



CP Racks & Pinions



KTSCP Tapered Pinions CP5, 10 Page 230	STRCPF · STRCPFD Tapered Racks CP5, 10 Page 230	MSCPG Ground Spur Gears CP5, 10 Page 232	MRGCPF · MRGCPFD Hardened Ground Racks CP5, 10 Page 232	KRGCPF-H · KRGCPFD-H Hardened Ground Racks CP5, 10 Page 234	KRGCP · KRGCFF · KRGCDF Ground Racks CP5, 10 Page 234	SSCPGS Ground Spur Pinion Shafts CP5, 10 Page 236
SSCPG Ground Spur Gears CP5 ~ 20 Page 236	SRGCP · SRGCPF · SRGCPD Ground Racks CP5 ~ 20 Page 238	KRCPF-H · KRCPFD-H Hardened Racks CP5, 10 Page 240	SRCPF-H · SRCPFD-H Hardened Racks CP5 ~ 20 Page 240	KSCP Hardened Spur Gears CP5, 10 Page 242	KRCPF Thermal Refined Racks CP5, 10 Page 242	SSCP Steel Spur Gears CP2.5 ~ 20 Page 244
SRCP · SRCPF · SRCPFD Racks CP2.5 ~ 20 Page 246	SUSCP Stainless Steel Spur Gears CP5, 10 Page 248	SURCPF · SURCPFD Stainless Steel Racks CP5, 10 Page 248	SROCP Round Racks CP2.5 ~ 10 Page 250	FRCP Metal Flexible Racks CP5 Page 250		

Catalog Number of KHK Stock Gears

Catalog Numbers of KHK stock gears are based on simple principles as follows. Please order KHK gears by specifying their Catalog Numbers.

(Example) CP Racks

S R CP 5 - 100

S Total length (100mm)
 R Circular pitch (5mm)
 CP Type (Rack)
 5 Material (S45C)

Material
 S S45C
 K SCM440
 SU SUS304
 F SS400

Other Information
 F Racks with Machined Ends
 D Racks with Bolt Holes
 K Racks with Drill Holes
 G Ground Racks
 H Racks with induction hardened teeth

Type
 R Racks
 RO Round Racks
 TR Tapered Racks

Feature Icons

RoHS Compliant Product	Finished Product	Ground Gear	Resin Product	Injection Molding Product
Re-machinable Product	Heat Treated Product	Stainless Product	Copper Alloy Product	Black Oxide coat-ed Product

- Spur Gears
- Helical Gears
- Internal Gears
- Racks
- CP Racks & Pinions
- Miter Gears
- Bevel Gears
- Screw Gears
- Worm Gear Pair
- Bevel Gearboxes
- Other Products

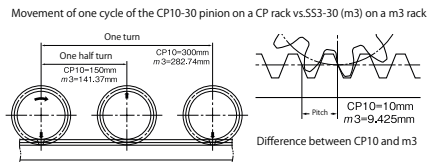
Characteristics



KHK stock CP racks and pinions are suitable in applications where very accurate positioning in linear motion is required. For your convenience, we offer circular pitches of 2.5 to 20 mm and in lengths of 100 to 2000 mm. (FRCP is available to 4000 mm)

About CP Racks & Pinions

The reference pitch of a metric module is computed by multiplying the number of module by π (3.14159). For example, the reference pitch of m3 rack is 9.425 mm (3 × π). When using a rack and a pinion in a linear motion application, the fact that the pitch is not an integral number presents a difficulty in accurate positioning. This problem is solved by CP racks and pinions where one rotation of a pinion moves it precisely 50, 100, 150, ... or 600 mm. The following table lists the main features. The following table lists the main features.



