

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.

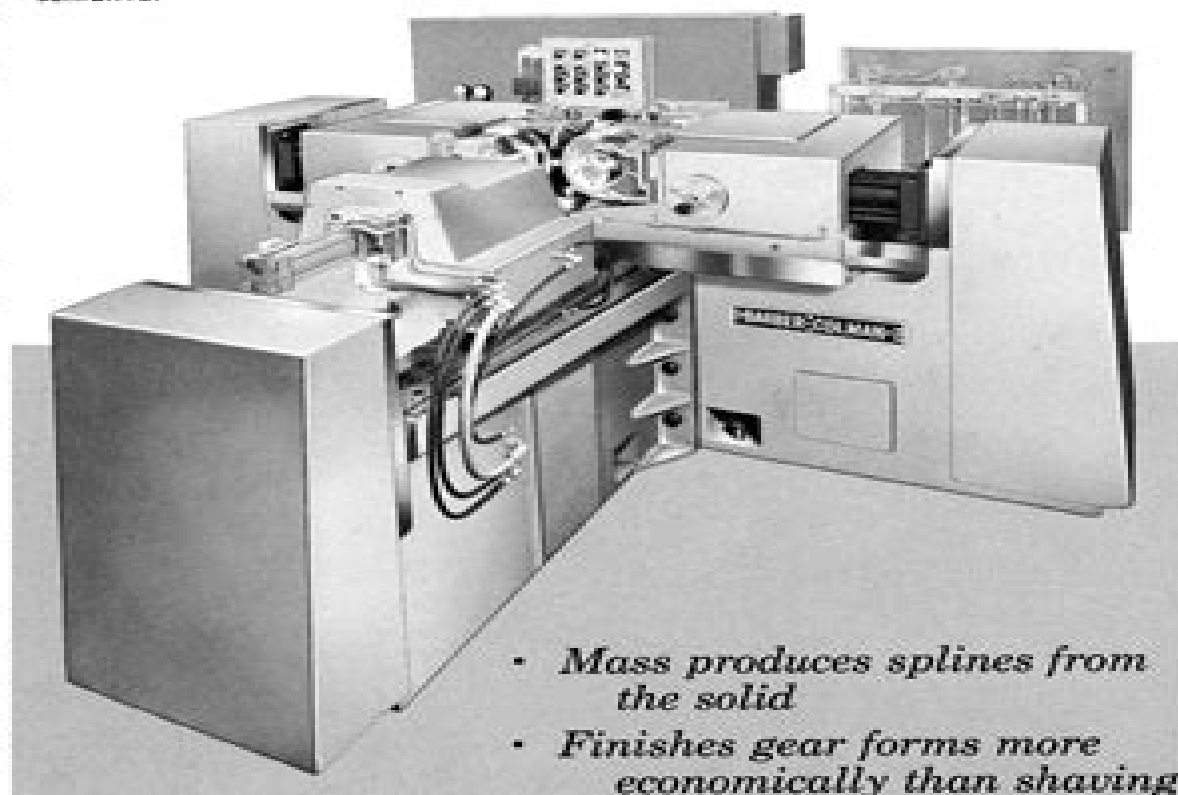
New . . . from Barber-Colman **No. 3-2 Rolling Machine**

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

AW Rasmussen



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Table of Contents Barber Colman Mk Manual

1. Understanding the eBook Barber Colman Mk Manual
 - The Rise of Digital Reading Barber Colman Mk Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Barber Colman Mk Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Barber Colman Mk Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Barber Colman Mk Manual
 - Personalized Recommendations
 - Barber Colman Mk Manual User Reviews and Ratings

- Barber Colman Mk Manual and Bestseller Lists
- 5. Accessing Barber Colman Mk Manual Free and Paid eBooks
 - Barber Colman Mk Manual Public Domain eBooks
 - Barber Colman Mk Manual eBook Subscription Services
 - Barber Colman Mk Manual Budget-Friendly Options
- 6. Navigating Barber Colman Mk Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Barber Colman Mk Manual Compatibility with Devices
 - Barber Colman Mk Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Barber Colman Mk Manual
 - Highlighting and Note-Taking Barber Colman Mk Manual
 - Interactive Elements Barber Colman Mk Manual
- 8. Staying Engaged with Barber Colman Mk Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Barber Colman Mk Manual
- 9. Balancing eBooks and Physical Books Barber Colman Mk Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Barber Colman Mk Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Barber Colman Mk Manual
 - Setting Reading Goals Barber Colman Mk Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Barber Colman Mk Manual
 - Fact-Checking eBook Content of Barber Colman Mk Manual
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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