

# CONTENTS

## CHAPTER 1 *page 1*

### **NOMENCLATURE, NOTATION AND CONVENTIONS**

#### TYPES OF GEAR

- 1.1 Spur Gears
- 1.2 Helical Gears
- 1.3 Double-Helical Gears
- 1.4 Crossed Helical Gears
- 1.5 Conical Involute Gears
- 1.6 Bevel Gears
- 1.7 Spiral Bevel Gears
- 1.8 Hypoid Gears
- 1.9 Worm Gears

#### NOMENCLATURE

- 1.10 Pitch: Pitch Circles
- 1.11 Pitch Line
- 1.12 Pitch Cylinders: Pitch Cones
- 1.13 Tooth Profile Elements
- 1.14 Lengthwise Tooth Elements
- 1.15 Planes and Angles
- 1.16 Transverse, Normal and Axial Pitch
- 1.17 Involute Base Dimensions
- 1.18 Reference, Basic, Nominal, Design and Standard Dimensions
- 1.19 Other Terminology

#### NOTATION

- 1.20 General
- 1.21 Principles of the Present System
- 1.22 Directions, Linear
- 1.23 Directions, Angular
- 1.24 Shaft and Helix Angles

## CHAPTER 2 *page 23*

### **PRINCIPLES OF TOOTH ENGAGEMENT**

- 2.1 Angular Velocity Ratio

#### CONTACT IN A PLANE

- 2.2 Kinematic Pitch Circles
- 2.3 Circular Pitch and Tooth Thickness
- 2.4 The Common Normal
- 2.5 Pressure Angle
- 2.6 Cycle of Contact: Path of Contact

- 2.7 Relationship of Path of Contact to Tooth Profile
- 2.8 Conjugate Profiles
- 2.9 Progressive and Retrogressive Contact
- 2.10 Corner or Edge Contact
- 2.11 Concurrent Contact
- 2.12 Interference and Undercutting
- 2.13 Counterpart Racks
- 2.14 Inter mating Series
- 2.15 Straight-sided Rack: Involute Teeth
- 2.16 Profile Shift (or Addendum Modification, or Correction) of Involute Gears
- 2.17 Involute Tooth Action at "Extended Centres"

#### CYLINDRICAL PITCH SURFACES

- 2.18 Kinematic Pitch Surfaces of Spur Gears
- 2.19 Tooth Spirals
- 2.20 Crossed Pitch Cylinders
- 2.21 The Normal Imaginary Rack
- 2.22 Contact between Helical Tooth and Rack
- 2.23 Involute Helicoid
- 2.24 Zone of Contact
- 2.25 The Common Normal: General Case
- 2.26 Contact in the Normal Plane
- 2.27 Contact of Crossed Helical Gears
- 2.28 Conical Involute Gears

#### CONICAL AND OTHER PITCH SURFACES

- 2.29 Pitch Surfaces of Straight Bevel Gears
- 2.30 Common Pitch Plane and Tooth Spirals of Spiral Bevel Gears
- 2.31 The Common Normal of Bevel Gears
- 2.32 The Imaginary Crown Wheel
- 2.33 Cylindrical-gear Basis of Worm Gear Action
- 2.34 Hyperboloidal and Hypoid Gears

## CHAPTER 3 *page 35*

### **PRINCIPLES OF GEAR-TOOTH GENERATION**

- 3.1 Process Categories
- 3.2 Generation from a Rack: Spur Gears
- 3.3 Helical Gear Planing
- 3.4 Generation-grinding

- 3.5 Worm Grinding
- 3.6 Gear-shaper Processes
- 3.7 Hobbing: Spur and Helical Gears
- 3.8 Hobbing: Wormwheels
- 3.9 Generation of Straight Bevel Gears
- 3.10 Generation of Spiral Bevel and Hypoid Gears
- 3.11 Gear Shaving: Honing: Lapping
- 3.12 Generating-cutter Forms
- 3.13 Tooth Layout Procedure

