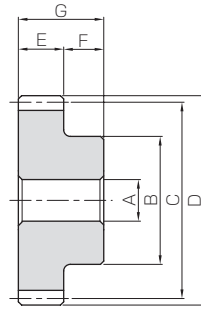


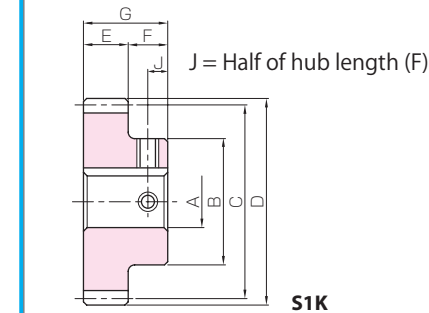


Specifications	
Precision grade	JIS grade N9 (JIS B1702-1:1998)
Reference section of gear	Normal plane
Gear teeth	Standard full depth
Normal pressure angle	20°
Helix angle	45°
Material	S45C
Heat Treatment	—
Surface treatment	Black oxide coating

\* The precision grade of J Series products is equivalent to the value shown in the table.



S1



S1K



To order J Series products, please specify: **Catalog No. + J + BORE.**

Catalog Number	Module	No. of teeth	Direction of spiral	Shape	Bore		Pitch dia.	Outside dia.	Face width	Hub width	Total Length	Allowable torque (N·m)	Allowable torque (kgf·m)	Backlash (mm)	Weight (kg)									
					A-H7	B																		
KSN2.5-10R KSN2.5-10L	m2.5	10	R L	S1	12	26	35.36	40.36	22	16	38	1.27	0.13	0.12~0.24	0.20									
KSN2.5-13R KSN2.5-13L		13	R L		15	35	45.96	50.96																
KSN2.5-15R KSN2.5-15L		15	R L		20	40	53.03	58.03																
KSN2.5-20R KSN2.5-20L		20	R L		20	60	70.71	75.71																
KSN2.5-26R KSN2.5-26L		26	R L		20	70	91.92	96.92																
KSN2.5-30R KSN2.5-30L		30	R L		20	80	106.07	111.07																
KSN3-10R KSN3-10L		m3	10		R L	S1	15	34								42.43	48.43	25	18	43	2.14	0.22	0.12~0.26	0.35
KSN3-13R KSN3-13L			13		R L		20	45								55.15	61.15							
KSN3-15R KSN3-15L	15		R L	20	50		63.64	69.64																
KSN3-20R KSN3-20L	20		R L	20	60		84.85	90.85																
KSN3-26R KSN3-26L	26		R L	20	80		110.31	116.31																
KSN3-30R KSN3-30L	30		R L	20	90		127.28	133.28																
KSN4-10R KSN4-10L	m4		10	R L	S1		20	45	56.57	64.57	30	20	50	4.84	0.49	0.16~0.34	0.72							
KSN4-13R KSN4-13L			13	R L			20	60	73.54	81.54														
KSN4-15R KSN4-15L		15	R L	20		70	84.85	92.85																
KSN4-20R KSN4-20L		20	R L	20		90	113.14	121.14																
KSN4-26R KSN4-26L		26	R L	20		100	147.08	155.08																
KSN4-30R KSN4-30L		30	R L	20		110	169.71	177.71																

- [Caution on Product Characteristics]
- When mating screw gears are made of the same material, they may cause abrasion and scoring. It is recommended to mate screw gears composed of different materials.
  - The allowable torques shown in the table are calculated values according to the assumed usage conditions. Please see Page 342 for more details.
  - The backlash values shown in the table are the theoretical values for the backlash in the normal direction of a pair of identical gears in mesh.
  - For offset shaft applications, match a RH with a RH, or LH with a LH, to make a set of screw gears. For parallel shaft applications, mesh opposite hands (RH and LH) of helical gear sets. Please see Page 342 for more details.
  - If the bore diameter is less than  $\phi 4$ , the bore tolerance class is H8. If the bore diameter is  $\phi 5$  or  $\phi 6$ , and the hole length (total length) exceeds 3 times the diameter, then the class is also H8.

- [Caution on Secondary Operations]
- Please read "Cautions on Performing Secondary Operations" (Page 343) when performing modifications and/or secondary operations for safety concerns.
  - Avoid performing secondary operations that narrow the tooth width, as it affects precision and strength.

