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(54) **SPUR TOOTHING ON A COUPLING ELEMENT FOR TRANSMITTING TORQUES**

(71) Applicant: **Schaeffler Technologies GmbH & Co. KG**, Herzogenaurach (DE)

(72) Inventors: **Roland Langer**, Schwanfeld (DE); **Ernst Masur**, Untereuerheim (DE); **Ralf Heiss**, Schweinfurt (DE); **Benno Fueller**, Karlstadt (DE); **Peter Niebling**, Bad Kissingen (DE)

(73) Assignee: **Schaeffler Technologies AG & Co. KG**, Herzogenaurach (DE)

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See application file for complete search history.

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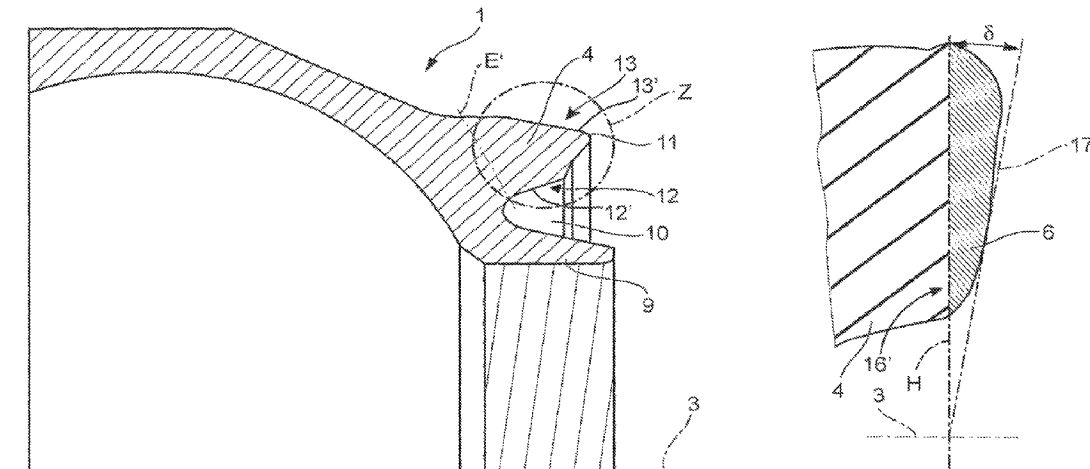
Primary Examiner — Jason L Vaughan

(74) *Attorney, Agent, or Firm* — Simpson & Simpson, PLLC

(57) **ABSTRACT**

The invention relates to a spur toothing on at least one coupling element for transmitting torques about a rotational axis, said spur toothing axially engaging with a corresponding mating cutting. The face cutting is provided with teeth from a material of the coupling element that has been plastically shaped in an at least partially noncutting manner.

16 Claims, 3 Drawing Sheets



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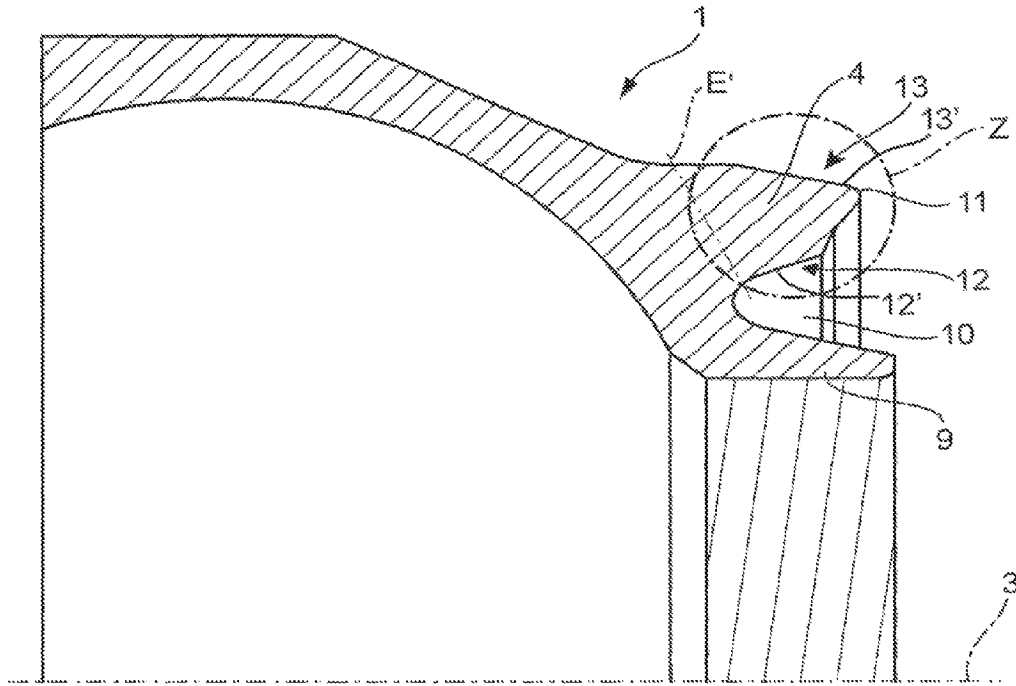