CHAPTER 4 *page 46*  
**ANALYTICAL GEOMETRY**

**SPUR GEARS**

- 4.1 Generation and Properties of Involutives
- 4.2 Involute Geometry: Roll Angle: Polar Angle
- 4.3 The Involute Function: Involute Polar Coordinates
- 4.4 Pitch Diameter: Base Diameter: Generating Rack: Profile-shift: Nominal Tooth-form: Undercutting
- 4.5 Circular Thickness and Space-width
- 4.6 Subtended Angles
- 4.7 Base Pitch: Base Circular Thickness: Thicknesses at other Radii: Crest Width
- 4.8 Rectangular Coordinates
- 4.9 Changes in Tooth-thickness
- 4.10 Tooth-thickness Modification Coefficient
- 4.11 Chordal Thickness
- 4.12 Tangent Length: Roll Distance: Roll Angle
- 4.13 Base Tangent (Span Gauging)
- 4.14 Gauging "Over Pins": Pitch-circle Pin: Mean-depth Pin: Tip-circle Pin
- 4.15 Magnification Factor
- 4.16 Modes of Generation of an Involute Helicoid
- 4.17 Normal, Transverse and Axial Pitches
- 4.18 Pressure Angles
- 4.19 Nominal Tooth-form
- 4.20 Base Dimensions of Involute Helicoid
- 4.21 The Normal Helicoid
- 4.22 Tangent Plane
- 4.23 Normal Plane Section: Virtual Number of Teeth
- 4.24 Thickness Dimensions in Normal Plane
- 4.25 Data for Axial Section
- 4.26 Coordinates of Axial Section
- 4.27 Base Tangent
- 4.28 Gauging over Pins: Location of Pin: Contact Angle: Magnification
- 4.29 Pin-gauging with Odd Number of Teeth

**SPUR AND HELICAL GEAR PAIRS**

- 4.30  $\Sigma T$  and  $\Sigma k$
- 4.31 Standard Centre Distance  $C$
- 4.32 Extended Centre Distance  $C_e$
- 4.33 Extension Ratio  $Q_e$
- 4.34 Extended and Close-mesh Pressure Angles
- 4.35 Backlash at Nominal Thickness  $z_0$
- 4.36 Nominal Close-mesh Centre Distance  $C_{m\ nom}$
- 4.37 Effect of Tooth-thickness Change on Close-mesh Centre Distance
- 4.38 Crossed Helical Gears: Helix Angles,

Pitch Diameters and Standard Centre Distance

- 4.39 Crossed Helical Gears at Extended Centres

**CONICAL INVOLUTE GEARS**

- 4.40 Principles
- 4.41 Basic Dimensions of Conical Involute Gears

**BEVEL GEARS**

- 4.42 Pitch Cones: Pitch Angles
- 4.43 Tooth-numbers: the Crown Wheel
- 4.44 Virtual Gears
- 4.45 Tooth-form: Straight Bevels
- 4.46 Tooth-form: Spiral Bevels

**WORM GEARS**

- 4.47 Worm Geometry

CHAPTER 5 *page 76*  
**PRINCIPLES OF MEASUREMENT**

- 5.1 General
- 5.2 Principal Types of Error
- 5.3 Pitch Errors
- 5.4 Measurement of Pitch Errors
- 5.5 Effect of Eccentricity on Apparent Pitch Error
- 5.6 The Significance of Pitch Errors
- 5.7 Departures from Involute Profile
- 5.8 Measurement of Involute Profiles
- 5.9 Effect of Eccentricity on Profile Errors
- 5.10 Error of Base Diameter, Pressure Angle or Base Pitch
- 5.11 Characteristic Involute Diagrams
- 5.12 Lead Measurements
- 5.13 Periodic Errors in Generation: Undulations
- 5.14 Errors due to Faulty Setting of Cutters
- 5.15 Measurement of Involute Helicoids along the Generating Line
- 5.16 Tooth-thickness Variations
- 5.17 Composite Errors
- 5.18 The Rolling Gear Test
- 5.19 Master Worms
- 5.20 Kinematic and Transmission Errors
- 5.21 Visual Check of Tooth Bearing
- 5.22 Recording Tooth Surface Condition

CHAPTER 6 *page 88*  
**SPUR GEARS**

- 6.1 Pitch
- 6.2 Tooth Proportions: Basic Racks
- 6.3 Fine Pitch Gears
- 6.4 Profile-shift: Pitch Diameter: Nominal Tooth-form
- 6.5 Limits of Profile-shift Coefficient
- 6.6 Crest Width: Topping
- 6.7 Radial Dimensions of Gears having Nominal Tooth-form

**CENTRE DISTANCE RATIO AND TOOTH DATA**

- 6.8 Basic Data:  $\Sigma T$  and  $\Sigma k$ : Ratio

- 6.9 Standard Centre Distance  $C$
- 6.10 Extended Centre Distance  $C_e$
- 6.11 Extension Ratio  $Q_e$ : Extended Pressure Angle  $\psi_e$
- 6.12 Extended Pitch Diameters
- 6.13 Choice of Tooth-numbers
- 6.14 The choice of  $\Sigma k$ : General
- 6.15  $\Sigma k$  for Stipulated Centre Distance
- 6.16  $\Sigma k$  for Alternative Tooth-sums
- 6.17  $\Sigma k$  for Close-mesh
- 6.18 Distribution of  $k_p$  and  $k_w$ : General
- 6.19 Choice of  $k_p$  and  $k_w$  when  $\Sigma k = 0$
- 6.20 Choice of  $k_p$  and  $k_w$  when  $\Sigma k \neq 0$
- 6.21 Negative Values of  $\Sigma k$
- 6.22 Speed-increasing Gears
- 6.23 Simple Trains
- 6.24 Internal Gearing

