

Stork Gears & Services, with a high degree of expertise in the field of gearboxes and gear technology, is a specialist in the manufacture, repair and modification of gearboxes, gears and all related components for all brand names. In the **Gearing** department, Stork Gears & Services manufactures numerous types of gearing with qualitatively high precision and unprecedented short delivery times.

Gear grinding machines

Stork Gears & Services has invested in a new gear grinding lathe/machine in order to fulfil the market quality demands. This gear grinding lathe/ provides **qualitatively superlative** gears. The technical specifications are as follows:

Maximum grinding diameter	1600 mm
Maximum modulus/module	25
Maximum tooth width (straight gearing)	800 mm
Bed/table load	6000 kg



Profile corrections such as tip and root relief, high barreling, end relief and flank line barreling are programmed in and executed by means of a CNC control. A gear grinding quality is guaranteed up to Class 4 in accordance with the DIN standard 3962. It is also possible to allow this machine to measure the total gearing quality such as profile, flank line and normal pitch deviation and have it print out the accompanying measurement graphs.

We currently have also three grinding machines with the following capacities:

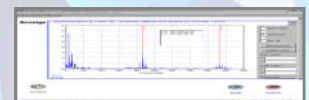


- * Niles 1500 maximum grinding diameter 1500 mm, modulus 24
- * Niles 630 maximum grinding diameter 630 mm, modulus 12
- * Höfler 1000 maximum grinding diameter 1000 mm, modulus 16

Gear hobbing machines

In mid-2004 a new gear hobbing machine will be deployed which provides quality superlative gears in very short time. Below the technical specifications:

- * Maximum hobbing diameter 1600 mm
- * Maximum module hob/ form gear cutter 22/28 mm
- * Hobbing quality according DIN 3962 Class 6
- * Maximum face width 1000 mm
- * Bed/table load 6.000 kg
- * Table range 1250 mm
- * Distance between centres 700-1700 mm



We currently use three gear hobbing machines that can manufacture gears with the following dimensions:

* Lorenz E16	maximum diameter Ø 2000 mm, modulus 16
* TOS or 16	maximum diameter Ø 1500 mm, modulus 24
* Lorenz F400	maximum diameter Ø 400 mm, modulus 4

We also have a large number of milling machines for machining spline gears, chain wheels, Klingelnberg (conical) wheels and worm transmissions.

In addition, the option also exists to grind gear hobs and cutters with special purpose-built grinding machines.

Measurement

An independent measurement of the gearing quality can also be carried out on two on-site measuring machines. The measurement quality can be specified from DIN 3962 Class 3 to Class 12 up to dimensions of Ø 1200 mm and a maximum weight of 1000 kg.

Gear cutters

For gearing by means of pitching, we have the following machines at our disposal:

* Lorenz Ls 1000	maximum internal diameter 1200 mm, modulus 10 maximum external diameter 1050 mm, modulus 10
* Lorenz Sj 7000	maximum internal/external diameter 1000 mm, modulus 10
* Lorenz Snj 5	maximum internal/external diameter 400 mm, modulus 4

Manufacturing and modification of numerous types of gearing takes place at a rapid pace, whereby quality of the product is the focal point. That way the client is able to use his gearbox, complete with new and/or modified gearing, in the shortest of times and suffering as less production loss as possible.

Below is a list of which gearing types Stork Gears & Services is able to manufacture:

- Internal and external cylindrically straight,
- Internal and external cylindrically bevelled,
- Double helical gearing
- Conical wheels, straight and bevelled/chamfered gearing
- Conical wheels, Klingelnberg gearing
- spline gearing internal and external
- worms and worm wheels
- screw gears
- chain wheels
- multiple key profiles

Correct gear meshing is created for better gear-to-gear contact by means of head and base/foot corrections as well as grinding an end relief onto the gearing. These actions are beneficial to the operational safety of the gearboxes.

Stork Gears & Services

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