

# Sunderland Gear Planers

## Model Nos. 27S, 27DH, 27SDH

**Model No. 27S** Specifically designed machine for the production of spur gears only up to 84 in. diameter.

Two modified versions are available with capacities for cutting gears up to 102 in. (2591 mm) and 128 in. (3251 mm) respectively.

**Model No. 27DH** Double-helical only machine with the capacity for cutting gears of 30° helix angle up to 84 in. diameter.

A modified version is available for cutting double-helical gears with a 22½° helix angle.

Model No. 27DH machines can be converted to Model No. 27SDH machine specifications by the use of additional spur cutting equipment.

**Model No. 27SDH** This machine is suitable for cutting both double-helical and spur gears up to 84 in. diameter.

Two modified versions of the Model No. 27SDH machine are available. One for cutting spur gears up to 102 in. (2591 mm) and another for cutting double-helical gears with a 22½° helix angle.

Specifications	Model No. 27S	Model No. 27DH	Model No. 27SDH
Spur gears, diameter, max.	84 in. (2134 mm)	—	84 in. (2134 mm)
face, max.	20 in. (508 mm)	—	20 in. (508 mm)
D.P., max.	1D.P. (Module 25)	—	1D.P. (Module 25)
Double helical, 30° helix angle, dia.	—	84 in. (2134 mm)	84 in. (2134 mm)
face, max.	—	20 in. (508 mm)	20 in. (508 mm)
D.P., max.	—	1½D.P. (Module 16)	1½D.P. (Module 16)
Minimum diameter at root of teeth	Spur - 7 in. (178 mm) dia. up to 4D.P. Double Helical - 7½ in. (191 mm) dia. up to 2D.P.		
Spindle bore, diameter	9¼ in. (235 mm)	9¼ in. (235 mm)	9¼ in. (235 mm)
Arbor, diameter	5 in. (125 mm)	5 in. (125 mm)	5 in. (125 mm)
Motor, main drive	15hp	15hp	15hp
Size, length × width	16 ft. × 9 ft 6½ in. (4877 × 2915 mm)	16 ft × 9 ft 6½ in. (4877 × 2915 mm)	16 ft × 9 ft 6½ in. (4877 × 2915 mm)
Weight, net, approx.	40814 lb (18513 kg)	41889 lb (18547 kg)	50091 lb (22721 kg)
Weight gross, packed for shipping	42014 lb (19057 kg)	46433 lb (21062 kg)	57657 lb (26153 kg)
Dimensions, packed for shipping	3 crates, 1186 cu. ft. (33,6M³)	3 crates, 1245 cu. ft. (35,3M³)	5 crates, 1457 cu. ft. (41,1M³)

### STANDARD EQUIPMENT

Two driving plates; one four screw chuck; one work arbor 5 in. (123 mm) diameter (unless otherwise ordered); two rim steadies are provided with each set of slides; a motorised coolant pump; one set of crank discs for giving the different lengths of stroke on DH & SDH machines; splash guards; set of spanners; operator's handbook; operating charts; change wheel cabinet and sharpening fixtures.

### ADDITIONAL EQUIPMENT

Spur spiral cutter slide (Model Nos. 27DH & 27SDH, details will be submitted against enquiry).

For Model No. 27 HD machine only—Spur cutter slide assembly and ancillary equipment (interchangeable with the double-helical cutter slides fitted on Model No. 27DH machines).

