



Case Study Planetary Gear Cases

Customer Profile:

A Virginia-based machining and fabrication shop dedicated to supplying the heavy trucking industry with planetary gear cases.

The Challenge:

Speed the process of reverse machining of planetary gear cases while maintaining high tolerances through heavy interrupted cut.

The Obtuz Solutions:

A Torque Bar Activated Autofacer was used on a vertical CNC machining center at a rate of 275 SF/Min, .003 IPR. $\varnothing 3.638$ spot face holding a ± 0.002 perpendicularity between front and back faces and through hole. Heavy Interrupted Cut.

The Results:

The Autofacer Advantage eliminated a costly secondary broaching operation. The Autofacer machined the front and back faces in a single operation without indexing the part, successfully maintaining spot face and perpendicularity tolerances through the heavily interrupted cut.

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