- CENTRE DISTANCE AND BACKLASH**
- 6.25 Conventions for Expressing Backlash and Changes of Tooth-thickness
  - 6.26 Nominal Thickness
  - 6.27 Backlash at Nominal Thickness  $z_0$
  - 6.28 Nominal Backlash: Backlash Allowance: Tooth-thickness Tolerance
  - 6.29 Backlash Allowance in Simple Trains
  - 6.30 Backlash Range: Minimum-backlash Requirement
  - 6.31 Nominal Close-mesh Centre Distance  $C_{m\ nom}$
  - 6.32 Values for Nominal Backlash and Tooth-thickness Tolerance

- TOOTH-THICKNESS GAUGING DIMENSIONS**
- 6.33 Magnification Factor  $M$
  - 6.34 "Equivalent  $k$ "
  - 6.35 Chordal Thickness and Chordal Height
  - 6.36 Constant Chord
  - 6.37 Span-gauging: External Teeth
  - 6.38 Span-gauging: Internal Teeth
  - 6.39 Gauging "Over Pins", External Gears
  - 6.40 Gauging "Between Pins", Internal Gears
  - 6.41 Pin-gauging Involute Splines
  - 6.42 The Rolling-gear Test: Scope: Datum Centre Distance
  - 6.43 Roll-test Specification, Product-gear Pair
  - 6.44 Roll-test Specification, with Master Gear

- REFINEMENTS OF SPECIFICATION**
- 6.45 Tolerance and Tolerance Systems, General
  - 6.46 Tip-easing
  - 6.47 Profile Modification
  - 6.48 Start of Active Profile: Form Diameter
  - 6.49 Roll Distances and Roll Angles: Completion of Profile Diagrams
  - 6.50 Minimum Tip Diameter of Master Gear
  - 6.51 Start of Rack-generated Profile: Fillet-radius Geometry
  - 6.52 Fillet Curves: Protuberance Hobs
  - 6.53 Tip Chamfering
  - 6.54 Rounding or End-chamfering
  - 6.55 Crowning

- GENERAL**
- 6.56 Choice of Facewidth

- 6.57 Design of Gear Blanks
- 6.58 Data on Spur Gear Drawings

CHAPTER 7 page 128  
**HELICAL GEARS**

- 7.1 Pitch: Helix Angle: Conversion of Pitches
- 7.2 Pitch Diameter: Transverse Pressure Angle: Base Diameter: Base Helix Angle: Lead
- 7.3 Tooth Proportions
- 7.4 Profile Shift: Nominal Tooth-form
- 7.5 Radial Dimensions
- 7.6 Virtual Numbers of Teeth: Normal Section
- 7.7 Crest Width: Topping
- 7.8 Facewidth: Axial Contact Ratio

- BASIC DATA**
- 7.9 Standard Centre Distance  $C$
  - 7.10 Extended Centre Distance  $C_e$ : Extension Ratio  $Q_e$
  - 7.11 Distribution of  $\Sigma k$  into  $k_p$  and  $k_w$
  - 7.12 Choice of Basic Data,  $\Sigma k = 0$  (Standard Centres)
  - 7.13 Choice of Basic Data,  $\Sigma k \neq 0$  (Extended or Closed Centres)
  - 7.14 Round-number Helix Angles
  - 7.15 Simple Trains
  - 7.16 Compound Trains

- BACKLASH AND BACKLASH ALLOWANCES**
- 7.17 Conventions: Backlash
  - 7.18 Nominal Thickness
  - 7.19 Backlash at Nominal Thickness  $z_0$
  - 7.20 Nominal Close-mesh Centre Distance  $C_{m\ nom}$
  - 7.21 Nominal Backlash  $z_{nom}$
  - 7.22 Backlash Allowance
  - 7.23 Backlash Allowances in Simple Helical Trains
  - 7.24 Tooth-thickness Tolerances  $g_{tol}$

- TOOTH-THICKNESS GAUGING DIMENSIONS**
- 7.25 Chordal Thickness
  - 7.26 Span-gauging
  - 7.27 Gauging Over Pins or Balls, External Teeth
  - 7.28 Gauging Internal Helical Teeth Between Balls
  - 7.29 Roll-test Specifications for Helical Gears

- REFINEMENTS OF SPECIFICATION**
- 7.30 General
  - 7.31 Profile and Helix Control
  - 7.32 Start of Active Profiles: Roll Distances: Roll Angles

- CROSSED HELICAL GEARS**
- 7.33 Shaft and Helix Angle
  - 7.34 Centre Distance and Basic Data
  - 7.35 Preliminary Choice of Helix Angles: Diameter Ratio  $Q_d$
  - 7.36 Choice of Tooth-numbers and Pitch
  - 7.37 Adjustment of Helix Angles

