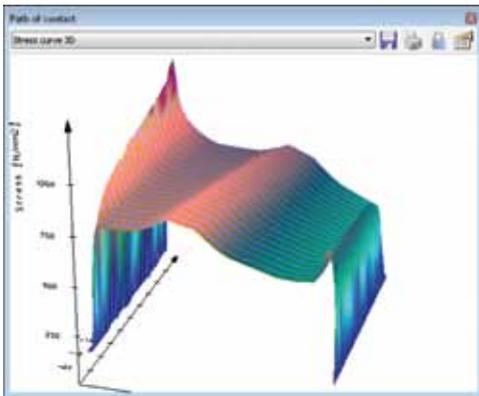
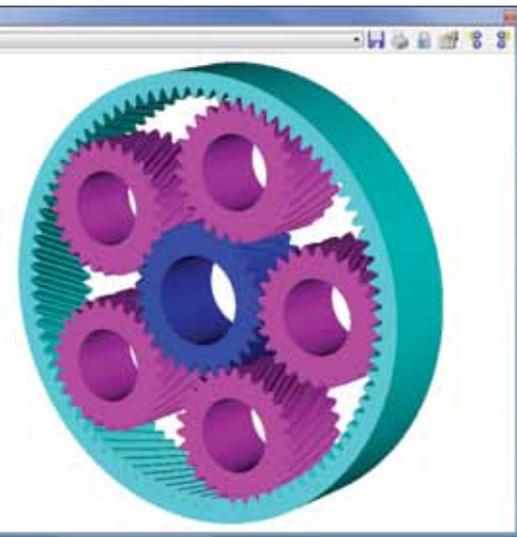


KISSsoft Update

INTEGRATES
PARASOLID
CAD CORE



The machine element package by KISSsoft for the design and optimization of components like gears, shafts, bearings and others is now available in the new version 04/2010. “There are currently two strong trends for the computer based calculation of machine elements like gears, shafts, bearings and so on: one is the combination of Finite Elements with the standardized methods, the other is the

tighter combination of the software tools in the machine design process by interfacing or even combining software for different tasks in this process,” says Dr. Stefan Beermann, vice president at KISSsoft. “In the current version of *KISSsoft* there is a CAD core (Parasolid) and a Finite Element library included, to take this fact into account. The standards defining calculation methods still remain their importance, but seem to be no longer sufficient for a competitive product design: the methods must be extended for practical application.”

Improvements to the software package include the integration of the parasolid CAD core into the software, so exact 3-D models are directly available for most gear types. Users can also utilize the generated model for load distribution analysis and stress and deformation analysis using FEA. The model can also be used for any kind of post-work such as local modification of the tooth surface for optimal load distribution and transmission error. Due to the STEP interface and the native parasolid format, these models can be exported to other software packages. For the most common 3-D CAD packages in machine design, however, the direct integration of KISSsoft into these packages provides fully parameterized models, according to the company’s press release.

A second section with major improvements is the tooth contact analysis for cylindrical gears. The stiffness model was extended to better take the load distribution in the width direction into account. For this purpose, the gear is split up into a number of slices. Each slice has a contact stiffness function assigned that is dependent on the meshing position, according to the model of Peterson. The single slices are then connected by springs with a stiffness value derived from the contact stiffness of the neighboring slices. Based on this model, the real contact between the flanks is

determined, considering deformation of the teeth, modifications, misalignment and manufacturing errors. As a consequence, the user gets graphs and numerical results for forces, stresses, transmission error, power loss and temperature—and for dry running plastic gears, even the wear on the flanks. The *KISSsoft* material database now incorporates material properties of 17 additional LNP specialty compounds from the SABIC Innovative Plastics portfolio for gear design. This data is now available for *KISSsoft* and includes temperature-dependent values for Young’s modulus, static bending strength as well as characteristic wear values at dry-run.

