

Contents

Chapter 1 Introduction	1
1.0 Cam-Follower Systems	1
1.1 Fundamentals	1
1.2 Terminology	4
Type of Follower Motion.....	4
Type of Joint Closure	4
Type of Follower.....	5
Type of Cam.....	6
Type of Motion Constraints	8
Type of Motion Program	8
1.3 Applications	9
1.4 Timing Diagrams	11
1.5 Cam Design Software.....	12
1.6 Units.....	12
1.7 References.....	14
Chapter 2 Unacceptable Cam Curves	16
2.0 Introduction.....	16
2.1 S V A J Diagrams	16
2.2 Double-Dwell Cam Design—Choosing S V A J Functions.....	18
2.3 The Fundamental Law of Cam Design	21
2.4 Simple Harmonic Motion (SHM)	21
2.5 Constant Acceleration (Parabolic Displacement).....	24
2.6 Cubic Displacement	24
2.7 Summary	25
2.8 References.....	25
Chapter 3 Double-Dwell Cam Curves	26
3.0 Introduction.....	26
3.1 Cycloidal Displacement for Double dwells.....	26
3.2 Combined Functions for Double dwells.....	29
Fall Functions.....	40
3.3 The SCCA Family of Double-Dwell Functions	40
3.4 Polynomial Functions.....	44
The 3-4-5 Polynomial.....	45
The 4-5-6-7 Polynomial	48
3.5 Fourier Series Functions	51
3.6 Summary	55
3.7 References.....	55
Chapter 4 Single-Dwell Cam Curves	56
4.0 Introduction	56
4.1 Single-Dwell Cam Design—Choosing S V A J Functions	56
4.2 Single-Dwell Applications of Polynomials	60
Effect of Asymmetry on the Rise-Fall Polynomial Solution	61
4.3 Summary	67

Chapter 5 Spline Functions..... 68

5.0	Introduction	68
5.1	Classical Splines	69
	<i>Knots</i>	69
	<i>Interpolation Equations</i>	70
	<i>Smoothness Equations</i>	70
	<i>Boundary Conditions</i>	71
	<i>Computation</i>	73
5.2	General Polynomial Splines.....	81
5.3	B-splines	85
5.4	Bezier Curves	96
5.5	Shape Preserving Splines	97
	<i>Hermite Splines</i>	98
	<i>Shumaker Quadratic Splines</i>	100
5.6	Knot Placement	105
5.7	Periodic Splines	114
5.8	Splines Other Than Polynomial Splines.....	118
	<i>Trigonometric Splines</i>	118
	<i>Rational Splines</i>	119
5.9	Summary	120
5.10	Bibliography	121

Chapter 6 Critical Path Motion Cam Curves..... 124

6.0	Introduction	124
6.1	Constant Velocity Motion	124
	<i>Polynomials Used for Critical Path Motion</i>	125
	<i>Half-Period Harmonic Family Functions</i>	132
6.2	Combined Displacement and Velocity Constraints.....	136
6.3	Summary	147

Chapter 7 Cam Size Determination 148

7.0	Introduction	148
7.1	Pressure Angle—Radial cam with Translating Roller Follower	149
	<i>Eccentricity</i>	150
	<i>Choosing a Prime Circle Radius</i>	153
7.2	Pressure Angle—Barrel Cam With Translating Roller Follower	154
7.3	Pressure Angle—Barrel Cam With Oscillating Roller Follower	156
7.4	Overturning Moment—Radial Cam With Translating Flat-Faced Follower	158
7.5	Pressure Angle—Radial Cam With Oscillating Roller Follower	159
7.6	Pressure Angle—Globoidal Cam With Oscillating Roller Follower	162
7.7	Radius of Curvature—Radial Cam With Translating Roller Follower	163
7.8	Radius of Curvature—Radial Cam With Translating Flat-Faced Follower	167
7.9	Radius of Curvature—Barrel Cam With Translating Roller Follower	171
7.10	Radius of Curvature—Barrel Cam With Oscillating Roller Follower	171
7.11	Radius of Curvature—Radial Cam With Oscillating Roller Follower	172
7.12	Radius of Curvature—Radial Cam With Oscillating Flat-Faced Follower	172
	<i>Undercutting of Radial Cams with Oscillating Flat-Faced Followers</i>	173
7.13	Radius of Curvature—Globoidal Cam With Oscillating Roller Follower	174
7.14	References	175

