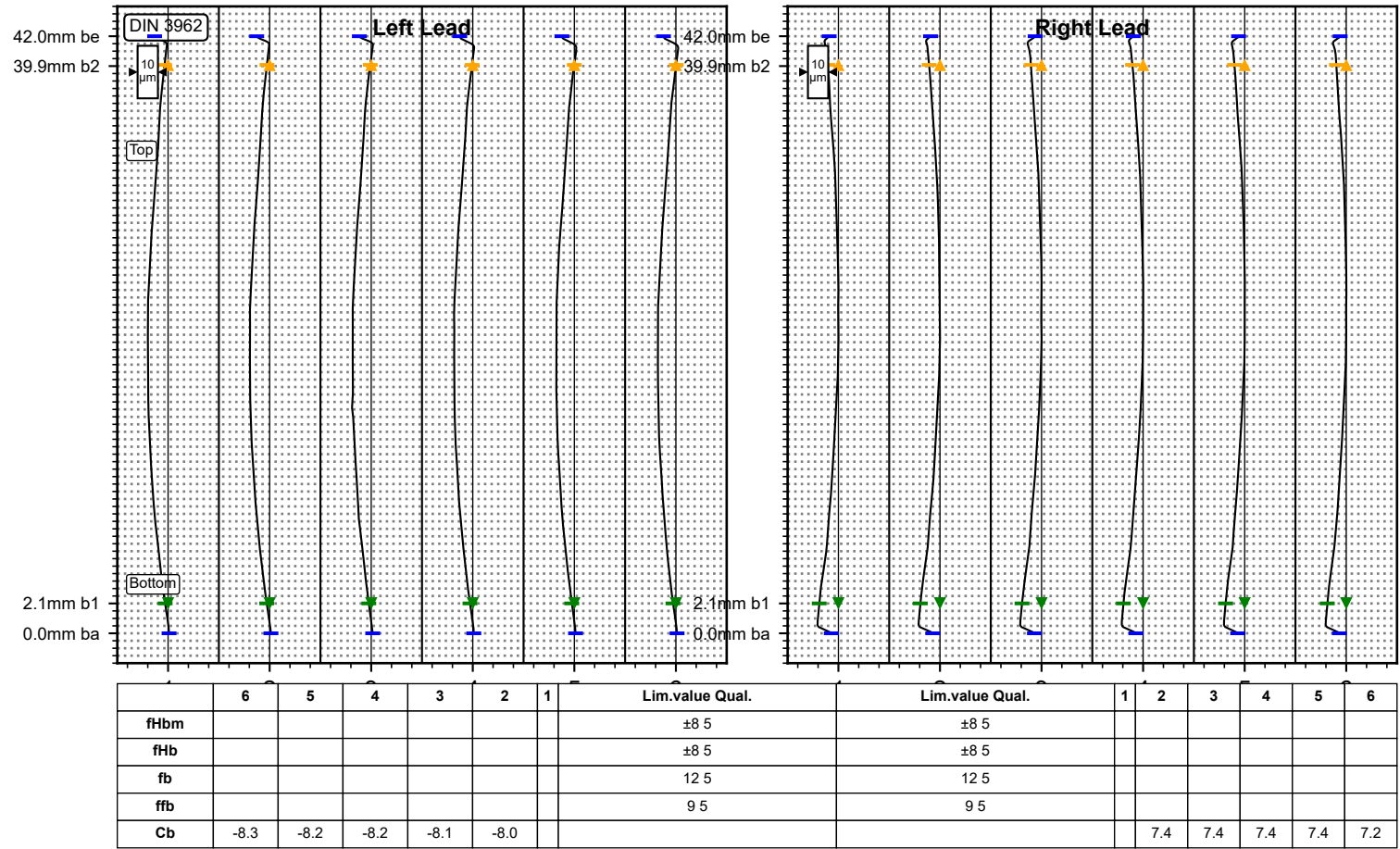
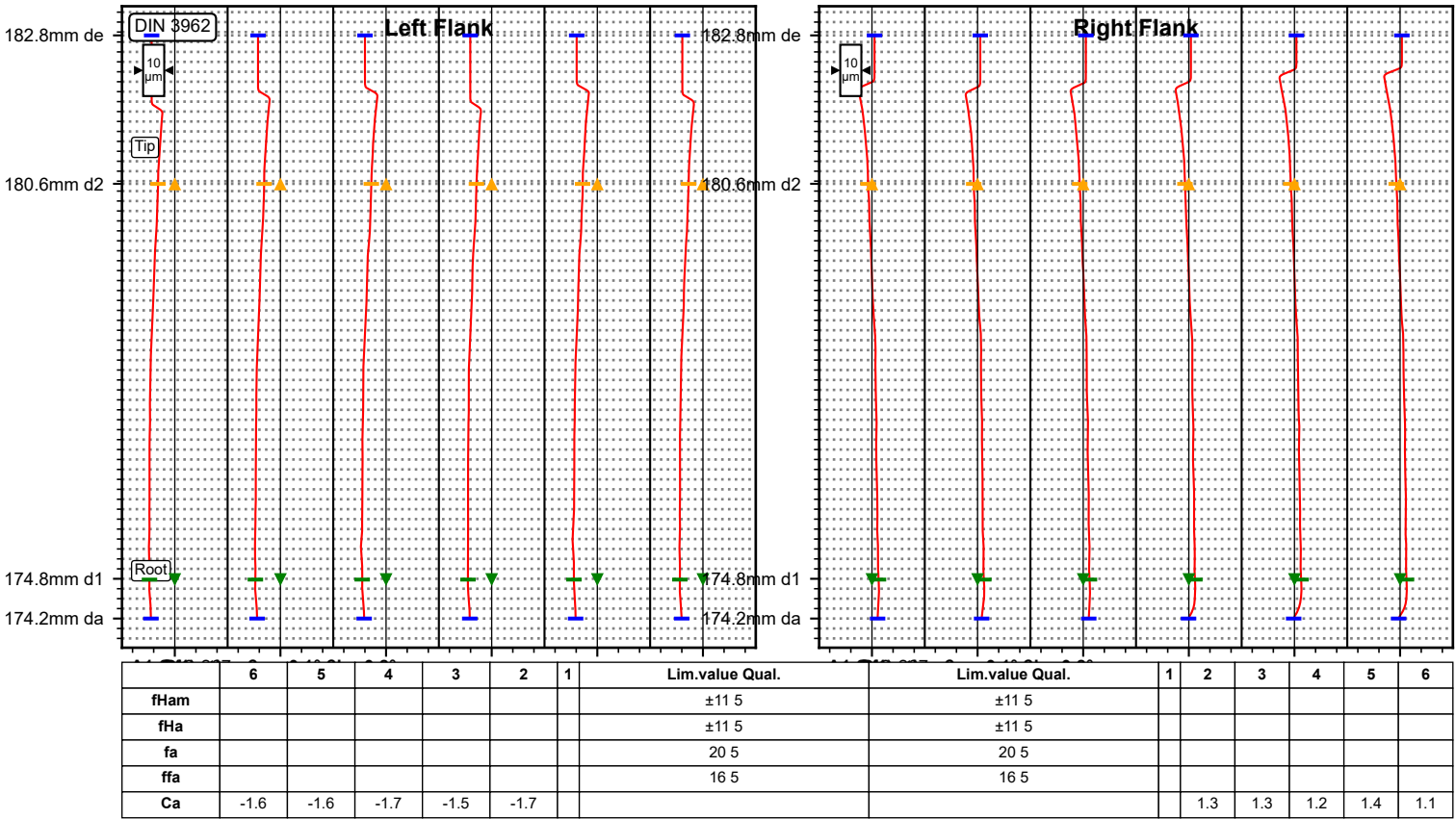


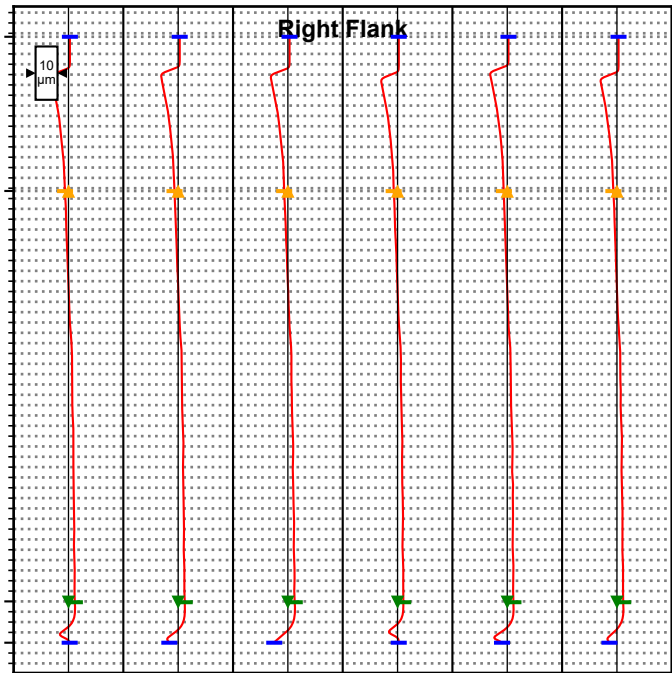
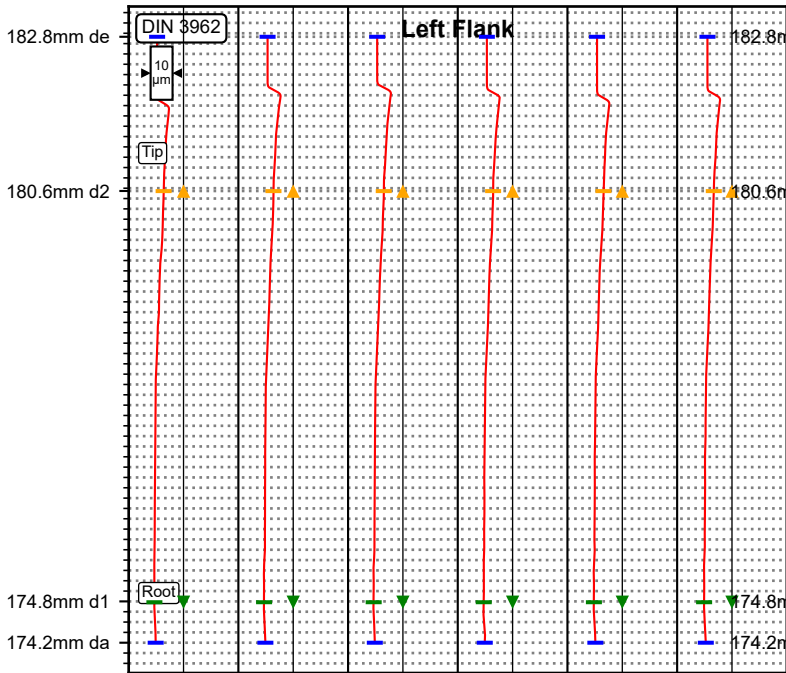
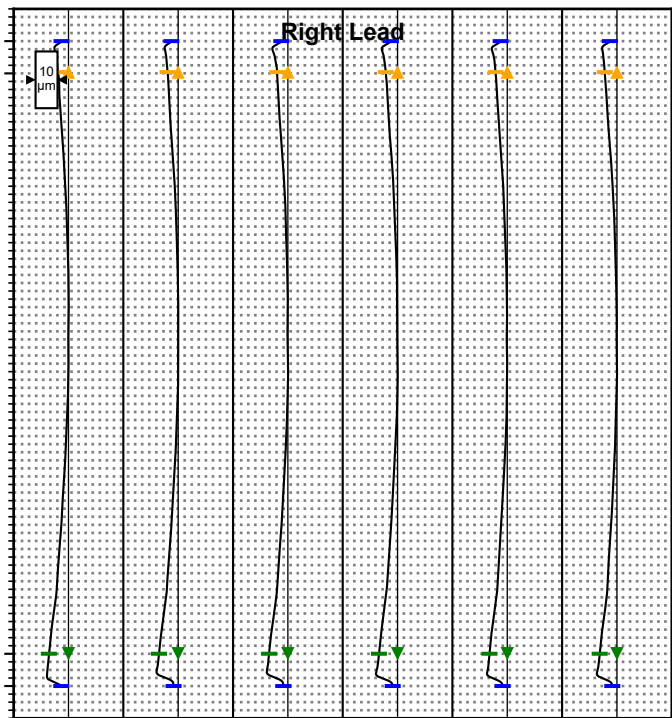
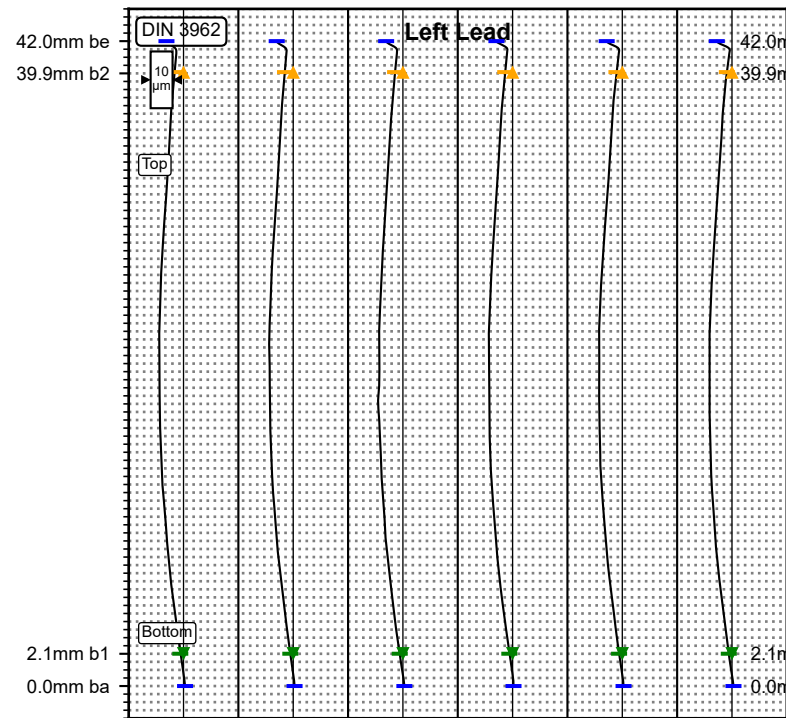
Gear Profile/Lead

Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. L $\alpha$ :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L $\beta$ :	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	0.58mm
Loc. of check:	Jintan	Base Cir.-Ø db:	167.6532mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	23.893°	Add.Mod.Coe:	-0.378



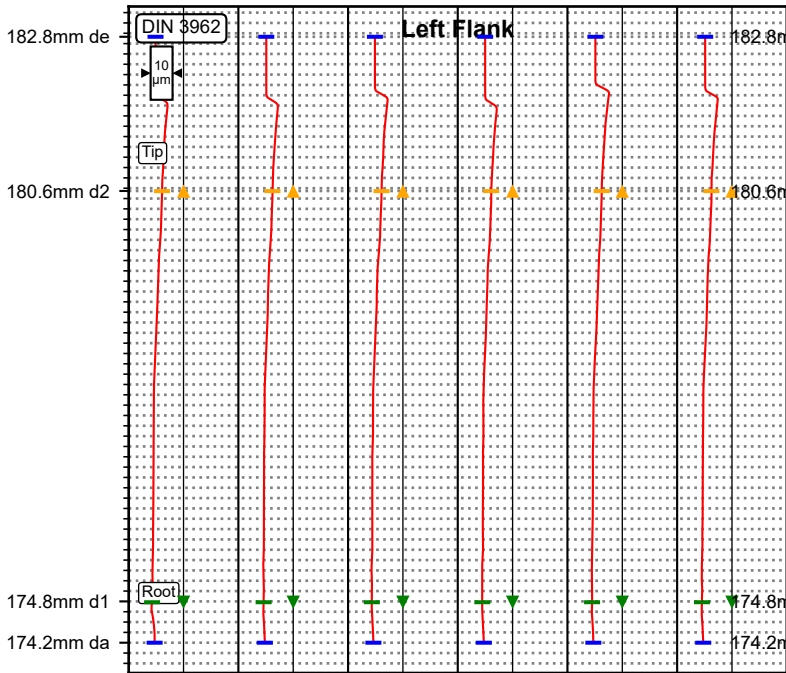
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

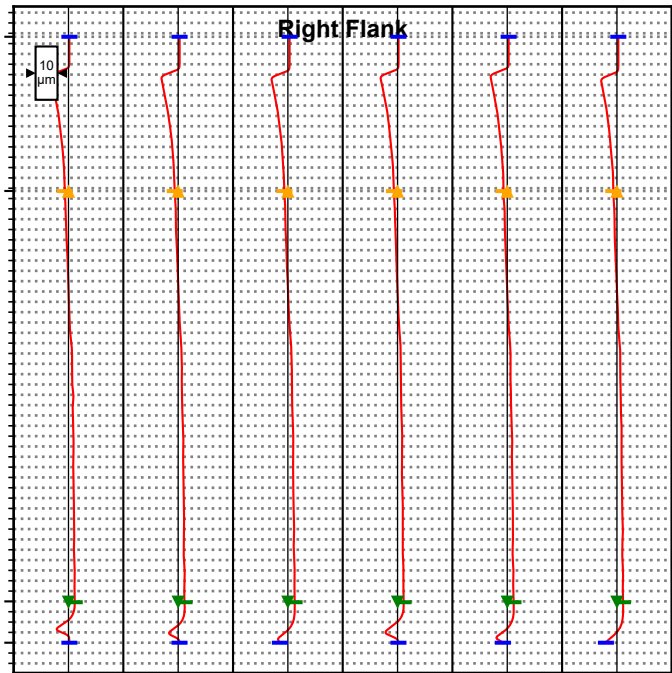
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## Gear Profile/Lead

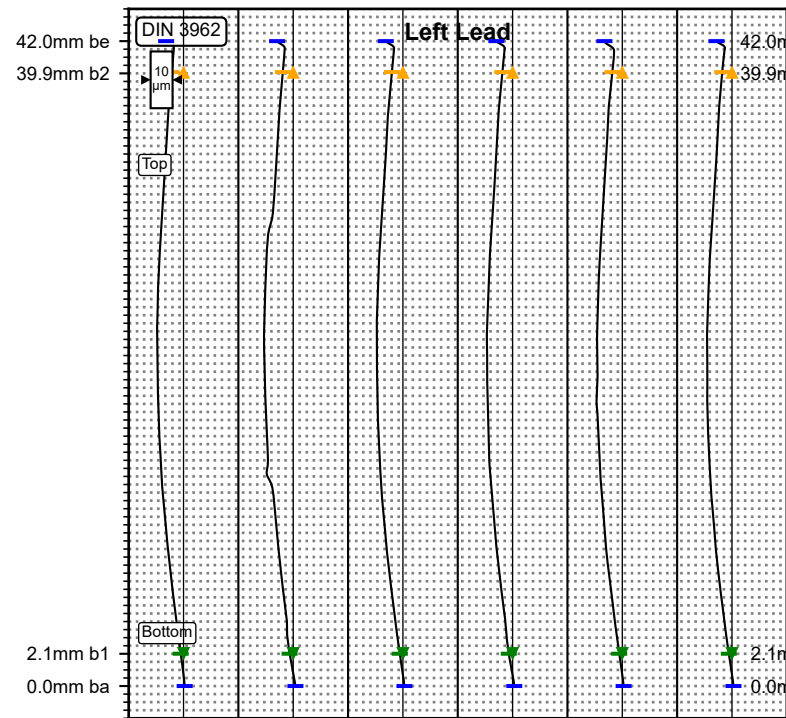
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<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



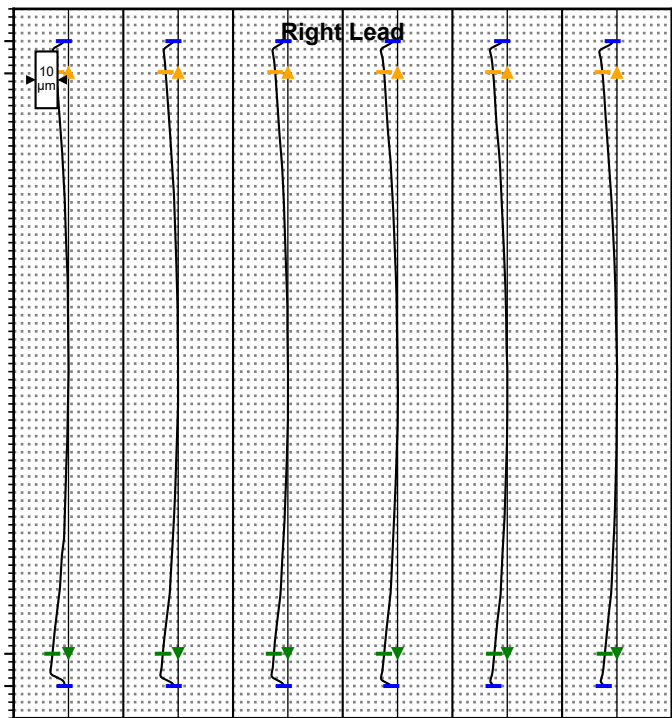
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fHam							±11 5
fHa							±11 5
fa							20 5
ffa							16 5
Ca							



Lim.value Qual.	1	2	3	4	5	6
±11 5						
±11 5						
20 5						
16 5						



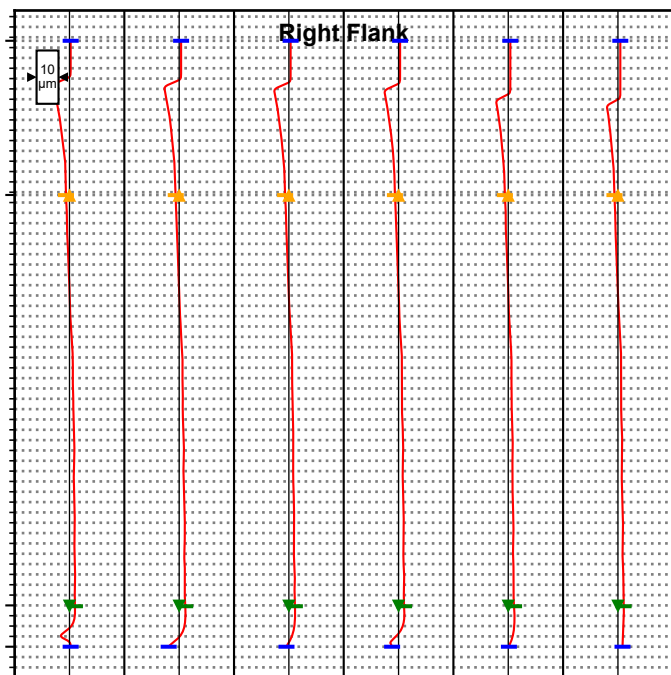
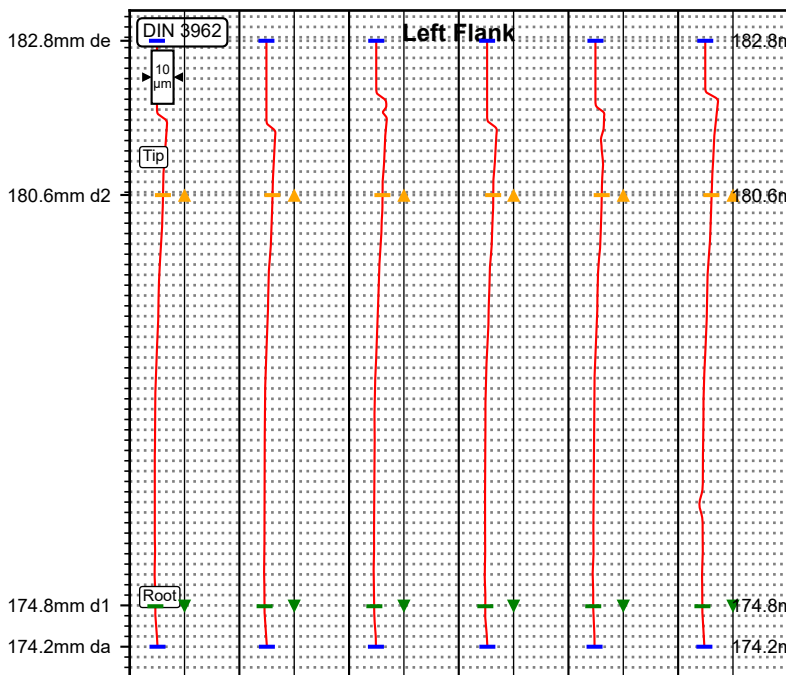
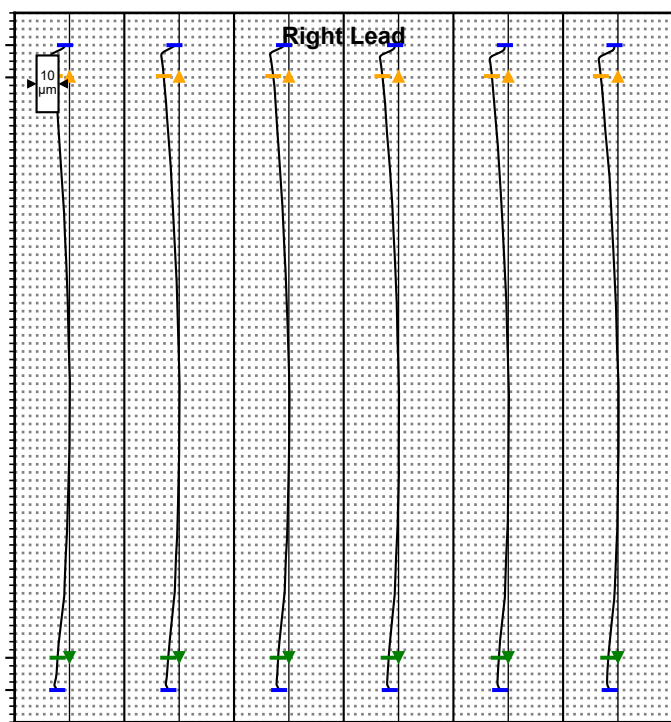
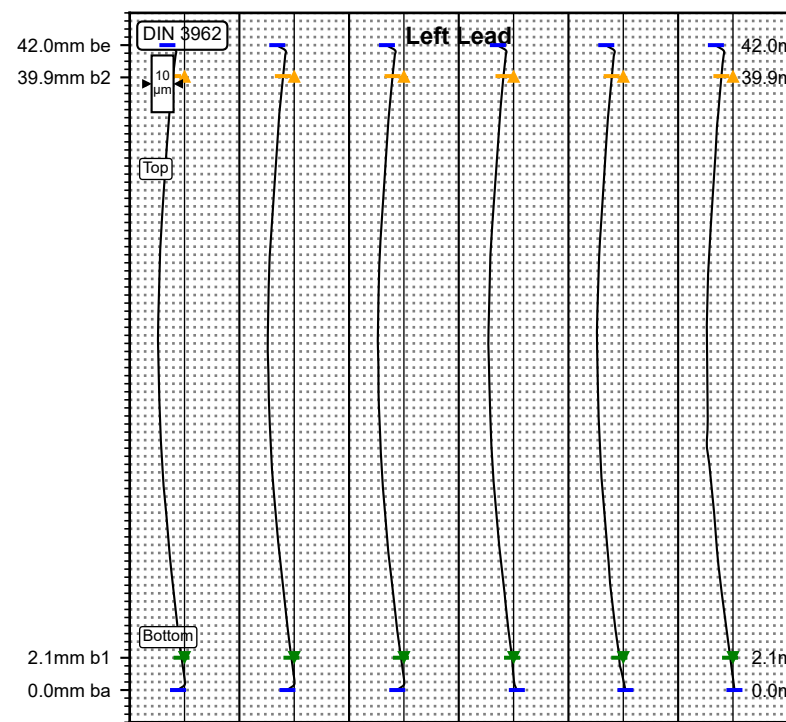
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fHbm							±8 5
fHb							±8 5
fb							12 5
ffb							9 5
Cb							