Bore H7	* The product shapes of J Series items are identified by background color.																	
	12	15	16	17	18	19	20	22	25	28	30	32	35	40	45	50		
Keyway J <sub>s9</sub>	4x1.8																	
Screw size	5x2.3				6x2.8				8x3.3				10x3.3		12x3.3		14x3.8	
Catalog Number	M4				M5				M6				M8		M10			
KSN2.5-10R J BORE	S1K																	
KSN2.5-10L J BORE	S1K																	
KSN2.5-13R J BORE		S1K	S1K	S1K	S1K	S1K												
KSN2.5-13L J BORE		S1K	S1K	S1K	S1K	S1K												
KSN2.5-15R J BORE		S1K	S1K	S1K	S1K	S1K	S1K	S1K										
KSN2.5-15L J BORE		S1K	S1K	S1K	S1K	S1K	S1K	S1K										
KSN2.5-20R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN2.5-20L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN2.5-26R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K				
KSN2.5-26L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K				
KSN2.5-30R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K			
KSN2.5-30L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K			
KSN3-10R J BORE		S1K	S1K	S1K														
KSN3-10L J BORE		S1K	S1K	S1K														
KSN3-13R J BORE						S1K	S1K	S1K										
KSN3-13L J BORE						S1K	S1K	S1K										
KSN3-15R J BORE						S1K	S1K	S1K	S1K	S1K								
KSN3-15L J BORE						S1K	S1K	S1K	S1K	S1K								
KSN3-20R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN3-20L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN3-26R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K			
KSN3-26L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K			
KSN3-30R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN3-30L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-10R J BORE						S1K	S1K											
KSN4-10L J BORE						S1K	S1K											
KSN4-13R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K						
KSN4-13L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K						
KSN4-15R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN4-15L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K					
KSN4-20R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-20L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-26R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-26L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-30R J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		
KSN4-30L J BORE						S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K	S1K		

- [Caution on J series]
- As available-on-request products, these require a lead-time for shipping within 2 working days (excludes the day ordered), after placing an order.
  - Number of products we can process for one order is 1 to 20 units. For quantities of 21 or more pieces, we need to quote price and lead time.
  - Keyways are made according to JIS B1301 standards, Js9 tolerance.
  - Certain products which would otherwise have a very long tapped hole are counterbored to reduce the length of the tap.
  - Areas of products which have been re-worked will not be black oxide coated.
  - For products having a tapped hole, a set screw is included.

### Features

KHK stock screw gears come in four materials, S45C, SUS303, CAC702 (old JIS A $\ell$ BC2) and MC nylon, in modules 1~4 and numbers of teeth from 10 to 30.

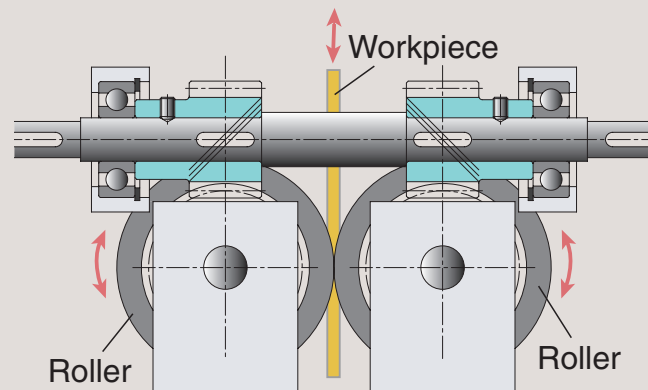
Catalog Number	Module	Material	Heat Treatment	Tooth Surface Finish	Precision JIS B 1702-1:1998	Secondary Operations	Features
KSN	1 to 4	S45C	—	Cut	N9	○	Popular screw gears. Additionally, gear tooth induction hardening secondary operations can be performed. J Series products are also available.
KSUN	1 to 3	SUS303	—	Cut	N9	○	Suitable for food machinery due to SUS303's rust-resistant qualities.
KAN	1 to 4	CAC702 (A $\ell$ BC2)	—	Cut	N9	○	Aluminum bronze made products have excellent wear resistance.
KPN	1 to 3	MC901	—	Cut	N9	○	Light-weight products made of MC Nylon can be used without lubrication.

○ Possible △ Partly possible × Not possible

### Application Examples

KHK stock screw gears are used in various labor-saving machines including feeding devices.

