

Title (en)

METHOD AND DEVICE FOR PRODUCING A GEAR TOGETHER WITH A CLAMPING MEANS

Title (de)

VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG EINES ZAHNRADES NEBST SPANNMITTEL

Title (fr)

PROCÉDÉ ET DISPOSITIF DE PRODUCTION D'UNE ROUE DENTÉE AVEC UN MOYEN DE SERRAGE

Publication

**EP 3107670 A1 20161228 (DE)**

Application

**EP 15706215 A 20150220**

Priority

- DE 102014002219 A 20140221
- EP 2015053566 W 20150220

Abstract (en)

[origin: WO2015124708A1] The invention relates to a method for producing at least one gear, in particular a helically toothed gear, wherein the gear is produced from a gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) pressed and sintered with an oversize in the region of the set of teeth (18), wherein the gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) has two opposite end faces and a circumference. In the method, the gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) is clamped in a clamping means (42). The gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) is compressed in the region of the oversize by means of the engagement of at least one circumferential tool (10, 28) having a set of mating teeth (12, 26) that engages with the set of teeth (18) of the gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84), wherein the gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) is radially clamped over the circumference by the clamping means (42) at both end faces during the compression of the gear blank, wherein each individual tooth (56, 66) of the set of teeth (18) of the gear blank (20, 38, 50, 52, 62, 72, 80, 82, 84) is supported by the clamping means (42) substantially over the entire tooth height. In this way, the quality of the set of teeth can be improved. The invention further relates to a device and to a clamping means.

IPC 8 full level

**B21H 5/02** (2006.01)

CPC (source: CN EP US)

**B21H 5/022** (2013.01 - CN EP US); **B22F 5/08** (2013.01 - US); **B22F 5/085** (2013.01 - US)

Citation (search report)

See references of WO 2015124708A1

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

DOCDB simple family (publication)

**WO 2015124708 A1 20150827**; CN 106163694 A 20161123; CN 106163694 B 20180313; DE 102014002219 A1 20150827; DE 102014002219 B4 20151210; EP 3107670 A1 20161228; EP 3107670 B1 20200826; US 10363598 B2 20190730; US 2017072453 A1 20170316

DOCDB simple family (application)

**EP 2015053566 W 20150220**; CN 201580008970 A 20150220; DE 102014002219 A 20140221; EP 15706215 A 20150220; US 201515120234 A 20150220