In the draft of the planned ISO/CD TR 6336-7, for the calculation of the lubrication gap and the analysis of the risk of micropitting, the calculation of the permissible lubricant film thickness IGFP was not covered. In the meantime, it was decided that the calculation will not be a part of the 6336-standard, but it will become the Technical Report ISO/TR 15144. According to the latest proposal for the Committee Draft, the ISO/CD TR 15144, the permissible lubricant film thickness is included. So, a reliable evaluation method of the safety against micropitting could be implemented in *KISSsoft*. With the AGMA 925, not only the determination of the permissible lubricant film thickness is possible, but also the probability of scuffing and wear can be calculated. Furthermore, the latest method for scuffing calculation, the ISO/TR 13989, is now available.

There are two more standards for cylindrical gears newly implemented: The AGMA 6011 for open gears and AGMA 6014 for speed increasers. For the configuration of steel worm with plastic gear, the guideline VDI 2736, the successor of the old VDI 2545 plastic gear guideline, contains a method calculating the worm gears root strength based on the shear stress

in the root. The new *KISSsoft* version implements the current state of this method. It should be noted, however, that this standard is still under development, and significant changes might still occur.

Another highlight of *KISSsoft 04/2010* is the possibility to determine the transmission error directly in the fine sizing. This allows the comparison of the different variants according to noise rating. Several standards were added regarding bevel gear calculation. The Klingelnberg standards have been implemented for spiral and hypoid gears with palloid method. Furthermore, the draft for ISO/TR 10300, with the calculation of hypoid gears, is implemented too. Parallel to the standards, a *KISSsys* functionality was developed in order to calculate the relative position of pinion and ring gear under load, considering the deflections of bearing and shafts.

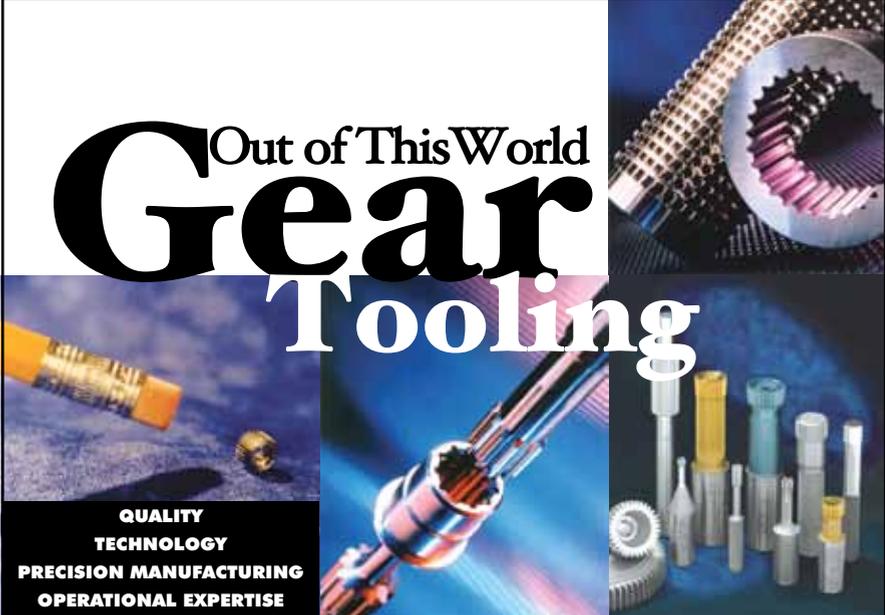
There are several more improvements in the software like the addition of splines according to DIN 5481 and DIN 5482, the extension of the calculation of interference fits to the plastic range, implementation of strength classes for bolts according to SAE J429, for bolts, nuts and washers according to ASME 18.2.1-1996, 18.2.2-1987 and B18.22.1-1965 (R1998), the calculation of the relaxation of garter springs, and the generation of 3-D shaft models in several CAD packages.