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



Rotate the rollers in reverse with one input shaft and move the pinched workpiece vertically

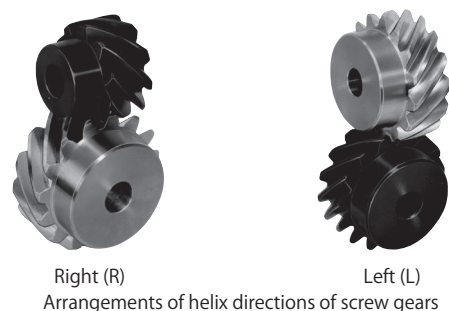
### Selection Hints

Please select the most suitable products by carefully considering the characteristics of items and contents of the product tables. Since screw gears come in right- or left-hand helix, make sure to include the letter "R" or "L" in the catalog number when you order.

#### 1. Caution in Selecting the Mating Gears

Screw gears are used for offset shafts. Whether the shafts are paralleled offset or skewed offset depends on the helix directions of the mating gears.

Direction of shaft	Arrangement of helix hands
Skewed Axes	RH-RH or LH-LH
Parallel Axes	RH-LH



Right (R) Left (L)  
Arrangements of helix directions of screw gears

#### 2. Caution in Selecting Gears Based on Gear Strength

The allowable surface strengths listed in the product pages were derived using the Niemann formula as reference values. (Used with skewed axes)

There is a paucity of data on the strength of screw gears. The values of constant  $K_0$  used in the calculations, which depend on the material of the mating gears, are our estimates. The mathematic expression below shows the Niemann formula to determine allowable tangential force  $F_t$  (kgf) and allowable torque  $T$  (kgf·m) on a basic circle.

$$F_t = 1.43 d_1^2 f_z K_s$$

$$T = \frac{F_t d_1}{2000}$$

Here,  $d_1$  : standard pitch diameter of pinion (mm)  
 $f_z$  : coefficient based on no. of teeth combination  
 $K_s$  : coefficient based on materials and sliding speed

$$K_s = K_0 \frac{2}{2 + V_s}$$

Here,  $K_0$  : coefficient based on material selection  
 $V_s$  : sliding speed (m/s)

$$V_s = \frac{\pi n d_1}{60000 \cos \beta}$$

Here,  $n$  : rotational speed (rpm)  
 $\beta$  : helix angle (45°)

#### ■ $f_z$ value

Z <sub>2</sub> \ Z <sub>1</sub>	10	13	15	20	26	30
10	1.538					
13	2.005	1.538				
15	2.279	1.786	1.538			
20	2.963	2.329	2.053	1.538		
26	3.695	2.963	2.588	2.005	1.538	
30	4.161	3.350	2.963	2.279	1.786	1.538

#### ■ Setting values depending on usage conditions

Catalog Number	Mating gear	K <sub>0</sub> value	Maximum allowable sliding speed m/s	No. of teeth of mating gears	Rotational Speed
KSN	SN	0.0030	2.5	Same no. of teeth	100 rpm
KSUN	SN	0.0030 Note 1	2.5 Note 1		
KAN	SN	0.0050	5		
KPN	SN	0.0030 Note 1 (0.0021)	2.5 Note 1 (1.0)		

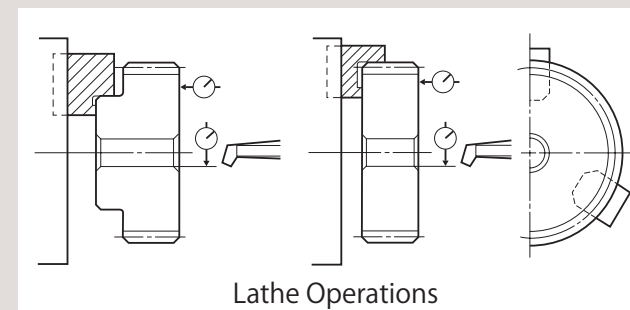
[NOTE 1] K<sub>0</sub> values and the maximum allowable sliding speed of KSUN & KPN products are set by KHK. Screw gears are basically used with lubrication. When using PN products without lubrication, the parenthetical values shown in the table are applied.

### Application Hints

In order to use KHK stock screw gears safely, read the Application Hints carefully before proceeding. Please refer to Page 26 for "Cautions on Handling" and Page 27 for "Cautions on Starting".

