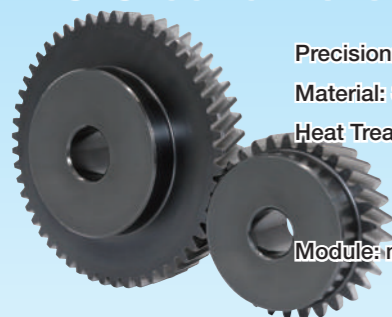


KHG Ground Helical Gears

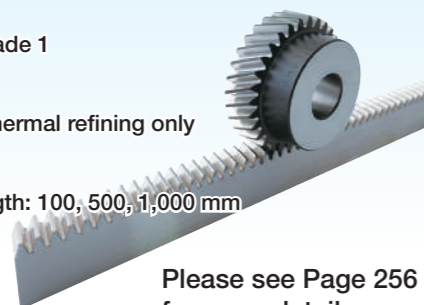


Precision: JIS Grade N6
Material: SCM440
Heat Treatment: Thermal refined / gear teeth induction hardened
Module: m1 to 3

Please see Page 194 for more details.

KRHG/KRHGF/KRHGFD Ground Helical Racks

Precision: KHK Grade 1
Material: SCM440
Heat Treatment: Thermal refining only
Module: m1 to 3
Nominal Total Length: 100, 500, 1,000 mm



Please see Page 256 for more details.

SH Helical Gears



Precision: JIS Grade N8
Material: S45C
Heat Treatment: -
Module: m2, 3

Please see Page 202 for more details.

SRH·SRHF·SRHFD Helical Racks

Precision: KHK Grade 5
Material: S45C
Heat Treatment: -
Module: m2, 3
Nominal Total Length: 100, 500, 1,000 mm



Please see Page 258 for more details.

ZSTP Ground Helical Gears

Dedicated for racks



Precision: JIS Grade N6
Material: SCM440
Heat Treatment: Thermal refined / gear teeth induction hardened
Module: m2 to 6

Please see Page 262 for more details.

SHE Helical Gears

Dedicated for racks



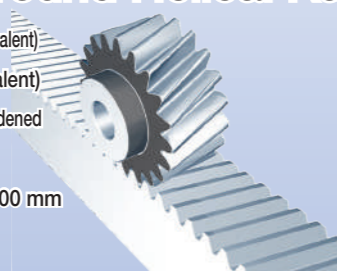
Precision: JIS Grade N8
Material: S45C
Heat Treatment: -
Module: m1.5 to 6

Please see Page 260 for more details.

ZST/ZSTD

Hardened Ground Helical Racks

Precision: DIN Grade 6 (KHK Grade 2 equivalent)
Material: DIN C45 (JIS S45C equivalent)
Heat Treatment: Gear teeth induction hardened
Module: m2 to 6
Nominal Total Length: 1,000, 2,000 mm



Please see Page 262 for more details.

SRHEF Helical Racks

Precision: KHK Grade 4
Material: S45C
Heat Treatment: -
Module: m1.5 to 6
Nominal Total Length: 1,000 mm

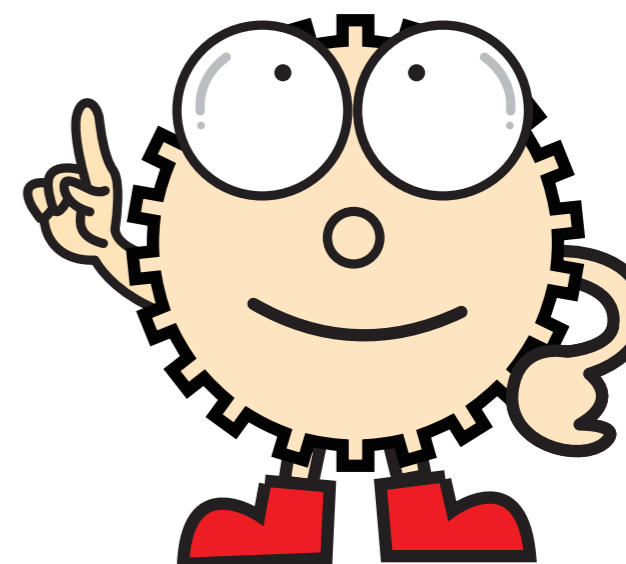


Please see Page 260 for more details.



