



Shot peening, blasting and vibratory grinding

Vibratory grinding

Improves the superficial surface

Round chamfered

Deburred

Smoothed and Polished



The surface finish of the tooth profile of gears can be improved by **vibratory grinding** after shot peening, because the process is inducing no temperature. But material removal should not exceed 10 % of the compressive stress layer.

Vibratory grinding before shot peening, round chamfers the tip edges at the teeth of gears to prevent changes of the tooth profile grinding.



Metal spray coatings are mostly very hard, porous and rough.

Shot peening reduces the porosity in the metal spray layer and improves the surface finish. (see page 84)

Vibratory grinding after shot peening improves the surface finish far beyond it.



Shot peening and vibratory grinding completes each other or have the same purpose e.g. deburring, surface finishing, polishing, smouthening, round chamfering, surface structuring, decontaminating, descaling, cleaning, stripping and fettling but act in a different way.



Decontamination by washing and rinsing service



Cleansing apparatus, model S 80

This hole equipment enables us to clean a wide range of different parts in different sizes and materials up to a length of approximate 8000 mm and a diameter of approximate 350 mm.

All aquiferous parts of the cleansing apparatus is made of stainless materials. The cleansing liquor, including alkaline agents inhibiting corrosion, is heated up to approx. 70° C.

The cleansing apparatus is working full automatic but can also be handled manual.

The part rotates on „PU coated“ cylinders during the process of cleaning. At the same time the rinsing nozzles are moved horizontally under rigidly controlled conditions over the hole part surface.

To clean holes two special nozzles are set up opposite to each other and the cleansing liquor swirled tremendously and cleans such difficult areas.

Axial and cross drilled holes are handled and processed manually with special nozzles.

If necessary, the parts will be dried after the cleaning process by compressed air nozzles.



Control of decontamination by use of an endoscope

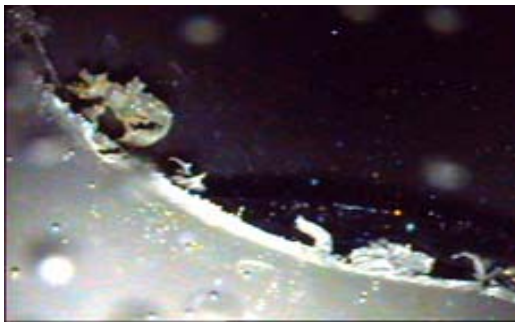


OLYMPUS IPLEX SA II Industry - Videoscope - System

To investigate and control inside surfaces of machined parts we use special video endoscopes.

With this systems we are able to investigate and control e.g.:

- drilled holes with a diameter of 3 mm Ø and a length of 1800 mm and
- drilled holes with a diameter of 6 mm Ø and a length of 3500 mm.



We are able to transmit immediately after the investigation by e-mail digital pictures of the inspected areas.



We are also able to transmit the recorded and coded data of the investigation live via world wide web.

We provide you with inspection and control service by use of an endoscope.