

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.

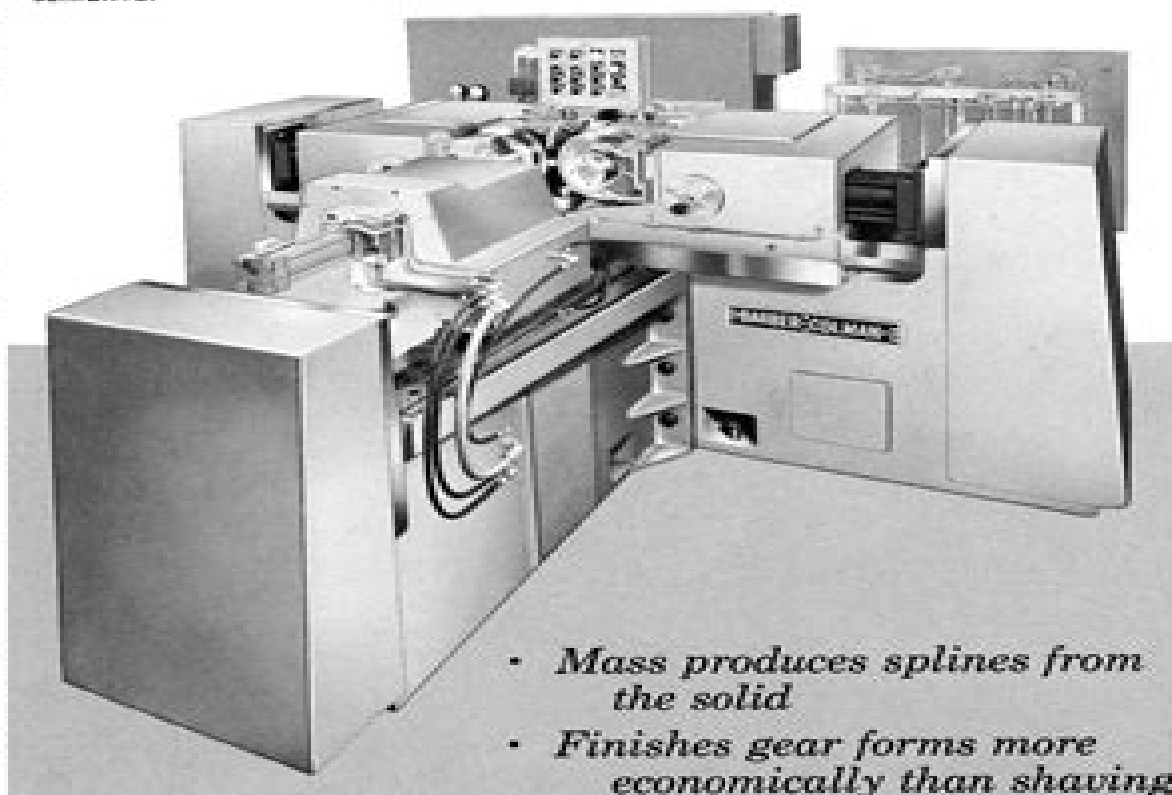
New . . . from Barber-Colman No. 3-2 Rolling Machine

All the benefits of rolling . . . speed, long tool life, stronger produced parts with finer finish and greater hardness, excellent part-to-part duplication, and, especially important, the accuracy which finish rolling can impart to hobbed gears . . . all these are provided in the new Barber-Colman No. 3-2 rolling machine.

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.

With the No. 3-2, the workpiece is held rock-steady on centers, not in bushings. And No. 3-2 is versatile. It can finish roll either spur or helical gear forms, and can roll either solid or hollow stock. Cycling is fully automatic; loading and unloading can be automated for any given part. Construction features include precision drive to die and work spindles, adjustable back-lash take-up, re-circulating way bearings, fully automatic lubrication, constant-load spindle braking which keeps out "slack" for greater accuracy.

For full details and help with your application, contact your Barber-Colman representative.



- Mass produces splines from the solid
- Finishes gear forms more economically than shaving

Barber Colman Mk Manual

Huangqi Zhang



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