Internal Gears

SI Steel Internal Gears	SIR Internal Ring Gears
	
Material: S45C m0.5-3 Page 208	Material: S45C m2-3 Page 210



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) Internal Gears

S I R 2 - 120



Features



KHK stock internal gears are offered in modules 0.5 to 3 in 50 to 200 teeth. They can be used in many applications including planetary gear drives.

Catalog Number	SI	SIR
Module	0.5~3	2~3
Material	S45C	S45C
Heat Treatment	—	—
Tooth Surface Finish	Cut	Cut
Precision JIS B 1702-1:1998	N8 NOTE 1	N9
Secondary Operations	Possible	Possible
Features	A popular type of internal gear; Allows secondary operations.	They have a ring shape with a large number of teeth. Allows secondary operations.

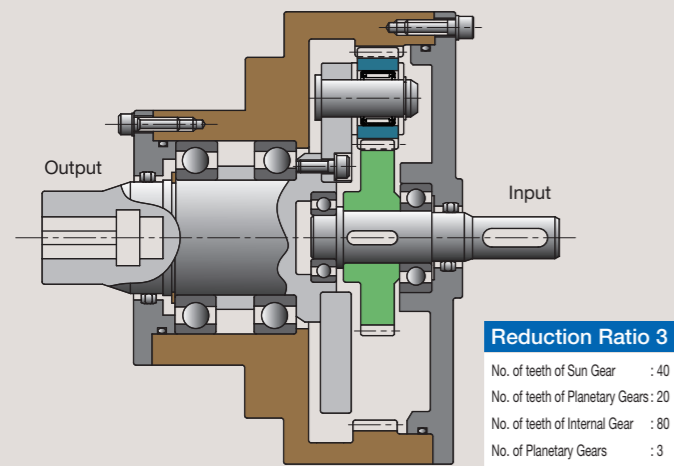
[Note 1] The product accuracy class having a module less than 0.8 corresponds to 'equivalent' as shown in the table.

Application Examples



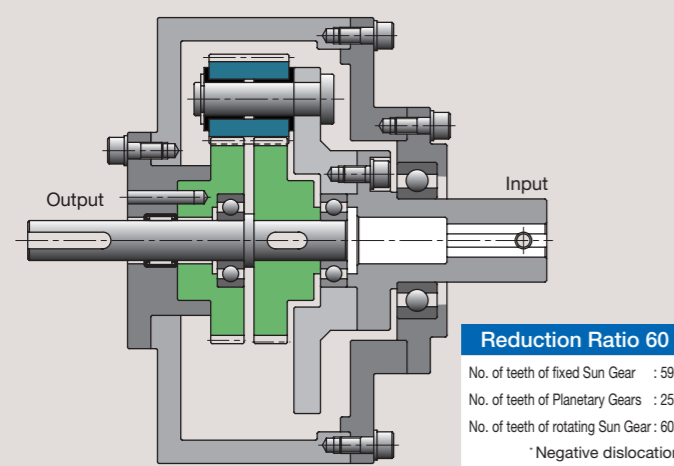
KHK stock internal gears are used to reduce the size of various equipment, such as reduction gears.

