

Title (en)

Method and apparatus forming a helical spline gear with a stopper on a rotary shaft.

Title (de)

Verfahren und Vorrichtung zum Formen einer Schrägverzahnung mit einem Anschlag auf einer umlaufenden Welle.

Title (fr)

Procédé et dispositif pour former une cannelure hélicoïdale avec butée sur un arbre rotatif.

Publication

**EP 0509734 B1 19950621 (EN)**

Application

**EP 92303284 A 19920413**

Priority

JP 11095191 A 19910415

Abstract (en)

[origin: EP0509734A1] In a method of forming a helical spline gear with a stopper on a shaft material, the large diameter portion of the shaft material is clamped between a pair of rolling tools each having on the outer cylindrical wall a plurality of helical teeth, and merging teeth which merge with every other helical teeth, and the rolling tools are driven to roll the shaft material under pressure, so that a plurality of helical grooves, and ahead of the helical grooves, communicating grooves communicated with every other helical grooves, and stopper portions remaining between the communicating grooves are formed on the large diameter portion in one rolling operation. With this method, the number of manufacturing steps can be reduced; that is, the rotary shaft can be formed readily and quickly. <IMAGE>

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