- 7.38 Virtual Numbers of Teeth: Profile-shift
- 7.39 Examples
- 7.40 Nominal Backlash and Tooth-thickness Tolerance
- 7.41 Backlash at Nominal Thickness and Backlash Allowance
- 7.42 Close-mesh Centre Distance
- 7.43 Facewidth of Crossed Helical Gears
- 7.44 Inter-mating Crossed Helical Gears
- 7.45 Drawing Data, Helical Gears

**CHAPTER 8** *page 142*  
**BEVEL GEARS**

**TOOTH-NUMBERS AND PITCH**

- 8.1 Tooth-numbers
- 8.2 Pitch
- 8.3 Pitch Angles
- 8.4 Cone Distance and Facewidths
- 8.5 The Generating Crown Wheel
- 8.6 Virtual Tooth-numbers

**STRAIGHT BEVEL GEARS**

- 8.7 General
- 8.8 Tooth Proportions and Pressure Angle
- 8.9 Profile-shift
- 8.10 Choice of Profile-shift Coefficient
- 8.11 Principal Dimensions, Straight Bevel Gears
- 8.12 Mounting Distance
- 8.13 Nominal Circular Thickness: Tooth-thickness Modification: Crest Width
- 8.14 Tooth Angle
- 8.15 Backlash
- 8.16 Tooth-thickness Tolerance
- 8.17 Chordal Thickness on Pitch Circle
- 8.18 Constant Chord
- 8.19 Tooth Bearing: Crowning
- 8.20 Refinements of Tooth Profile

**SPIRAL BEVEL GEARS**

- 8.21 General
- 8.22 Spiral Angle: Hand of Spirals
- 8.23 Face Contact Ratio
- 8.24 Influence of Form of Tooth Spiral
- 8.25 Tooth Proportions: Gleason-type Spiral Bevel Gears
- 8.26 Oblique Spiral Bevel Gears
- 8.27 Klingelnberg "Palfoid" Spiral Bevel Gears
- 8.28 Tooth-thickness Dimensions
- 8.29 Hypoid Gears
- 8.30 Drawing Data, Bevel Gears

**CHAPTER 9** *page 153*  
**WORM GEARS**

- 9.1 General
- 9.2 Worm Thread Forms
- 9.3 The Use of the Module
- 9.4 The Designation " $t/T/q/m$ ": The Corresponding Spur Gears
- 9.5 Lead Angle: Lead: Normal Module
- 9.6 Worm Thread Form: Basic and Generating Racks

- 9.7 Base Dimensions of the Thread Surface
- 9.8 Worm Thread Proportions
- 9.9 Depth Modification
- 9.10 Preferred Values of  $m$  and  $q$
- 9.11 Choice of  $t$ ,  $T$ ,  $q$  and  $m$
- 9.12 Shafts at Right Angles
- 9.13 Facewidth of Worm: End-finish: Balance
- 9.14 Profile-shift Coefficient
- 9.15 Axial Section of Worm Threads
- 9.16 Ball-gauging Worm Threads
- 9.17 Span-gauging Dimensions
- 9.18 Constant-chord Thickness of Worm Threads
- 9.19 Extended or Closed Centre Distance
- 9.20 Radial Dimensions of Wormwheels
- 9.21 Facewidths of Wormwheel: Rim Sections
- 9.22 Backlash
- 9.23 Tooth Contact Marking: Entry Gap
- 9.24 Drawing Data, Worm Gears

**CHAPTER 10** *page 166*  
**FIXED-AXIS GEAR TRAINS**

- 10.1 Types of Gear Train
- 10.2 Tooth-number Calculations, General
- 10.3 Conjugate Fractions
- 10.4 The Brocot Table
- 10.5 Derived Conjugate Fractions
- 10.6 Derivation of Intermediate Fractions
- 10.7 Example
- 10.8 The Factor Table
- 10.9 To Find a Fraction Conjugate to a Given Fraction
- 10.10 The Angular Vernier
- 10.11 Link-mounted Gear Trains
- 10.12 Closed Trains
- 10.13 Assembly of Multiple-contact Trains
- 10.14 Multi-ratio Trains
- 10.15 Tooth Contact Frequency
- 10.16 Skeleton Diagrams
- 10.17 References

**CHAPTER 11** *page 180*  
**PLANETARY TRAINS**

- 11.1 Nomenclature
- 11.2 Algebraic Signs
- 11.3 Notation

**SIMPLE PLANETARY TRAINS**

- 11.4 Typical Arrangements
- 11.5 Speed-ratios by the Tabular Method
- 11.6 The Method of Fixed-carrier Ratios
- 11.7 The Sun/Planet/Annulus Train
- 11.8 High-ratio Trains: Conjugate Sun/Planet Ratios
- 11.9 Direction of Power-flow: Fixed-carrier Efficiency
- 11.10 Torque Distribution
- 11.11 Epicyclic Efficiency
- 11.12 Internally-transmitted Power
- 11.13 The Simple Differential