Racks

Catalog No. Note 1	Pitch (mm)	Total Length (mm) No. of teeth	Material	Heat Treatment	Tooth Surface Finish	Precision KHK R 001 () denotes JIS B 1702-1	Features
STRCPF · STRCPFD	5, 10	1000	S45C	—	Cut	4	By pairing with KTSKP pinion, the backlash may be adjusted.
MRGCPF MRGCPFD	1.5 ~ 3	500	SCM415	Tooth area Carburized	Ground	1	Has the highest strength and precision in the KHK standard rack series. Bolt holes can be remachined as carburizing is applied only within the tooth area. J Series products are also available.
KRGCP · H KRGCPFD · H	5, 10	500, 1000	SCM440	Thermal refined, teeth induction hardened	Ground	1	Heat treated ground gears with high precision and strength has excellent cost-performance ratio. J Series products are also available.
KRGCP · KRGCPF KRGCPD	5, 10	100, 500, 1000	SCM440	Thermal Refined	Ground	1	High strength and abrasion-resistant for precision linear motion.
SRGCP · SRGCPF SRGCPFD	5, 10, 15, 20	100, 500, 1000	S45C	Gear teeth induction hardened	Ground	3	Reasonably priced ground racks with abrasion-resistant characteristics. J Series products are also available.
KRCPF · H KRCPFHD	5, 10	1000	SCM440	Thermal refined, teeth induction hardened	Cut	5	This is a strong rack made of Chromoly steel, treated by carburizing. Has high-strength, high wear resistance, and enables downsizing of SR racks. J Series products are also available.
SRCPF · H SRCPFHD	5, 10, 15, 20	1000	S45C	—	Cut	5	Stable Hardened racks with high strength, long life span are reasonably priced. J Series products are also available.
KRCPF · KRCPFHD	5, 10	1000	SCM440	Thermal Refined	Cut	4	Increased strength with SCM440 material which is thermal refined.
SRCP · SRCPF SRCPFD · SRCPFK	2.5, 5, 10, 15, 20	100, 500, 1000, 1500, 2000	S45C	—	Cut	4	Widely applicable due to low cost and large selection of pitches and lengths.
SURCPF SURCPFD	5, 10	500, 1000	SUS304	Solution treated	Cut	5	Suitable for food machinery due to SUS304 material's rust-resistant quality.
SROCP	2.5, 5, 10	500	S45C	—	Cut	4	Convenient in applications where the rack has reciprocal motion.
FRCP	5	2000, 3000, 4000	S5400	—	Cut	8	Cut continuously. Long length and bendable to a contour.

Pinions

KTSKP	5, 10	(20 ~ 40)	SCM440	Thermal refined	Cut	(N8)	By pairing with STRCPF rack, the backlash may be adjusted.
MSCPG	5, 10	(20 ~ 40)	SCM415	Overall carburizing	Ground	(N5)	Designed with positive partial transposition and to have an integral value (mm) for the mounting distance, so both strength and usability are enhanced.
SSCP GS	5, 10	(10 ~ 25)	S45C	Thermal refined, teeth induction hardened	Ground	(N7)	Ground Spur Gears with Pinions, can be directly assembled with the shaft bearing, by modifying the pinion.
SSCPG	5, 10, 15, 20	(20 ~ 40)	S45C	Gear teeth induction hardened	Ground	(N7)	Perform secondary operations to suit your requirement on these ground CP spur gears.
KSCP	5, 10	(20 ~ 40)	SCM440	Thermal refined, teeth induction hardened	Cut	(N9)	Thermal refined and tooth-hardened chromoly racks, excellent in abrasion resistance. Use as mating pinions for KRCPF(-H) Racks.
SSCP	2.5, 5, 10, 15, 20	(20 ~ 40)	S45C	—	Cut	(N8)	Low cost and widely applicable, with a large selection of pitches and numbers of teeth.
SUSCP	5, 10	(20 ~ 30)	SUS303	—	Cut	(N8)	Suitable for food machinery due to SUS303 material's rust-resistant quality.

(NOTE 1) The catalog numbers in the above tables with a suffix of F have both ends machined so that they can be butted against each other to make any desired length. The items with (D) have mounting screw holes for easier assembly.

