

4th – Sem Lab Manual

(1) SPUR GEAR MILLING:

AIM:-

To machine a spur gear to the given module and number of teeth in the given workpiece.

TOOLS AND EQUIPMENTS REQUIRED :

Milling machine, Vernier caliper, Mandrel.

PROCEDURE :

1. Calculate the gear tooth proportions.

Blank diameter = $(Z + 2) m$

Tooth depth = $2.25 m$

Tooth width = $1.5708 m$

where,

Z = Number of teeth required

m = module

2. Indexing calculation
Index crank movement = $40 / Z$
3. The dividing head and the tail stock are bolted on the machine table. Their axis must be set parallel to the machine table.
4. The gear blank is held between the dividing head and tailstock using a mandrel. The mandrel is connected with the spindle of dividing head by a carrier and catch plate.
5. The cutter is mounted on the arbor. The cutter is centred accurately with the gear blank.
6. Set the speed and feed for machining.
7. For giving depth of cut, the table is raised till the periphery of the gear blank just touches the cutter.
8. The micrometer dial of vertical feed screw is set to zero in this position.
9. Then the table is raised further to give the required depth of cut.

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