## COMPOUND AND COUPLED PLANETARY TRAINS

- 11.14 Compound Planetary Trains
- 11.15 Examples of Compound Planetary Trains
- 11.16 Coupled Planetary Trains
- 11.17 The Compound Differential
- 11.18 Coupled Differentials
- 11.19 Differential Infinitely-variable Gears

## DETAIL DESIGN

- 11.20 Choice of Tooth-numbers for Assembly
- 11.21 Profile-shift of Sun/Planet/Annulus Trains
- 11.22 Planet Speed
- 11.23 Frequency of Load-application
- 11.24 "Float"

## CHAPTER 12 *page 200*

### CONTACT GEOMETRY

- 12.1 Modes of Relative Surface Motion
- 12.2 Contact-motion Characteristics
- 12.3 Contact-velocity Relationships
- 12.4 Simulation of Tooth-contact Conditions

### SPUR GEARS

- 12.5 Contact Ratio at Standard Centres:  
Addendum Contact Ratio
- 12.6 Contact Ratio at Extended Centres:  
Contact-ratio Decrement: Extension  
Contact-ratio Factor
- 12.7 Addendum Contact-ratios of Engagement
- 12.8 Addenda of Engagement at Extended  
Centres: Addendum Ratio
- 12.9 Internal Gears: Contact Conditions: Tip  
Interference: Trimming
- 12.10 Radii of Curvature, General Case
- 12.11 Radii of Curvature, Involute Profiles
- 12.12 Contact Velocities, General Case
- 12.13 Contact Velocities, Involute Gears
- 12.14 Equivalent Cylinders

### HELICAL GEARS

- 12.15 Zone of Contact: Inclination of Contact Line
- 12.16 Transverse, Normal and Axial Contact  
Ratios
- 12.17 Calculation of Contact Ratio
- 12.18 Pressure Angles of Engagement at  
Extended Centres
- 12.19 True Length of Contact Line
- 12.20 Fractional Axial Contact Ratios
- 12.21 Radii of Curvature of Helical Teeth
- 12.22 Contact Velocities of Helical Gears
- 12.23 Contact Velocities of Crossed Helical Gears
- 12.24 Bevel Gears: The Virtual Spur or Helical  
Gears
- 12.25 Zone of Contact, Involute Helicoid Worm,  
 $\Sigma = 90$  degrees
- 12.26 Contact Velocities of Worm Gears
- 12.27 Curvature

## CHAPTER 13 *page 216*

### GEAR TOOTH LOADS

- 13.1 Tangential Load, Spur and Helical Gears

- 13.2 Tangential Load, Bevel Gears
- 13.3 Tangential Load, Worm Gears
- 13.4 Load per Inch of Facewidth, Spur and  
Helical Gears
- 13.5 Equivalent Load per Inch of Facewidth,  
Bevel Gears
- 13.6 Resultant and Radial Tooth-loads, Spur  
Gears
- 13.7 Resultant, Radial and Axial Tooth Loads,  
Helical and Worm Gears
- 13.8 Resultant, Radial and Axial Loads,  
Straight Bevel Gears
- 13.9 Resultant, Radial and Axial Tooth Loads,  
Spiral Bevel Gears
- 13.10 Contact-line Loading, Spur Gears
- 13.11 Contact-line Loading, Helical Gears
- 13.12 Contact-line Loading, Bevel Gears
- 13.13 Tooth Deflection
- 13.14 Combined Deflection, Single-pair Contact
- 13.15 Double-pair Contact
- 13.16 Profile Modification: Static Transmission  
Error
- 13.17 Stress-increase due to Simple  
Malalignment
- 13.18 Bending and Torsional Deflection of  
Pinions
- 13.19 Dynamic Loading
- 13.20 References

## CHAPTER 14 *page 227*

### BEARING LOADS

- 14.1 General
- 14.2 Plane of Reference
- 14.3 Spur Gears, Straddle Mounted
- 14.4 Spur Gears, Overhung
- 14.5 Single-helical Gears, Straddle Mounted
- 14.6 Single-helical Gears, Overhung
- 14.7 Bevel Gears
- 14.8 Worm Gears and Crossed Helical Gears
- 14.9 Shafts Carrying Two or More Gears
- 14.10 Intermediate Shafts
- 14.11 Torque Reaction

## CHAPTER 15 *page 234*

### GEARS IN SERVICE

- 15.1 General
- 15.2 Practical Causes of Gear Failure
- 15.3 Classification of Gear-tooth Failures

#### GROUP 1: FRACTURES

- 15.4 Typical Bending-fatigue Fracture
- 15.5 Fatigue Failure Accelerated by  
Lengthwise Maldistribution
- 15.6 Fatigue Failure and Fillet Radius
- 15.7 Fatigue Failure Induced by Careless  
Dressing or Tooth-rounding
- 15.8 Grinding Cracks
- 15.9 Fractures Originating at Damaged Area  
of Surface
- 15.10 Tip Crumbling
- 15.11 Rim Fractures
- 15.12 Wormwheel Tooth Fractures

