

## SPECIFICATIONS

Capacity for form rolling involute splines: PA DP Number of teeth Maximum rolling depth	30° Minimum 16/32 Maximum 6 through 96 0.100"
Capacity for finish rolling involute gears: Form Helix angle (helical gears) PA DP	Spur or helical No limit 14½° or greater 10 Maximum
Capacity for form rolling threads or worms	No specific limits*
General work capacities: Diameter	¼" to 3"
Face	2" Standard (Up to 4" available on special)
Overall work length	No specific limit**
Die carriage travel (each)	4" maximum
Work carriage travel	37/8" maximum
Distance, work-center-to-die-center	5½" minimum
Die OD range	9" to 11"
Work spindle speed	22.3 to 1200 RPM
Die spindle speed	6.7 to 30 RPM
Feed cam speed	0.06 to 18 RPM
Main drive motor	15-HP, 1800-RPM, 3-phase A-C
Floor space	Approximately 9½' x 9½'

\*Any thread or worm specification which can be incorporated in the dies can be rolled into the work, subject to the general limitations for spline and gear rolling.

\*\*Machine can accommodate any reasonable work length. Work spindle has a 2" center hole which permits long work (up to 2" in diameter) to be loaded from the rear, and the tail center can be re-located.

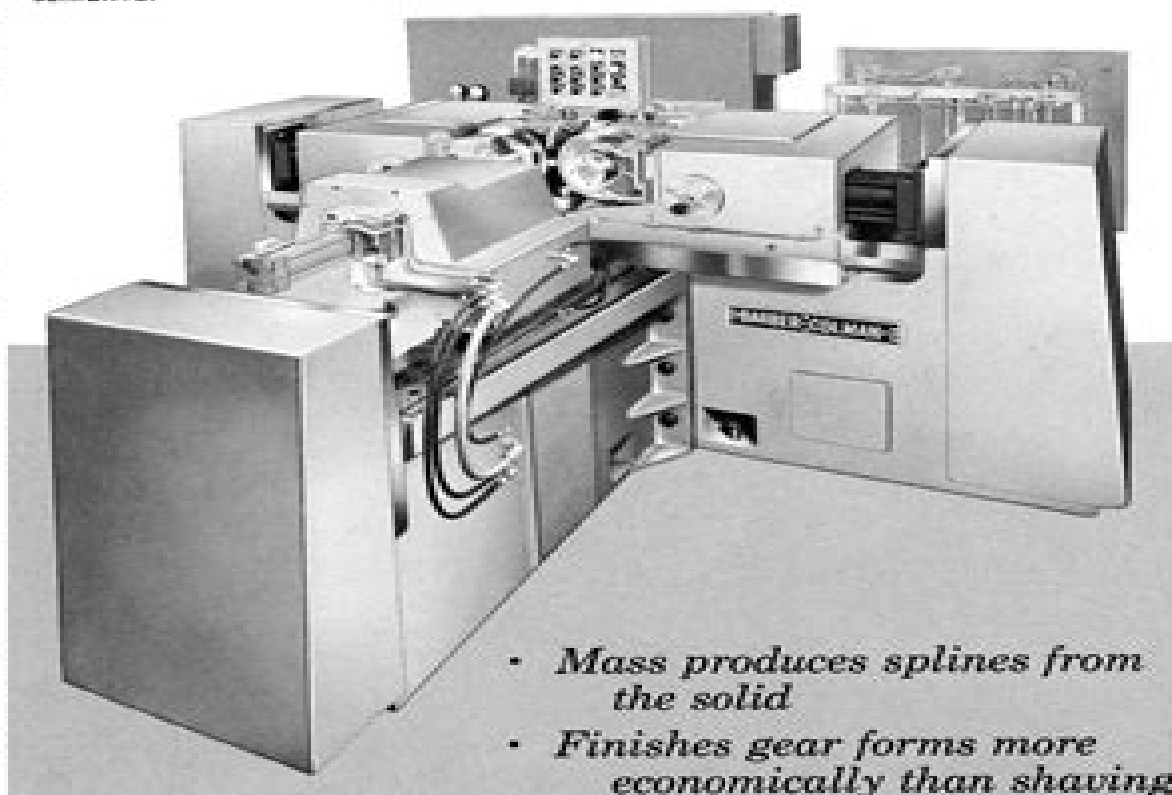
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A machine for rolling splines and spiral forms from the solid, and for finish rolling gears, No. 3-2 operates by means of two opposed hydraulic cylinders which drive rotating cylindrical dies into the workpiece under heavy pressure, imparting the desired form. Gradual infeeding is provided by a cam interposed between the two die spindle carriages which, for maximum flexibility, is independently controlled. The work blank may be driven in an indexed relationship to the die spindles. A unique oscillating motion has been provided whereby the piece is rolled alternately in both directions to produce more symmetrical teeth.

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- *Mass produces splines from the solid*
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# Barber Colman Series 15 Manual

**William Thomas Lowndes**



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