

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

The conic gearwheel holding jig comprises a split frame, consisting of two parts (1) and (2), which are installed onto the main spindle of the working machine by means of three threaded holes and a cylindrical inside. Between the split parts of the frame (1) and (2) there are made cavities (3), (4) and (5), wherein there is placed the PVC paste (6). By means of piston-screws (7) the PVC paste (6) acts on piston-rods (8) regulable by height due to the thread of the support (9), to which there are fastened by means of nuts (10), holding straps (11). In the first part (1) of the jig frame there is placed a screw (12), coming in contact with the spiral groove (13) of the piston-rod (8). To the part (1) of the jig frame there is fixed by screws (14) a disk (15) with holes. Into the disk (15) there are installed supports (16) with mashing balls (17). Onto the balls (17) there is installed a conic gearwheel (18). Between the disk (10) and the holding straps (11), onto the piston-rod (8), there is installed a spring (19).

Claims: 5

Fig.: 6

