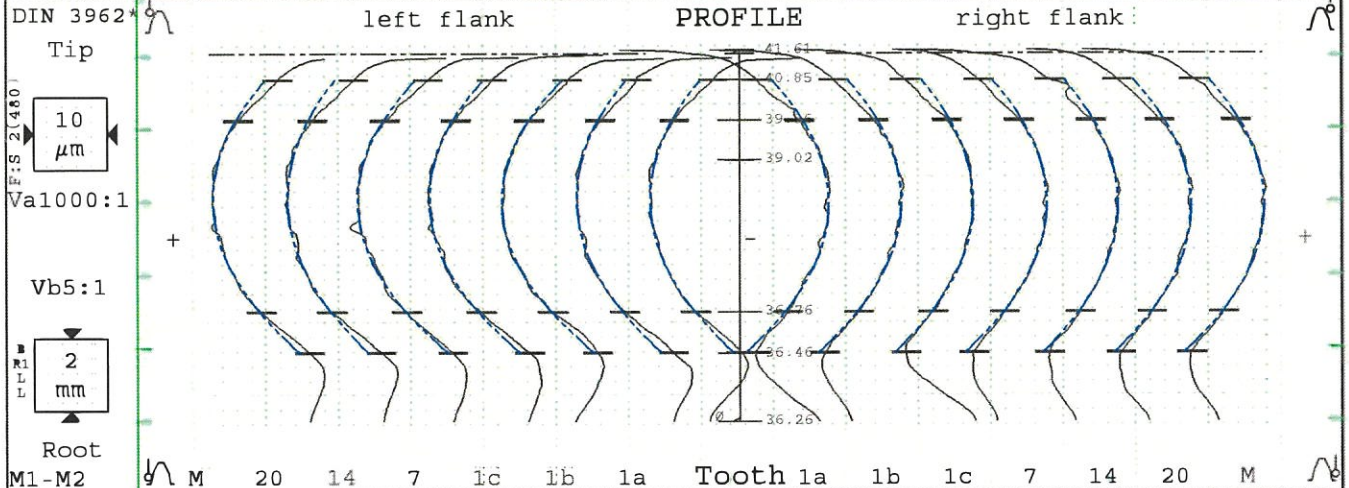
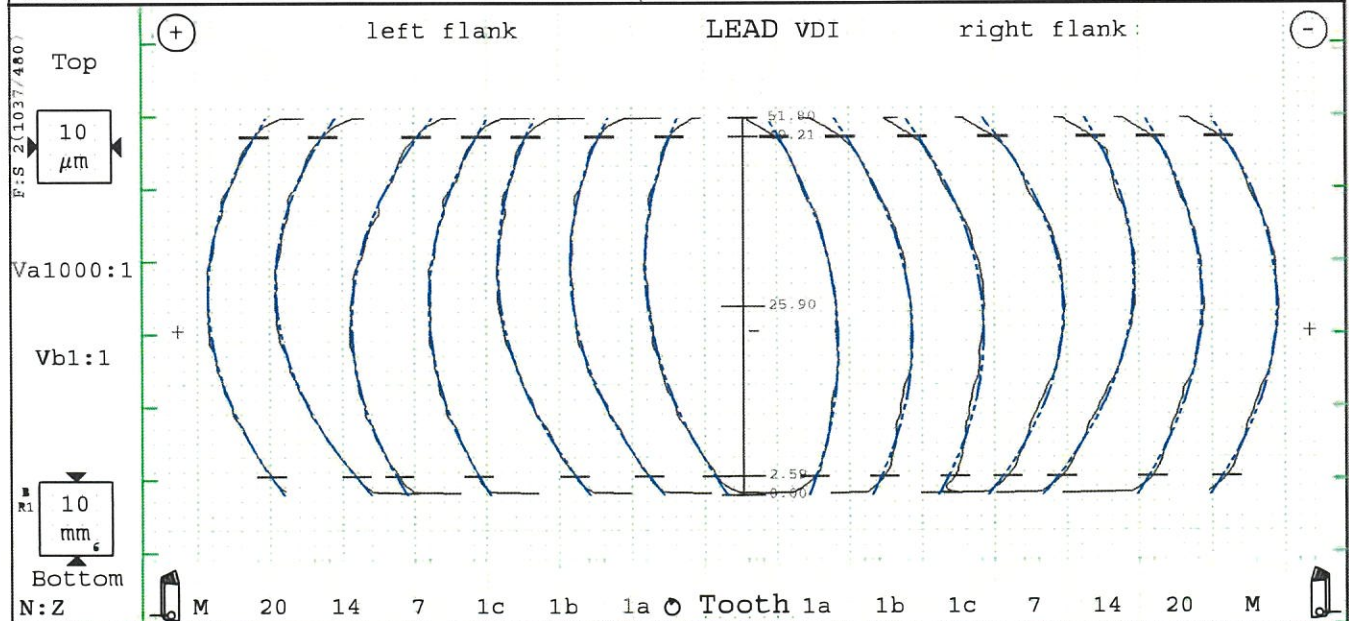


Gear Profile/Lead

Prog.No.: GST0435_05 4.24.0 0	P 26 601738	Operator:	Date: 19.10.2023 09:12
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.: 0818 C2F1 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	



