



BG	1000S-T	2000S-T	2000S-C	3000S-C
Feed	Table		Column	
Distance between Centers (mm)	1,000	2,000	2,000	3,000
Center Height (mm)	280		400	
Workpiece Diameter (mm)	10 - 200		20 - 600	
Table Travel (mm)	1,690	2,600	3,000	4,000
Spindle Power (kW)	48			
Spindle Cone (mm)	HSK 63			
Grinding Wheel (mm)	400 x 100			
Swivel Angle	0°			

BG	1000H-T	2000H-T	2000H-C	3000H-C
Profile Grinding (helical)				
Swivel Angle	+/-120°			

All values are approximated and may change depending on selected options.
All information is subject to change.

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Broach Grinding



Grinding Applications
for a Global Market

E011508E-0

Experience the BG

The BG product line consists of machines designed for the manufacturing of flat and round broaching tools found mainly in the automotive and aerospace industries. The profile grinding machine of the BG series furthermore can handle a variety of grinding applications of rotationally symmetric parts.

Design and programming of the BG series is based on many years of manufacturing experience and knowledge of the tool industry. The BG series signifies not only a machine concept but also a complete technological package consisting of machine and competence in the tool manufacturing arena.



The smaller models feature a compact traveling table concept for the grinding of broaches up to 200 mm diameter. The larger models are based on a moving column design and display a very consistent machining concept even on very heavy work pieces. They are designed for broaches up to 600 mm diameter.

The stable design of the machine and the position of the dressing unit on the table guarantees a high level of accuracy and profile consistency. The machines are designed to grind circular broach tools or as a flexible machine for circular and helical broach tools. For the grinding of helically cut parts, the grinding spindle pivots in the helix angle.

With an (optional) measuring probe the tooth thickness and pitch for the profile grinding and the tooth pitch for the back taper can be measured.



Design Characteristics

- Wear-free linear motor (traveling table)
- Ball screw driven table with glass scale (moving table configuration)
- Direct drive in the workpiece axis
- Direct drive in the workpiece pivot axis
- Dressing spindle on the work table (as an option)

Machine Concept

- Traveling table design for tools up to 200 mm diameter
- Traveling column design for tools up to 600 mm diameter
- Optional swivel head for helical tools

Controls

- Siemens 840D Solution Line
- Comprehensive package of software for the grinding of broaching tools
- Easy to program through parameter input
- Additional software available to grind spline shafts, involute splines and Hirth serrations

Benefit Overview

- High-precision profile machine for tool industry
- Short retooling times between circular and flat form tools
- Variety of grinding applications of rotationally symmetric parts
- Easy to program through parameter input

