

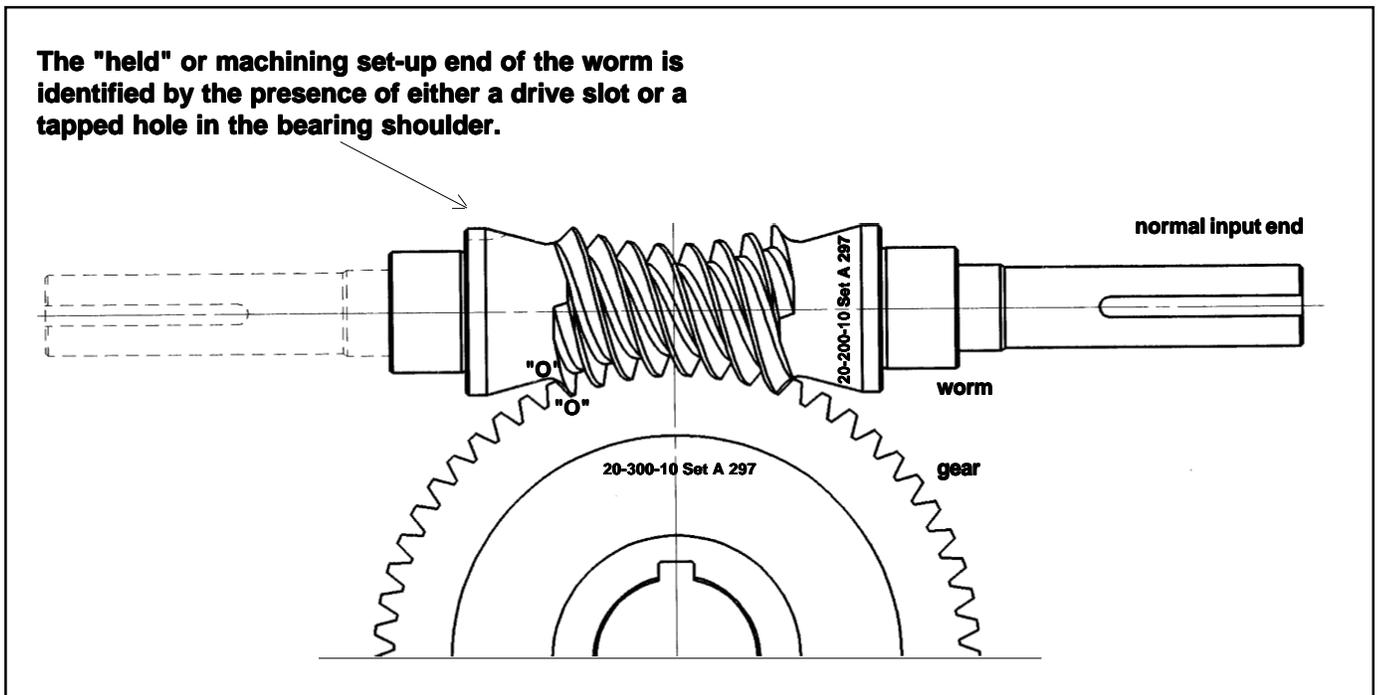
Matching Relationships & 'O' Markings

Cone Drive gear sets have one, and sometimes two, matching relationships which must be considered during assembly. The purpose of these matching relationships is to indicate the relative positioning of the worm and the gear in a checking and matching fixture which is used at the conclusion of the manufacturing process. Repeating the matched and checked orientation during assembly will assure optimum gear set performance.

One matching relationship is the gear side orientation relative to the worm shaft. This matching relationship applies to all Cone Drive gear sets and is indicated by the side of the gear which bears the stamped part numbers. This stamped side of the gear must be

positioned relative to the worm (as shown below). That is, with the worm on top of the gear and the 'held' or machining setup end of the worm to the left, and the part numbers of the worm to the right toward the normal input end, the stamped side of the gear will be facing you.

A second relationship, 'O' markings, appears on some, but not all gear sets with multiple threaded worms. In the past, all Cone Drive multiple threaded worms had 'O' markings, but today, due to new manufacturing processes, 'O' markings are not always used. When 'O' markings are present, care should be taken during assembly to ensure that the 'O' marks are properly aligned. As indicated in the sketch below, when properly aligned, the 'O' stamped worm thread will pass through the 'O' stamped space between two gear teeth.



TEXTRON

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