Fig. 1

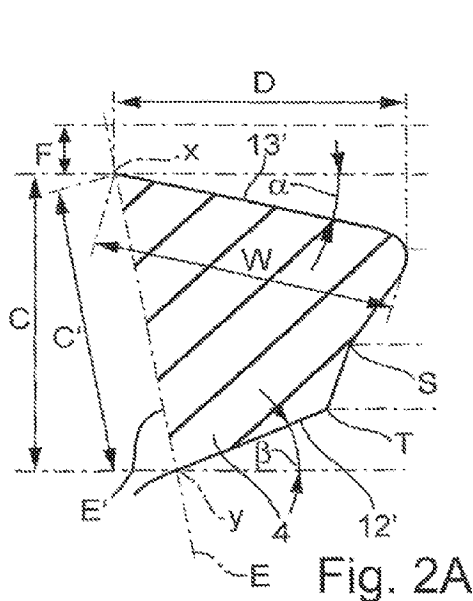


Fig. 2A

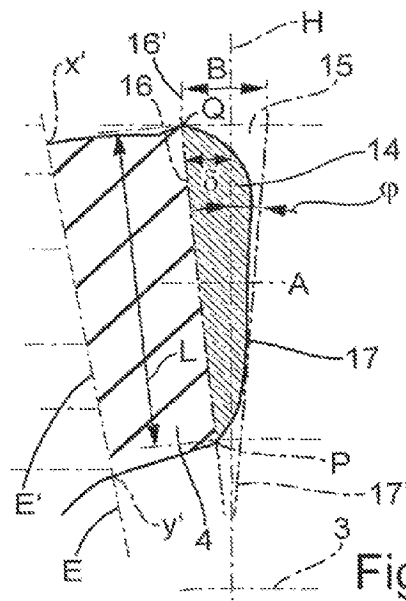
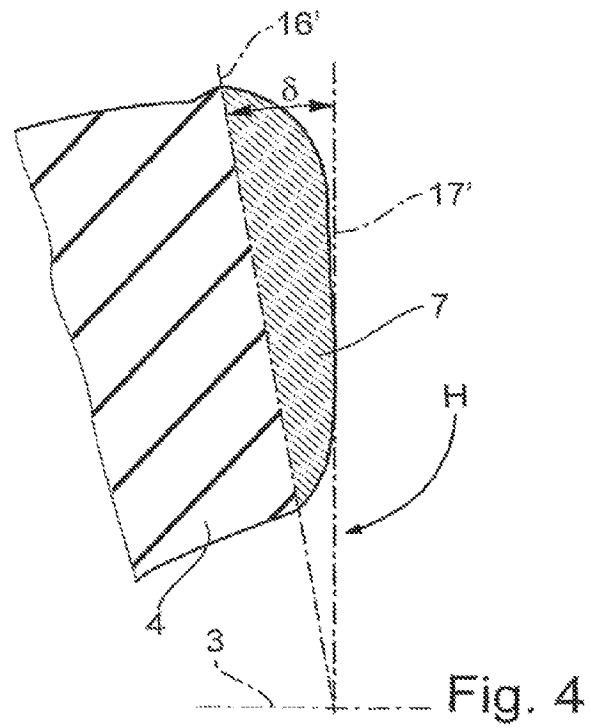
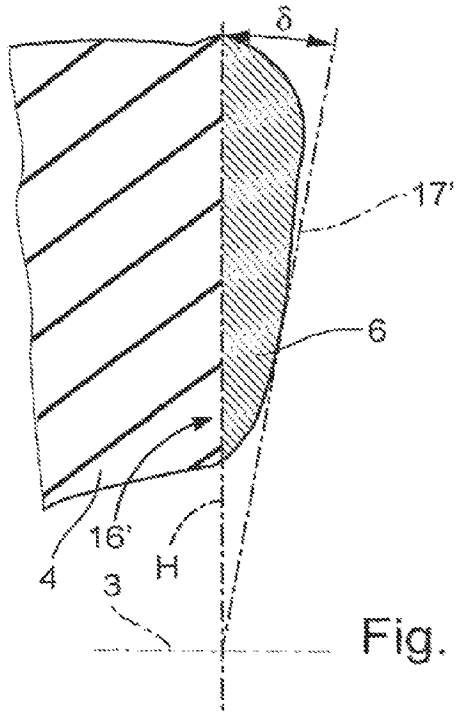