In *KISSsys*, the GPK Model used for sizing of one- to five-stage gearboxes is enlarged by some significant improvements. The main functionality is the automatic transfer of the relative position of gears, considering the shaft and bearing deflections. Together with the previously mentioned tooth contact analyses, the user is able to optimize and analyze the gear modifications under real conditions. Other functionalities are the import of housings and the collision check with the gear elements. In the field of the preci-

sion mechanics, the automatic shaft and bearing sizing is optimized, and proposals for smallest designs are calculated. The free test version of the new release *04/2010* is available for download at www.KISSsoft.com.

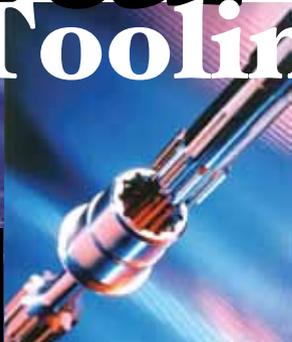
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Gerlach

URNS POWDERED METAL INTO PROFIT WITH TURNING CELLS

By using the new Eurotech-Famar Pronto 5 Turning Cells, as well as CNC lathes and various machining centers, Charles Gerlach, president of Gerlach Machine and Tool, located in St. Henry, Ohio, is turning powdered metal into profit. Gerlach does high-volume machining, plus bead blasting and honing of various powdered metal and cast aluminum parts. Their customers include major suppliers of automotive components such as timing sprockets, engine/drive line components and auto body parts. Gerlach frequently does the final machining on near-net-shape products for subsequent delivery to Tier One automotive vendors.

The purchase of two Eurotech-Famar Pronto 5 Turning Cells with a Siemens CNC control, drive and spindle package onboard each was necessitated by the unique machining characteristics inherent in powdered metal work. "We're machining very high quantities of powdered metal automotive components, which causes excessive tool wear and therefore requires constant offset adjustments," Gerlach says. "The Eurotech-Famar representative trained us on the set-up, programming and the time-saving features for our particular operation.

"The machines had been put into action almost immediately after delivery, to meet current customer production schedules, so we'd had less time than expected to test run the cells. What we learned was that the Siemens control package allowed us to add separate sets of electronic pushbuttons at the operators' worktables, each wired into the machine, to make offset changes by the



Eurotech-Famar CNC Pronto 5 Turning Cells features Siemens controls, drive and spindle package.

push of a button, rather than keying in the change on the control panel's offset page. Within the cutting program, each pushbutton controls a tool offset and is assigned a specific positive or negative numerical value," Gerlach says. "Then, each time a button is pushed by the operator while the machine is running, the offset assigned to that particular button will change by the given numerical value. This basic capability saves time and simplifies tool adjusting, which in turn increases our productivity substantially."

Additionally, Gerlach cites other benefits of the machines, including the capability of assigning offsets a maximum value the control will accept per adjustment, thereby preventing machine "crashes," which occur when an offset



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value is changed to an incorrect large number. He also notes the programming as an added upside of the machine control package, which features the Siemens Sinumerik 840D CNC, Simodrive 611D and spindle as original equipment on the Eurotech-Famar Pronto 5 Turning Cells. Axis and spindle motion are all

controlled by the Siemens CNC, with Gerlach storing all data/programs on the hard drive with floppy disk back-up.

For more information:

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The next-generation 150SPH Power Honing Machine from Gleason uses the latest patented Spheric Honing process to finish hardened spur and helical gears up to 150 mm in diameter in half the time required by existing machines.

continued



President Charlie Gerlach (right) and general manager Terry Fisher (left) assess a powder metal gear.

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The 150SPH is appropriate for production environments that require higher volume finishing of high precision gears with low noise characteristics, like those typically found in modern transmission applications. With a high-speed, direct-drive honing head, the 150SPH can hone

at speeds almost twice as fast. Gleason's patented Spheric Honing process uses a combination of Gleason software and Siemens 840D CNC to allow users to produce quieter gears faster by improving tooth geometry, reducing concentricity and indexing errors while optimizing



overall tooth flank contact characteristics.