## GROUP II: SURFACE FAILURES DUE TO INTERNAL STRESS

- 15.13 Pitting
- 15.14 Pitch-line Fissure of Case-hardened Gears
- 15.15 Flaking and Case-crushing
- 15.16 Fine Flaking
- 15.17 Smooth Abrasion
- 15.18 Plastic Flow: Rippling

## GROUP III: SURFACE DAMAGE FOLLOWING OIL-FILM BREAKDOWN

- 15.19 General
- 15.20 Scuffing: Scoring: Tearing
- 15.21 Ridging and Grooving
- 15.22 Low-speed Wear

## GEAR NOISE

- 15.23 Types of Gear Noise
- 15.24 Origins of Gear Noise
- 15.25 Noise Diagnosis
- 15.26 The Attack on Gear Noise

## CHAPTER 16 *page 248* **BENDING STRESS**

- 16.1 General
- 16.2 Nominal Stress
- 16.3 The Choice of Critical Section
- 16.4 The Choice of Load-point
- 16.5 Stress-concentration
- 16.6 Design Strength Factor: Tip Strength Factor
- 16.7 Calculation of Tip Strength Factor: Radius of Curvature at the Stress-point
- 16.8 Graphical Determination of Tip Strength Factor
- 16.9 Calculation of Strength Factor for Other Load-points
- 16.10 Design Strength Factors, Spur Gears
- 16.11 Strength Factor, Straight Bevel Gears
- 16.12 Strength Factor, Helical Gears
- 16.13 Effect of Axial Contact Ratio
- 16.14 Strength Factor, Spiral Bevel Gears
- 16.15 Effects of Thickness Modification
- 16.16 Tooth Overhang
- 16.17 Bending Stresses and Deflection, Wormshafts
- 16.18 Stresses in Wormwheel Teeth

## CHAPTER 17 *page 259* **CONTACT STRESS CRITERIA**

- 17.1 General
- 17.2 Hertzian Compressive Stress
- 17.3 The Criterion " $S_c$ "
- 17.4 The Criterion " $K$ "
- 17.5 Calculation of  $S_c$ , Spur Gears
- 17.6 Calculation of  $K$  and  $S_c$ , Helical Gears
- 17.7 Calculation of  $K$  and  $S_c$ , Straight Bevel Gears
- 17.8 Calculation of  $K$  and  $S_c$ , Spiral Bevel Gears
- 17.9 Effect of Axial Contact Ratio
- 17.10 Effect of Lengthwise Maldistribution

- 17.11 Zone Factor
- 17.12 Criteria of Contact-loading, Worm Gears
- 17.13 Contact Stresses, Crossed Helical Gears
- 17.14 Sub-surface Stresses: Case-depth
- 17.15 General
- 17.16 Pressure/Temperature/Viscosity Characteristics
- 17.17 Oil-film Entrainment and Pressure Distribution
- 17.18 Film Thickness
- 17.19 Phenomena within the Oil-film
- 17.20 The Coefficient of Friction
- 17.21 Temperature Flash
- 17.22 Scuffing Criteria
- 17.23 Influences of Contact Phenomena on Contact-stress Criteria
- 17.24 References

## CHAPTER 18 *page 276* **GEAR MATERIALS**

- 18.1 General
- 18.2 The Significance of the Conventional Properties
- 18.3 Cast Iron
- 18.4 Carbon Steels
- 18.5 Alloy Steels
- 18.6 Case-hardened Steels
- 18.7 Nitrided Steels
- 18.8 Flame-hardening
- 18.9 Induction Hardening
- 18.10 Non-ferrous Metals
- 18.11 Non-metallic Materials
- 18.12 Surface Treatments for Steel Gears
- 18.13 Residual Stresses
- 18.14 Surface Effects

## FATIGUE CHARACTERISTICS

- 18.15 Fatigue Strength in Bending
- 18.16 The  $S-N$  Curve
- 18.17 Confidence-limits
- 18.18 Characteristics of  $S-N$  Curves
- 18.19 Analytical Treatment of the  $S-N$  Curve
- 18.20 Variable Loading: Cumulative Fatigue Damage
- 18.21 The  $S_b-N$  Curve at Low Values of  $N$
- 18.22 Resistance to Reversed Loading
- 18.23 Effects of Stress-concentration; Stress-concentration Factor
- 18.24 The "Size-effect"
- 18.25 Variations in Bending-fatigue Properties
- 18.26 Fatigue under Contact Stress: Pitting
- 18.27 References

## CHAPTER 19 *page 290* **CALCULATED STRESSES AND DESIGNED LIFE**

- 19.1 General
- 19.2 Loading, Spur and Helical Gears
- 19.3 Calculated Bending Stress, Spur Gears
- 19.4 Calculated Contact Stress, Spur Gears
- 19.5 Calculated Bending Stress, Helical Gears