- For safer handling and to prevent damage such as deformation, KHK stock CP racks have round chamfering on the corners of the top land of the gear tooth. This rounded chamfered shape is patented by KHK. Because it is effective for reducing noise, all of KHK CP racks have this chamfering treatment.
- Black colored products are KHK stock gears that have an applied black oxide coating for rust resistance; this 'blackness' is a product characteristic of KHK stock gears.

Selection Hints



Please select the most suitable products by carefully considering the characteristics of items and contents of the product tables. It is also important to read all applicable notes before the final selection.

1. Caution in Selecting the Mating Gears

- KHK stock CP racks are mated with CP spur gears having the same pitch. Since CP2.5 (m0.796), CP5 (m1.592) and CP10 (m3.183) are very close in size to m0.8, m1.5 and m3 respectively, the selecting the proper mating gear should be verified to make sure that the items are correct. Otherwise, complications could arise.
- STRCPF and STRCPFD Tapered Racks are mated with KTSKP Spur Gears having the same pitch. They can also be mated with other spur gears, however, they can not be used as parallel axis gears due to the setting angles.

2. Caution in Selecting Gears Based on Gear Strength

The gear strength values shown in the product pages were computed by assuming a certain application environment. Therefore, they should be used as reference only. We recommend that each user computes his own values by applying the actual usage conditions. The table below contains the assumptions established for these products in order to compute gear strengths.

Calculation assumptions for Bending Strength

Item	Racks						Pinions						
	MRGCPF MRGCPFD	KRGCPF-H KRGCPFD-H	KRGCP KRGCPF KRCPF	SRGCP SRGCPF SRGCPFD	SRCP · SRCPF SRCPFD SRCPFK	SURCPF SURCPFD FRCP	MSCPG	SSCP GS	SSCPG	KTSKP	KSCP	SSCP	SUSCP
Formula NOTE 1	Formula of spur and helical gears on bending strength (JGMA401-01)												
No. of teeth of mating gear	30						Racks						
Rotation	100rpm												
Durability	Over 10 ⁷ cycles												
Impact from motor	Uniform load												
Impact from load	Uniform load												
Direction of load	Bidirectional												
Allowable bending stress at root, σ_{br} (kgf/mm ²) NOTE 2	47	32	32	20	20	10.5	47	24.5	19	28.5	30	19	10.5
Safety factor, S_F	1.2												

Calculation assumptions for Surface Durability (Except those in common with bending strength)

Item	Formula of spur and helical gears on surface durability (JGMA402-01)												
	MRGCPF MRGCPFD	KRGCPF-H KRGCPFD-H	KRGCP KRGCPF KRCPF	SRGCP SRGCPF SRGCPFD	SRCP · SRCPF SRCPFD SRCPFK	SURCPF SURCPFD FRCP	MSCPG	SSCP GS	SSCPG	KTSKP	KSCP	SSCP	SUSCP
Formula NOTE 1	Formula of spur and helical gears on surface durability (JGMA402-01)												
Kinematic viscosity of lubricant	100cSt (50°C)												
Gear support	Support on one end												
Allowable Hertz stress σ_{Hlim} (kgf/mm ²)	106	112	79	90	52.5	41.3	166	99	90	74.5	112	49	41.3
Safety factor, S_H	1.15												

(NOTE 1) The gear strength formula is based on JGMA (Japanese Gear Manufacturers Association) specifications. The units for the number of rotations (rpm) and the stress (kgf/mm²) are adjusted to the units needed in the formula.

(NOTE 2) The allowable bending stress at the root σ_{br} Film is calculated from JGMA401-01, and set to 2/3 of the value in the consideration of the use of planetary, idler, or other gear systems, loaded in both directions.

Definition of bending strength by JGMA 401-01 (1974)

The allowable bending strength of a gear is defined as the allowable tangential force at the pitch circle based on the mutually allowable root stress of two meshing gears under load.



Example of the failure due to insufficient bending strength.