The Spheric Honing process was first introduced by Gleason with the ZH 125 and ZH 250 honing machines. The process allows for tooth trace and crowning modifications generated by machine movements only, making change unnecessary to the dressing master when modifications are required or when changing over from one workpiece type to another. This reduces tooling costs and non-productive changeover time. When dressing is required, a patented process is used that can extend honing tool life by up to four times. The process also improves compressive stress in the surface of the tooth flanks to prevent early wear and extend gear durability and life.

Siemens 840D CNC combined with Gleason's Windows-based Intelligent Dialogue software makes setup and operation simpler. Other standard features include a fully integrated, high-speed automatic loading system that cuts workpiece changeover by up to 70 percent. Also the loading system was designed to make it easy to interface with a customer's existing factory automation systems.

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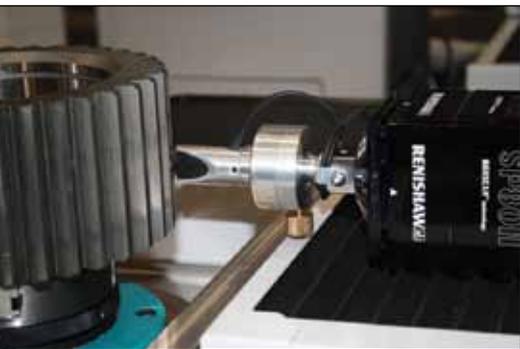
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Grind Burn Detection Capability Developed



The Wenzel WGT 500 gear measuring machine is equipped with Stresstech Rollscan R500 Barkhausen noise analyzer System integrated with a horizontally-mounted Renishaw SP80 probe.

Wenzel GmbH and Stresstech GmbH have developed a gear measuring machine feature that detects the presence of grind burn or pits on gears. The sensor technology applied uses the Magnetic Barkhausen Noise Method, which is based on inductively detecting a noise-like signal generated when a magnetic field is applied to a ferromagnetic material. Barkhausen Noise can be used to analyze the micro-structure of a material's surface in terms of hardness and its microstructural condition.

The Stresstech Rollscan R300 is the digital Barkhausen noise analyzer system being applied to Wenzel GearTec machines. It includes the instrument, sensor and software. The sensor has been integrated into the probe plate of the Wenzel InovaGear, WGT series and LH Gear CMM bridge style machines. The Barkhausen probe can be stored in the integrated change rack. The software is also integrated into the GearTec controller.

“Because gear measuring machines

utilize very sophisticated programming software to inspect all geometrical features of gears and gear teeth, it's logical that a sensor adapted to the same measuring arm, making many of the same inspection movements, should be able to inspect for grind burn and pits that can occur on the flanks of ground gear teeth,” says

Chris Pomm, Wenzel technical director. “Typically chemical acid baths and optical methods are used to check for grind burn. With our new method, grind burn on gear flanks can be analyzed at the same time inspection occurs, eliminating the need for additional processing.”

continued



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Northfield Precision

RELEASES THE MODEL 1000 PITCH LINE CHUCK



Northfield Precision Instrument Corp., a designer and manufacturer of precision workholding chucks, introduces its Model 1000 10 inch diameter Pitch Line chuck. This chuck grips the outside diameter of 9 inch diameter helical gears. The pins are mounted in a loose-fitting housing so they can float. They pick up the pitch diameter and the jaws grip the outside diameter of the pins. The pitch is measured over pins, so it is gripping the same way it measures.

The Model 1000 has two "pin cages," one for a left-hand helix and one for a right-hand helix. The pin cages are changed out by removing three mounting screws. Northfield Precision designs and manufactures air chucks for any lathe, boring machine, grinder or VMC. Models include through-hole, high-speed and quick-change and are available in SAE or metric, in sizes from 3 inches (76 mm) to 18 inches (457 mm). Accuracies of 0.001 inches (0.0254 mm) to 0.0001 inches (0.000254 mm) guaranteed. Custom workholding chucks and jaws are available, and free engineering assistance is offered.