Fig. 2B



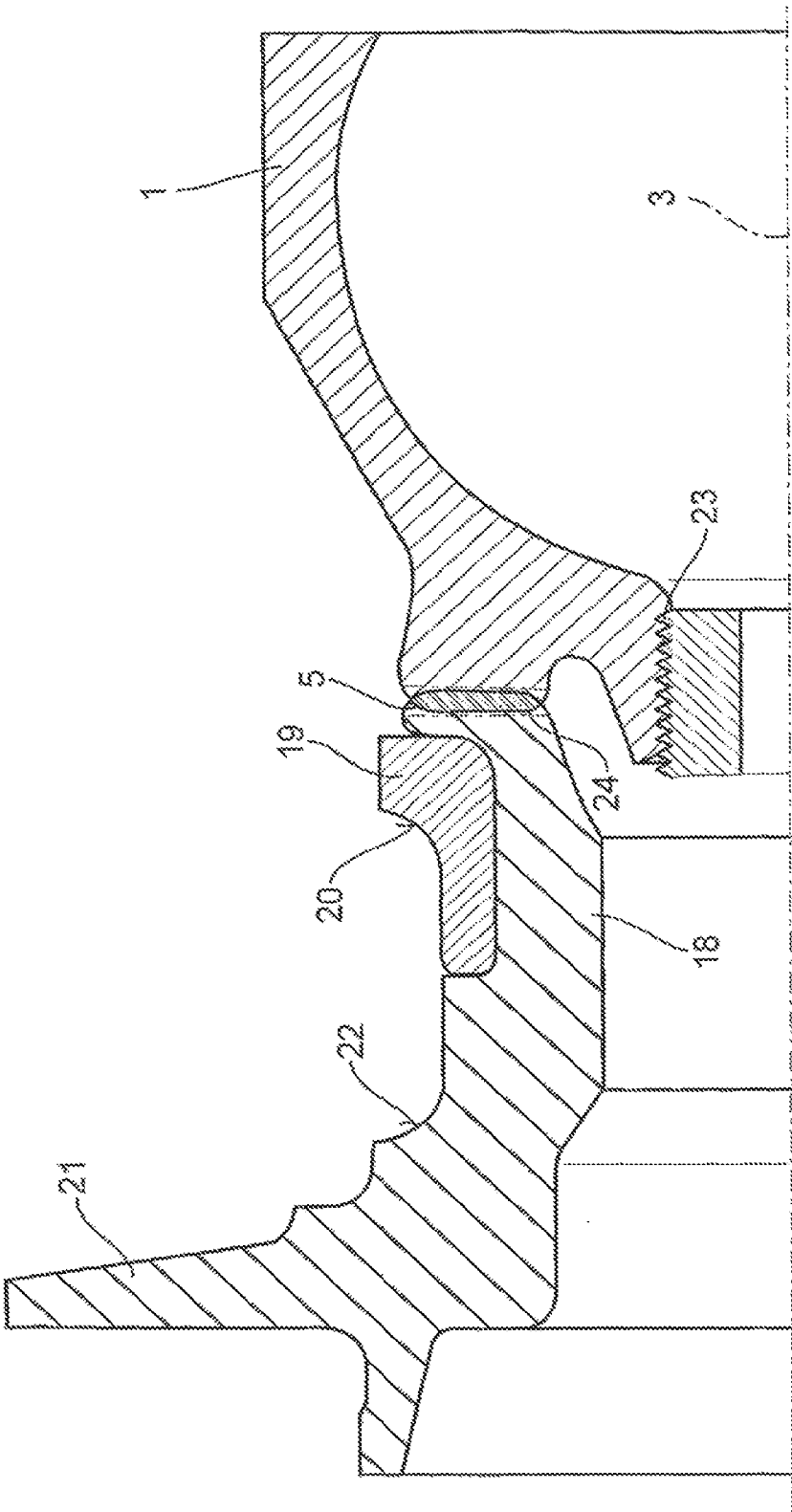


Fig. 5

SPUR TOOTHING ON A COUPLING ELEMENT FOR TRANSMITTING TORQUES

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a divisional of U.S. patent application Ser. No. 11/912,000, filed Oct. 19, 2007, which application is a national stage application of PCT International Application No. PCT/DE2006/000677 filed Apr. 19, 2006, which application claims priority from DE 10 2005 018 127.9 filed Apr. 20, 2005, all of which applications are hereby incorporated by reference herein in their entireties.

FIELD OF THE INVENTION

The invention relates to a spur toothing on at least one coupling element for transmitting torques about a rotational axis, with the spur toothing engaging axially into a corresponding mating toothing, the spur toothing having teeth composed of material, which is at least partially plastically formed in a non-cutting process, of the coupling element.

BACKGROUND OF THE INVENTION

A spur toothing of said type is provided, for example according to DE 36 36 243 A1, in a wheel bearing unit. In the wheel bearing unit, a hub is rotatably mounted by means of a wheel bearing. The hub is connected rotationally fixed connected to a vehicle wheel and can be driven by a cardan shaft arrangement. In the case considered, the hub is coupled to the cardan shaft arrangement. Provided as a coupling element is the bell of a joint, on which bell the spur toothing is formed. The spur toothing faces axially toward a corresponding mating toothing. The mating toothing is likewise a spur toothing and is formed directly on the hub or on an inner ring, which is seated on the hub, of the wheel bearing. The spur toothings engage into one another axially and are clamped to one another axially. By means of said connection, torques about the rotational axis from the cardan shaft arrangement to the hub and therefore to the vehicle wheel, or in the inverse direction are transmittable. The toothings are generally clamped to one another axially in such a way that the tooth flanks are uniformly loaded. This assumes, however, that the geometry of the toothing is formed very precisely, so that the load-bearing component which acts axially and at the peripheral side is very high.

It is provided according to DE 36 36 243 A1 that the spur toothings are formed by cold-forming of certain regions of the material of the coupling elements. For this purpose, the material is plastically displaced by feeding forming dies from the axial direction and partially also by pivoting the dies relative to the rotational axis in the radial direction. The resistance of the material against displacement is particularly high, especially at the coupling element of the cardan shaft arrangement, since the material must be formed directly out of the surface of the coupling element and therefore out of a relatively large and solid material accumulation. The forces required for the forming process are very high. Machines having the correspondingly high required power are expensive. It is difficult to form individual teeth of the toothing with the required accuracy and with a high load-bearing component of the teeth, since a large part of the material escapes radially outward on account of the high forming forces, and does not flow into the forming die.

