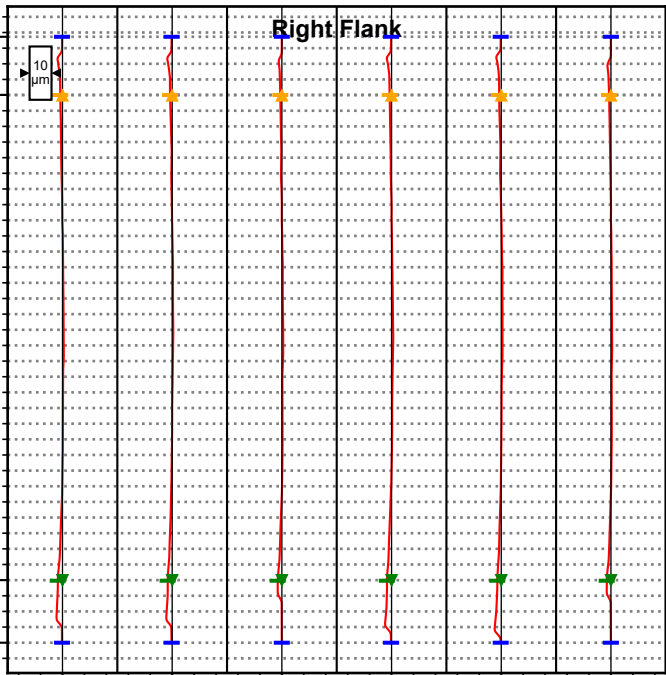
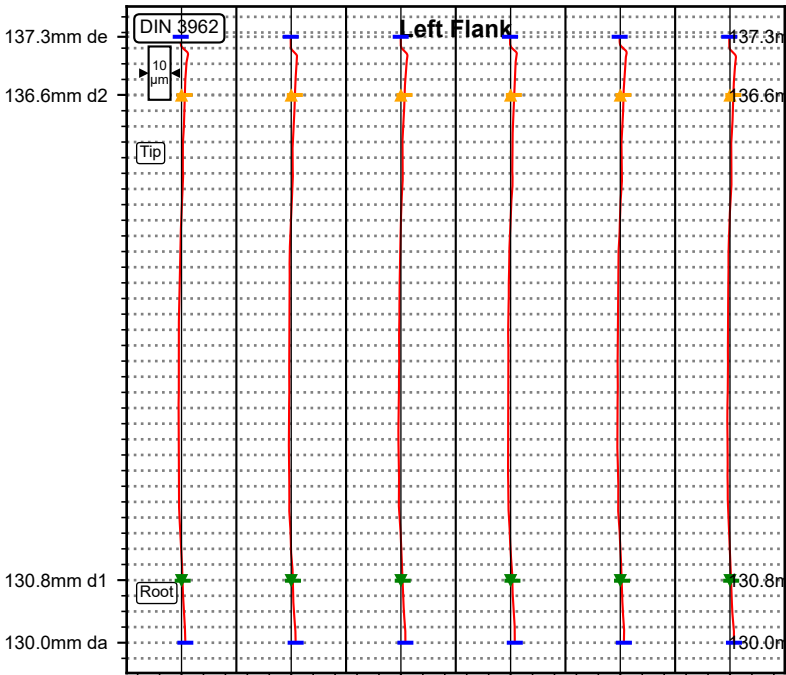
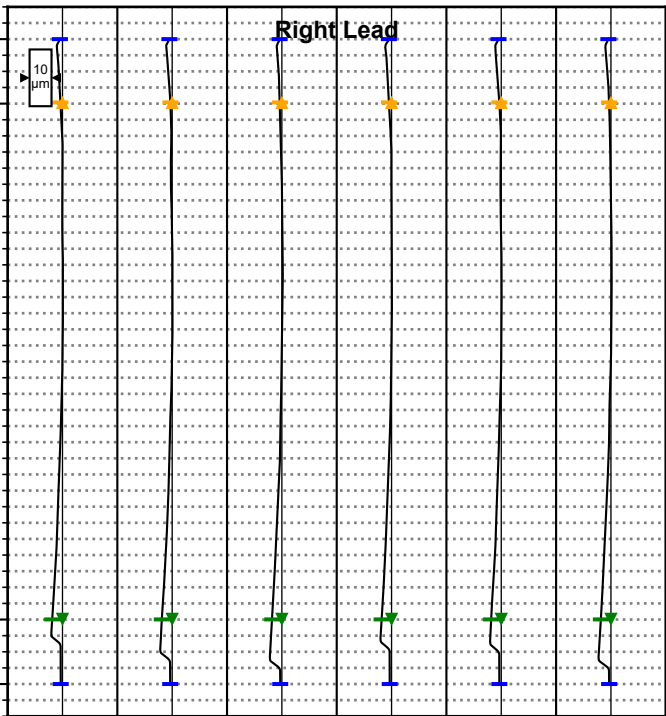
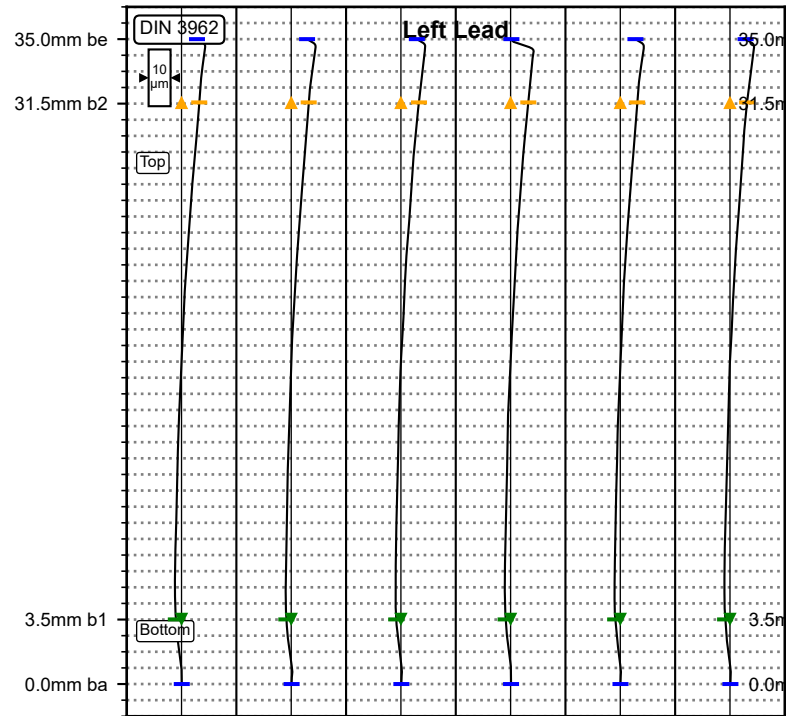


Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



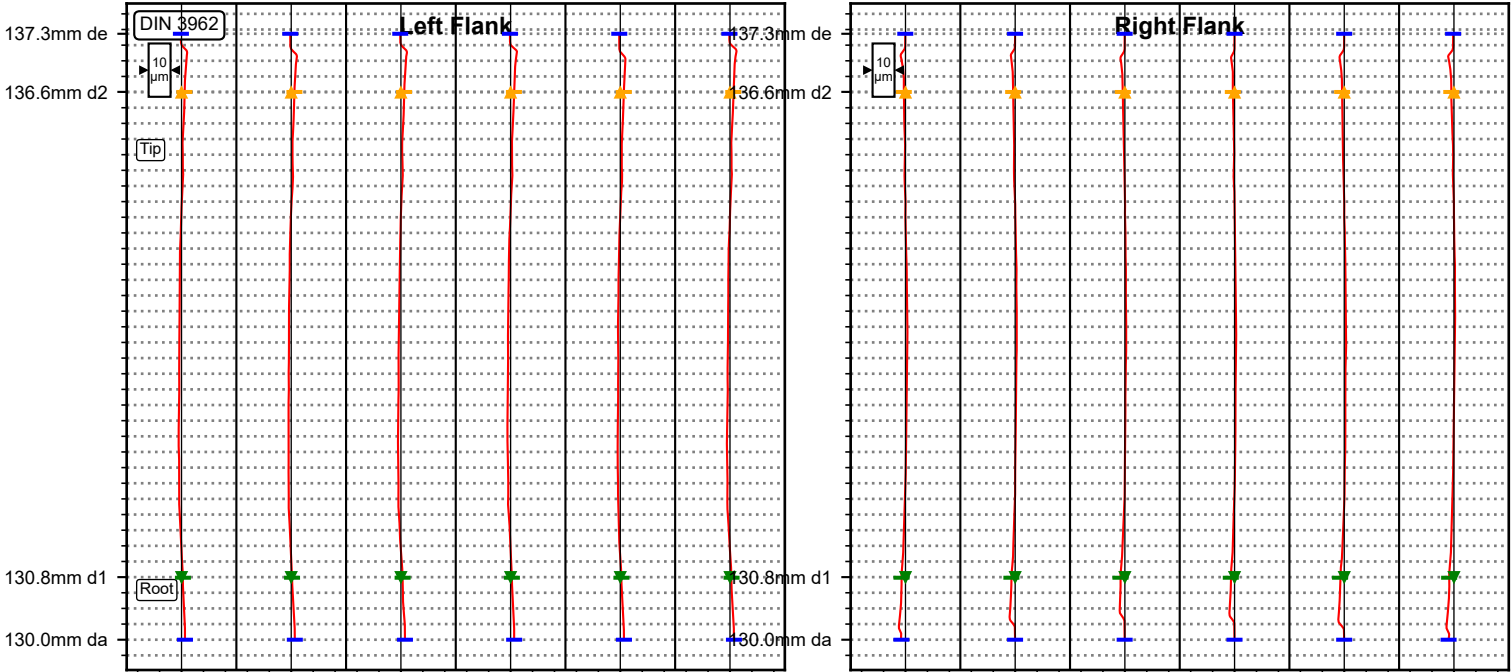
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6