Definition of surface durability by JGMA 402-01 (1975)

The surface durability of a gear is defined as the allowable tangential force at the pitch circle, which permits the force to be transmitted safely without incurring surface failure.



Example of the defacement due to insufficient surface durability.

3. Selecting Racks By Precision

The precision standards of KHK stock racks are established by us. Please be sure to see the pages below when selecting.

- Pitch Error of Racks NOTE 2 (KHKR001) → Page 190
- Precision of Rack Blanks NOTE 2 → Page 191
- Backlash of Rack Tooth → Page 191

(NOTE 2) Convert CP to m (module) when reference is made to the data in the table. (m=CP/π)

Application Hints

In order to use KHK stock gears safely, carefully read the Application Hints before proceeding. If there are questions or if you require clarifications, please contact our technical department or your nearest distributor.

KHK CO., LTD.
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1. Caution on Performing Secondary Operations

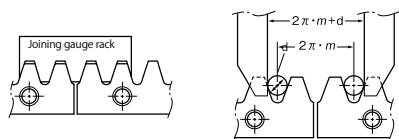
- Secondary operations can be performed on all KHK stock CP racks except for the racks where the gear teeth are induction hardened. To avoid problems of gear precision, do not reduce the face width. The precision of ground racks and racks with mounting holes may drop if you do not exercise extreme caution during installation or while modifying.
- Pitch lines of racks are controlled by using the bottom surface as the reference datum and over-pin measurements on tooth thickness. If you machine the bottom surfaces, the precision of the racks may be affected.
- When connecting two racks, the machining of the mating ends requires careful consideration. The meshing will be poor if the pitch (CP) straddling the connection has a positive tolerance. We recommend a minus tolerance on pitch of at the connection. The below is an indication of pitch tolerance for each module.

Unit : mm

CP	Tolerance
CP2.5	-0.05 -0.25
CP5	-0.1 -0.3
CP10	-0.1
CP15	-0.4
CP20	-0.4

- To use dowel pins to secure racks, attach the racks to the base and drill both simultaneously.
- KHK stock CP racks made of S45C and SCM440 (except for ground racks) can be induction hardened. However, the precision of pitch is decreased.
- To be able to handle parts safely, all burrs and sharp corners should be removed after the secondary operations are done.
- If you are going to modify the gear by gripping the teeth, please exercise caution not to crush the teeth by applying too much pressure. Any scarring will cause noise during operation.

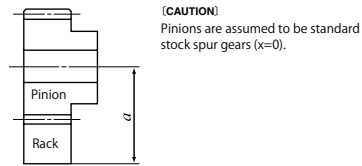
An example of Rack Joining, we recommend the following method.



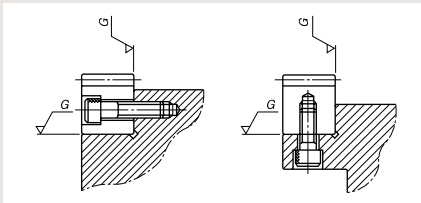
2. Points of Caution in Assembling

- KHK stock CP racks are designed to give the proper backlash when assembled using the mounting distance given by the formula below (mounting distance tolerance of H7 to H8 required). The backlash values are given in the table on Page 191. Make sure that the mounting distance stays constant for the length of the rack.

Mounting distance $a = \text{Height of pitch line of rack} + \text{Pitch radius of pinion}$



- KRGCP type of KHK stock ground racks have four surfaces ground parallel to within $10 \sim 15 \mu\text{m}$. To maintain true angle, they should be mounted on high precision bases as shown below. It is even possible to correct for the angular errors of racks by compensating the mounting base. With recent increases in the requirement for zero backlash linear drives, such accurate assembly as shown is becoming more important.