SUMMARY OF THE INVENTION

It is therefore the object of the invention to create a spur toothing with a high loadbearing component which can be produced cost-effectively.

The object is achieved in that the spur toothing is formed on at least one section which projects axially out of the coupling element. The section, of any desired shape, has the teeth of the spur toothing at least proportionally on an axial end side. The spur toothing can also be the mating toothing of the further coupling element in the torque coupling.

The section, which is preferably formed in one piece with the coupling element, is designed such that, during the forming process, only the material which is required for forming the toothing must be displaced. Further material of the coupling element no longer hinders the forming process, since initially the accumulation of the material is restricted to a minimum. The forces required for the forming process are reduced. It is possible in a cost-effective manner to use machines with lower power characteristics. The teeth are formed better and have a higher load-bearing component.

The invention relates to all couplings for transmitting rotational movements and torques in which at least two coupling elements engage into one another by means of axial spur toothings—preferably torque couplings in wheel bearing units which have a hub which is driven by means of a cardan shaft arrangement.

The geometry of the section is arbitrary. It is thus conceivable for the section to be centered with respect to the rotational axis on a substantially rotationally symmetrical coupling element and formed so as to be rotationally symmetrical about said rotational axis, for example as a truncated cone.

One embodiment of the invention provides that the section runs annularly in a rotationally symmetrical fashion around the rotational axis. This is particularly advantageous, if an axially open annular groove is formed radially between the section, which projects axially out of the coupling element, and a part of the coupling element, that is to say if the annular section concentrically surrounds at least a part of the coupling element.

Further embodiments of the invention relate to the geometric design of the section before forming. It is thus provided that, before the forming of the teeth, the section is delimited at least radially by contours which converge on one another radially, and therefore narrows in cross section in one direction. At the narrower regions of the section, less material must be displaced during the forming. The small amount of material flows in a controlled fashion into the die molds and does not escape in an uncontrolled fashion. With designs of said type, it is therefore possible to influence the precision and the quality of the forming process in a targeted fashion.

The section is preferably designed such that the contours, from the point where the section projects axially from the coupling element, converge on one another radially to an increasing degree in the direction of the end side. The contours are outlined, in arbitrary longitudinal sections which are aligned axially along the rotational axis, initially by contour lines which are situated opposite one another radially and which converge on one another toward the end side.

In one possible embodiment of tile section, tile radially outer contour line in longitudinal section initially runs so as to taper toward the rotational axis in tile direction of the end side, and ultimately merges at the end side into a radially inner contour line. This is for example the case when, on an annular section, the outer diameter of the radial outer contour narrows

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to an increasing degree in the direction of the end side in a continuously linear fashion, a degressive fashion or with an arbitrarily varying profile.

It is also provided that a radially inner contour line in longitudinal section initially runs so as to rise above the rotational axis in the direction of the end side, and then merges at the end side into a radially outer contour line. This is the case when the inner diameter of an annular section becomes larger in the direction of the end side in a continuously linear fashion, or a degressive or progressive fashion, or with an arbitrarily varying profile.

It is advantageous if both of the above-stated profiles are realized simultaneously on one section.

The material which is to be displaced becomes increasingly less with decreasing distance from the end side. When the forming die strikes the end side, initially a small amount of material is displaced. The material therefore provides little resistance to the forming process at the start and does not escape into the forming die and to the side.

The material does not flow outward unintended but rather into the forming die, and is then distributed in the forming die at least partially in the radial directions. The forming die is filled with the material more effectively. The closer the forming die approaches the base axially, the greater the resistance to the flow. The base is the transition at which the section projects from or merges into the mass of the material of the coupling element. The material which is situated in the die is distributed uniformly in the forming die and fills up the latter almost completely. The shape of the teeth on the finished toothing is accordingly better formed.