Lim.value Qual.	1	2	3	4	5	6
±8 5						
±8 5						
12 5						
9 5						

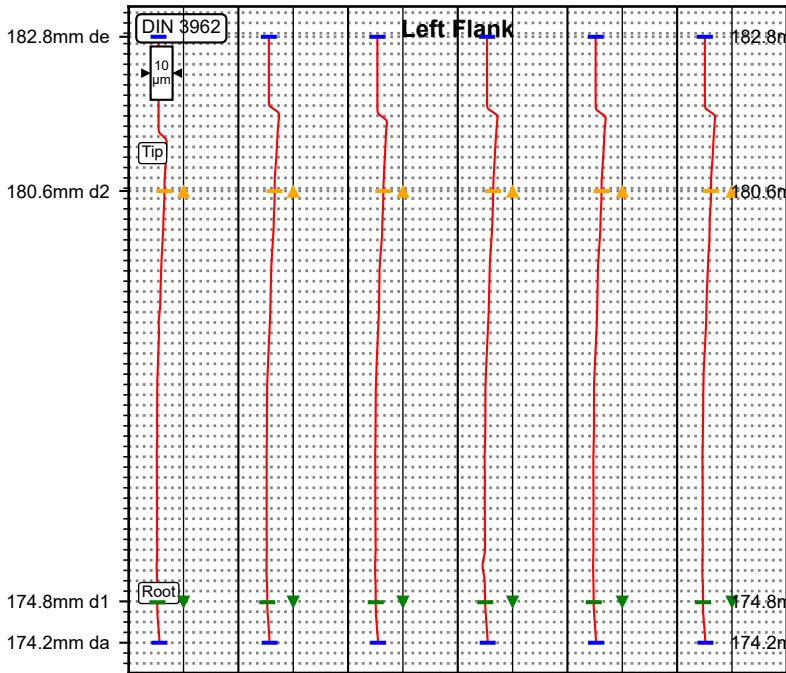
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

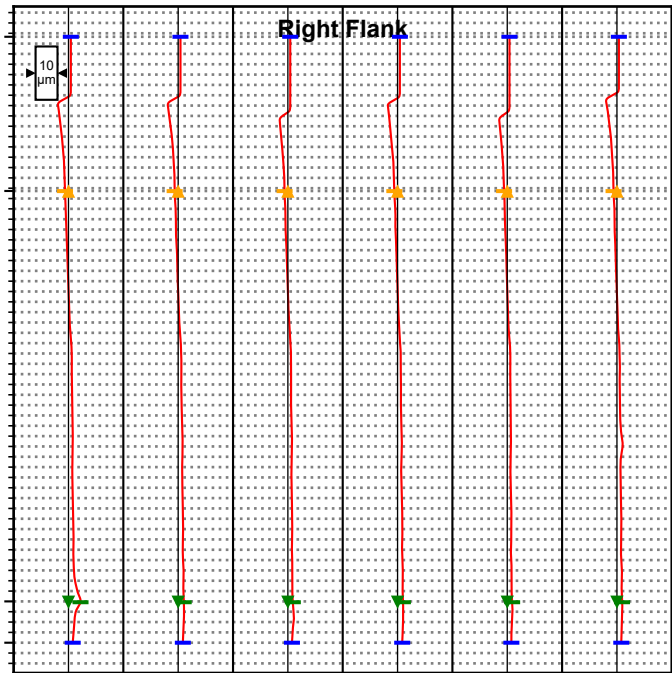
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## Gear Profile/Lead

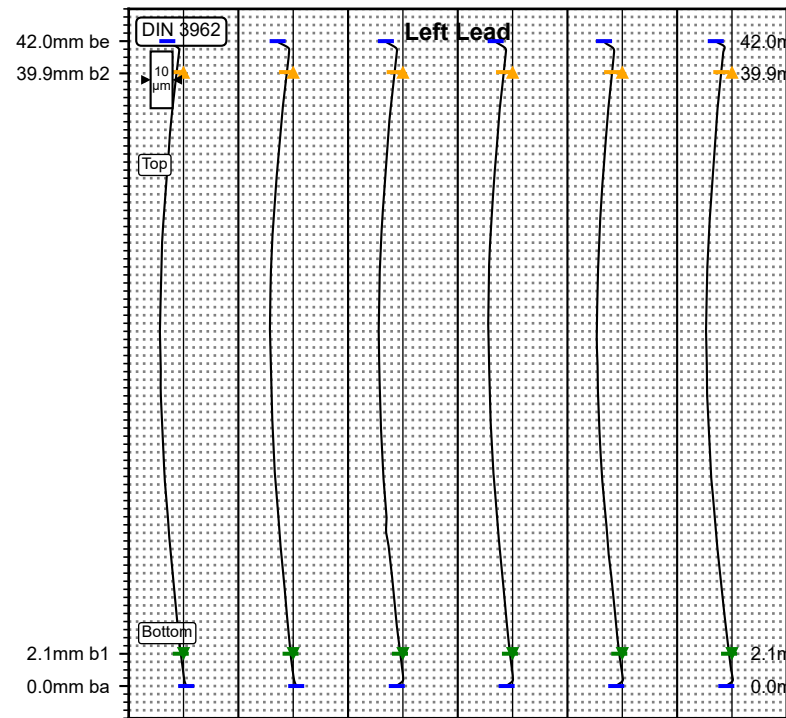
<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



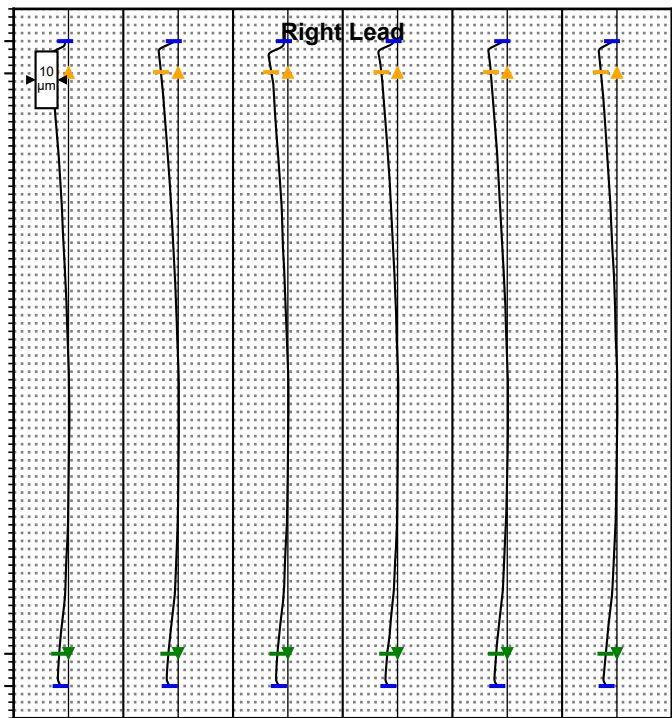
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fHam							±11 5
fHa							±11 5
fa							20 5
ffa							16 5
Ca							



Lim.value Qual.	1	2	3	4	5	6
±11 5						
±11 5						
20 5						
16 5						



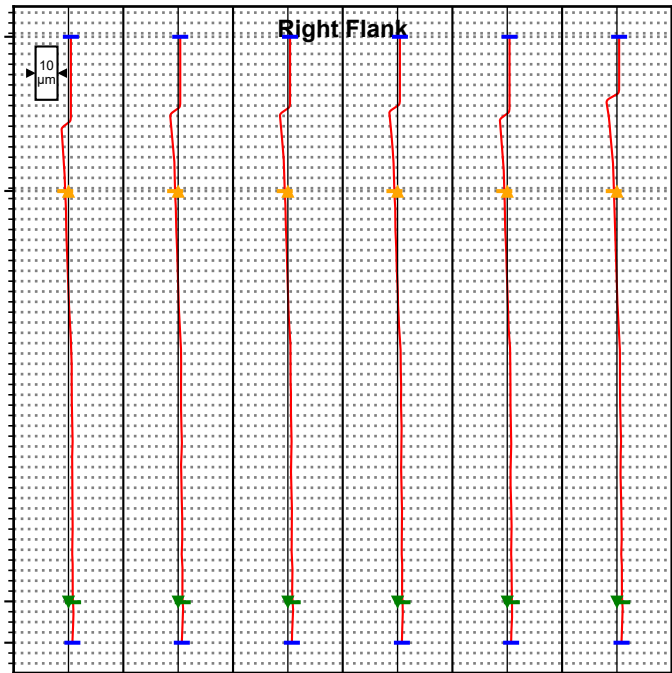
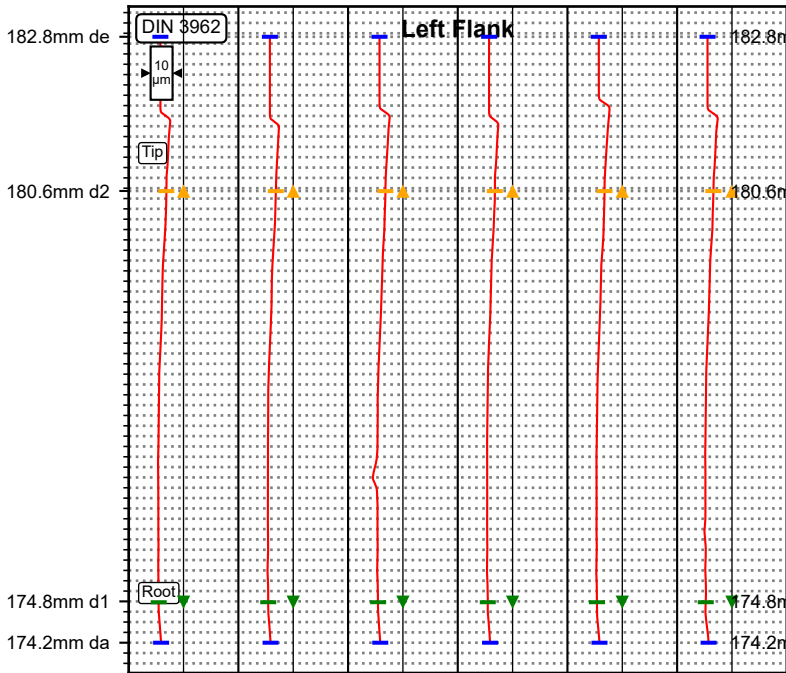
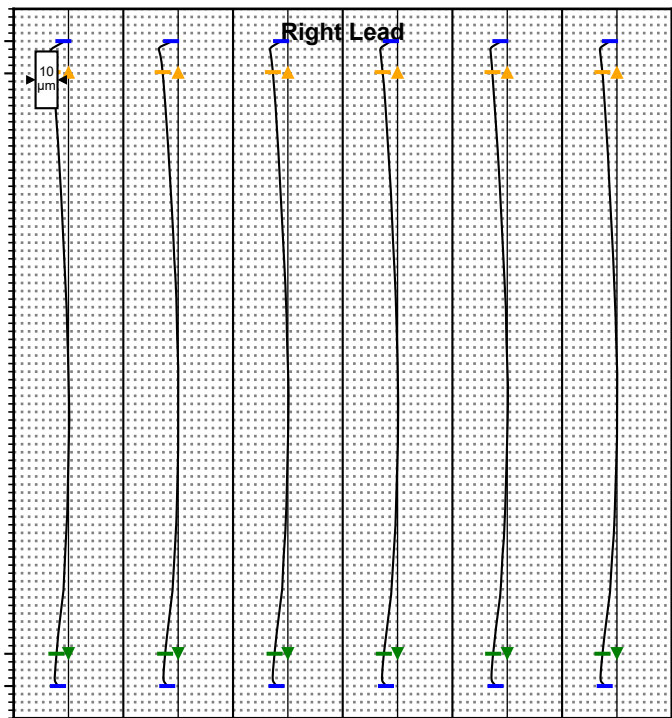
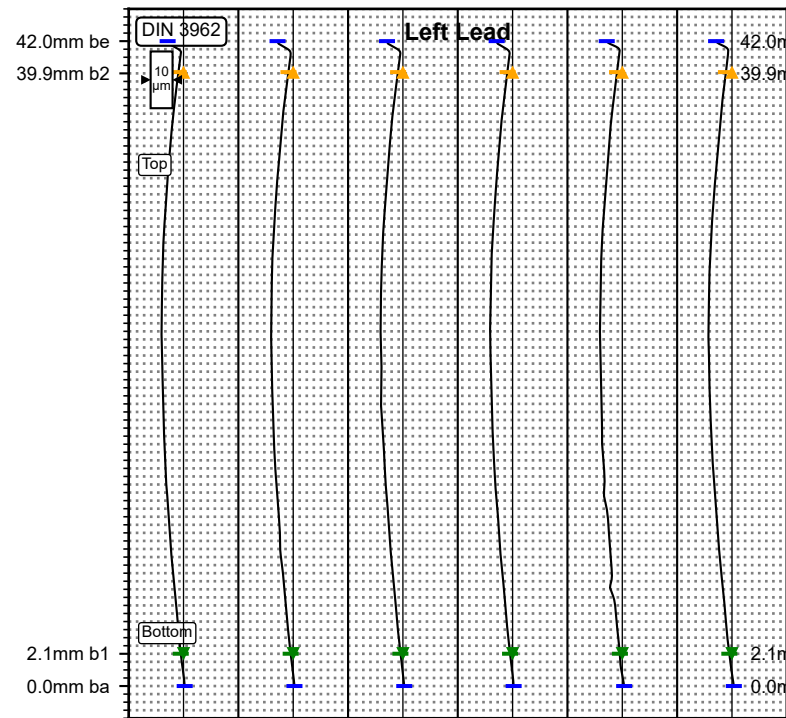
	6	5	4	3	2	1	Lim.value Qual.
fHbm							±8 5
fHb							±8 5
fb							12 5
ffb							9 5
Cb							



