

## MIRA SF

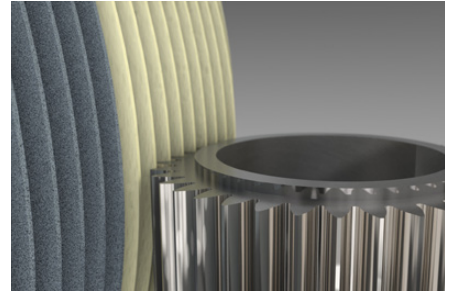
2-zone gear grinding wheels for continuous generating grinding and superfinishing of gears

# MIRA SF

The MIRA SF product line has been specifically developed for superfinishing (SF) gears during continuous generating grinding. The worm grinding wheel is designed as a 2-zone tool with a vitrified bonded zone and a resin bonded zone. The vitrified zone is used for pre-grinding and finish grinding, while the resin zone is used for superfinishing. This innovative tool design meets the high surface requirements of the automotive and transmission industries for polished surfaces on tooth flanks.

### Application

Grinding and superfinishing of a gear during continuous generating grinding with MIRA SF



### + Superfinishing of gear profiles:

Highest level of gear quality and surface finish achieved by superfinishing.

### + Vs 80 m/s:

The worm grinding wheels are approved for a cutting speed of up to  $V_s = 80$  m/s. The 2-part structure in the resin zone guarantees additional safety.



### + 2-zone worm grinding wheel:

Innovative resin bonded zone for superfinishing in combination with a vitrified zone. The dressing process is unchanged.

### + Wide variety of specifications:

Superfinishing can be combined with the Tyrolit product lines MIRA Ultra and MIRA ALPHA.

## Sample application

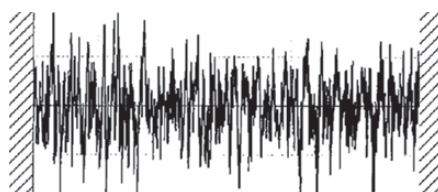
Sample application for continuous generating grinding with MIRA SF

### Worm grinding wheel:

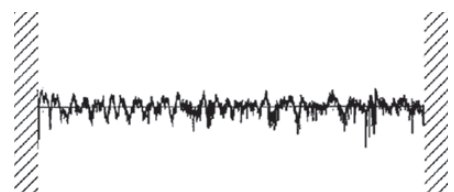
275x160x160 mm / 1-start

### Teeth:

Module 2.8 / pressure angle  $20^\circ$  / number of teeth 40 / tooth width 34 mm



Surface finish grinding  $R_a = 0.223$



Surface superfinishing  $R_a = 0.051$