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



Planetary Gear Mechanism used in a reduction gear

Reduction Ratio 3	
No. of teeth of Sun Gear	: 40
No. of teeth of Planetary Gears	: 20
No. of teeth of Internal Gear	: 80
No. of Planetary Gears	: 3



Mechanical Paradox Gear Mechanism used in a large reduction gear

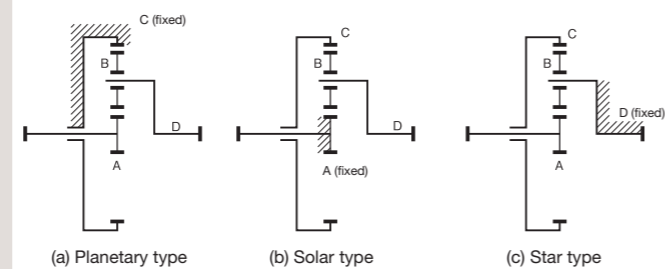
Reduction Ratio 60	
No. of teeth of fixed Sun Gear	: 59
No. of teeth of Planetary Gears	: 25
No. of teeth of rotating Sun Gear	: 60

*Negative dislocation

Example of combinations

No. of teeth of Internal Gear	No. of Planetary Gears	No. of teeth of sun gear	No. of teeth of Planetary Gears	Reduction ratio of planetary type	Reduction ratio of solar type	Reduction ratio of star type
60	3	18	21	4.333	1.3	-3.333
80	3	16	32	6	1.2	-5
80	3	40	20	3	1.5	-2
100	3	20	40	6	1.2	-5
100	3	50	25	3	1.5	-2

Types of Planetary Gear Mechanism



Selection Hints



Please select the most suitable products by carefully considering the characteristics of items and contents of the product tables.

1. Caution in Selecting the Mating Gears

KHK stock internal gears can mate with any spur gears of the same module, however, there are cases of interference depending on the number of teeth of the mating gear. The table below contains the assumptions established for these products in order to compute gear strengths.

Interferences and the symptoms

Type	SYMPTOMS	CAUSES
Involute interference	The tip of the internal gear digs into the root of the pinion.	Too few teeth on the pinion.
Trochoid interference	The exiting pinion tooth contacts the internal gear tooth.	Too little difference in number of teeth of the two gears.
Trimming interference	Pinion can slide in or out axially but cannot move radially.	Too little difference in number of teeth of the two gears.

Allowable Mating Pinions and Number of Teeth

No. of teeth of Internal Gear	No. of teeth of Allowable Mating Pinions		
	Lower limit No. of teeth due to involute interference	Upper limit No. of teeth due to trochoid interference	Upper limit No. of teeth due to trimming interference
50	22	41	33
60	21	51	43
80	20	72	64
100	19	92	84
120	19	112	104
160	19	152	144
200	18	192	184

2. Caution in Selecting Gears Based on Gear Strength

The gear strength values shown in the product pages were computed by assuming the application environment in the table below. Therefore, they should be used as reference only. We recommend that each user computes their own values by applying the actual usage conditions. The table below contains the assumptions established for various products in order to compute gear strengths.

Calculation of Bending Strength of Gears

Item	Catalog Number	SI	SIR
Formula NOTE 1	Formula of spur and helical gears on bending strength (JGMA401-01)		
No. of teeth of mating gears	30		
Rotational Speed	100rpm		
Design Life (Durability)	Over 10 ⁷ cycles		
Impact from motor	Uniform load		
Impact from load	Uniform load		
Direction of load	Bidirectional load (calculated with allowable bending stress of 2/3)		
Allowable bending stress at root σ_{Hlim} (kgf/mm ²)	19		
Safety factor S_F	1.2		

Calculation of Surface Durability (Except where it is common with bending strength)

Item	Catalog Number	SI	SIR
Formula NOTE 1	Formula of spur and helical gears on surface durability (JGMA402-01)		
Kinematic viscosity of lubricant	100cSt (50°C)		
Gear support	Symmetric support by bearings		
Allowable Hertz stress σ_{Hlim} (kgf/mm ²)	49		
Safety factor S_H	1.15		

[NOTE 1] The gear strength formula is based on JGMA (Japanese Gear Manufacturers Association) specifications. The units for the rotational speed (rpm) and the stress (kgf/mm²) are adjusted to the units needed in the formula.