Lim.value Qual.	1	2	3	4	5	6
±8 5						
±8 5						
12 5						
9 5						

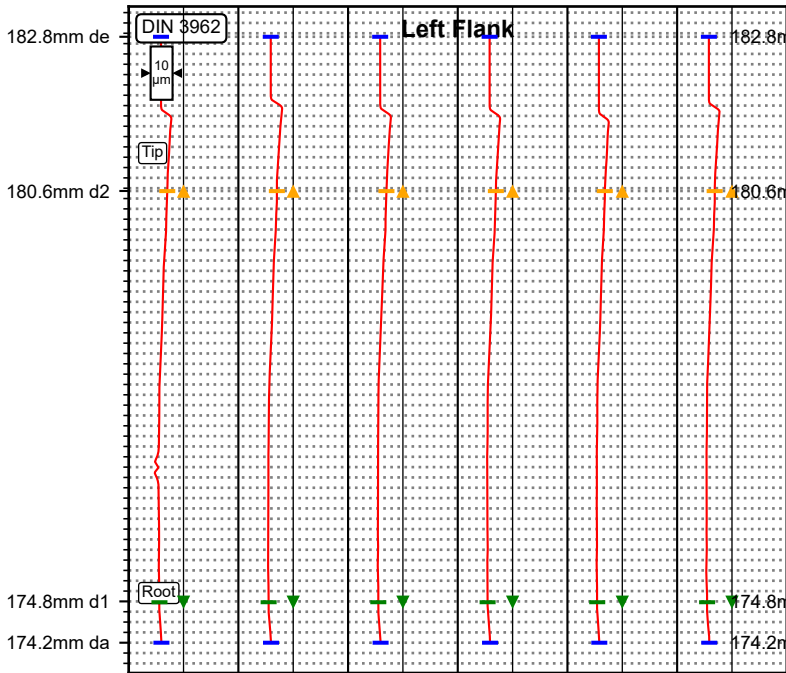
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

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## Gear Profile/Lead

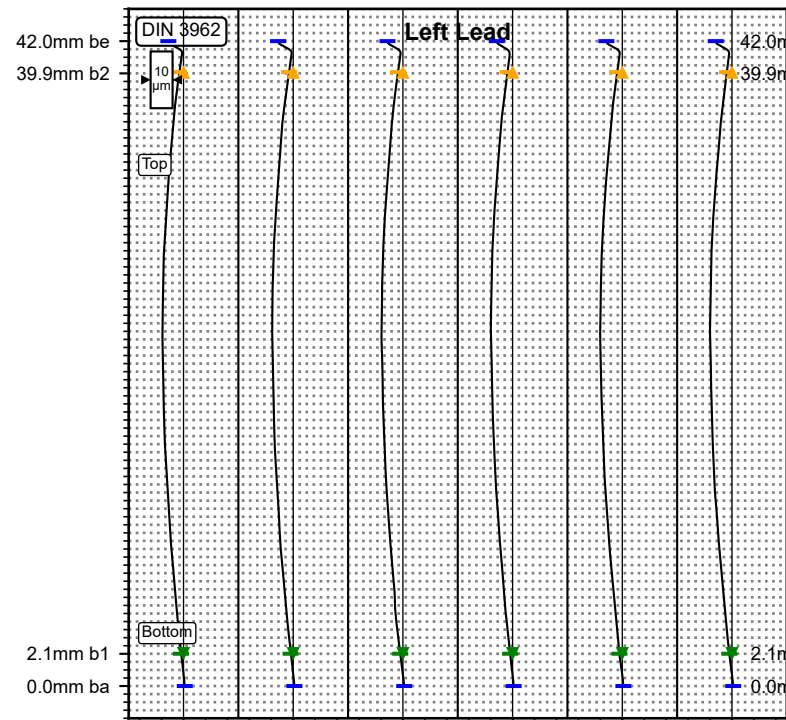
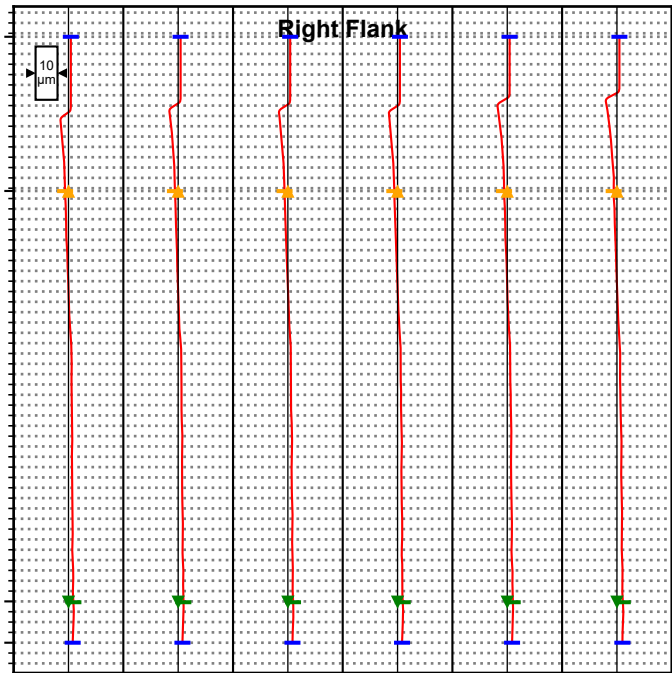
<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



	6	5	4	3	2	1
fHam						
fHa						
fa						
ffa						
Ca						

Lim.value Qual.
±11 5
±11 5
20 5
16 5

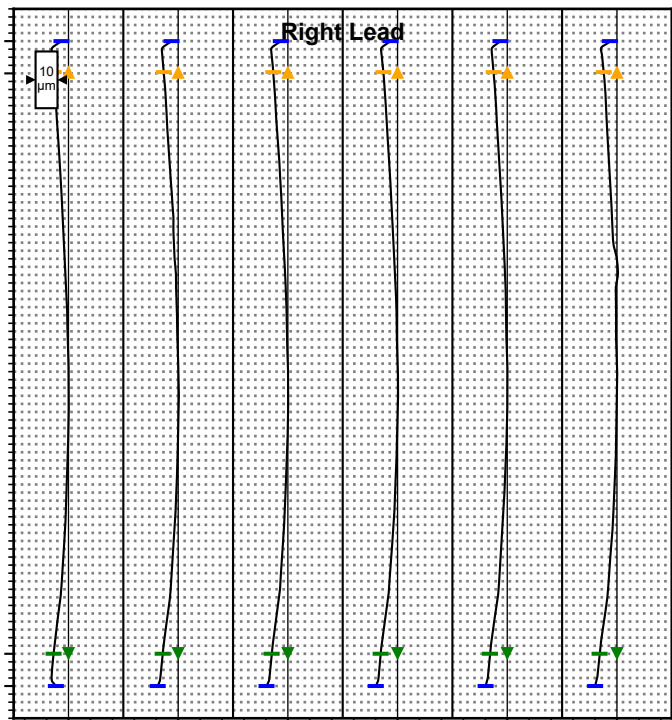
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±11 5						
±11 5						
20 5						
16 5						



