

**95-0270**

The invention relates to the plastic metal working field and may be used for conic wheels teeth rolling.

The process for conic wheels teeth rolling consists in bringing the wheel into the rotary motion around the vertical axle, the rolling is realized by means of some conic gear rolls, the conic gear rolls are disposed in circumference and communicate them the reciprocating motion around the wheel vertical axle creating them by a radio-frequency ultrasonic generator.

Device for realization of this process comprises a base, a mechanism for wheels rotation around the wheel vertical axle, a gear rolling mechanism having a body, an axle a conic gear roll for teeth rolling, the axle longitudinal reciprocating displacement mode and the wobbling motion node. The conic gear roll is rotary installed. The body wobbling displacement node is made in the form of a crankshaft, a bracket, a cam lever and a pusher.

The crankshaft is mounted on the base vertically over the rotation mechanism and align to the axle of its rotation.

The axle longitudinal displacement node is made in the form of an ultrasound oscillator. The body is freely installed on the crankshaft crank. The axle and node of its longitudinal displacement are fixed to the bracket.