

## SPECIFICATIONS

|                                                                                                     |                                                              |
|-----------------------------------------------------------------------------------------------------|--------------------------------------------------------------|
| Capacity for form rolling involute splines:<br>PA<br>DP<br>Number of teeth<br>Maximum rolling depth | 30° Minimum<br>16/32 Maximum<br>6 through 96<br>0.100"       |
| Capacity for finish rolling involute gears:<br>Form<br>Helix angle (helical gears)<br>PA<br>DP      | Spur or helical<br>No limit<br>14½° or greater<br>10 Maximum |
| Capacity for form rolling threads or worms                                                          | No specific limits*                                          |
| General work capacities:<br>Diameter                                                                | ¼" to 3"                                                     |
| Face                                                                                                | 2" Standard<br>(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,<br>3-phase A-C                              |
| Floor space                                                                                         | Approximately<br>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.

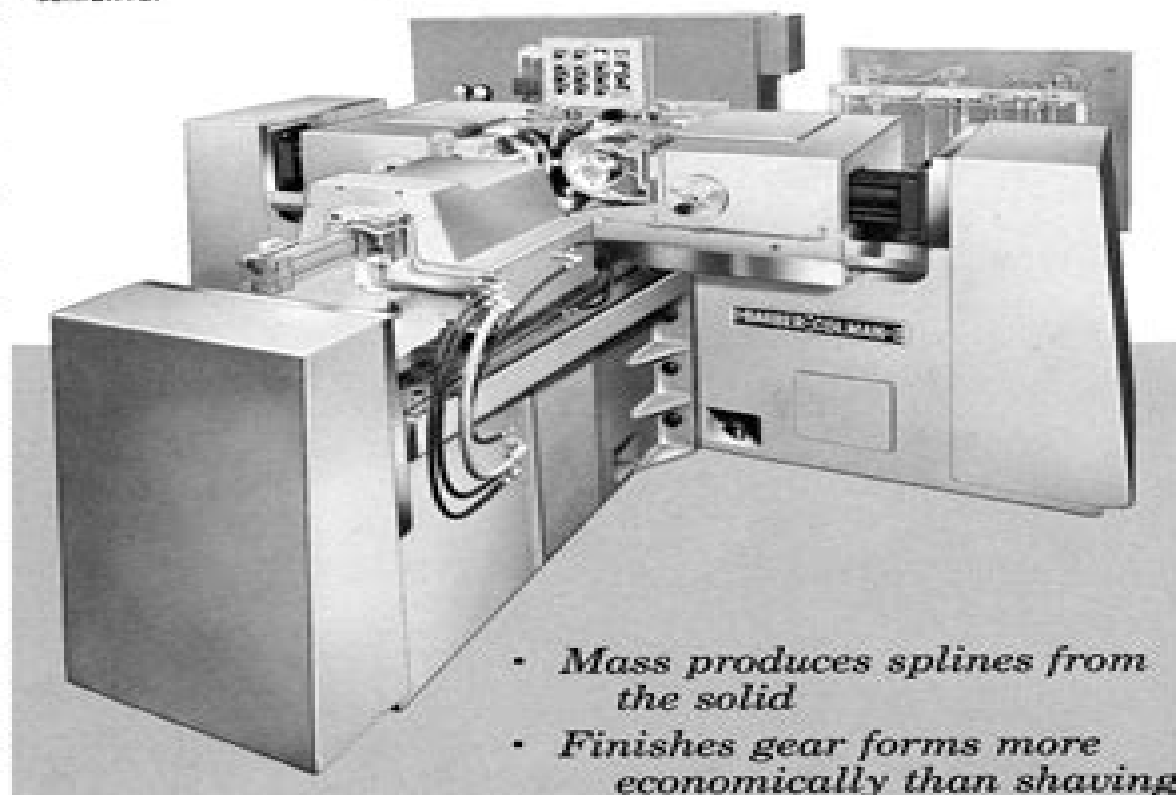
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All the benefits of rolling . . . speed, long tool life, stronger produced parts with finer finish and greater hardness, excellent part-to-part duplication, and, especially important, the accuracy which finish rolling can impart to hobbed gears . . . 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

**Michael Hoelscher**



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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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