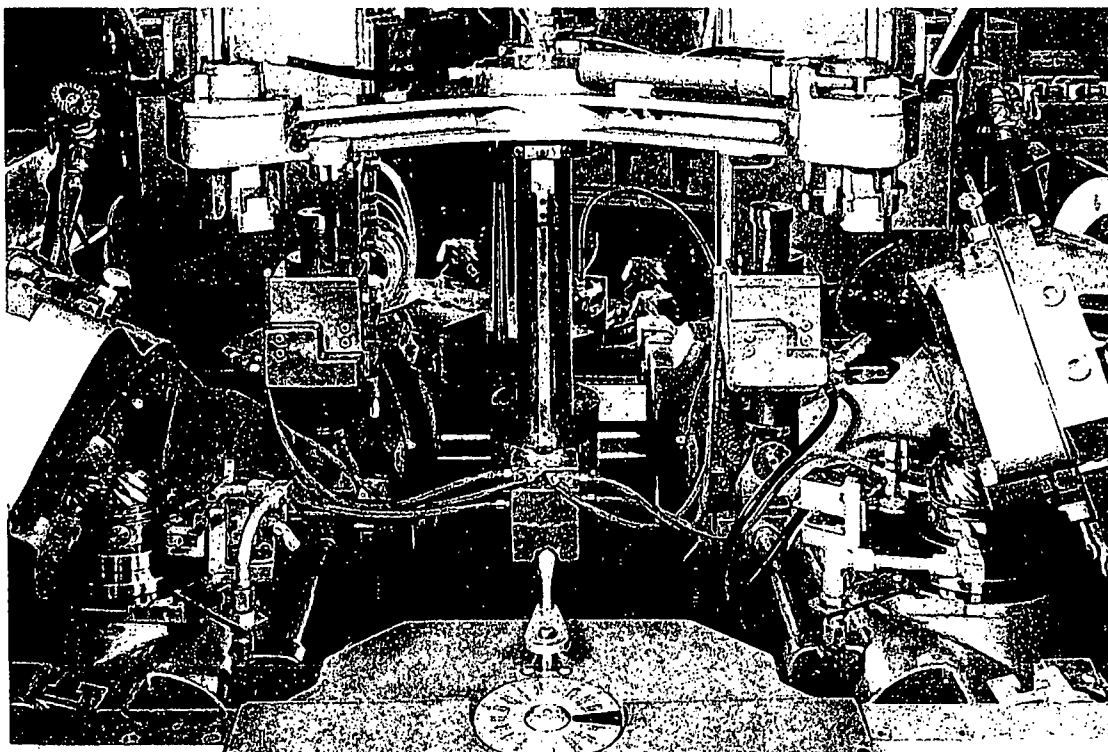




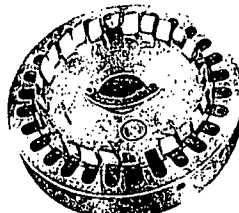
The Systems Concept

The Gleason systems concept of production and inspection can out-produce all previous methods of pinion manufacture, while setting new and higher standards of quality.

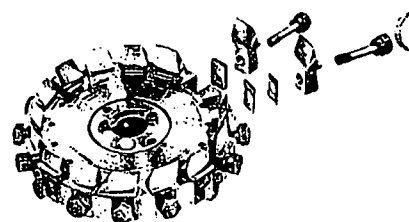
To obtain the full production advantages of the No. 950, the system includes new cutters, cutter inspection equipment, and soft testing equipment.

WEDG-AC roughing cutters employ a new wedge-type clamp block to hold the cutter blades securely in the blade slots and against the backing ring. No blade screws are required. WEDG-AC cutters have more blades for a given diameter; this makes possible faster machine cycles without increasing individual blade chip loads. And, the new wedge-type blade clamping results in stronger blades which are more rigidly secured in the head, which in turn increases cutter life.

TRIPLEX-type WEDG-AC cutters are used for the plunge-cut roughing operation. Alternate-blade WEDG-AC cutters are used for ratio control roughing.



WEDG-AC
ROUGHING CUTTER



HARDAC® II FINISHING CUTTER

The fast finish cutting rates of the No. 950 result from the use of high cutter speeds—up to 600 surface feet per minute. HARDAC II cutters have blades of high speed steel with high "red hardness" characteristics. This particular material withstands the elevated cutting temperatures which occur at high cutting speeds while maintaining excellent cutter life.

HARDAC II finishing cutter heads have one non-adjustable master blade slot, held accurately to a fixed radial dimension. Thus, exactly the same point diameter can be maintained on all cutters of the same specification. The heads also have a proof surface for checking axial runout.