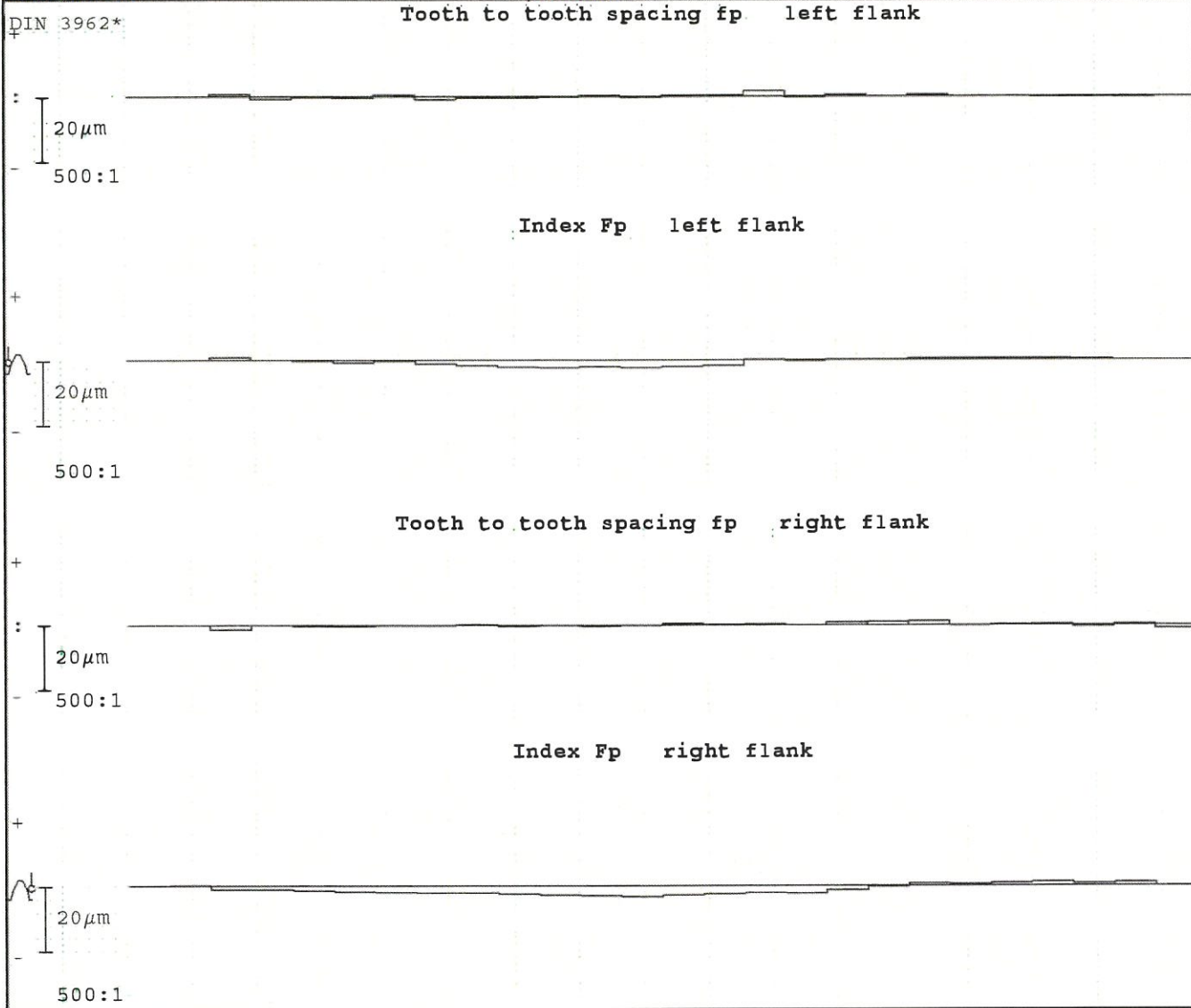
	Act.value[μ m]						Lim.value Qual		Act.value[μ m]						Quality	
fH α m	3.3						B	0.4	8							
fH α	3.1	3.1	3.5 x	3.0	3.4	3.1										
F α	3.2	3.9	4.0 x	3.5	3.7	3.3										
ff α	1.2	1.9 x	1.1	0.6	0.9	0.9										
C α	4.2	5.0	4.8	5.0	4.4	4.4										
fFu	-7.1	-6.6	-7.2	-7.1	-7.4	-6.8										
fKo	-6.3	-6.1	-5.6	-5.5	-5.6	-5.6										
ff α i	0.7	0.5	0.6	0.3	0.5	0.3										
UCut	-9.2	-8.4	-8.7	-7.2	-9.7	-7.4										
R/T-Ø[mm]	34.320						[34/34.38]		41.488						[41.41/41.61]	



	Act.value[μ m]						Lim.value Qual		Act.value[μ m]						Quality	
fH β m	2.4						B	11.1	14							
fH β	4.9	-3.4	0.4	7.5	7.7 x	6.8										
F β	5.1	3.0	0.9	6.7	6.9 x	6.4										
ff β	0.8	1.2 x	0.9	0.8	0.7	0.7										
C β	8.6	7.7	6.8	6.9	7.0	6.1										
ff β i	0.0	0.0	0.0	0.0	0.0	0.0										

Gear Spacing

Prog.No.: GST0435 05 4.24.0 0	P 26 601738	Operator:	Date: 19.10.2023 09:12
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.: 0818 C2F1 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	1.8		1.3	
Worst spacing variation	fu max	2.1		1.3	
Range of Pitch Error	Rp	2.7		2.4	
Total index variation	Fp	3.2	43.0	4.6	43.0
Total index var.within sector	Fpz/8	2.5	35.0	3.0	35.0

DIN 3962*		Runout Fr (Ball-Ø = 2.5mm)		⊙ : 1.7µm	
+					
20µm					
-					
500:1		MdK 42.47[mm]/Ball-Ø 2.5			
Pitch Line Runout	Fr	4.0	35.0	Lim. value	42.49 42.45
Variation of tooth thickness	Rs			Act.	42.464 42.466 42.462