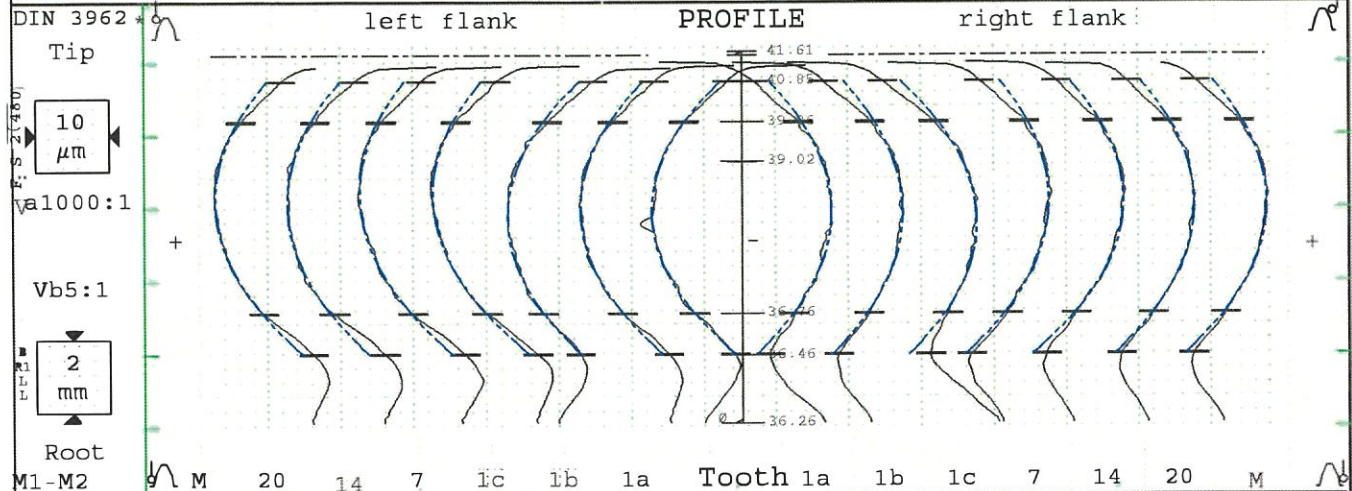
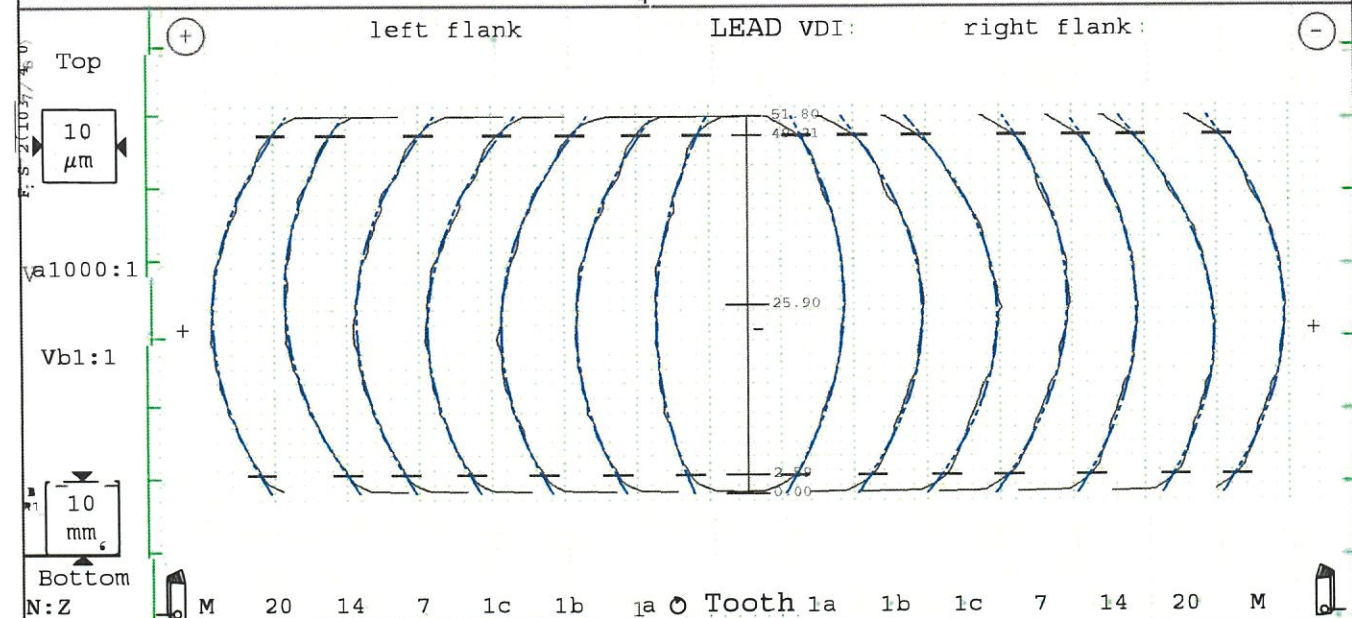


