

Process Matrix	Processes	Dimensions								Machine list		
		Module		Width (mm)		Diameter (mm)		Length (mm)		Machines (quantity)		Machine brands
		From	To	From	To	From	To	From	To	CNC	Konv	
Cylindrical Gears	Hobbing	0,5	50	0	1.500	10	8.000			14	1	Gleason, Modul, Höfler, EMAG
	Internal gearcutting, disc-cutter	5,0	30	0	1.500	500	8.000			3		Gleason
	Internal gearcutting, shaping	1,0	8	0	130	25	600			1	2	Gleason, TOS
	External gear grinding, form grinding	1,0	16	0	500	30	800			2		Gleason
	External gear grinding, generating	0,5	7	0	300	10	330			1		Burri Reishauer
	Skiving	1,0	12			10	5.000			7		Gleason
	Power Skiving	0,5	5	0	100	25	700			4		DMG, Okuma, EMAG
Bevel Gears	Straight tooth	1,0	10			10	550			6		Klingelnberg, Modul Serwema
	Spiral bevel	1,0	7			10	540			2	2	Klingelnberg Palloid
Worms & wormwheels	Wormshafts cutting	1,0	10			10	250	30	500	2	1	Gleason
	Wormshafts skiving	1,0	8			10	250	30	500	2		Gleason
	Wormshafts grinding	1,0	10			10	250	30	500		2	Klingelnberg
	Worm wheel, hobbing	1,0	20			10	5.000			9	1	Gleason, Höfler
Splines & keyways	Broaching	0,5	3,0			10	150	5	100		2	Rausch, Stenhoj
	Key seating					B=3	B=50	5	400	1		Gierth
	Key slotting					B=5	B=20	5	250	1		Perini
Turning & milling	Turning / milling / drilling					8	800	10	1.000	24	1	Okuma, DMG, EMAG, Monforts, Haas
	Vertical turning / milling / drilling					300	5.000	10	1.000	5		Pietro Carnaghi, Honor, Sedin, Unisign
Grinding	External grinding					10	300	10	1.000	3	1	Studer, Kellenberger, Tachella, TOS
	Internal grinding					10	300	10	1.000	2		Emag, Studer
	Surface grinding					10	500	5	1.000		2	Jakobsen
Surface treatment	Case hardening					10	1.000	5	1.200	2		IVA
	Induction hardening					10	7.000	5	1.000	3		EMA
	Metalization					10	5.000	10	3.500		1	
Measuring	Gear measuring	0,5	40			10	5.000	1	600	5		Gleason, Zeiss Acura/Gaugemax, Römer, Hexagon
	3D-measuring					10	12.000	1	12.000	5		Zeiss, Römer, Tesa, Leica AT500, Hexagon-arm
	2D-measuring			0	1.250			1	6.000	1		Trimos