	6	5	4	3	2	1
fHbm						
fHb						
fb						
ffb						
Cb						

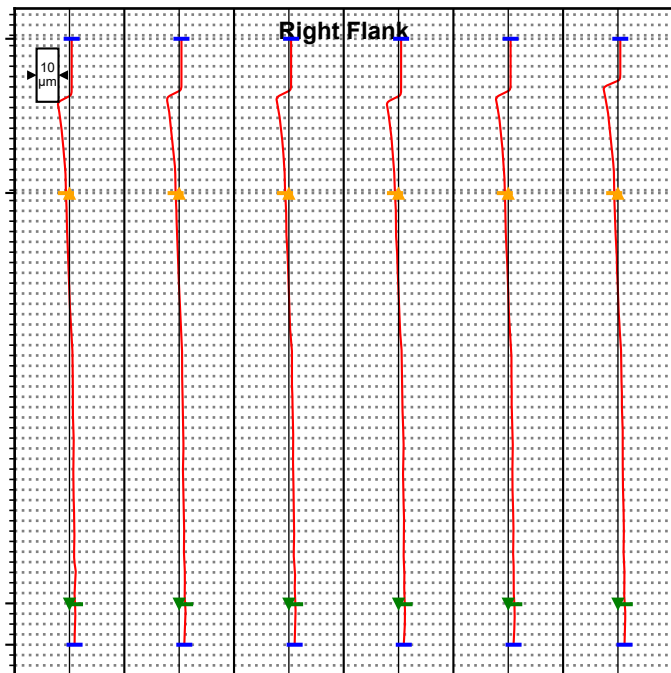
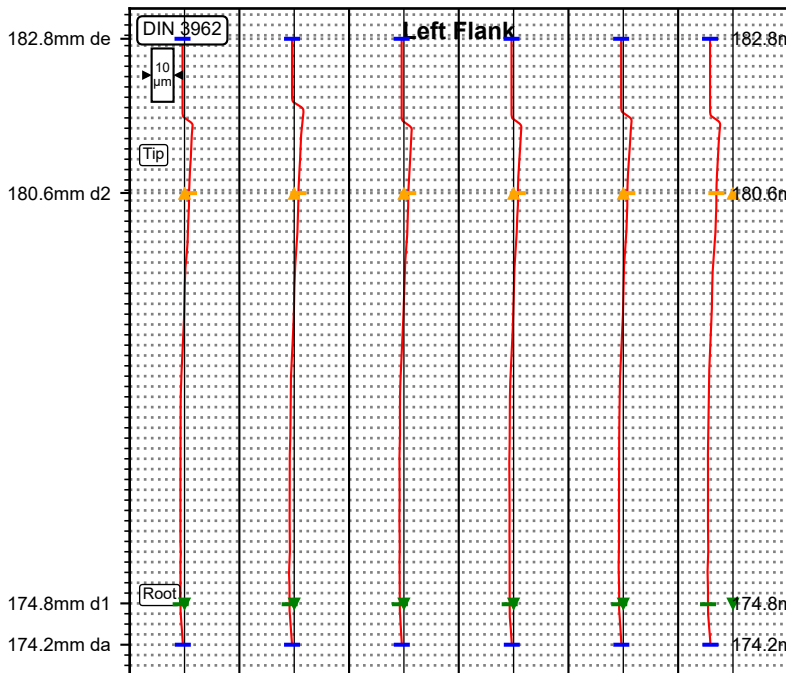
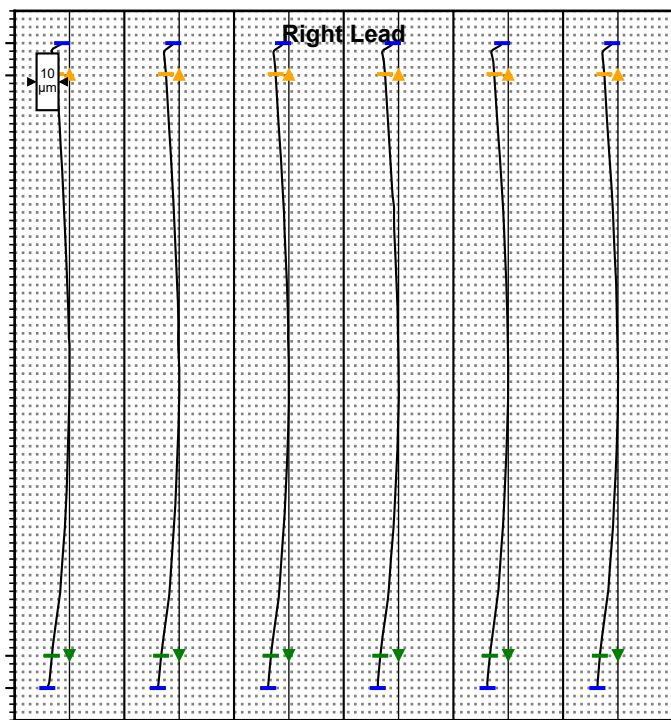
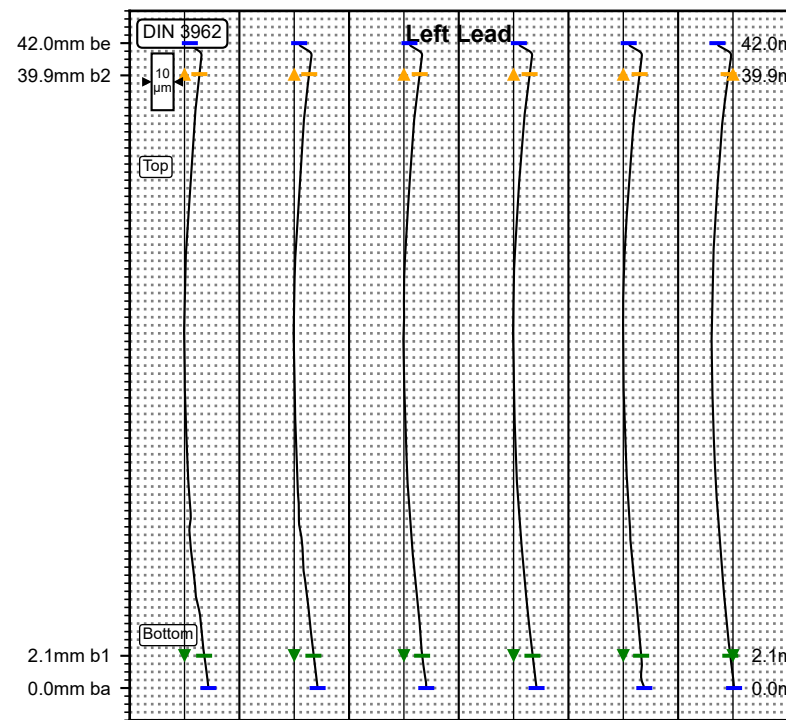
Lim.value Qual.
±8 5
±8 5
12 5
9 5

Lim.value Qual.	1	2	3	4	5	6
±8 5						
±8 5						
12 5						
9 5						



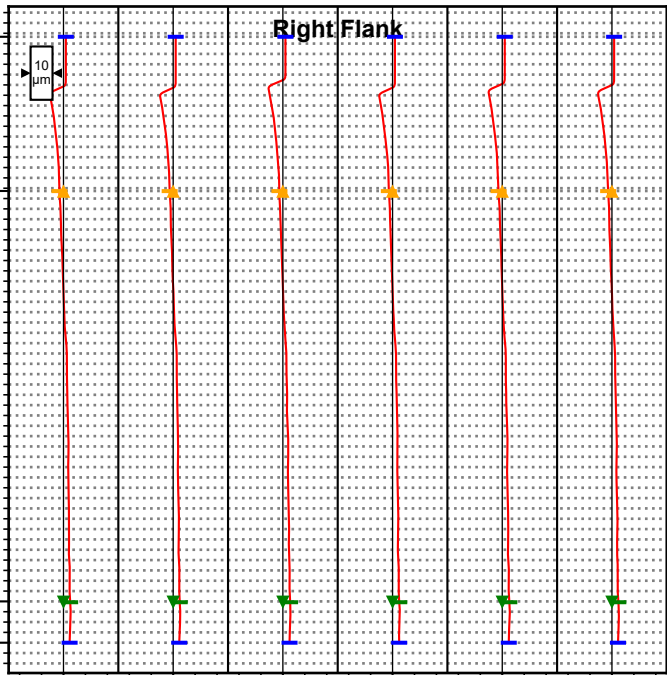
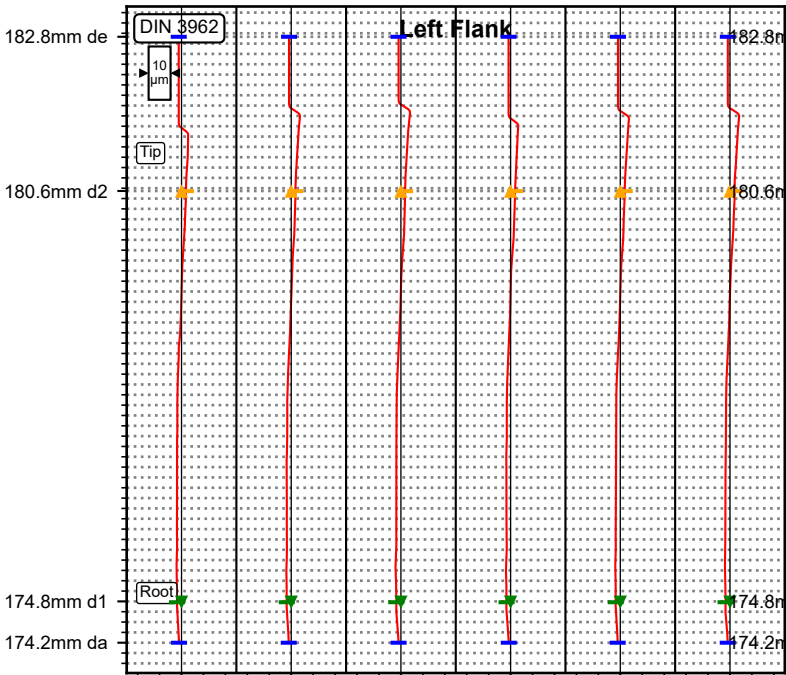
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

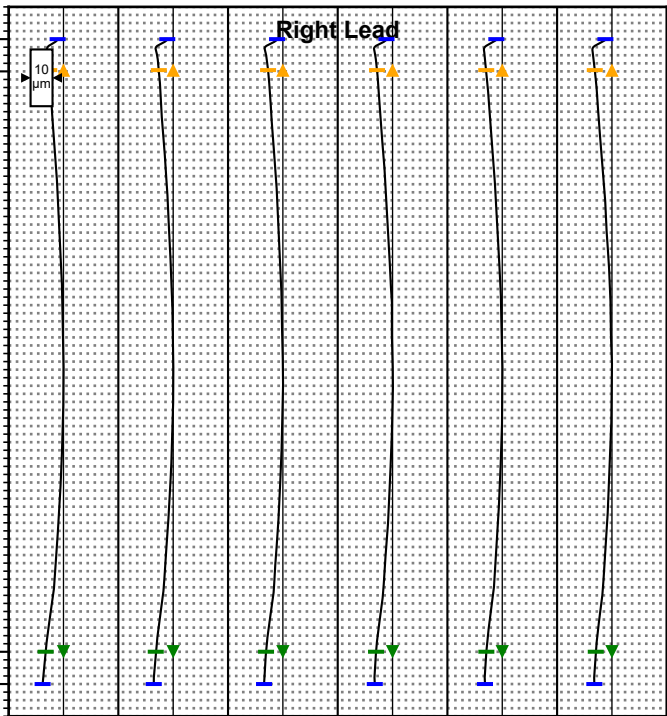
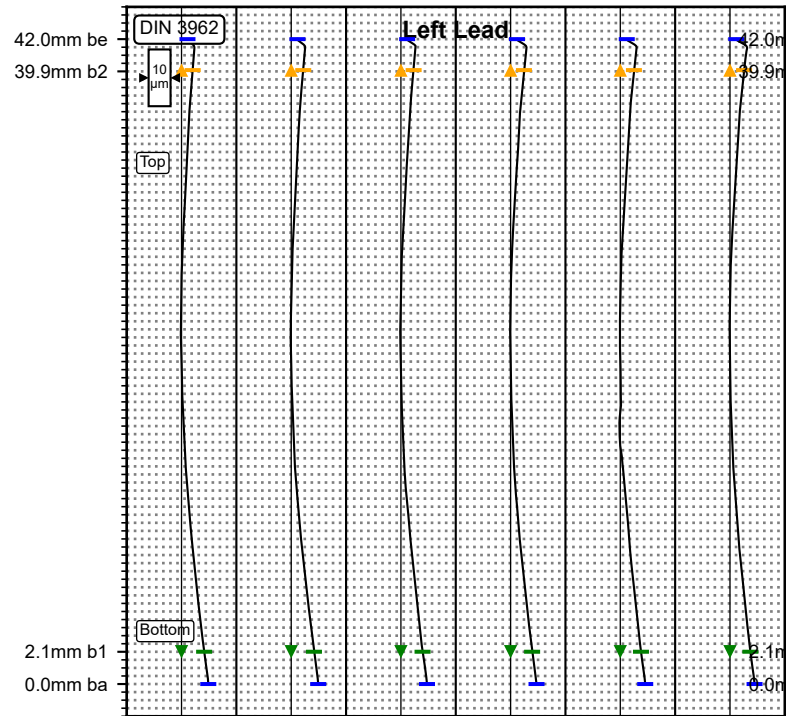
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Gear Profile/Lead

Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. Lα:	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. Lβ:	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	0.58mm
Loc. of check:	Jintan	Base Cir.-Ø db:	167.6532mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	23.893°	Add.Mod.Coe:	-0.378