Gear Profile/Lead

Prog.No.: GST0435 05 4.24.0 0	P 26 601738	Operator:	Date: 19.10.2023 09:02
Type: COM PINION GEAR	No. of teeth 26	Face Width: 51.8mm	
Drawing No.: 596504-3 HONING SM	Module m 1.4468mm	Length Ev. La 5.26mm	
Order No.: 0945 C1F1 2905	Pressure angle 20°	Length Ev. Lb 46.62mm	
Cust./Mach. No.: 02905	Helix angle 13.727°	Appr. Length M1 3.01mm	
Loc. of check: QDASMX	Base Cir.-Ø db 36.2612mm	Stylus-Ø (#4) 0.8mm	
Condition:	Base Helix angle 12.884°	Add.Mod.Coeff x 0.108	



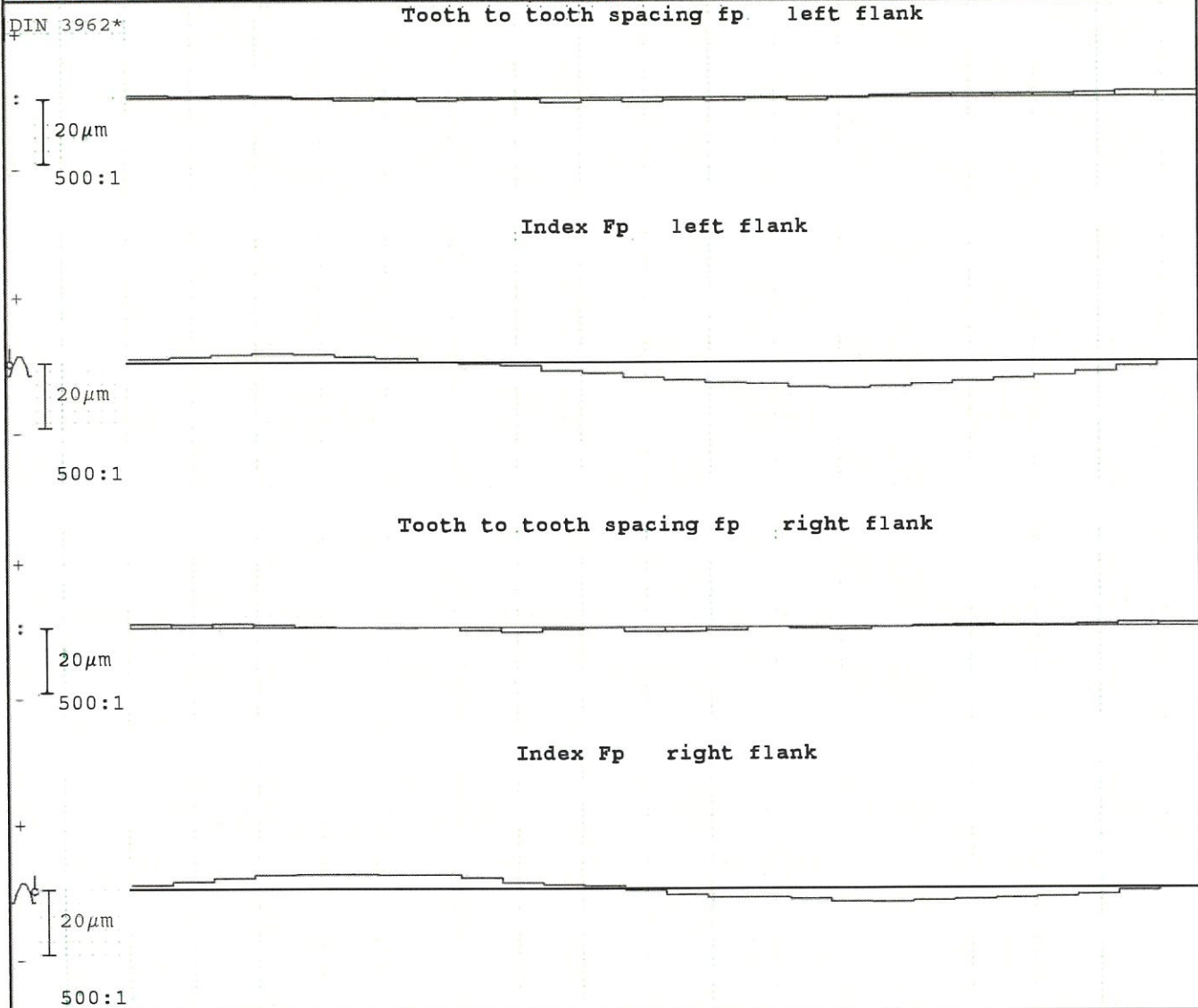
	Act.value[μ m]						Lim.value Qual		Act.value[μ m]						Quality	
fH α m	3.4						B	2.8	8							
fH α	2.7	4.6	4.6 x	0.1	1.8	1.4										
F α	3.5	4.6	4.6 x	1.8	2.3	3.4										
ff α	1.2	0.8	0.8	1.1	0.8	2.0 x										
C α	4.5	4.4	4.7	4.9	4.9	5.2										
fFu	-7.9	-7.7	-7.3	-5.4	-6.8	-5.9										
fKo	-5.8	-6.1	-6.1	-6.8	-6.2	-6.0										
ff α i	0.5	0.5	0.3	0.4	0.3	0.5										
UCut	-9.7	-9.8	-9.0	-5.9	-8.2	-6.4										
