



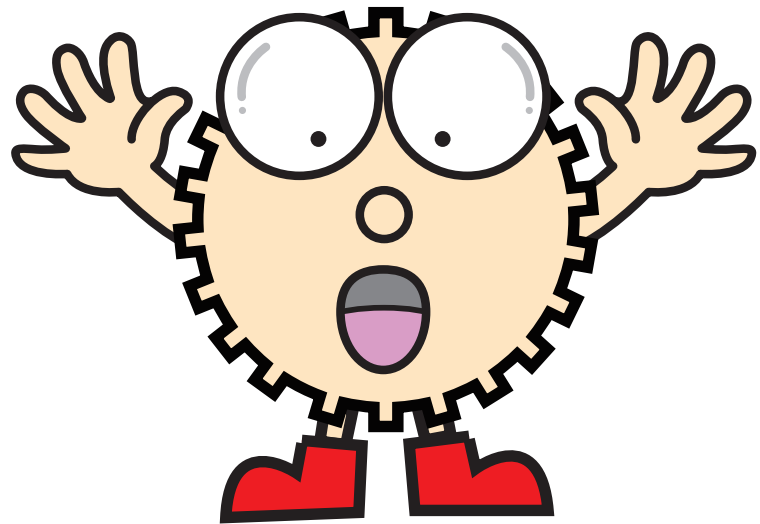


Screw Gears

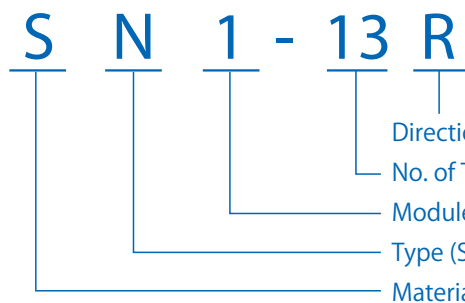
SN Screw Gears	SUN Stainless Steel Screw Gears	AN Screw Gears	PN Plastic Screw Gears
 Precision: N9 Material: S45C m1 ~ 4 Page 344	 Precision: N9 Material: SUS303 m1 ~ 3 Page 348	 Precision: N9 Material: CAC702 (A1BC2) m1 ~ 3 Page 350	 Precision: N9 Material: MC901 m1 ~ 3 Page 352



Catalog Number of KHK Stock Gears

The Catalog Number for KHK stock gears is based on the simple formula listed below. Please order KHK gears by specifying the Catalog Numbers.

(Example) Screw Gears



Material

S	S45C
SU	Stainless Steel
A	CAC702
P	MC901

Type

N	Screw Gears
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Spur Gears

Helical Gears

Internal Gears

Racks

CP Racks & Pinions

Miter Gears

Bevel Gears

Screw Gears

Worm Gear Pairs

Bevel Gearboxes

Other Products

Features

KHK stock screw gears come in four materials, S45C, SUS303, CAC702 (old JIS A4BC2) and MC nylon, in modules 1~4 and numbers of teeth from 10 to 30.

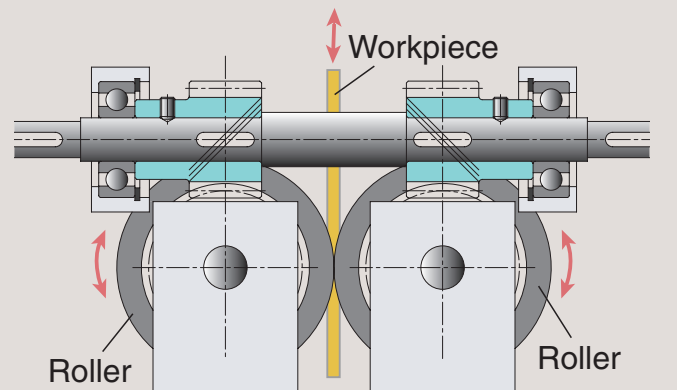
Catalog Number	Module	Material	Heat Treatment	Tooth Surface Finish	Precision JIS B 1702-1:1998	Secondary Operations	Features
SN	1 to 4	S45C	—	Cut	N9	○	Popular screw gears. Additionally, gear tooth induction hardening secondary operations can be performed. J Series products are also available.
SUN	1 to 3	SUS303	—	Cut	N9	○	Suitable for food machinery due to SUS303's rust-resistant qualities.
AN	1 to 4	CAC702 (A4BC2)	—	Cut	N9	○	Aluminum bronze made products have excellent wear resistance.
PN	1 to 3	MC901	—	Cut	N9	○	Light-weight products made of MC Nylon can be used without lubrication.