Application Hints



In order to use KHK stock internal gears safely, read the Application Hints carefully before proceeding. Please refer to Page 48 for "Cautions on Handling" and Page 49 for "Cautions on Starting".

1. Caution on Performing Secondary Operations

- ① If performing outer diameter machining, it is important to pay special attention to locating the center in order to avoid runout.
- ② Please exercise caution not to cause deformation when chucking the outer diameter. Gear precision may deteriorate and cause trouble.
- ③ To avoid problems of reduced gear precision and other manufacturing difficulties, do not attempt to machine the gears to reduce face widths.

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.

2. Points of Caution during Assembly

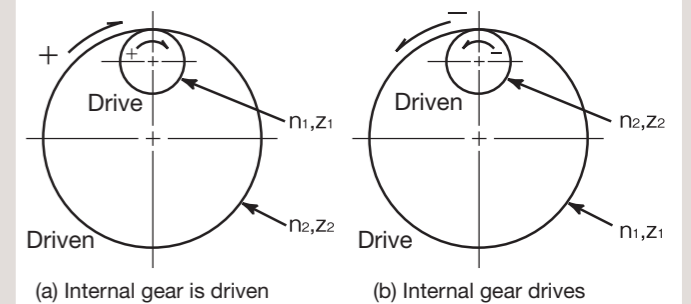
- ① KHK stock internal gears are designed to give the proper normal direction backlash when assembled using the center distance given by the formula below. The amount of backlash is given in the dimension table for each gear.

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

Where
 a : Center distance
 d_1 : Pitch diameter of pinion
 d_2 : Pitch diameter of internal gear

- ② Refer to the figure below for the direction of rotation of internal gears.

Gear Ratio and Direction of Rotation



(a) Internal gear is driven (b) Internal gear drives

$$\text{Gear Ratio } i = \frac{z_2}{z_1} = \frac{n_1}{n_2} \quad \begin{matrix} z : \text{No. of teeth} \\ n : \text{Rotational speed} \end{matrix}$$

- ③ To use as a planetary gear drive, the following conditions must be satisfied.

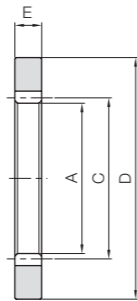
Gear tooth conditions for planetary gear mechanisms

- Condition 1: $z_c = z_a + 2z_b$
 - Condition 2: $\frac{z_a + z_c}{N} = \text{Integer}$
 - Condition 3: $z_b + 2 < (z_a + z_b) \sin \frac{180^\circ}{N}$
- z_a : No. of teeth of Sun Gear
 z_b : No. of teeth of Planetary Gears
 z_c : No. of teeth of Internal Gear
 N : No. of Planetary Gears



Specifications	
Precision grade	JIS grade N8 (JIS B1702-1: 1998)
Gear teeth	Standard full depth
Pressure angle	20°
Material	S45C
Heat treatment	—
Tooth hardness	(less than 194HB)
Surface treatment	Black oxide coating

* The precision grade of products with a module of less than 0.8 is equivalent to the value shown in the table.