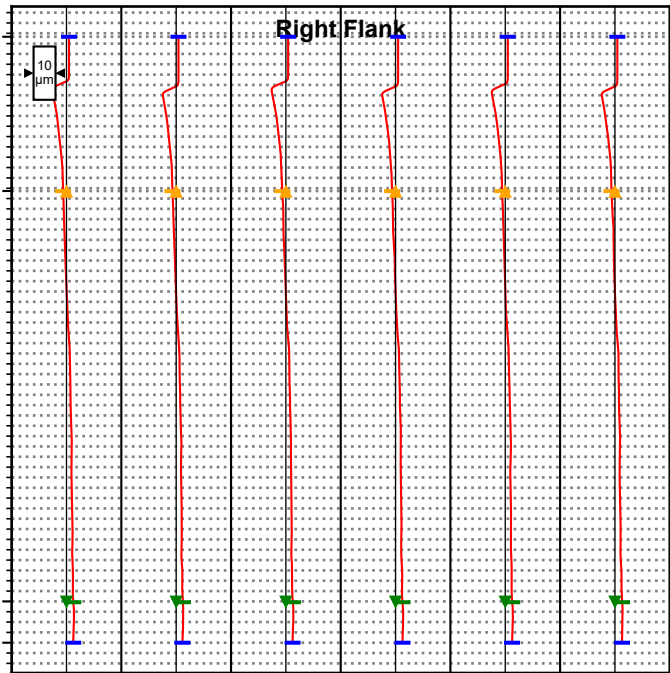
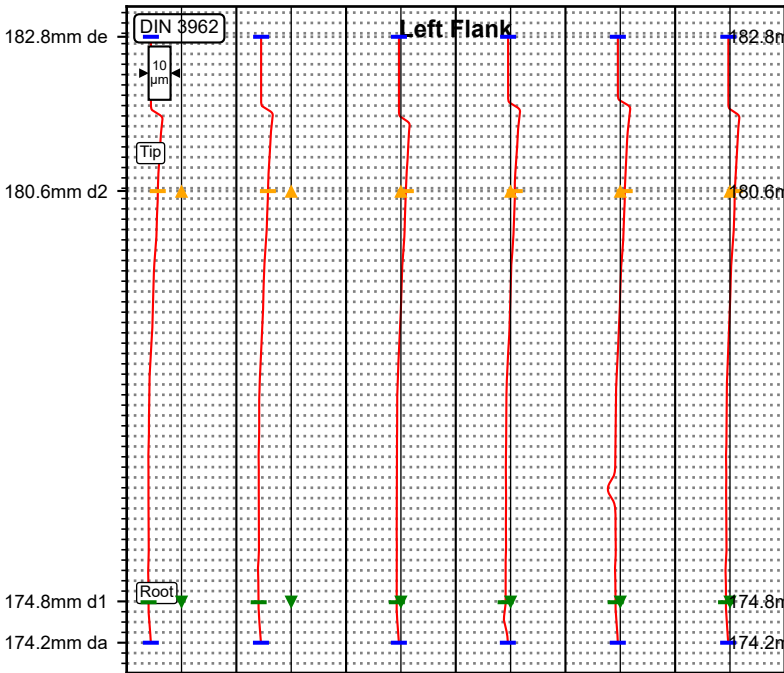
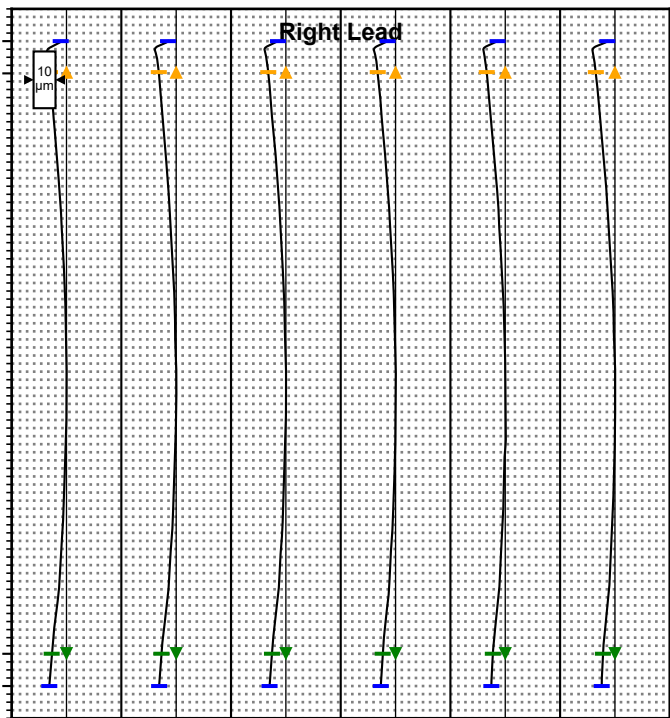
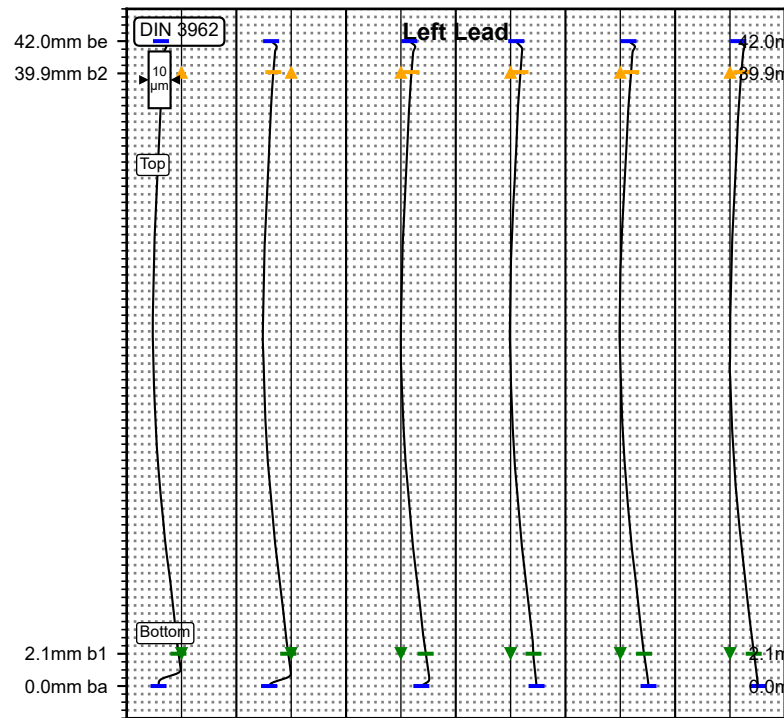
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fHam							±11 5			±11 5								
fHa							±11 5			±11 5								
fa							20 5			20 5								
ffa							16 5			16 5								
Ca																		



	6	5	4	3	2	1	Lim.value Qual.			Lim.value Qual.			1	2	3	4	5	6
fHbm							±8 5			±8 5								
fHb							±8 5			±8 5								
fb							12 5			12 5								
ffb							9 5			9 5								
Cb																		

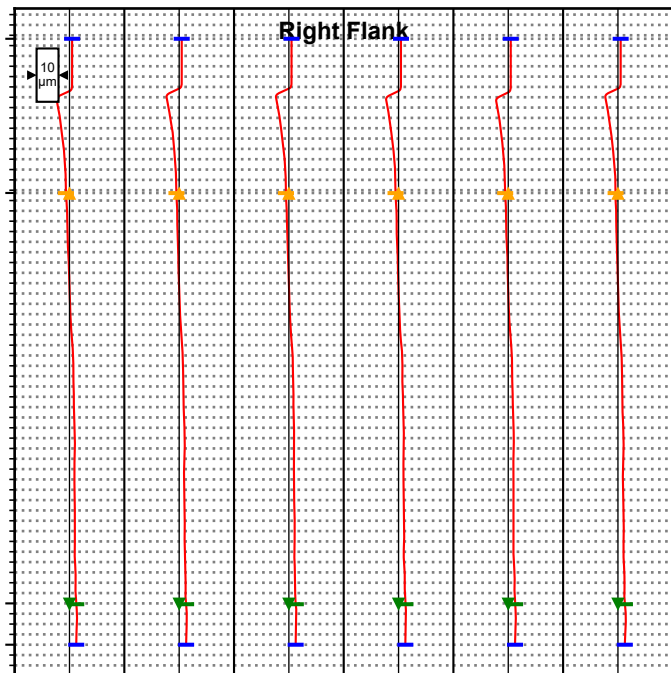
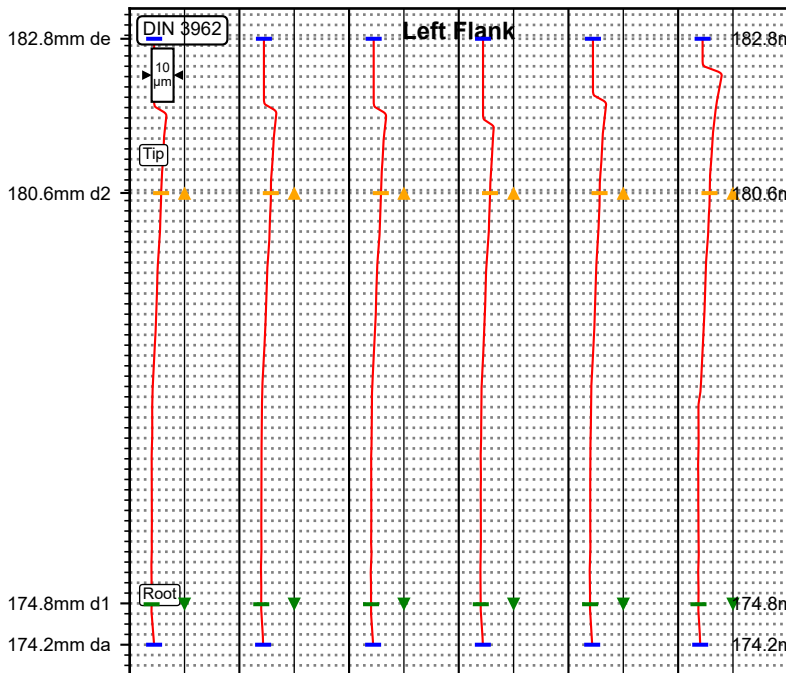
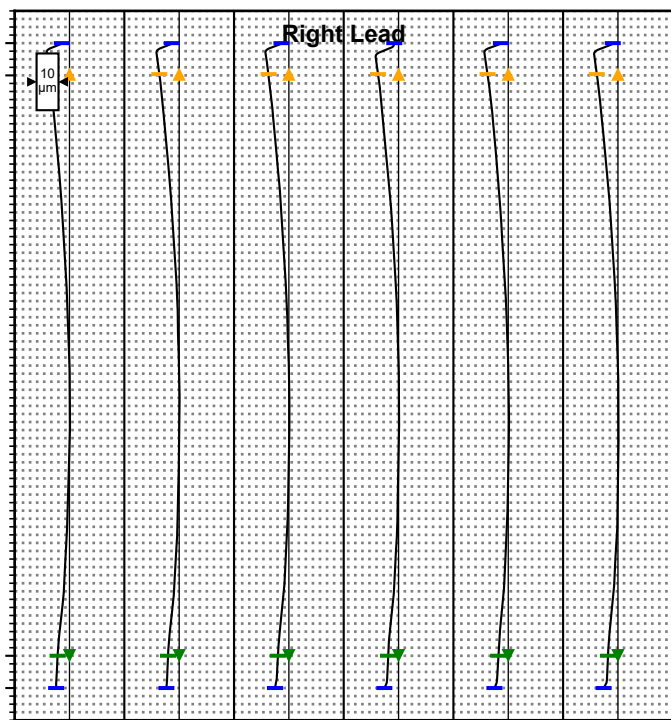
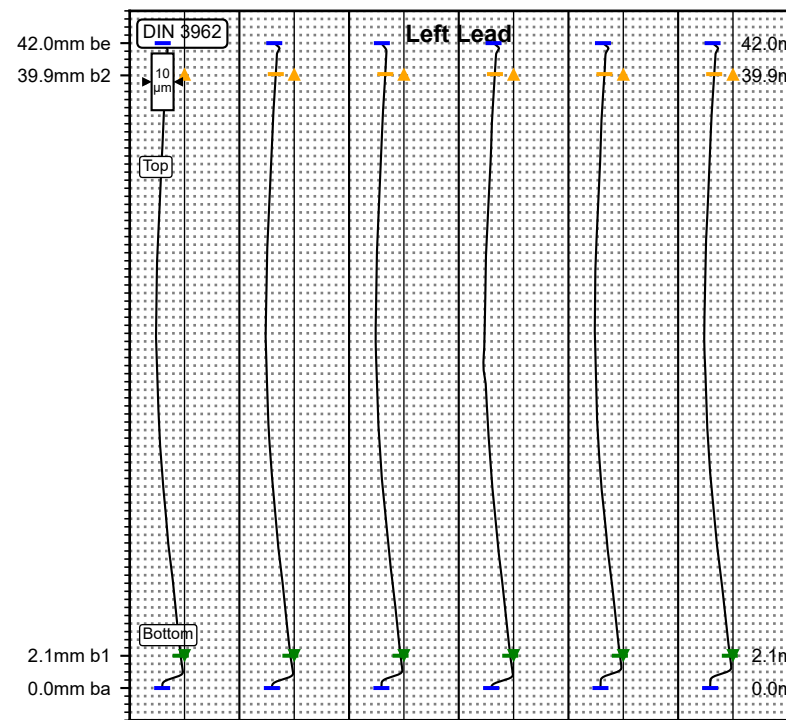
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

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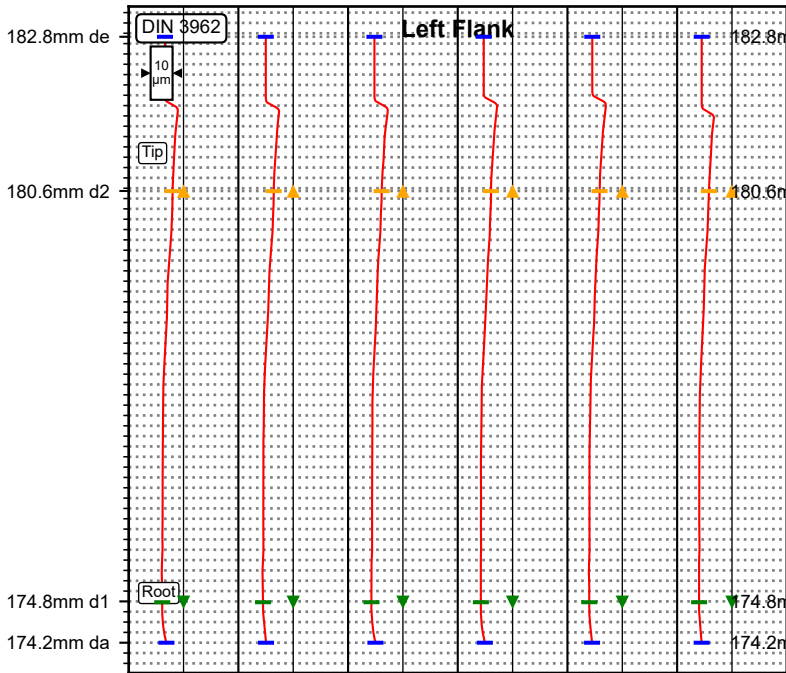
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

[illegible][illegible]