The shape of the teeth is of optimal design if, before the forming of the teeth, the outline of the section is delimited by the contours, as already described above, which converge on one another radially. The dimensions of the section before the forming and the dimensions of the teeth after the forming are in a predetermined ratio. It is thus provided with one embodiment of the invention that, before the forming of the teeth, the greatest spacing between the contours is where the section projects from the coupling element. The smallest overall length of the formed teeth considered in the axial projection is greater than the greatest spacing in the axial projection by at most $\frac{1}{5}$ of the greatest spacing, considered in the axial projection, between the contours. The overall length considered in the projection can also be smaller than or equal to the axial spacing in the axial projection. The overall length is measured in the tooth root plane of the spur toothing.

Alternatively or at the same time, before the forming of the teeth, the section is at least twice as long in the radial projection as the theoretical tooth height of the formed teeth. In this case, the greatest spacing between the end side and the base at which the section projects axially from the coupling element is projected into the radial projection. The theoretical tooth height is the greatest measured axial spacing between the tooth root plane and the tooth tip plane in a forming die for forming the teeth.

As a result of the invention, it is possible by means of the finished nominal dimensions of the individual teeth and/or of the toothing to design the blank in the form of the section in a simple manner with regard to the forming forces and the material flow.

In this case, a spur toothing and its teeth are to be understood to mean any arrangement of ridges which are adjacent to one another and project axially on the end side, which cooperate in an orderly or arbitrary manner in the vicinity with axial depressions (for example tooth gaps) between the elevations, and which correspond with a corresponding mating toothing. The known form of spur toothing is preferably

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provided, in which teeth and tooth gaps of the teeth are arranged adjacent to one another at the peripheral side and are aligned radially lengthwise. The toothing is preferably produced by means of cold forming from steel; also conceivable, however, is the use of all further conceivable forming processes, the use of light metals or light metal alloys and plastics.

Also provided is cutting finishing of the teeth after the forming process.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will be further understood and appreciated by reading the following description in conjunction with the accompanying drawings, in which:

FIG. 1 is a partial cross-sectional view of a coupling element of the present invention;

FIG. 2A is a partial cross-sectional view showing detail Z of a section of the coupling element from FIG. 1 before the forming of the toothing;

FIG. 2B is a partial cross-sectional view showing detail Z of a section of the coupling element from FIG. 1 after the forming of the toothing;

FIG. 3 is a partial cross-sectional view of an alternative embodiment of the section;

FIG. 4 is a partial cross-sectional view of a further alternative embodiment of the section; and

FIG. 5 is a cross-sectional view of the coupling element fixed to a hub.

DETAILED DESCRIPTION OF THE INVENTION

The invention is explained in more detail below on the basis of exemplary embodiments.

FIG. 1 shows an exemplary embodiment of a coupling element 1 in the form of a joint bell in a cardan shaft arrangement (not illustrated in any more detail). The joint bell, which is formed so as to be substantially rotationally symmetrical about the rotational axis 3, is illustrated partially in a longitudinal section axially along the rotational axis 3. The coupling element 1 is provided with a section 4 which, in FIG. 1, is illustrated in an initial state before the forming process and, in FIGS. 3, 4 and 5, with the toothing 5, 6 or 7 integrally formed thereon.

The section 4 is an annular bead which, on a base E', projects axially in one piece from the material of the coupling element 1 and whose axis of symmetry lies on the rotational axis 3. Formed radially between the section 4 and a part 9 of the coupling element 1 is an annular groove 10. The annular groove 10 is open in the axial direction in which the end side 11 on the section 4 points.

The section 4 is delimited radially by contours 12 and 13 which converge on one another. The contours 12 and 13 proceed from the points X and Y. The plane E which runs through the points X and Y is in this case considered as the base E' of the section 4 at which the section 4 merges into the coupling element 1. The contour 12 is described by the contour lines 12' and 13' in the longitudinal sections along the rotational axis 3 as per FIGS. 1, 2, 3 and 4. The radially outward-running outer contour line 13' is situated radially opposite the radially inwardly running inner contour line 12' at least until the contour lines 12' and 13' merge into one another radially at the end side 11.

FIGS. 2A and 2B shows, as a comparison, and illustrated not to scale and enlarged, the detail Z of the section 4 from FIG. 1 before the forming of the toothing 5 (FIG. 2A), and the

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section 4, which has been formed by means of cold forming, having the toothing 5 (FIG. 2B).