T1

Catalog Number	Module	No. of teeth	Shape	Outside dia.			Face width	Allowable torque (N·m)				Backlash (mm)	Weight (kg)
				A	C	D		Bending strength	Surface durability	Bending strength	Surface durability		
SI0.5-60 SI0.5-80 SI0.5-100	m0.5	60	T1	29	30	50	5	3.75	0.67	0.38	0.068	0.04~0.15	0.049
80		39		40	60	4.85		0.75	0.49	0.077	0.062		
100		49		50	70	5.97		0.87	0.61	0.089	0.074		
SI0.8-60 SI0.8-80 SI0.8-100	m0.8	60		46.4	48	75	15.4	2.87	1.57	0.29	0.16	0.05~0.16	0.16
80		62.4		64	90	19.9	3.24	2.03	0.33	0.20			
100		78.4		80	105	24.5	3.75	2.50	0.38	0.23			
SI1-60 SI1-80 SI1-100	m1	60		58	60	90	30.0	5.95	3.06	0.61	0.28	0.09~0.21	0.28
80		78		80	110	38.8	6.59	3.96	0.67	0.35			
100		98		100	130	47.8	7.64	4.87	0.78	0.43			
SI1.5-50 SI1.5-60 SI1.5-80 SI1.5-100	m1.5	50		72	75	115	87.1	20.9	8.88	2.13	0.70	0.11~0.25	0.70
60		87		90	130	101	20.6	10.3	2.10	0.81			
80		117		120	160	131	23.3	13.4	2.38	1.04			
100		147		150	190	161	27.0	16.5	2.75	1.26			
SI2-50 SI2-60 SI2-80 SI2-100	m2	50		96	100	150	206	50.3	21.0	5.13	1.54	0.12~0.28	1.54
60		116		120	170	240	50.5	24.5	5.15	1.79			
80		156	160	210	311	57.0	31.7	5.81	2.28				
100		196	200	250	382	65.7	39.0	6.70	2.77				
SI2.5-50 SI2.5-60 SI2.5-80	m2.5	50	120	125	185	403	101	41.1	10.3	2.87	0.14~0.31	2.87	
60		145	150	210	469	101	47.8	10.3	3.33				
80		195	200	260	607	114	61.9	11.6	4.25				
SI3-50 SI3-60	m3	50	144	150	220	697	178	71.0	18.1	4.79	0.15~0.35	4.79	
60		174	180	250	811	178	82.7	18.2	5.57				

- [Caution on Product Characteristics] ① The backlash values shown in the table are the theoretical values for the normal direction for the internal ring in mesh with an SS spur gear.
 ② The allowable torques shown in the table are calculated values according to the assumed usage conditions. Please see Page 207 for more details.
 ③ Please check for the involute interference, trochoid interference and trimming interference prior to using internal gears.
- [Caution on Secondary Operations] ① Please read "Cautions on Performing Secondary Operations" (Page 207) when performing modifications and/or secondary operations for safety concerns.
 KHK Quick-Mod Gears, the KHK system for quick modification of KHK stock gears, is also available.
 ② Avoid performing secondary operations that narrow the tooth width, as it affects precision and strength.

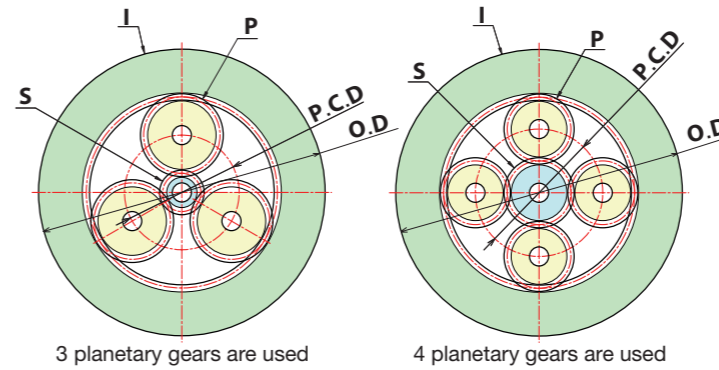
Ground internal gears are available.