- 19.6 Calculated Contact Stress, Helical Gears
- 19.7 Loading, Bevel Gears
- 19.8 Calculated Bending Stress, Straight Bevel Gears
- 19.9 Calculated Contact Stress, Straight Bevel Gears
- 19.10 Calculated Bending Stress, Spiral Bevel Gears
- 19.11 Calculated Contact Stress, Spiral Bevel Gears
- 19.12 Loading, Worm Gears
- 19.13 Calculated Bending Stress, Wormwheel
- 19.14 Calculated Contact Stress, Wormwheel
- 19.15 Calculated Bending Stress, Wormshafts
- 19.16 Loading and Contact Stress, Crossed Helical Gears
- 19.17 Calculated Stresses in Hypoid Gears

#### LIFE CALCULATIONS

- 19.18 Designed Life: Duty Cycle: Equivalent Life
- 19.19 Reversing Load-direction
- 19.20 Multiple Contact
- 19.21 Equivalent Running Time and Equivalent Life
- 19.22 Block Load Diagram
- 19.23 Duty-cycle Diagram
- 19.24 Constant Torque, Uniformly-varying Speed
- 19.25 Constant Speed, Uniformly-varying Torque
- 19.26 Varying Torque and Speed
- 19.27 General Case of Varying Torque and Speed

#### CHAPTER 20 *page 309* **ALLOWABLE STRESSES AND RATING FORMULAE**

- 20.1 The Expression of Load-capacity
- 20.2 Basic Stresses and Modifying Factors, General
- 20.3 Logarithmic Life Factors
- RATING FORMULAE
- 20.4 Basic Stresses in British Standard Specifications
- 20.5 Speed Factors for "Strength" in B.S. Specifications
- 20.6 Equivalent Basic Bending Stresses of B.S.436: 1940
- 20.7 Speed Factors for "Wear" in B.S. Specifications
- 20.8 Equivalent Contact-stress Rating in B.S. Specifications
- 20.9 Rules of Lloyd's Register of Shipping
- 20.10 N.C.B. Specification No. 383/1963—Winding Engine Reduction Gears
- 20.11 Horsepower Rating Formulae
- 20.12 The Four Ratings: Limiting Rating: Design Margin
- 20.13 Factor of Safety: Margin of Safety
- 20.14 The Size Criterion  $C^2, f$
- 20.15 Bevel Gear Rating Formulae
- 20.16 Worm Gear Rating: B.S. 721: 1963

#### DOMESTIC RATINGS

- 20.17 The Domestic Stress Problem

- 20.18 Loading Criteria
- 20.19 Allowable Stresses: Spur, Helical and Bevel Gears
- 20.20 Allowable Stresses: Worm Gears
- 20.21 Life Rating
- 20.22 Vehicle Transmissions: Mileage Rating
- 20.23 Basic Stress: Endurance Stress: Application Factor: Stresses in Metric Units
- 20.24 Bending Stress-concentration Factor
- 20.25 Lubrication Factor
- 20.26 Some Application Factors from Practice

#### STRESS-COMPARISON

- 20.27 Stress-comparison, General: Unfactored Stress
- 20.28 Speed-factored Stresses
- 20.29 Life-factored Stresses
- 20.30 Stress-comparison by Application Factor
- 20.31 The Analysis of Application Factors
- 20.32 The Analysis of Test Data
- 20.33 Comparison with Practice in the Rating of Rolling Bearings

#### CHAPTER 21 *page 334* **LUBRICATION AND COOLING**

- 21.1 Requirements of a Lubricating System

#### THE APPLICATION AND FLOW CONTROL OF LUBRICANT

- 21.2 Splash Lubrication
- 21.3 Spray Lubrication
- 21.4 Oil Control

#### THE CHOICE OF LUBRICANT

- 21.5 General
- 21.6 The Economics of Lubrication
- 21.7 The Choice of Lubricant
- 21.8 Quantity of Lubricant

#### COOLING

- 21.9 Rate of Heat Generation
- 21.10 Heat Dissipation by Natural Convection
- 21.11 Air-draught Cooling
- 21.12 Liquid Cooling
- 21.13 Temperature-Time Curves: Time Constant
- 21.14 Prediction of Equilibrium Temperature
- 21.15 Intermittent Running
- 21.16 Estimation of Efficiency from Temperature Rise
- 21.17 Significance of Temperature Rise

#### CHAPTER 22 *page 345* **EFFICIENCY AND TESTING**

- 22.1 Instantaneous Efficiency, Spur Gears
- 22.2 Efficiency over the Cycle of Engagement
- 22.3 Tooth-loss Factor, Spur Gears
- 22.4 Tooth-loss Factor, Internal Spur Gears
- 22.5 Tooth-loss Factor, Helical Gears
- 22.6 Tooth-loss Factors, Bevel Gears
- 22.7 The Coefficient of Friction