Chapter 8 Dynamics of Cam Systems—Modeling Fundamentals..... 176

8.0	Introduction	176
8.1	Newton's Laws of Motion	176
8.2	Dynamic Models	177
8.3	Mass	177
8.4	Mass Moment and Center of Gravity	178
8.5	Mass Moment of Inertia (Second Moment of Mass)	180
8.6	Parallel Axis Theorem (Transfer Theorem)	181
8.7	Radius of Gyration	182
8.8	Modeling Rotating Links	183
8.9	Lumped Parameter Dynamic Models	184
	<i>Spring Rate</i>	184
	<i>Damping</i>	184
8.10	Equivalent Systems	187
	<i>Combining Dampers</i>	189
	<i>Combining Springs</i>	190
	<i>Combining Masses</i>	191
	<i>Lever and Gear Ratios</i>	191
8.11	Modeling Nonlinear Springs	196
	<i>Determining the Effective Spring Rate of an Air Cylinder</i>	200
8.12	Modeling an Industrial Cam-Follower System	205
8.13	References	211

Chapter 9 Dynamics of Cam Systems—Force, Torque, Vibration 212

9.0	Introduction	212
9.1	Dynamic Force Analysis of the Force-Closed Cam-follower	212
	<i>Undamped Response</i>	214
	<i>Damped Response</i>	216
9.2	Resonance	222
	<i>Follower Rise Time</i>	223
9.3	Estimating Damping	225
	<i>Logarithmic Decrement</i>	226
9.4	Kinetostatic Force Analysis of the Force-closed Cam-Follower	231
9.5	Kinetostatic Force Analysis of the Form-Closed Cam-Follower	235
9.6	Kinetostatic Camshaft Torque	239
9.7	Controlling Cam Speed—Motors	243
	<i>Electric Motors</i>	243
9.8	Controlling Cam Speed—Flywheels	250
9.9	Torque Compensation Cams	256
9.10	References	262

Chapter 10 Modeling Cam-Follower Systems 263

10.0	Introduction	263
10.1	Degrees of Freedom	264
10.2	Single-Mass SDOF Linear Dynamic Models	265
	<i>Force-Closed Models</i>	266
	<i>Form-Closed Model</i>	268
10.3	Two-Mass, one- or two-DOF, Nonlinear Dynamic Model of a Valve Train	269
10.4	Multi-DOF Dynamic Model of a Valve Train	271
10.5	One-mass Model of an Industrial Cam-Follower System	273
10.6	Two-Mass Model of an Industrial Cam-Follower System	278
10.7	Multi-Degree-of-Freedom (MDOF) Models	281
	<i>Two-Degree-of-Freedom Models</i>	281
	<i>Three-Degree-of-Freedom Models</i>	285

10.8	Solving 1-DOF System Differential Equations	286
	<i>Block Diagram Solution—Simulink/MatLab</i>	286
	<i>Ordinary Differential Equation Solution—Using Mathcad</i>	289
	<i>State Space Solutions</i>	289
10.9	Solving Multi-DOF System Differential Equation Sets	294
10.10	Modeling a Cam-Follower System With Impact	300
10.11	Polydyne Cam Functions	305
	<i>Double-Dwell Polydyne Curves</i>	314
10.12	Splinedyne Cam Functions	323
10.13	References	328

Chapter 11 Residual Vibrations in Cam-Follower Systems 330

11.0	Introduction	330
11.1	Residual Vibration	330
11.2	Residual Vibration of Double-Dwell Functions	331
11.3	Double-Dwell Functions for Low Residual Vibration	334
	<i>Freudenstein 1-3 Fourier Series (Harmonic) Function</i>	336
	<i>Gutman F-3 Fourier Series (Harmonic) Function</i>	336
	<i>Berzak-Freudenstein Polynomials</i>	337
	<i>Residual Vibration Spectra for "Low Vibration" Functions</i>	340
	<i>Actual Cam Performance Compared to Theoretical Performance</i>	346
11.4	References	348