Proceeding from X, the contour line 13' runs initially as a straight line inclined by the α —in the direction of the rotational axis. The angle α is preferably $5^\circ < \alpha < 20^\circ$. In the further profile, the contour line 13' curves in the direction of the rotational axis and merges into the contour line 12'. The contour line 12 rises as a straight line proceeding from Y and is inclined with respect to the rotational axis by the angle β . The angle β is preferably $15^\circ < \beta < 30^\circ$. In the further profile, the contour line 12' bends from the point T and runs with a steeper ascent, as well as from the point S with a shallower ascent, and finally curves in the radial direction in order to merge into the contour line 13'. It is alternatively also conceivable that the contour lines 12' and 13' are described, instead of by straight lines, by curved profiles or by combinations of straight lines and curved profiles.

The dotted lines 16 and 17 in the illustration with the formed teeth 14 of the toothing 5 indicate, in a highly schematized fashion, the contours of a negative form 15 of the die for an individual tooth 14. The negative form 15 is theoretically completely filled with material which has been displaced out of the section 4. The line 16 delimits the tooth root and therefore also represents, in the illustration, a tooth root plane 16 which runs through the points P and Q. The tooth root plane 16' is the transition at which the tooth 14 merges into the section 4 and at the same time marks, in the view, the apex in the base of the tooth gaps. The line 17 marks the theoretical tooth tip line or tooth tip plane 17'.

The greatest spacing C' between the contours 12 and 13 before the forming of the teeth is in the base E' between the points X and Y. In the axial projection, the path C' results in the spacing C. The overall length of the teeth L is, in the tooth root plane 16', the path L between the points P and Q. The axial projection of L is the path A. According to one embodiment of the invention, it is provided that the path A is greater than the path C by at most one-seventh. The points X and Y accordingly barely move in the axial direction during the forming of the teeth. The material which is plastically displaced during the forming therefore flows, in order to form the tooth 14, almost exclusively into the negative form 15.

The greatest length W of the section 4, reflected in the radial projection D before the forming of the teeth 14 is at least twice as long as the theoretical tooth height B of the formed teeth 14. The greatest spacing W between the end side 11 and the base E' is projected into the radial projection. The theoretical tooth height B is the greatest measured axial spacing B between the tooth root plane 16' and the tooth tip plane 17' in a forming die for forming the teeth.

The tooth root plane 16' of the toothing 5 is, in the longitudinal section according to FIG. 2, inclined counterclockwise at an acute angle θ away from the plane H. The plane H is the plane which is penetrated perpendicularly by the rotational axis 3. The tooth tip plane 17' is inclined clockwise by the acute angle ϕ with respect to the plane H. In the illustration according to FIG. 3, of an alternative embodiment of the section 4 after the forming of a toothing 6, the tooth root plane 16' lies in the plane H and is therefore penetrated perpendicularly by the rotational axis 3. The tooth tip plane 17 is, in this case, inclined clockwise by the acute angle ϕ away from the tooth root plane 16' and therefore from the plane.

In the illustration according to FIG. 4, the tooth tip plane 17' of a toothing 7 is penetrated perpendicularly by the rotational axis 3 and therefore lies in the plane H. The tooth root plane 16' is in this case inclined counterclockwise at an acute angle θ away from the tooth root plane 17'.

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FIG. 5 shows, in a longitudinal section, how the coupling element 1 in the form of the joint bell is coupled rotationally fixed to a hub 18. The hub 18 is part of a wheel bearing unit, of which only an inner ring 19 with a raceway 20 for rolling bodies, and a flange 21 on the hub 18 for fastening a vehicle wheel (not illustrated), are illustrated. A further raceway 22 for a further row of rolling bodies is formed on the flange 21. The hub 18 is coupled to the coupling element 1. For this purpose, the toothing 5 and a corresponding mating toothing 24 engage axially into one another and are clamped to one another axially by means of screw elements 23. Torques about the rotational axis 3 can be transmitted between the coupling element 1 and the hub 18.