Klingelberg Gear Grinding Machine VIPER 500W

Internal ground gear machining range	
Maximum gear accuracy	JIS B 1702-1:1998 Grade N5 (former JIS Grade 1)
Maximum module	About m4 (DP6, CP12), special sizes available
Max. helix angle	27°, right/left helix direction available
Maximum outer diameter	φ 500mm
Minimum inner diameter	φ 150mm
Maximum weight	500 kgf (jig weight included)

Planetary Gear Systems created by using KHK Stock Gears



3 planetary gears are used

4 planetary gears are used

KHK's stock internal and spur gears working together will allow you to create planetary gear devices. "In the table below, we introduce examples of planetary gear. Note 1 are for planetary gear systems created with a stationary internal gear. When used as speed reducers, the input is the sun gear and the output is the carrier. "Selection of the number of teeth also enables you to create various planetary gear devices with different transmission

Speed ratio	Stock gears used in the system													Allowable transmission torque (kgf·m)				Total weight (kg)	
	Internal gears (I)			Planetary gears (P)				Sun gear (S)		Sun gear_T1		Planetary carrier_T2							
	OD(mm)	Catalog Number	No. of teeth	Catalog Number	No. of teeth	Quantity	P.C.D(mm)	Equal angles	Catalog Number	No. of teeth	Bending strength	Surface durability	Bending strength	Surface durability					
Note 1	90	SI1-60	60	SSA1-24	24	3	36	120°	SSS1-12	12	0.58	0.0023	3.47	0.11	0.48				
	130	SI1.5-60		SSA1.5-24			54		SS1.5-12		1.77	0.0081	10.7	0.40	1.20				
	170	SI2-60		SSA2-24			72		SS2-12		4.21	0.020	25.2	0.99	2.66				
	210	SI2.5-60		SSA2.5-24			90		SS2.5-12		8.21	0.040	49.3	1.98	5.03				
	250	SI3-60		SSA3-24			108		SS3-12		14.2	0.070	85.2	3.49	8.57				
	110	SI1-80		SSA1-32			32		3		48	120°	SS1-16	16	0.99	0.0047	5.96	0.24	0.57
	160	SI1.5-80	SSA1.5-32	72	SS1.5-16	3.35		0.026		20.1	1.32		1.72						
	210	SI2-80	SSA2-32	96	SS2-16	7.95		0.064		47.7	3.22		3.85						
	6	260	SI2.5-80	SSA2.5-32	32	3	120	120°	SS2.5-16	16	15.5	0.13	93.2	6.45	7.33				
		105	SI0.8-100	SS0.8-40A			40		4		48	90°	SS0.8-20A	20	0.95	0.0082	5.68	0.41	0.59
		130	SI1-100	SSA1-40							60		SS1-20		1.85	0.016	11.1	0.82	0.84
		190	SI1.5-100	SSA1.5-40	90	SS1.5-20		6.24		0.058	37.5		2.90		2.62				
250		SI2-100	SSA2-40	40	4	120	90°	SS2-20	20	14.8	0.14	88.8	7.09	6.01					
60		SI0.5-80	SS0.5-30B			30		4		25	120°	SS0.5-20A	20	0.23	0.0012	1.13	0.070	0.12	
90		SI0.8-80	SS0.8-30C							40		SS0.8-20A		0.93	0.0050	4.65	0.30	0.40	
110		SI1-80	SSA1-30	50	SS1-20		1.82		0.010	9.08		0.60		0.59					
160		SI1.5-80	SSA1.5-30	75	SS1.5-20		6.13		0.035	30.63		2.13		1.86					
210		SI2-80	SSA2-30	100	SS2-20		14.5		0.087	72.6		5.21		4.18					
260		SI2.5-80	SSA2.5-30	125	SS2.5-20		28.4		0.17	142		10.4		7.97					
5		60	SI0.5-80	SS0.5-20A	20	4	30	90°	SSG0.5-40B	40	0.46	0.0016	1.39	0.10	0.13				
	90	SI0.8-80	SS0.8-20A	48			SS0.8-40A		1.89		0.0068	5.68	0.41	0.35					
	110	SI1-80	SSA1-20	60			SS1-40		3.70		0.014	11.1	0.82	0.60					
	160	SI1.5-80	SSA1.5-20	90			SS1.5-40		12.5		0.048	37.5	2.91	1.77					
	210	SI2-80	SSA2-20	120			SS2-40		29.6		0.12	88.8	7.12	3.93					
	260	SI2.5-80	SSA2.5-20	150			SS2.5-40		57.8		0.24	173	14.3	7.47					
	3	70	SI0.5-100	SS0.5-25B	25	3	37.5	120°	SS0.5-50B	50	0.47	0.0020	1.42	0.12	0.16				
		130	SI1-100	SSA1-25			75		SS1-50		3.79	0.017	11.4	1.01	0.75				
		190	SI1.5-100	SSA1.5-25			112.5		SS1.5-50		12.8	0.060	38.4	3.58	2.24				
		250	SI2-100	SSA2-25	150	SS2-50	30.4	0.15	91.1	8.79	5.02								