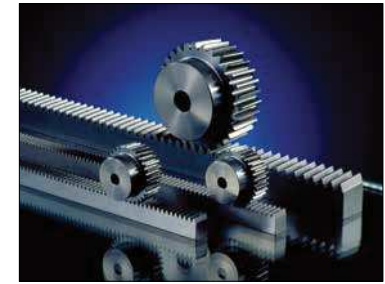
- If the racks are not secured properly to the base, they could shift during operation and cause unexpected problems. It is very important to insure firm mounting by the use of dowel pins or similar devices.
- Machined end type racks such as SRCPF and SRCPFD series have the pitch tolerance of $-0.1/ -0.3$ for modules less than Module 2.5, and $-0.1/ -0.4$ for larger modules. If you try to connect the racks without any space, the pitch at the connection will be too small and will cause problems. Please follow the following diagrams for assembly.



(CAUTION) Joining gauge racks for helical racks must have the opposite hand from the racks. Please use Module 1..10 100 racks as a joining gauge rack, or alternatively the rack of the same specifications on hand.

Features of KHK Tapered Racks and Pinions

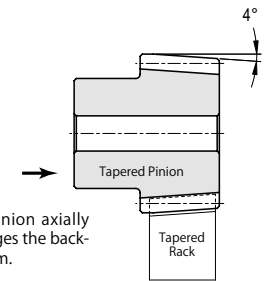
- Easy adjustment of Backlash value
Generally, adjustment of backlash value is made by changing mounting distance (adjusting the height of the motor shaft). The backlash of KHK stock tapered racks and pinions are adjustable only by moving the pinion axially.
- Reasonable Prices
The precision of KHK stock tapered racks and pinions are obtained by rationalization in the production process with our cutting-edge technologies. This enables us to offer quality tapered racks and pinions in the same price range as the CP racks and pinions. (SRCPF and SSC).



Example of Comparison

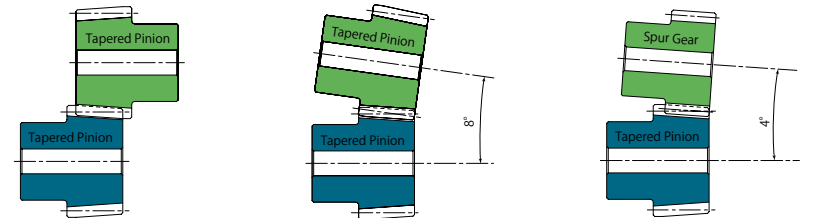
- SRCP5-1000 and SSCP5-30 combination produces a backlash value of 0.1 to 0.26.
- STRCPF5-1000 and KTSCP5-30 combination produces a backlash value of 0.05 or less. (Target value)

- Note above backlash values are theoretical values when meshed under ideal conditions.
- Tapered racks and pinions are not interchangeable with KHK stock CP racks and pinions.
- Different modules, number of teeth, ground gear versions and custom-made items are available as special orders.



Examples of special applications of Tapered Pinions

The shaft angle illustrated below can be obtained by changing the assembly orientation of the tapered spur gear or by mating with a regular spur gear.

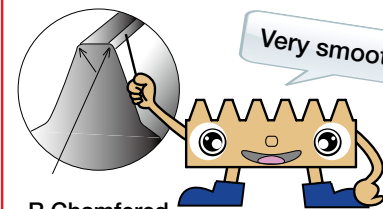


When mating a tapered pinion and a tapered pinion, where each hub is set in opposite direction, a 0° shaft angle is obtained. (Axis Parallel)

When mating a tapered pinion and a tapered pinion, where each hub is set in the same direction, an 8° shaft angle is obtained.

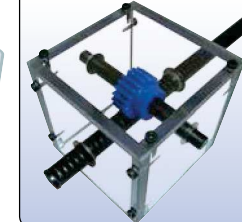
When mating a tapered pinion and a spur gear, a 4° shaft angle is obtained.

Information



R Chamfered

GCU-R Rack Kit



Installation : Parallel axes gear
Gear Type : Racks & Pinions
Gears : SRO1.5-500
PS1.5-20
Weight : Approx. 1kg

Use of racks enables the conversion of rotation motion to linear motion. Applications include devices that provide lift.