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Ondrives

LAUNCHES CROSSED HELICAL GEARS



A precision range of crossed helical gears was released from Ondrives Ltd. These 45 degree crossed helical gears have already been specially manufactured to several customers' specifications for the standard range. "We believe this is because we make all our precision gears in-house, and ultimately, this gives us complete control over the finished quality of the parts as well as enabling us to offer quick turnarounds to meet customer's just-in-time requirements where needed," says Amanda Laughton, marketing manager for Ondrives.

This range of helical gears is available as standard from sizes 0.5 module to 3.0 module, and a right-hand helix runs with another right-hand helix. They are manufactured to 7e25 DIN 58405 (AGMA Q10) with other quality grades available on request.

Standard materials are 817M40T (28 HRC) steel and 805M20 (58 HRC) case hardened steel. Tapped holes, pin holes, different bore sizes, different numbers of teeth and keyways are all available to quote on request. Discounts are available for quantity purchases.

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with the correct adaptors and diamond dressing wheels. The machine is also capable of processing threaded wheels with multiple starts for the latest generation of threaded wheel grinders using the electronic control the machine is equipped with.

In the past, gear companies that were processing threaded wheels with an AM10 dresser were restricted to one or possibly two starts on the grinding wheel. This dramatically restricted how the gear could be processed and the time it took to grind it. Operators also needed to manually run the AM10 dresser, which tied them up for the time this took, according to a press release issued by JRM International, the machine's North American distributor.

The PM280T can profile up to nine starts depending on the size of the wheel and the diametral pitch, with an unattended machine. Once the program is generated in the machine control in a few minutes, the operator starts the cycle and can leave. The machine runs automatically, and after 10 to 12 minutes, for a one start wheel, it shuts itself off at the end of the cycle.

For more information:

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SAV North America introduced a line of magnetic chucks that deliver heavy duty holding for accurately cutting parts. The Radial Pole High Power Electro-Permanent Chucks hold parts while allowing full access in a single set-up, to reduce labor costs and increase throughput of finished work.

The chucks are engineered with heavy-duty holding force of 245 pounds per square inch. The surface area of the chucks allows for hard turning without sacrificing speed and feed capabilities of machine tools. Part size is unrestricted, and those with limited surface areas can be held securely, reducing the chance of slippage, inferior cuts and wasted materials.

The solid body construction allows for high balance and stability of a workpiece, which provides flexible mounting options. Top tooling raises workpieces to be turned or cut, so they are more accessible with quick changeovers. A separate top plate is fully sealed for preventing short-circuiting that could occur with coolant leaks. Custom mechatronic part centering is an option for error-free workpiece placing.

These chucks have a greater clamping force than other magnets due to electro-permanent magnet technology. A programmable release cycle is activated to fully demagnetize the chuck and release workpieces. The chucks operate on standard North American voltages.

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Emuge

EXPANDS SOLID CARBIDE THREAD MILLS

An expanded line of Solid Carbide Thread Mills was introduced to Emuge Corp.'s Threads-All program. The new thread mills require minimal tooling and adapt quickly to a range of threading requirements to machine with high thread quality and tool life.

The thread mills require eight standard tool sizes, numbers 10-1/4-5/16-3/8-7/16-1/2-5/8-3/4, so it is possible to make over 100 commonly produced screw thread designations, including UNC-UNF-STI UNC-STI UNF-UNEF-UNS-UNJC-UNJF-M-

MJ. The tools also provide total control over pitch diameter limits, including 2B, 3B, 3BG and all oversize variants.

The Threads-All program is designed for difficult-to-cut materials, up to 58Rc—including stainless steels, titanium and Inconel—that are often used in demanding industries, such as aerospace, defense and medical.

The Threads-All program also includes miniature tools in 10 sizes from 0 to STI 8. "Emuge recognizes the need to continually deliver new tooling solutions to help manufacturers cut costs, improve delivery times and produce world-class products," says Mark Hatch, thread milling manager at Emuge. "With the new Threads-All program, we offer manufacturers a high quality threading solution, which maximizes profitability and minimizes tool inventories."



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