Calculation of Allowable Transmission Torque

M ... Made to Order

One advantage of a planetary gear system is that they share load burdens by grouping multiple planetary gears. This enables high torque capacity transmission.

The following formula is the calculation method for T1 (Allowable transmission torque of Sun Gear) and T2 (Allowable transmission torque of Planetary Carrier), shown in the table.

$$T1 = Ts \cdot Zp \cdot \eta \quad (\text{kgf} \cdot \text{m}) \quad \dots (1)$$

$$T2 = Ts \cdot Zp \cdot u \cdot \eta \quad (\text{kgf} \cdot \text{m}) \quad \dots (2)$$

Here,

Ts : Allowable transmission torque for a Sun gear (kgf·m) on a meshed pair of sun gear and planetary gear.

For a sun gear meshed with a planetary gear, the number of revolutions is set to 100rpm.

Zp : Number of planetary gears used in the system

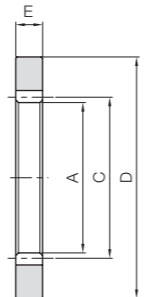
u : Speed ratio

η : Contact efficiency for torque transmission

In consideration of machining accuracy, variation in tooth thickness or other factors on the planetary carrier, the contact efficiency is set to 75%.



Specifications	
Precision grade	JIS grade N9 (JIS B1702-1: 1998)
Gear teeth	Standard full depth
Pressure angle	20°
Material	S45C
Heat treatment	—
Tooth hardness	(less than 194HB)
Surface treatment	Black oxide coating



T1

Catalog Number	Module	No. of teeth	Shape	Dimensions (mm)				Allowable torque				Backlash (mm)	Weight (kg)
				A	C	D	E	(N-m)		(kgf-m)			
SIR2-120	m2	120	T1	236	240	286	20	413	68.8	42.1	7.02	0.12~0.28	2.98
SIR2-200		200		396	400	446	20	677	110	69.0	11.2		
SIR2.5-120	m2.5	120		295	300	355	25	807	138	82.3	14.0	0.14~0.31	5.55
SIR2.5-200		200		495	500	555	25	1320	220	135	22.5		
SIR3-120	m3	120		354	360	424	30	1390	244	142	24.9	0.15~0.35	9.28
SIR3-160		160		474	480	544	30	1840	315	188	32.1		

- [Caution on Product Characteristics]
- The backlash values shown in the table are the theoretical values for the normal direction for the internal ring in mesh with an SS spur gear.
 - The allowable torques shown in the table are calculated values according to the assumed usage conditions. Please see Page 207 for more details.
 - Please check for the involute interference, trochoid interference and trimming interference prior to using internal gears.
- [Caution on Secondary Operations]
- Please read "Cautions on Performing Secondary Operations" (Page 207) when performing modifications and/or secondary operations for safety concerns. KHK Quick-Mod Gears, the KHK system for quick modification of KHK stock gears, is also available.
 - Avoid performing secondary operations that narrow the tooth width, as it affects precision and strength.

Established equipment and technology Custom gears are also available.

