

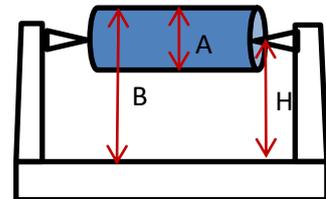
Inspection method of resharpening accuracy for hobs - Top rake of cutting face

In order to use hobs while maintaining accuracy and life, it must have the correct resharpening accuracy. Therefore, it is important to evaluate the hob accuracy after resharpening. The measurement method is described in JIS B4355, test number 5-7, However it seems a little abstract and difficult to understand. So we introduce a practical method that users can measure without a specialised measuring device.

Form and position of cutting face

<Devices>

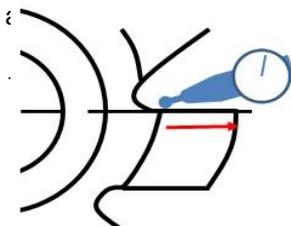
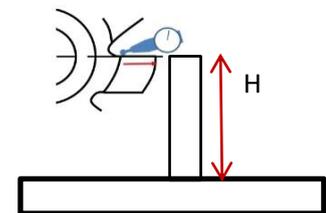
1. Bench Center	1set
2. Straight mandrel	1set
3. Dial test indicator (Lever type) with magnetic stand (Min scale 0.002mm)	1set
4. Gauge block	1pc
5. Micrometer	1pc



How to measure

- Mount the hob on the straight mandrel and set the mandrel up on the bench center.
- Calculate the center point height of mandrel
 - Measure the mandrel outer diameter by the micrometer / A
 - Set the mandrel up on the bench center.
 - Measure the height of mandrel. / B
 - Calculate the center point height of mandrel. / H

$$H = B - (A/2)$$
- Assemble the gauge blocks to level the height as same as the center point (Note 1).
- Set the tester probe up on the top face of blocks and adjust the dial.
- Move the tester probe near the bottom of the hob cutting face and rotate the hob until the tester indicates "0". (Do not adjust)
- Move the probe to the tip side and read the dial.

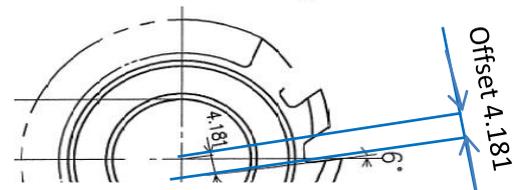
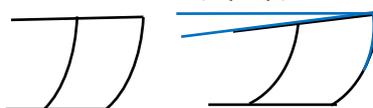


In case of the raked cutting face, adjust the block height as below
 Block height = Mandrel center point / H - Offset length

Negative rake
(Tip down)



Positive rake
(Tip up)



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