LIST OF REFERENCE SYMBOLS

1	Coupling element
3	Rotational axis
4	Section
5	Spur toothing
6	Spur toothing
7	Spur toothing
9	Part
10	Annular groove
11	End side
12	Contour
12'	Contour line
13	Contour
13'	Contour line
14	Tooth
15	Negative form
16	Line
16'	Tooth root plane
17	Line
17'	Tooth tip plane
18	Hub
19	Inner ring
20	Raceway
21	Flange
22	Raceway
23	Screw element
24	Mating toothing

What we claim is:

1. A method of forming a spur toothing on a coupling element, the coupling element having a rotational axis extending in an axial direction, and the coupling element having a first section comprising plastically formable material, the first section formed as an annular bead extending in the axial direction from the coupling element, the method comprising the steps of: providing the coupling element having the first section; forming the first section with a die, thereby distributing the material in the die to form the spur toothing proportionally on an axial end side of the first section; wherein the coupling element comprises a second section which extends in the axial direction from the coupling element and is disposed radially inward of the first section whereby, when the spur toothing is formed, an annular groove is formed between the spur toothing and the second section; and wherein, before the step of forming, the first section is delimited radially by a first contour and a second contour disposed radially inwardly of the first contour which converge on one another radially such that a cross section of the first section narrows along the axial direction.
2. The method of claim 1, wherein the method comprises displacing substantially only matter that forms the spur toothing.

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3. The method of claim 1, wherein the coupling element and the first section are both rotationally symmetric about the rotational axis.

4. The method of claim 1 wherein, in the cross section, the first contour and the second contour converge on one another radially to an increasing degree along the axial direction.

5. The method of claim 1 wherein, before the step of forming, in the cross section a greatest spacing between the first contour and the second contour in a radial direction is located where the first section is connected to the coupling element.

6. The method of claim 1 wherein, in the cross section, a smallest overall length of the formed teeth as measured in axial projection after the step of forming is greater than a greatest spacing between the first contour and the second contour in axial projection before the step of forming by at most $\frac{1}{5}$ of the greatest spacing.

7. The method of claim 1 wherein, in the cross section, a smallest overall length of the formed teeth as measured in axial projection after the step of forming is equal to or smaller than a greatest spacing in axial projection before the step of forming.

8. The method of claim 1 wherein, before the step of forming, in a cross section of the first section, the first section is at least twice as long in radial projection as a tooth height after the teeth are formed.

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9. The method of claim 1, wherein the first section comprises steel and the step of forming comprises cold forming the steel.

10. The method of claim 1 wherein, in the cross section, the first contour comprises a first portion that extends linearly from a location where the first section is connected to the coupling element.

11. The method of claim 10, wherein the first portion extends in a direction at an angle of 5 to 10 degrees relative to the rotational axis.

12. The method of claim 1 wherein, in the cross section, the second contour comprises a first portion that extends linearly from a location where the first section is connected to the coupling element.

13. The method of claim 10, wherein the first portion extends in a direction at an angle of 15 to 30 degrees relative to the rotational axis.

14. The method of claim 1 wherein, after the step of forming, the die is substantially completely filled with material that has been displaced from the first section.

15. The method of claim 1, wherein a greatest length of the first section before the step of forming as measured in a radial projection is at least twice as long as the tooth height of the formed teeth.

16. The method of claim 1, wherein a tooth tip plane of the formed teeth is inclined clockwise by an acute angle relative to the tooth root plane.

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UNITED STATES PATENT AND TRADEMARK OFFICE
CERTIFICATE OF CORRECTION

PATENT NO. : 9,289,814 B2
APPLICATION NO. : 14/245734
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INVENTOR(S) : Langer et al.

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

In the claims

Claim 1, line 10, delete "Loathing" and insert --toothing--.



Signed and Sealed this
Thirtieth Day of August, 2016

Michelle K. Lee

Michelle K. Lee
Director of the United States Patent and Trademark Office