Diameter ϕ 700mm maximum, Module 6.5 maximum, Cutting Stroke 170 mm



Gear cutting by CNC Gear Shaper



Racks

MRGF/MRGFD Hardened Ground Racks Material: SCM415 m1.5-3 Page 224	KRGF-H/KRGFD-H Hardened Ground Racks Material: SCM440 m1.5-3 Page 226	KRG/KRGF/KRGFD Thermal Refined Ground Racks Material: SCM440 m1-3 Page 228	SRG/SRGF/SRFGD/SRFGK Hardened Ground Racks Material: S45C m0.5-6 Page 230	KRF-H/KRFD-H Hardened Racks Material: SCM440 m1.5-5 Page 232	SRF-H/SRFD-H Hardened Racks Material: S45C m1.5-6 Page 234	SRF-HL/SRFD-HL Laser Hardened Racks Material: S45C m1.5-6 Page 236
KRF/KRFD Thermal Refined Racks Material: SCM440 m1.5-5 Page 238	SRAF/SRAFD/SRAFK Square Racks Material: S45C m1.5-4 Page 240	SR Racks Material: S45C m0.5-10 Page 242	SRF Steel Racks with Machined Ends Material: S45C m0.5-10 Page 243	SRFD/SRFK Steel Racks with Bolt Holes Material: S45C m0.5-6 Page 244	SUR/SURF/SURFD Stainless Steel Racks Material: SUS304 m1-4 Page 246	DRF/DRFD/DRFK Plastic Racks Material: Polyacetal m1-3 Page 248
PR/PRF Plastic Racks Material: MC901 m1-3 Page 250	BSR Racks Material: Free cutting brass (C3604) m0.5-1 Page 251	SRO/SROS Round Racks Material: S45C m1-5 Page 252	SURO Stainless Steel Round Racks Material: SUS303 m1-3 Page 253	DR Molded Flexible Racks Material: Duracon (R) (M25-44) m0.8-2 Page 254	SSDR/ARL/SRS Rack Clamps for Pinions/Rack Guide Rails For Molded Flexible Racks Material: S45C, etc. Page 254	KRHG/KRHGF/KRHGFD Ground Helical Racks Material: SCM440 m1-3 Page 256
SRH/SRHF/SRHFD Helical Racks Material: S45C m2, 3 Page 258	SRHEF Helical Racks Material: S45C m1.5-6 Page 260	SHE Helical Gears Material: S45C m1.5-6 Page 260	ZST/ZSTD Hardened Ground Helical Racks Material: DIN C45 (S45C equivalent) m2-6 Page 262	ZSTP Ground Helical Gears Material: SCM440 m2-6 Page 262	ZST-GL Assembly Gauges Material: S45C m1.5-6 Page 264	

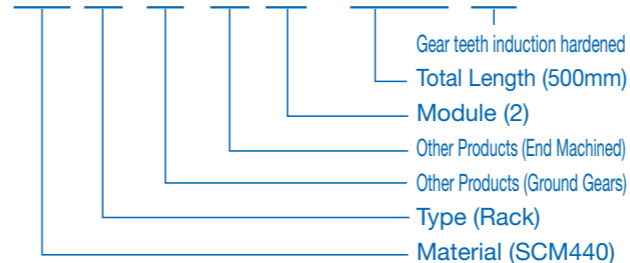
M Includes Made to Order

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) Racks

K R G F 2 - 500 H



Material		Other Information	
M	SCM415	F	Racks with Machined Ends
K	SCM440	D	Racks with Bolt Holes
S	S45C	K	Racks with Drill Holes
SU	Stainless Steel	G	Ground Gears
BS	Brass	H	Gear teeth induction hardened
P	MC901	HL	Laser hardened
D	Polyacetal	ZST	#####
Type			
R	Racks		
RH	Helical Racks		
RO	Round Racks		
S	Spur Gears		
H	Helical Gears		