table with the handle.



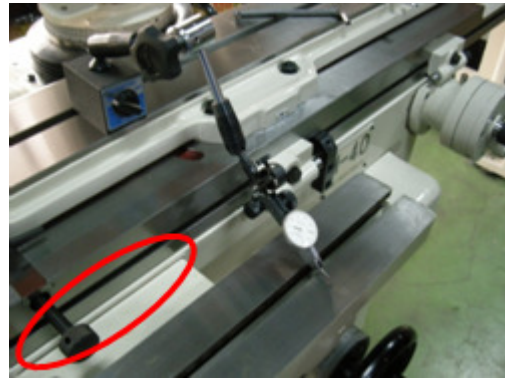
(d) Once the screws on the first not fully tighten to correct.



(e) Use Scale Calibration accessories for bed sets parallelism.



(f) In parallel to the before and after correction, if that can be used before and after a large gap in the Annex steel pads and bed side table seams, as it depends on the choice of steel depending on prevailing conditions, the correction after the completion of the four screws symmetrically fixed locking.



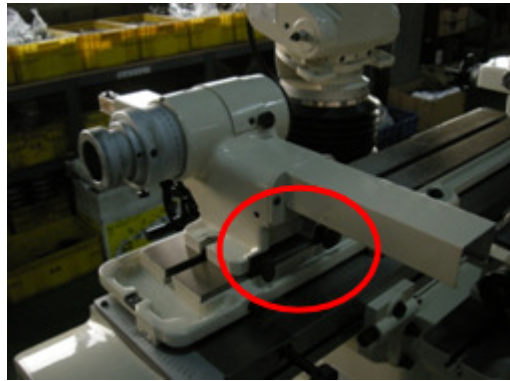
(g) As previously installed and then slide to put a good platform.



(h) Use the chart screws, locking the rails on the platform.

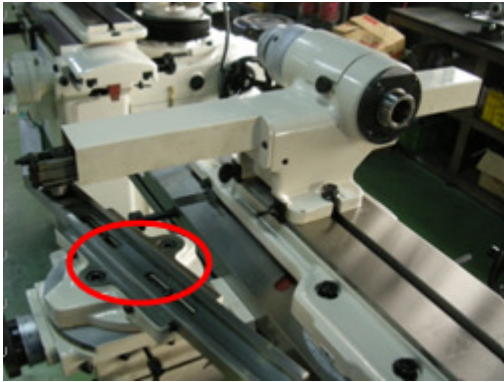


(i) Augers mounted to the bed and then the stage, the lock screw and fixed.



4. Use

(a) First, the first slide to adjust the dials on the attachment angle you want.



(b) In the grinding material safety device on the knife.



(c) Guide rod placement angle.

After the dia of cutter to be ground and helix angle of cutter are determined, calculate the lead of cutter and setting angle of guide bar.

$$\tan\theta = D / L \dots\dots\dots(1)$$

$$\tan\psi = \pi d / L = 157.08 / L \dots\dots\dots (2)$$

θ : Helix angle

D : Diameter (mm)

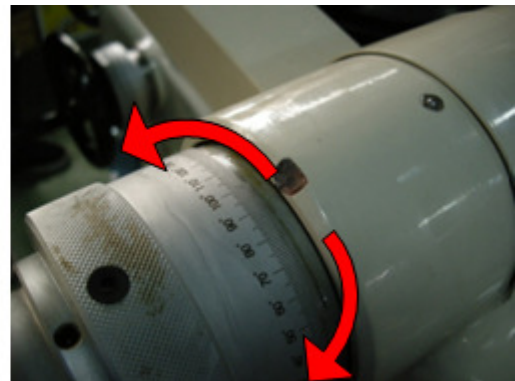
L : Lead (mm)

ψ : Guides set the angle

d : 50 (mm)

From Equation (1) and (2), the placement angle obtained.

(d) With indexing plate can grind want Flutes, pull back the next chart wheel, you can adjust the desired angle.



6. Helix Angle Grinding Device List

項目	品號	品名	規格	數量
1	M160010**	Screw the seat		1
2	M160180**	Front axle cover		1
3	GB010939	Angular contact ball bearings	7208CTYNSUMP4	2
4	M160020**	Helix angle spindle		1
5	M160030**	Spindle nut		1
6	M160040**	Winding Wheel		1
7	GB010722	Deep groove ball bearing	6009ZZ	1
8	M160050**	Spindle rear axle cover		1
9	M160060**	Positioning tooth plate		1
10	M160080**	Nuts		1
11	M160100**	Retaining collar jacket		1
12	M160110**	Clutch (24T)		1
13	M160170**	Spindle feed shaft		1
14	M160250**	Hob axis		1
15	M160260**	Nuts		1
16	M160160**	Spring		1
17	M160290**	Retaining nut		1
18	M160300**	Screw the seat cover		1
19	M160310**	Cover		1
20	M160320**	Cover		1
21	M160150**	Scale wheel infeed		1
22	M160190**	Rails		1
23	M160330**	Bolt		1
24	M160240**	Bearing lever		4
25	M450030**	Key		2
26	M450060**	Clamping block		2
27	M450070**	Butterfly Bolts		2
28	M450080**	T-bolt		2
29	M160120**	Nuts		1
30	M160130**	Nuts		1
31	M160140**	Nuts		1
32	GB010926	Deep groove ball bearing	629Z	8
33	GF010667	Hex button head screws	M5*16	4

34	GE010214	Washer 5.0 (Black)		4
35	GE020185	Spring washer	M5	4
36	M160090**	Collars		1
37	M160340**	Chuck handle 4 "	MT4	1
38	M160350**	Tighten the screw		1
39	M160070**	Axis positioning chaining		1
40	M160200**	Chock		1
41	M160210**	Washer		1
42	M160220**	Bolt		1
43	M160230**	Washer		2
44	M160270**	Spacer		5
45	M160280**	Washer		2
46	GB020127	Roller Bearings / CF-shaped cam follower	CF10	1