## Gear Profile/Lead

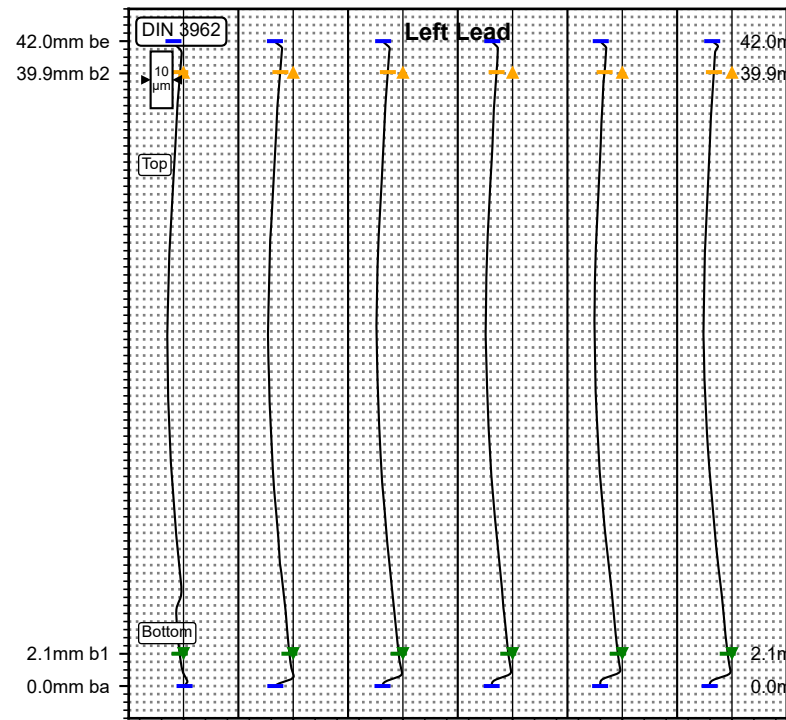
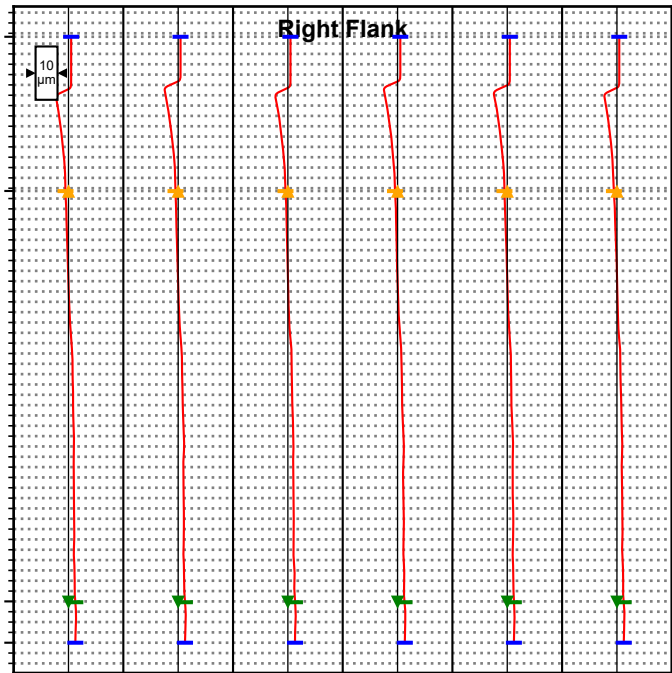
<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



	6	5	4	3	2	1
fHam						
fHa						
fa						
ffa						
Ca						

Lim.value Qual.
±11 5
±11 5
20 5
16 5

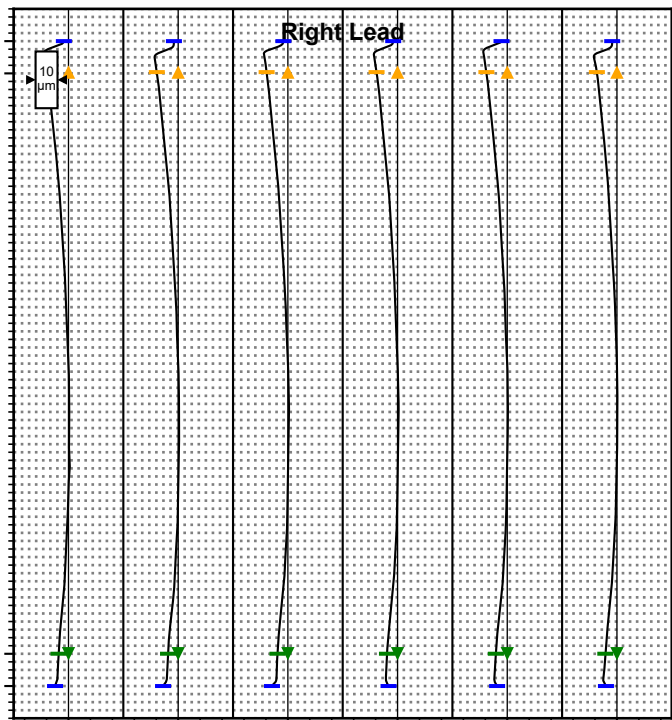
Lim.value Qual.	1	2	3	4	5	6
±11 5						
±11 5						
20 5						
16 5						



	6	5	4	3	2	1
fHbm						
fHb						
fb						
ffb						
Cb						

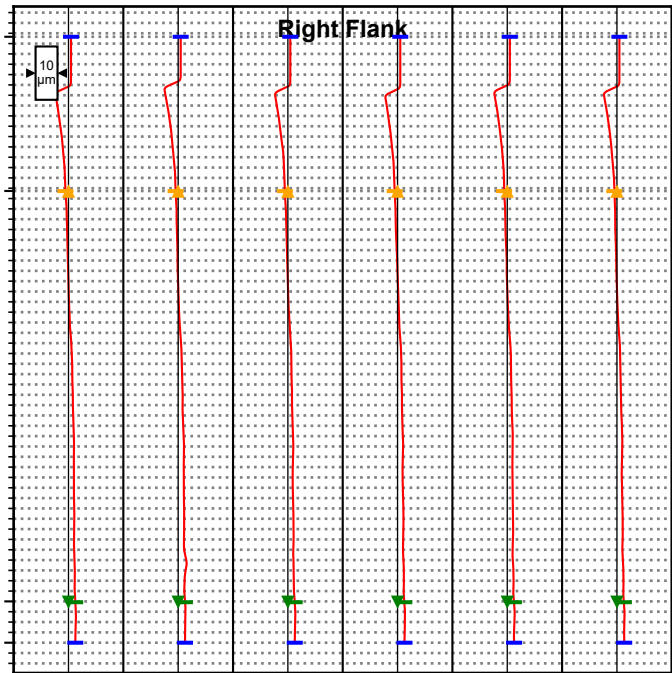
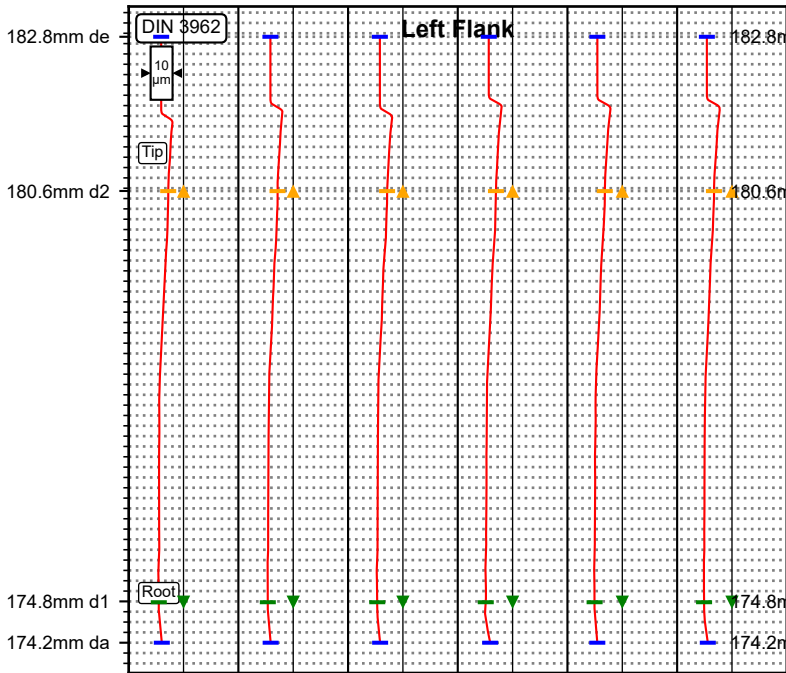
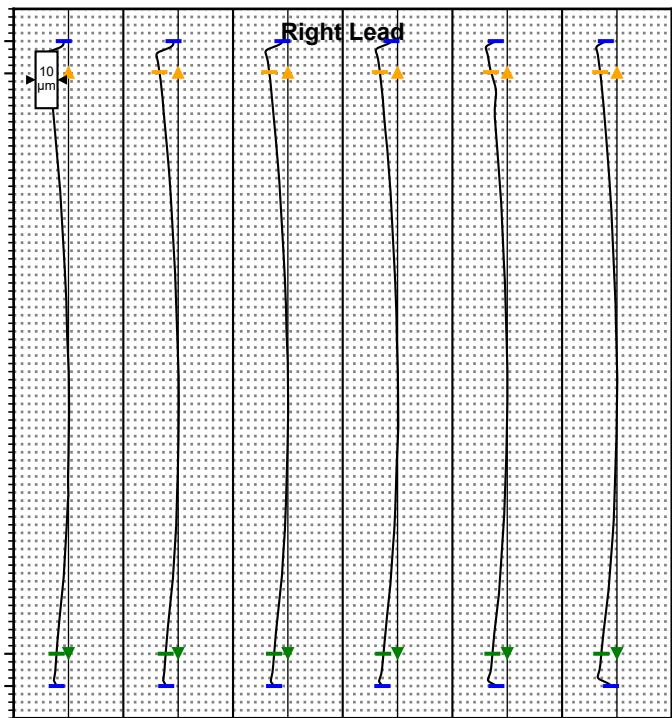
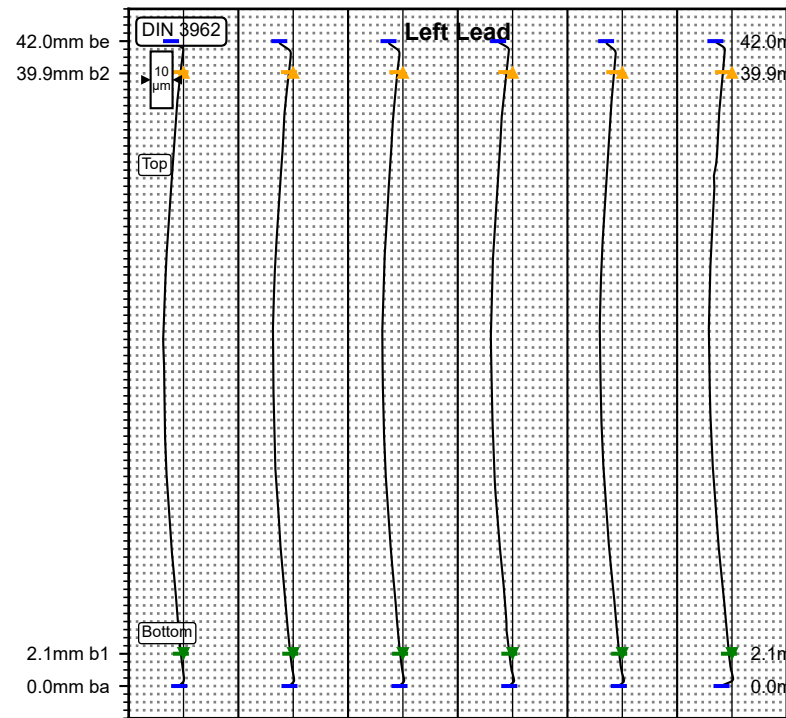
Lim.value Qual.
±8 5
±8 5
12 5
9 5