fHam	1.1 1	V 0.2					±11 5	±11 5	0.5 1	V 0.9				
fHa	1.2 1	1.0	1.0	1.1	1.0	1.1	±11 5	±11 5	0.5	0.8	0.1	0.9 1	0.8	0.0
fa	5.5 2	4.6	4.8	5.1	5.3	4.5	20 5	20 5	3.6	3.5	2.7	4.1 1	3.9	2.7
ffa	4.7 2	4.0	4.2	4.5	4.6	3.9	16 5	16 5	3.9	3.9	2.7	4.3 2	4.1	2.7
Ca	-2.2	-2.1	-2.0	-2.2	-2.2	-1.9			1.9	1.8	1.6	2.0	1.8	1.6



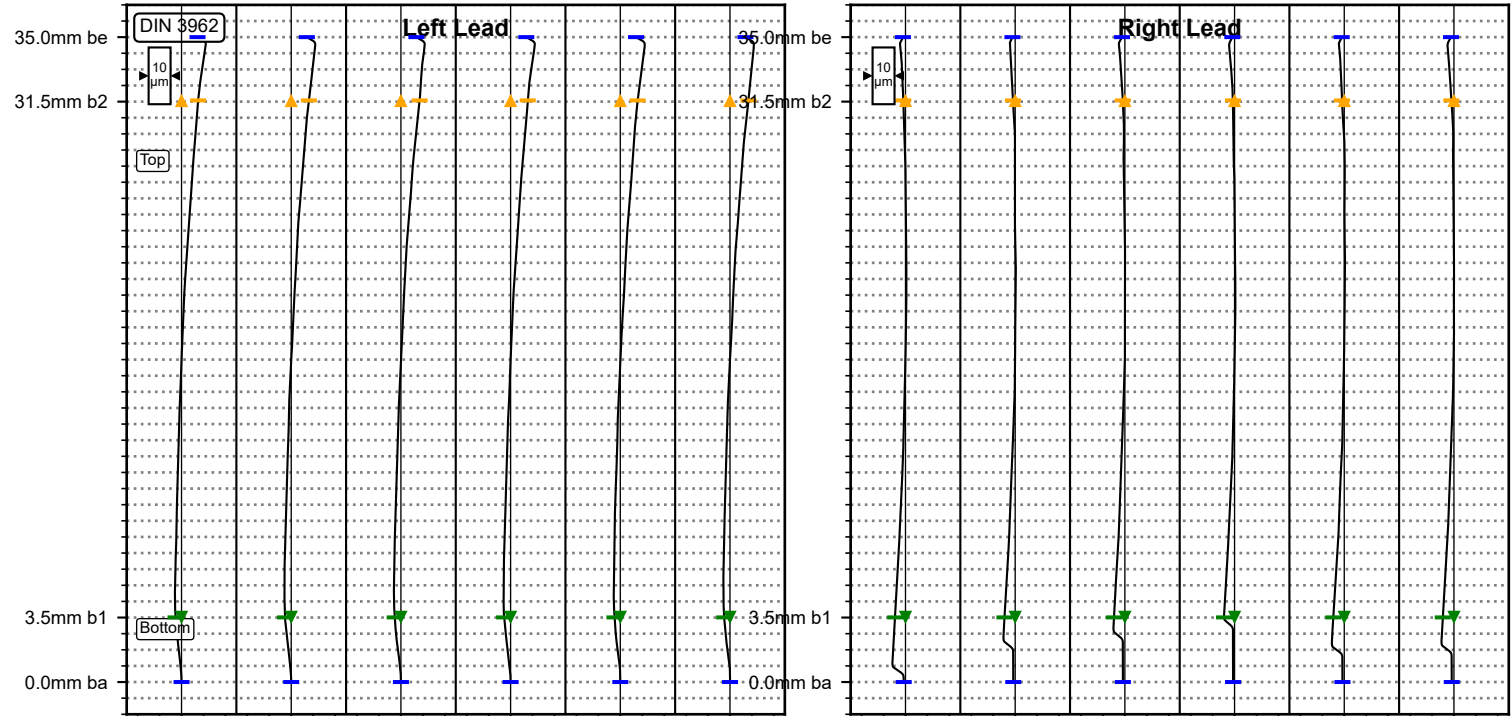
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6
fHbm	12.0 7	V 1.2					±8 5	±8 5	3.0 2	V 0.9				
fHb	12.6 7	12.2	12.1	11.4	11.9	12.0	±8 5	±8 5	2.6	3.1	3.4	2.6	2.7	3.5 2
fb	14.3 6	14.1	14.0	14.1	13.7	13.9	12 5	12 5	5.6	5.9	6.2	5.5	5.6	6.3 3