- 22.8 Data for Calculating  $\mu$ , Spur Gears
- 22.9 Data for Calculating  $\mu$ , Helical Gears
- 22.10 Analysis of Efficiency Tests
- 22.11 Condensed Formula for Tooth Loss
- 22.12 Worm Gear Efficiency, Shaft Angle 90 degrees
- 22.13 Efficiency when  $\Sigma \neq 90$  degrees
- 22.14 Coefficient of Friction, Worm Gears
- 22.15 Efficiency of Crossed Helical Gears
- 22.16 Irreversible Worm Gears

#### TESTING

- 22.17 Significance of Efficiency and Efficiency-loss
- 22.18 Sources of Power Loss
- 22.19 Relationships between Losses and Efficiency
- 22.20 Thermal Measurement of Efficiency
- 22.21 Mechanical Measurement of Efficiency
- 22.22 Closed-circuit Test Arrangements
- 22.23 Calculation of Efficiency in Closed-circuit Tests
- 22.24 References

#### APPENDIX 1 *page 358*

### ACCURACY OF CALCULATION

#### APPENDIX 2 *page 359*

### INTERPOLATION

#### APPENDIX 3 *page 361*

### DESIGN CALCULATIONS IN METRIC UNITS

#### APPENDIX 4 *page 366*

### TRIGONOMETRICAL RELATIONSHIPS

#### APPENDIX 5 *page 366*

### ANGULAR MEASUREMENT

#### APPENDIX 6 *page 367*

### GEAR DESIGN TABLES

- 1 Tooth proportions
- 2 Trigonometrical functions
- 3 Involute functions (short table)
- 4 Involute polar coordinates
- 5 Functions of helix angle  $\sigma$
- 6 Functions of number of teeth  $T$
- 7 Functions of profile-shift coefficient  $k$
- 8 Functions of extension ratio  $Q_e$
- 8A Extension contact-ratio factor  $K_\Delta$
- 8B Contact-stress conversion factor  $C_K$
- 9 Addendum contact-ratio factor  $K_C$
- 10 Span-gauging factor  $K_n$
- 11 Factor table
- 12 Bevel gear and Brocot table
- 13 Tooth-numbers in sun/planet/annulus trains
- 14 Interpolation coefficients  $B$
- 15 Helical contact-stress conversion factor  $C_{KH}$

#### APPENDIX 7 *page 429*

### CALCULATION SEQUENCES

- 1 Profile-shift, tooth-thickness and backlash, spur and helical gears
- 2 Crest-width and topping, spur and helical pinions
- 3 Radial dimensions, spur gear pair
- 4 Radial dimensions, leads, helical gear pair
- 5 Chordal dimensions, spur and helical gears
- 6 Span-gauge dimensions, spur gears
- 7 Pin-gauging dimensions, spur gears
- 8 Span-gauge dimensions, helical gears
- 9 Pin or ball gauging, helical gears
- 10 Contact ratio: spur, helical and crossed helical and bevel gears
- 11 Roll angles and distances, spur and helical gears
- 12 Tooth and blank dimensions, straight bevel gears
- 12A Preliminary data, straight bevel gears,  $\Sigma$  not 90 degrees
- 13 Tooth and blank dimensions, wormgears

#### APPENDIX 8 *page 458*

### CHARTS

- 1 Crest width, full-depth teeth,  $\psi = 20$  deg.
- 2 Chordal decrement and height increment
- 3 Tip-circle pin diameter, full-depth teeth,  $\psi = 20$  deg.
- 4 Distribution of profile-shift
- 5A Tip strength factors, B.S. Class A2/B
- 5B Tip strength factors, full-depth teeth,  $\psi = 20$  deg, shaved
- 5C Tip strength factors, bevel gear teeth,  $\psi = 20$  deg.
- 5D Tip strength factors, stub teeth, 0.8 depth,  $\psi = 20$  deg.
- 6 Strength factors, B.S. Class A2/B,  $\Sigma k = 0$
- 6A Strength factors, B.S. Class A2/B,  $\Sigma k = 0.5$
- 7A Contact ratios, full-depth teeth,  $\psi = 20$  deg,  $\Sigma k = 0$
- 7B Contact ratios, full-depth teeth,  $\psi = 20$  deg,  $\Sigma k = 0.5$
- 8 Logarithmic life factors
- 9A Ratio  $Q_{R/y} =$  fillet radius/beam depth, B.S. Class A2/B
- 9B  $Q_{R/y}$ , full-depth teeth,  $\psi = 20$  deg, shaved
- 9C  $Q_{R/y}$ , bevel gear teeth,  $\psi = 20$  deg
- 9D  $Q_{R/y}$ , stub teeth, 0.8 depth,  $\psi = 20$  deg
- 10 Values of  $C_s$  for variable torque
- 11 Values of  $C_a$  and  $C_r$  for variable torque and speed
- 12 Coefficients of friction
- 13 Worm gear efficiency