Chapter 12 Failure of Cam Systems—Stress, Wear, Corrosion 350

12.0	Introduction	350
12.1	Surface Geometry	352
12.2	Mating Surfaces	353
12.3	Adhesive Wear	355
12.4	Abrasive Wear	357
	<i>Abrasion-Resistant Materials</i>	357
12.5	Corrosion Wear	357
	<i>Corrosion Fatigue</i>	358
	<i>Fretting Corrosion</i>	359
12.6	Stress	360
12.7	Strain	362
12.8	Principal Stresses	362
12.9	Plane Stress and Plane Strain	365
	<i>Plane Stress</i>	365
	<i>Plane Strain</i>	365
12.10	Applied Versus Principal Stresses	366
12.11	Surface Fatigue	367
12.12	Spherical Contact	369
	<i>Contact Pressure and Contact Patch in Spherical Contact</i>	369
	<i>Static Stress Distributions in Spherical Contact</i>	371
12.13	Cylindrical Contact	373
	<i>Contact Pressure and Contact Patch in Parallel Cylindrical Contact</i>	374
	<i>Static Stress Distributions in Parallel Cylindrical Contact</i>	375
12.14	General Contact	377
	<i>Contact Pressure and Contact Patch in General Contact</i>	378
	<i>Stress Distributions in General Contact</i>	379
12.15	Dynamic Contact Stresses	382
	<i>Effect of a Sliding Component on Contact Stresses</i>	382
12.16	Surface Fatigue Failure Models—Dynamic Contact	390
12.17	Surface Fatigue Strength	393

12.18	Roller Followers	398
	<i>Types of Rolling-Element Bearings</i>	401
12.19	Failure of Rolling-element bearings	401
12.20	Selection of Rolling-Element Bearings	402
	<i>Basic Dynamic Load Rating C</i>	402
	<i>Basic Static Load Rating C₀</i>	403
	<i>Calculation Procedures</i>	403
12.21	References	405

Chapter 13 Cam Profile Determination..... 407

13.0	Introduction	407
	<i>Inversion</i>	408
	<i>Digitization Increment</i>	408
13.1	Radial Cams With Roller Followers	409
	<i>Offset Translating Roller Follower</i>	409
	<i>Oscillating Roller Follower</i>	413
13.2	Radial Cams With Flat-Faced Followers	416
	<i>Radial Cams with Translating Flat-Faced Followers</i>	417
	<i>Radial Cams with Oscillating Flat-Faced Followers</i>	419
13.3	Barrel Cams With Roller Followers	421
	<i>Barrel Cam With Translating Roller Follower</i>	421
	<i>Barrel Cam With Oscillating Roller Follower</i>	423
13.4	Linear Cams With Roller Followers	426
13.5	Globoidal Cams with Oscillating Arm Roller Followers	427
13.6	Conjugate Cams	429
	<i>Designing Conjugate Cams</i>	429
	<i>Conjugate Radial Cams With Translating Followers</i>	429
	<i>Conjugate Radial Cams With Oscillating Followers</i>	431
	<i>Conjugate Axial Ribbed Cams With Oscillating Followers</i>	432
	<i>Indexing Cams</i>	433
13.7	Cam-Linkage Combinations	436
	<i>Modifying the Cam Contour for Follower Linkage Geometry</i>	436
13.8	Shifting the Cam Contour to Machine Zero	437
13.9	References	438

Chapter 14 Cam Materials and Manufacturing..... 439

14.0	Introduction	439
14.1	Cam Materials	440
	<i>Cast Irons</i>	440
	<i>Wrought Steels</i>	441
	<i>Forged Steel</i>	441
	<i>Sintered Metals</i>	442
	<i>Steel Numbering Systems</i>	442
14.2	Hardness	444
14.3	Heat Treatment	445
	<i>Surface (Case) Hardening</i>	447
14.4	Cam Manufacturing Methods	448
	<i>Geometric Generation</i>	448
	<i>Manual or NC Machining to Cam Coordinates (Plunge-Cutting)</i>	449
	<i>Continuous Numerical Control with Linear Interpolation</i>	450
	<i>Continuous Numerical Control with Circular Interpolation</i>	453
	<i>Analog Duplication</i>	454
14.5	Cutting the Cam	456
	<i>Interpolation Method</i>	458
	<i>Digitization Increment</i>	458
	<i>Resampling the Data</i>	459

