

SERRATION AND GEAR TOOTH CUTTERS

Serration cutters are designed with parallel offset rows of teeth. Single milling slots on the work piece are not necessary anymore. Cutters with logarithmically relief grinding retain a constant profile form until the cutter is completely used up. The cutters are especially suitable for the interconnected gear tooth forming of mouth parts on surgical instruments.



STANDARD CUTTERS - HSS-E

- Dimensions: Outside diameter 63 mm
Diameter of bore 22 H7
- Clamping: Longitudinal slot
- Gearing: Helical toothed 14°, 24 flutes
- Form: Without bevel (Form A)
Flank angle 60°
- Type: Fine relief-turned



Form A
without bevel



Form B
with bevel, 35°



Form C
with bevel and
mirror face = 2xpitch length



Form D
with bevel and
mirror face = 2xpitch length

Pitch (mm)	Width of cutter (mm)															
	10	15	20	25	30	35	40	45	50	60	70	80	90	100	110	120
0,3	✓	✓	x	x	x	x	x	x	x	x	x	x	x	x	x	x
0,4	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	x	x	x	x	x	x
0,5	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
0,6	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
0,7	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
0,8	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
0,9	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
1,0	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
1,25	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
1,5	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
1,75	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
2,0	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

✓ Standard version. Please indicate pitch, form and width of the cutter when you place your order.

x Technical producibility is checked on request.

SPECIAL DESIGN

- Material: HSS-E / VHM
- Dimensions: Design according to feasibility and customer requirement
- Form: According to sample, drawing or work piece drawing
- Fixture: Bore or straight shank (also non-standard sizes)
- Clamping: Keyway or clamping flat
- Gearing: Straight toothed- or helical toothed
- Type: Fine relief-turned, ground or logarithmically relief-ground