○ Possible △ Partly possible × Not possible

Application Examples

KHK stock screw gears are used in various labor-saving machines including feeding devices.

■ Design example of feeding device (not a design for machinery or a device in actual use)



Rotate the rollers in reverse with one input shaft and move the pinched workpiece vertically

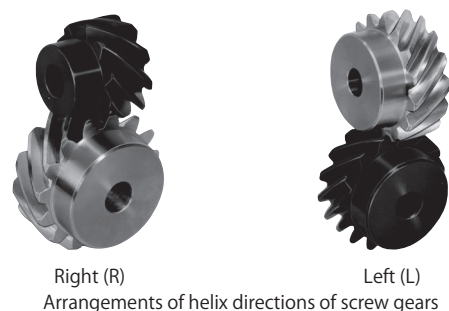
Selection Hints

Please select the most suitable products by carefully considering the characteristics of items and contents of the product tables. Since screw gears come in right- or left-hand helix, make sure to include the letter "R" or "L" in the catalog number when you order.

1. Caution in Selecting the Mating Gears

Screw gears are used for offset shafts. Whether the shafts are paralleled offset or skewed offset depends on the helix directions of the mating gears.

Direction of shaft	Arrangement of helix hands
Skewed Axes	RH-RH or LH-LH
Parallel Axes	RH-LH



2. Caution in Selecting Gears Based on Gear Strength

The allowable surface strengths listed in the product pages were derived using the Niemann formula as reference values. (Used with skewed axes)

There is a paucity of data on the strength of screw gears. The values of constant K_0 used in the calculations, which depend on the material of the mating gears, are our estimates. The mathematic expression below shows the Niemann formula to determine allowable tangential force F_t (kgf) and allowable torque T (kgf·m) on a basic circle.

$$F_t = 1.43 d_1^2 f_z K_s$$

$$T = \frac{F_t d_1}{2000}$$

Here, d_1 : standard pitch diameter of pinion (mm)

f_z : coefficient based on no. of teeth combination

K_s : coefficient based on materials and sliding speed

$$K_s = K_0 \frac{2}{2 + V_s}$$

Here, K_0 : coefficient based on material selection

V_s : sliding speed (m/s)

$$V_s = \frac{\pi n d_1}{60000 \cos \beta}$$

Here, n : rotational speed (rpm)

β : helix angle (45°)

■ f_z value

$Z_2 \backslash Z_1$	10	13	15	20	26	30
10	1.538					
13	2.005	1.538				
15	2.279	1.786	1.538			
20	2.963	2.329	2.053	1.538		
26	3.695	2.963	2.588	2.005	1.538	
30	4.161	3.350	2.963	2.279	1.786	1.538

■ Setting values depending on usage conditions

Catalog Number	Mating gear	K_0 value	Maximum allowable sliding speed m/s	No. of teeth of mating gears	Rotational Speed
SN	SN	0.0030	2.5	Same no. of teeth	100 rpm
SUN	SN	0.0030 Note 1	2.5 Note 1		
AN	SN	0.0050	5		
PN	SN	0.0030 Note 1 (0.0021)	2.5 Note 1 (1.0)		

[NOTE 1] K_0 values and the maximum allowable sliding speed of SUN & PN products are set by KHK. Screw gears are basically used with lubrication. When using PN products without lubrication, the parenthetical values shown in the table are applied.

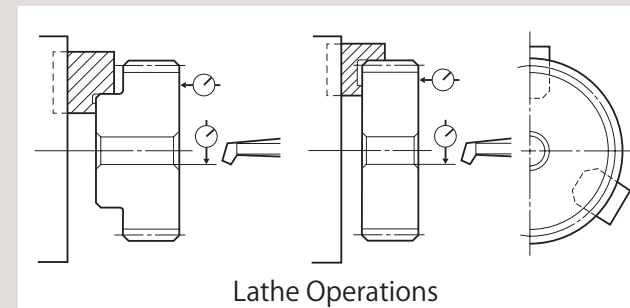
Application Hints

In order to use KHK stock screw gears safely, read the Application Hints carefully before proceeding.

Please refer to Page 26 for "Cautions on Handling" and Page 27 for "Cautions on Starting".