14.6	Pythagorean Hodographs	460
14.6	Manufacturing Methods	463
	Finishing Processes	463
	Polishing Processes	464
14.7	Surface Coatings	464
14.8	Measuring the Cam	465
14.9	References	465
14.10	Bibliography	466

Chapter 15 Lubrication of Cam Systems 467

15.0	Introduction	467
15.1	Lubricants	469
15.2	Viscosity	470
15.3	Types of Lubrication	471
	Full-Film Lubrication	472
	Boundary Lubrication	475
15.4	Material Combinations in Cam-Follower Joints	476
15.5	Hydrodynamic Lubrication Theory	476
	Petroff's Equation for No-Load Torque	476
	Reynolds' Equation for Eccentric Journal Bearings	477
15.6	Nonconforming Contacts	480
15.7	Cam Lubrication	487
15.8	References	489

Chapter 16 Cam- and Servo-Driven Mechanisms 490

16.0	Introduction	490
16.1	Servomotors	491
16.2	Servo Motion control	492
	Servo Motion Functions	492
16.3	Cam-Driven Linkages	493
16.4	Servo-Driven Linkages	501
16.5	Other Linkages	507
16.6	Cam-Driven Versus Servo-Driven Mechanisms	507
	Flexibility	508
	Cost	508
	Reliability	508
	Complexity	508
	Robustness	509
	Packaging	509
	Load Capacity	509
16.7	References	510
16.8	Bibliography	510

Chapter 17 Measuring Cam-Follower Performance 511

17.0	Introduction	511
17.1	Transducers	511
	Angular Position Transducers	512
	Displacement Transducers	513
	Velocity Transducers	515
	Strain Transducers	515
	Force Transducers	515
	Acceleration Transducers	517
	Vibration Measurement	518

17.2	Experimental Cam-Follower Measurements	519
17.3	Data Analysis.....	520
	<i>Analog to Digital Conversion</i>	520
	<i>Spectrum Analysis</i>	522
	<i>Forms of Spectra</i>	525
	<i>Modal Domain</i>	526
	<i>Frequency Response Functions (FRF)</i>	527
	<i>Dynamic Signal Analyzers</i>	528
	<i>Measuring the FRF</i>	528
	<i>The "Q" of a System</i>	530
	<i>Convolution and Deconvolution</i>	531
17.4	References.....	534
17.5	Bibliography	534
Chapter 18 Case Studies.....		535
18.0	Introduction.....	535
18.1	Analyzing Vibrations in an IC Engine Valve Train.....	535
	<i>Conclusions</i>	546
18.2	Analyzing Vibrations in Cam-Driven Automated Assembly Machinery.....	547
	<i>Conclusions</i>	555
18.3	References.....	556
Chapter 19 Cam Design Guidelines		557
19.0	Introduction.....	557
19.1	Practical Design Considerations.....	557
	<i>Translating or Oscillating Follower?</i>	557
	<i>Force or Form-Closed?</i>	558
	<i>Radial or Barrel Cam?</i>	559
	<i>Roller or Flat-Faced Follower?</i>	559
	<i>To Dwell or Not to Dwell?</i>	561
	<i>To Grind or Not to Grind?</i>	561
	<i>To Lubricate or Not to Lubricate?</i>	562
	<i>What Double-Dwell Cam Program to Use?</i>	563
	<i>What Cam Program to Use For Difficult or Complicated Motions?</i>	563
	<i>To Polydyne or Not to Polydyne?</i>	563
	<i>Camshaft Design</i>	564
	<i>Follower Train Design</i>	564
	<i>Follower Train Dynamics</i>	564
	<i>Natural Frequencies</i>	565
	<i>Backlash</i>	565
	<i>How Important is Theoretical Peak Acceleration?</i>	565
19.2	Rules of Thumb for Cam Design.....	566
19.3	References.....	568
Appendix A Computer Programs		569
Appendix B Material Properties.....		571
Appendix C Geometric Properties		575
Bibliography.....		577
Glossary of Terms		597
Index		599