R/T- σ [mm]	34.175															



	Act.value[μ m]						Lim.value Qual		Act.value[μ m]						Quality	
fH β m	-2.2						B	7.1	14							
fH β	2.3	-2.5	-4.8	-4.8 x	-3.8	-1.8										
F β	2.5	2.3	3.9	3.9 x	3.3	2.8										
ff β	0.8	1.0	1.3 x	1.1	1.1	1.0										
C β	7.4	7.7	7.7	7.6	7.0	5.0										
ff β i	0.4	0.0	0.0	0.5	0.5	0.0										

Gear Spacing

Prog.No.: GST0435 05 4.24.0 0	P 26 601738	Operator:	Date: 19.10.2023 09:02
Type: COM PINION GEAR		No. of teeth 26	Pressure angle 20°
Drawing No.: 596504-3 HONING SM		Module m 1.4468mm	Helix angle 13.727°
Order No.: 0945 C1F1 2905		Loc. of check: QDASMX	
Cust./Mach. No.: 02905		Condition:	



Pitch measuring circle: 39.008 z=25.9mm		left flank		right flank	
		Act.value	Qual.	Act.value	Qual.
Worst pitch variation	fp max	1.7		1.5	
Worst spacing variation	fu max	1.0		1.1	
Range of Pitch Error	Rp	3.2		2.7	
Total index variation	Fp	11.0		8.7	
Total index var. within sector	Fpz/8	4.6		3.6	