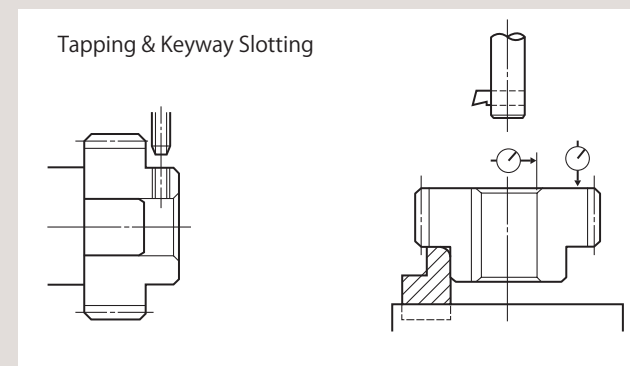
1. Cautions on Performing Secondary Operations

- ① If re boring, it is important to pay special attention to locating the center in order to avoid runout.
- ② The reference datum for gear cutting is the bore. Therefore, use the bore for locating the center. If it is too difficult to do for small bores, the alternative is to use one spot on the bore and the runout of the side surface.
- ③ If reworking using scroll chucks, we recommend the use of new or re bored jaws for improved precision. Please exercise caution not to crush the teeth by applying too much pressure. Any scarring will cause noise during operation.



- ④ The maximum bore size is dictated by the requirement that the strength of the hub is to be higher than that of the gear teeth. The maximum bore size should be 60% to 70% of the hub diameter (or tooth root diameter), and 50% to 60% for keyway applied modifications.

- ⑤ In order to avoid stress concentration, round the keyway corners.



2. Points of Caution during Assembly

- ① KHK stock screw gears are designed to give the proper normal direction backlash when assembled using the center distance given by the formula below with a tolerance of H7 to H8. The amount of backlash is given in the product table for each gear.

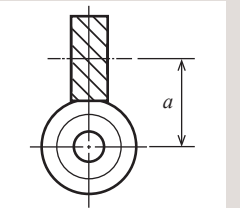
$$a = \frac{d_1 + d_2}{2}$$

Where

a : Center distance

d_1 : Pitch diameter of pinion

d_2 : Pitch diameter of gear



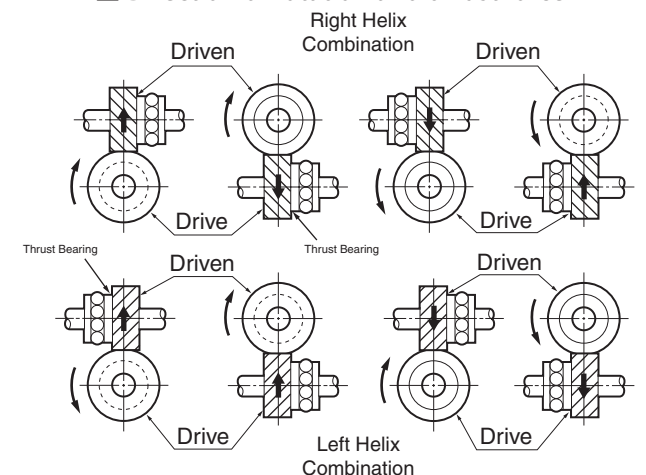
- ② Total Length Tolerance for Screw Gears

Total Length (mm)	Tolerance
30 or less	0 - 0.10
31 to 100	0 - 0.15

[NOTE] PN Plastic Screw Gears are excluded.

- ③ Due to the helix of screw gears, they produce axial thrust forces. The bearings must be selected properly to be able to handle these thrust forces. The directions of thrust change with the direction of helix and the direction of rotation as illustrated below.

■ Direction of rotation and thrust force



[NOTE] For parallel shaft applications, see the Application Hints for KHK Helical Gears (Page 167).

KHK considers safety a priority in the use of our products.

When handling, adding secondary operations, assembling, and operating KHK products, please be aware of the following issues in order to prevent accidents.



Warning: Precautions for preventing physical and property damage

1. When using KHK products, follow relevant safety regulations (Occupational Safety and Health Regulations, etc.).
2. Pay attention to the following items when installing, removing, or performing maintenance and inspection of the product.
 - ① Turn off the power switch.
 - ② Do not reach or crawl under the product.
 - ③ Wear appropriate clothing and protective equipment for the work.



Caution Cautions in Preventing Accidents

1. Before using a KHK product, read the precautions in the catalog carefully in order to use it correctly.
2. Avoid use in environments that may adversely affect the product.
3. Our products are manufactured under a superior quality control system based on the ISO9000 quality management system; if you notice any malfunctions upon purchasing a product, please contact the supplier.