Lim.value Qual.	1	2	3	4	5	6
±8 5						
±8 5						
12 5						
9 5						



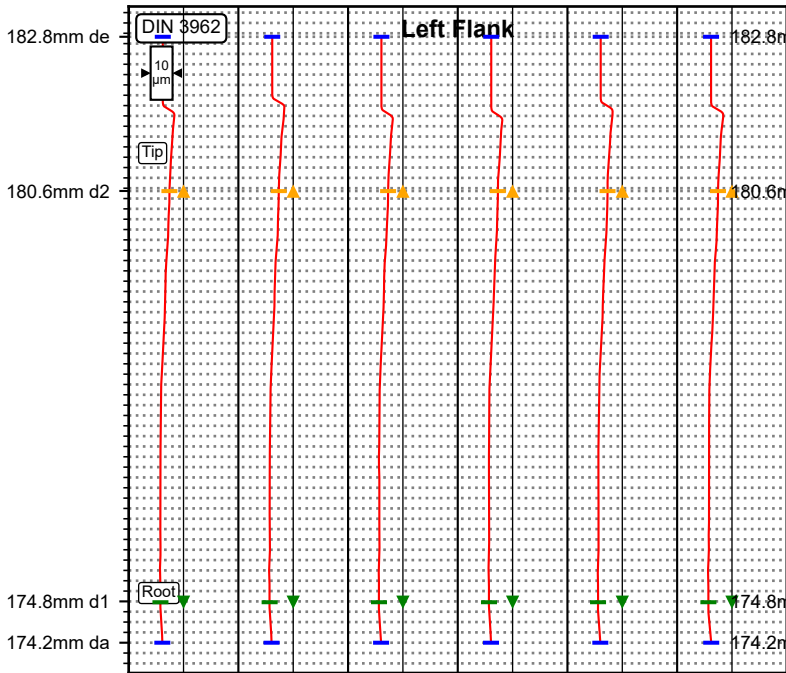
## Gear Profile/Lead

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378

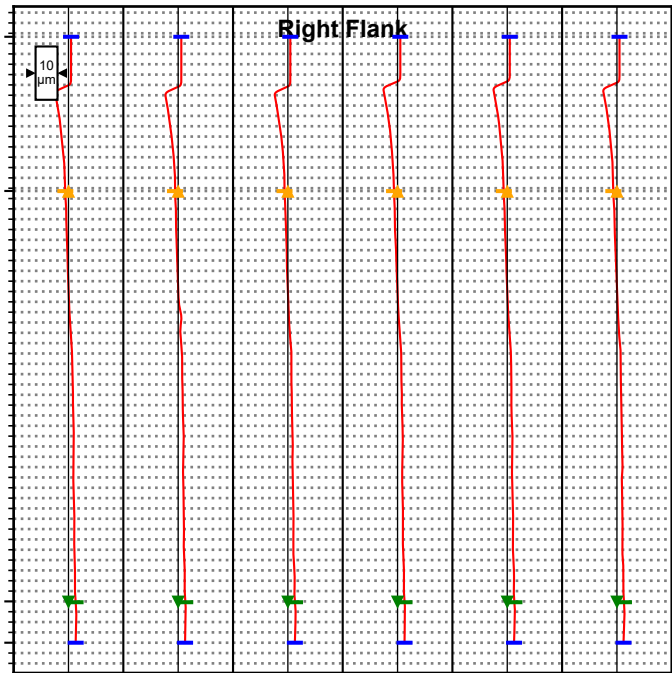
[illegible][illegible]

## Gear Profile/Lead

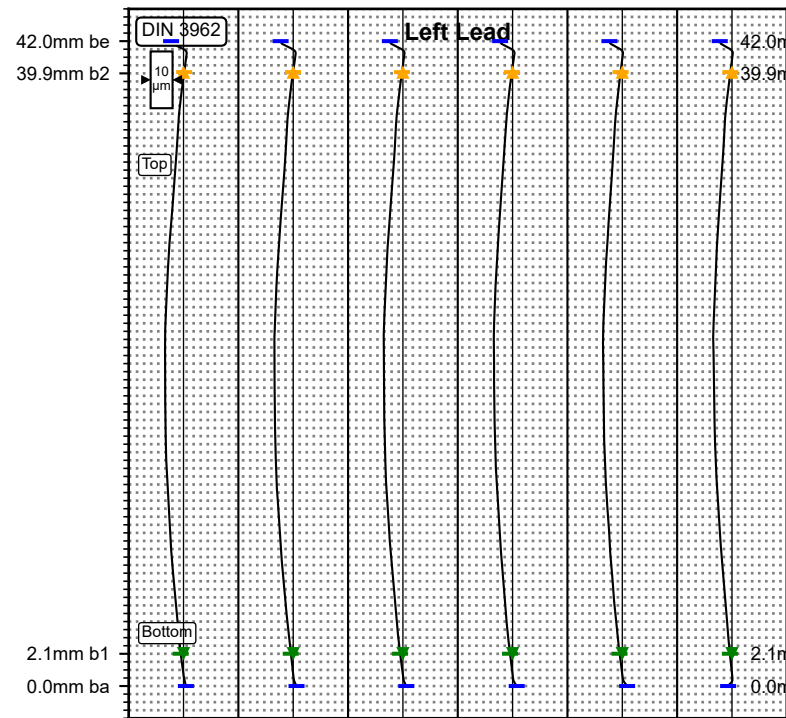
<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. L<math>\alpha</math>:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. L<math>\beta</math>:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



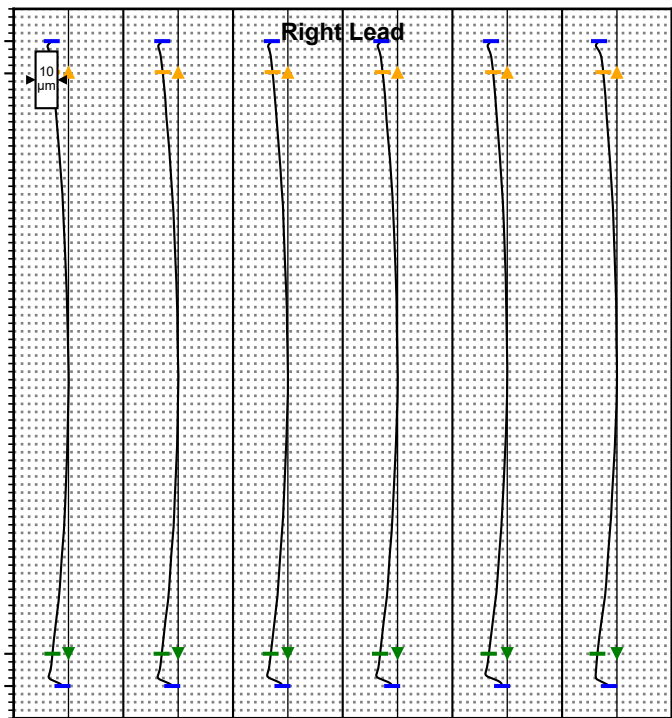
	6	5	4	3	2	1	Lim.value Qual.
fHam							±11 5
fHa							±11 5
fa							20 5
ffa							16 5
Ca							



Lim.value Qual.	1	2	3	4	5	6
±11 5						
±11 5						
20 5						
16 5						



	6	5	4	3	2	1	Lim.value Qual.
fHbm							±8 5
fHb							±8 5
fb							12 5
ffb							9 5
Cb							

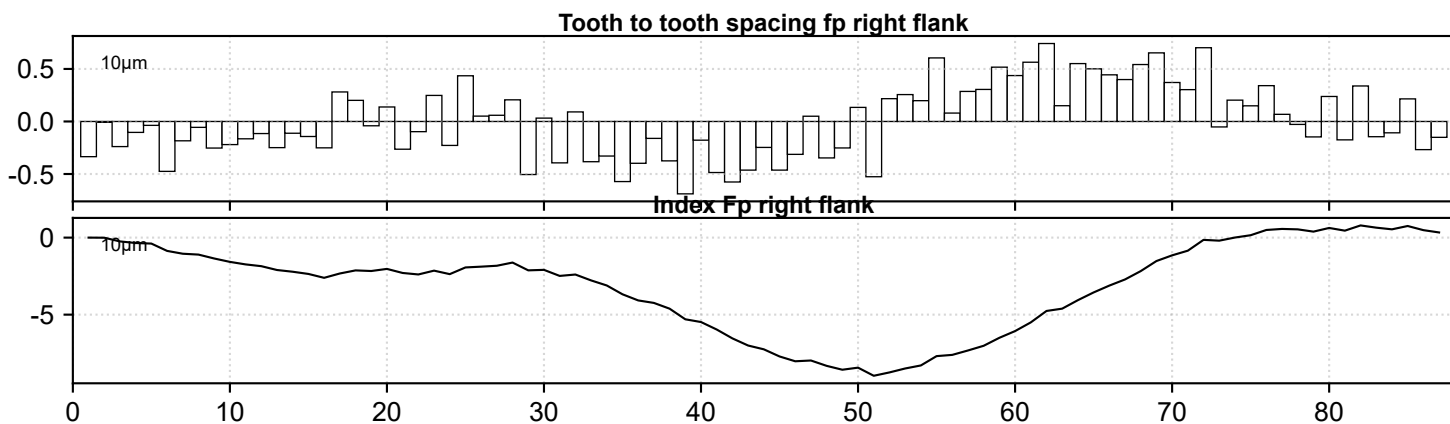
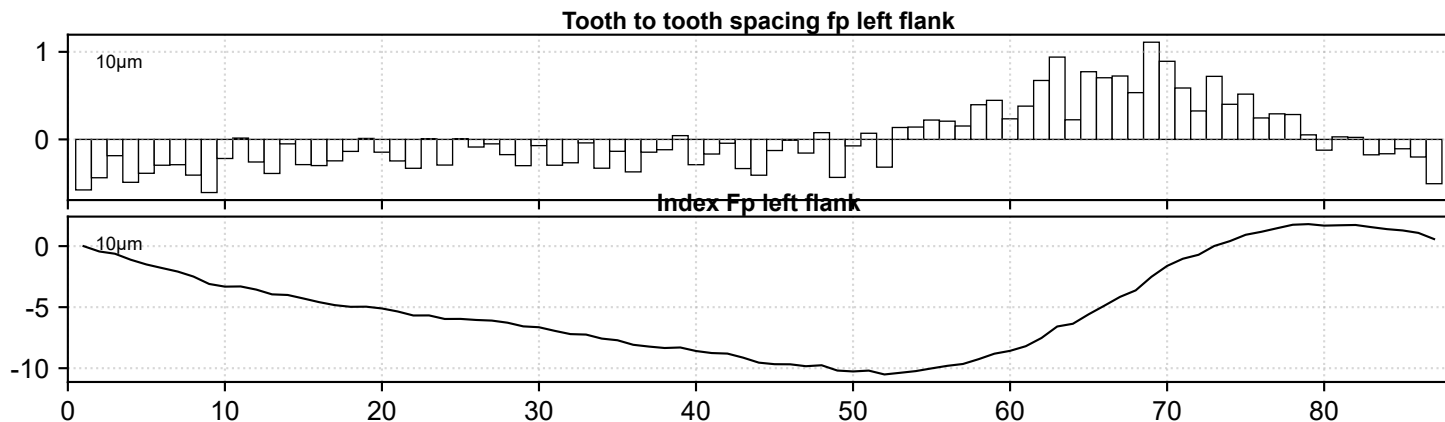


Lim.value Qual.	1	2	3	4	5	6
±8 5						
±8 5						
12 5						
9 5						



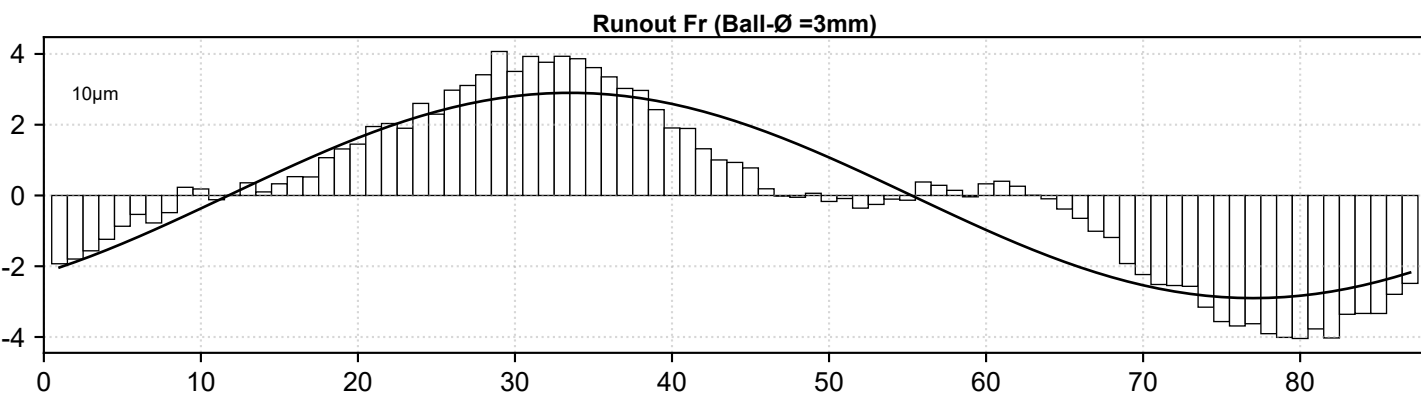
## Gear Spacing

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Pressure angle:</b>	19°
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-W	<b>Module m:</b>	1.86mm	<b>Helix angle:</b>	25°
<b>Order No.:</b>	263751-018-WAV	<b>Loc. of check:</b>	Jintan		
<b>Cust./Mach. No.:</b>	P26 -601418	<b>Condition:</b>	Grinding-0403		



Pitch measuring circle:

Pitch measuring circle:		left flank		right flank		
	Act.value	Qual.	Lim.value Qual.	Act.value	Qual.	Lim.value Qual.
Worst single pitch deviation fp max	1.1		12 5	0.7		12 5
Worst spacing deviation fu max	0.7			0.8		
Range of Pitch Error Rp	1.7			1.4		
Total cum. pitch dev. Fp	12.3		36 5	9.8		36 5
Cum. pitch deviation Fp10	7.2			5.0		



MdK 183.239[mm]/Ball-Ø 1								
Pitch Line Runout	Fr	8.1				Lim.value	183.239	183.239
Variation of tooth thickness	Rs					Act.	181.395	183.240 179.571