

PRESRITE NEAR NET GEAR TECHNICAL REPORT

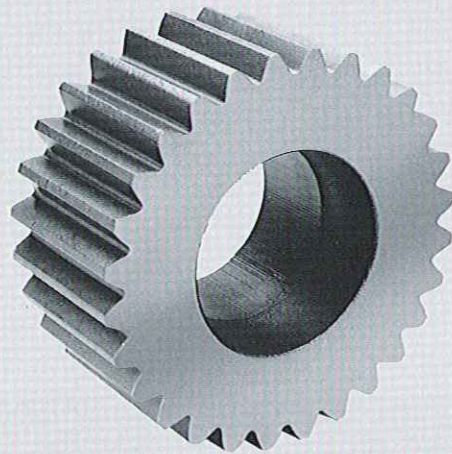
The 1-2SA near net gear is reducing costs for the gear manufacturer through the elimination of cutting equipment and processes.

Product Use:

The 1-2SA near net gear was developed for use on large, coarse-pitch gears (less than 5 D.P.) for improved utilization of raw material, the elimination of rough hobbing, and improved mechanical properties.

Features Include:

- Lower Tooling Cost
- Longer Tool Life
- Reduced Cycle Times
- Shorter Thru-Put Times
- Improved Mechanical Properties
- Less Heat Treat Distortion
- Higher Quality Finished Part



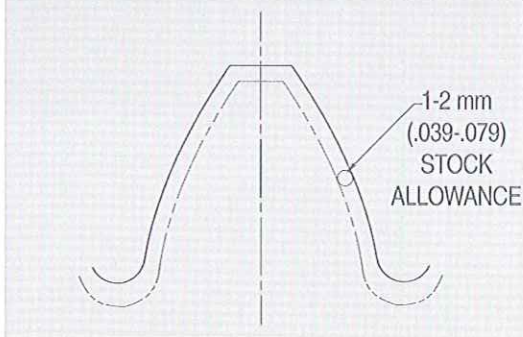
1-2 mm
(.039-.079)
STOCK
ALLOWANCE



Presrite Corporation

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Cleveland: 7105 Bessemer Avenue, Cleveland, OH 44127
Jefferson: 322 South Cucumber Street, Jefferson, OH 44047

NEAR NET GEAR SPECIFICATIONS



Process Capability

<i>Lead Error Per Inch</i>	<i>.08 mm/.003</i>
<i>Circ. Tooth Thickness</i>	<i>.2 mm/.008</i>
<i>Max. P.D. Runout</i>	<i>.2 mm/.008</i>
<i>Max. Involute Profile Variation</i>	<i>.16 mm/.006</i>
<i>Max. Index Variation (any two teeth)</i>	<i>.16 mm/.006</i>
<i>Over Pin Measurement</i>	<i>± 1.0 mm/.040</i>

Specification

<i>Max. Workpiece Diameter</i>	<i>356 mm/14 inches</i>
<i>Max. Face Width</i>	<i>203 mm/8 inches</i>
<i>Pitch Range</i>	<i>Less than 5 mod./5 D.P.</i>
<i>Helix Angle Max.</i>	<i>30° max.</i>
<i>Profile Tolerance Zone</i>	<i>1 mm ± .5/.039 ± .019</i>