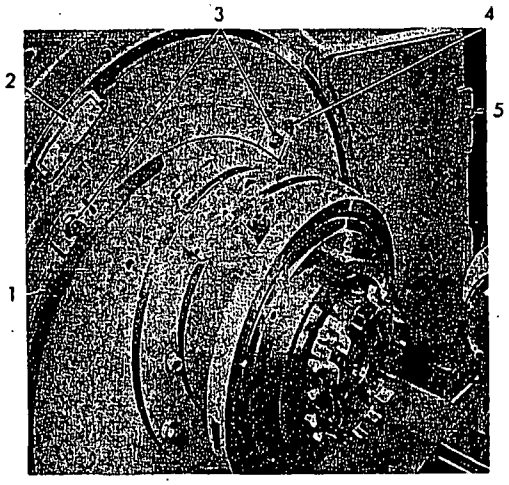


Fig. 12.

the generating gear, which, in turn, controls the width of the tooth bearing. It is also used to control pressure angle.

9. Set Swivel Angle

Loosen three nuts 4 Fig. 11 (one nut not shown). Set swivel angle to desired angular setting on the scale and vernier 3 Fig. 11 by inserting wrench in 2 Fig. 11, and turning. Tighten nuts. This setting controls the effective direction of the tilt produced by the cutter spindle rotation angle.



Fig. 13. This view located on left inside door 6 Fig. 2.

10. Set Eccentric Angle

Loosen three nuts 3 Fig. 12 (one nut not shown). Set eccentric angle to desired setting on the scale and vernier 1 Fig. 12 by inserting wrench in 4 Fig. 12 and turning. Tighten nuts. This setting determines the distance between the cutter center and cradle axis. It is used to control the spiral angle.

11. Change Feed Cam Roller

(For Machines with Double Feed Path Only)

Jog the machine with the button 5 Fig. 12 until the plate "change cam roller" on the feed cam is in line with the pointer as shown in Fig. 13. Turn off the main line switch. Loosen nut 4 Fig. 14. Insert wrench in 2 Fig. 14 and turn to engage the proper roller in the feed cam as shown on plates 6 Fig. 14. Tighten nut 4 Fig. 14.

The two feed cam rollers are marked "A" and "B". When roughing flat gears (pitch angles greater than 68°) without generating roll or when finishing Formate gears by the Unitool Method, the feed cam roller marked "A" must be engaged. When roughing and finishing gears or pinions with roll, the feed cam roller marked "B" must be engaged.

12. Adjust Feed Cam Throw

First set control lever 1 Fig. 8 in the advance position. (NOTE: When using a collet type arbor

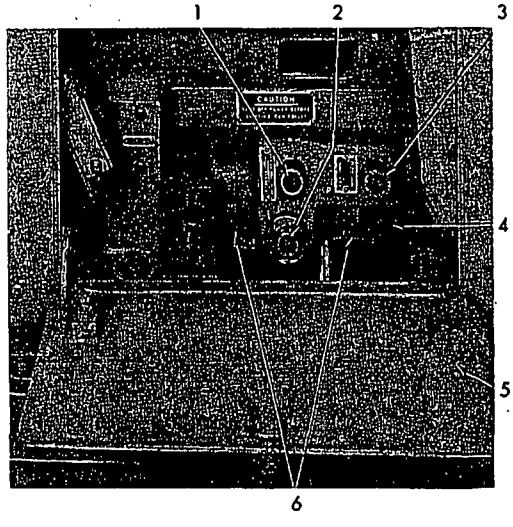


Fig. 14. This view located inside door 3 Fig. 2.

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