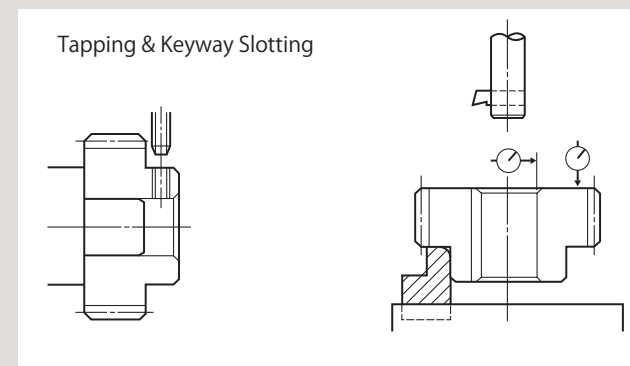
#### 1. Cautions on Performing Secondary Operations

- If re boring, it is important to pay special attention to locating the center in order to avoid runout.
- The reference datum for gear cutting is the bore. Therefore, use the bore for locating the center. If it is too difficult to do for small bores, the alternative is to use one spot on the bore and the runout of the side surface.
- If reworking using scroll chucks, we recommend the use of new or re bored jaws for improved precision. Please exercise caution not to crush the teeth by applying too much pressure. Any scarring will cause noise during operation.



Lathe Operations

- The maximum bore size is dictated by the requirement that the strength of the hub is to be higher than that of the gear teeth. The maximum bore size should be 60% to 70% of the hub diameter (or tooth root diameter), and 50% to 60% for keyway applied modifications.
- In order to avoid stress concentration, round the keyway corners.



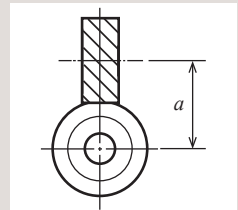
Tapping & Keyway Slotting

#### 2. Points of Caution during Assembly

- KHK stock screw gears are designed to give the proper normal direction backlash when assembled using the center distance given by the formula below with a tolerance of H7 to H8. The amount of backlash is given in the product table for each gear.

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

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



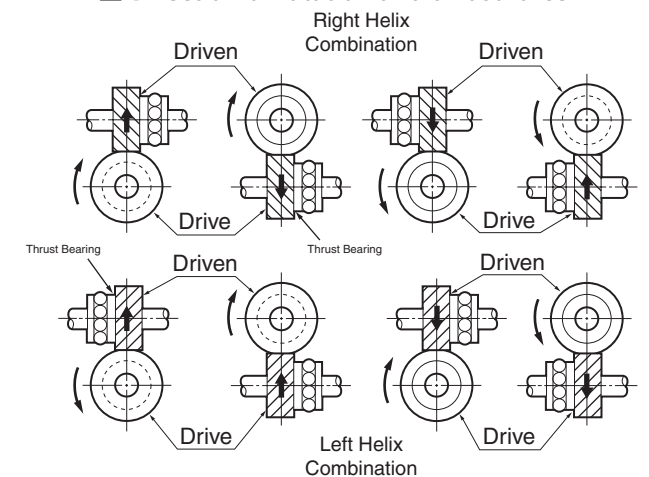
#### ② Total Length Tolerance for Screw Gears

Total Length (mm)	Tolerance
30 or less	0 - 0.10
31 to 100	0 - 0.15

[NOTE] KPN Plastic Screw Gears are excluded.

- Due to the helix of screw gears, they produce axial thrust forces. The bearings must be selected properly to be able to handle these thrust forces. The directions of thrust change with the direction of helix and the direction of rotation as illustrated below.

#### ■ Direction of rotation and thrust force



[NOTE] For parallel shaft applications, see the Application Hints for KHK Helical Gears (Page 167).

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

- When using KHK products, follow relevant safety regulations (Occupational Safety and Health Regulations, etc.).
- Pay attention to the following items when installing, removing, or performing maintenance and inspection of the product.
  - Turn off the power switch.
  - Do not reach or crawl under the product.
  - Wear appropriate clothing and protective equipment for the work.

#### ⚠ Caution Cautions in Preventing Accidents

- Before using a KHK product, read the precautions in the catalog carefully in order to use it correctly.
- Avoid use in environments that may adversely affect the product.
- 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.