

The invention relates to the holder-type jigs with self-centering, used for centering and holding of conic gearwheels for machining by correction of the central hole and one of the faces.

The conic gearwheel holding jig, according to the first variant, comprises a split frame, consisting of external (1) and internal (2) bushes, which are fixed onto the main spindle of the working machine by means of three threaded couples and a cylindrical inner surface. Between the external (1) and internal (2) bush esthere are made cavities, wherein there is placed hydraulic plastic material. The hydraulic plastic material (6) by means of piston-screws acts on piston-rods (8) regulable by height by means of supports (9), to which there are fastened by means of nuts (10) holding straps (11). Into the external bush (1) there are placed screws (12), coming in contact with spiral grooves (13), made onto the piston-rods (8). Into the hub of the external bush (1) there is fixed by screws (14) a disk (15) wherein there are made holes. Into the holes of the disk (15) there are installed the supports equipped with meshing balls, onto which there is installed a conic gearwheel (18). Between the disk (15) and the holding straps (11), onto the piston-rods (8) there iare installed springs (19). The holding straps (11) can be made with the possibility of holding arm variation.

The holding jig, according to the second variant, comprises piston-rods regulable by height, placed into the external bush, coming in contact with the holding straps wherein there is made a hole, wherein there are installed spring supports, regulable by height, placed into guide grooves, made into the disk fixed by screws into the hub of the external bush.

The supports with meshing balls can be made with self-adjustment, consisted of a flexible articulated element installed onto an axis and contacting with the conic wheel ring by means of two balls simultaneously.

Claims: 4

Fig.: 6