ffb	12.6 7	12.6 7	12.2	11.5	12.0	12.1	9 5	9 5	5.4	6.0	5.3	5.7	5.7	6.4 3
Cb	-2.7	-2.7	-2.7	-2.7	-2.7	-2.5			2.5	2.6	2.7	2.6	2.5	2.7

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



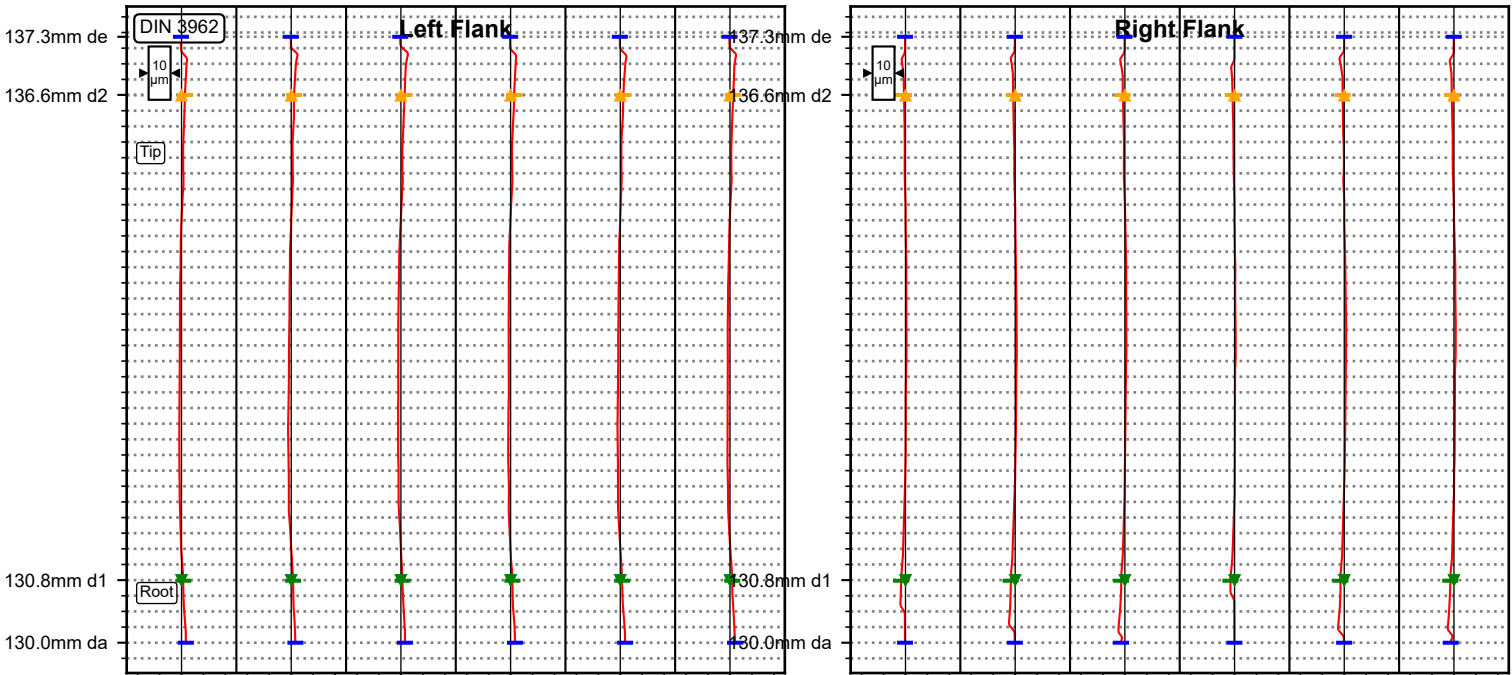
	12	11	10	9	8	7	Lim.value	Qual.	Lim.value	Qual.	7	8	9	10	11	12
fHam	1.2 1	V 0.3					±11	5	±11	5	0.6 1	V 0.8				
fHa	1.0	1.2	1.2	1.3 1	1.1	1.3 1	±11	5	±11	5	0.9	0.4	0.5	0.5	0.4	1.2 1
fa	4.7	4.7	5.1	5.4 2	4.0	5.4 2	20	5	20	5	4.2	3.7	3.4	3.4	3.9	4.3 1
ffa	4.0	4.0	4.4	4.6 2	3.5	4.6 2	16	5	16	5	4.5	3.7	3.6	3.4	3.9	4.8 2
Ca	-2.0	-1.9	-1.9	-2.2	-1.9	-2.0					2.0	1.8	1.9	1.8	2.0	2.0



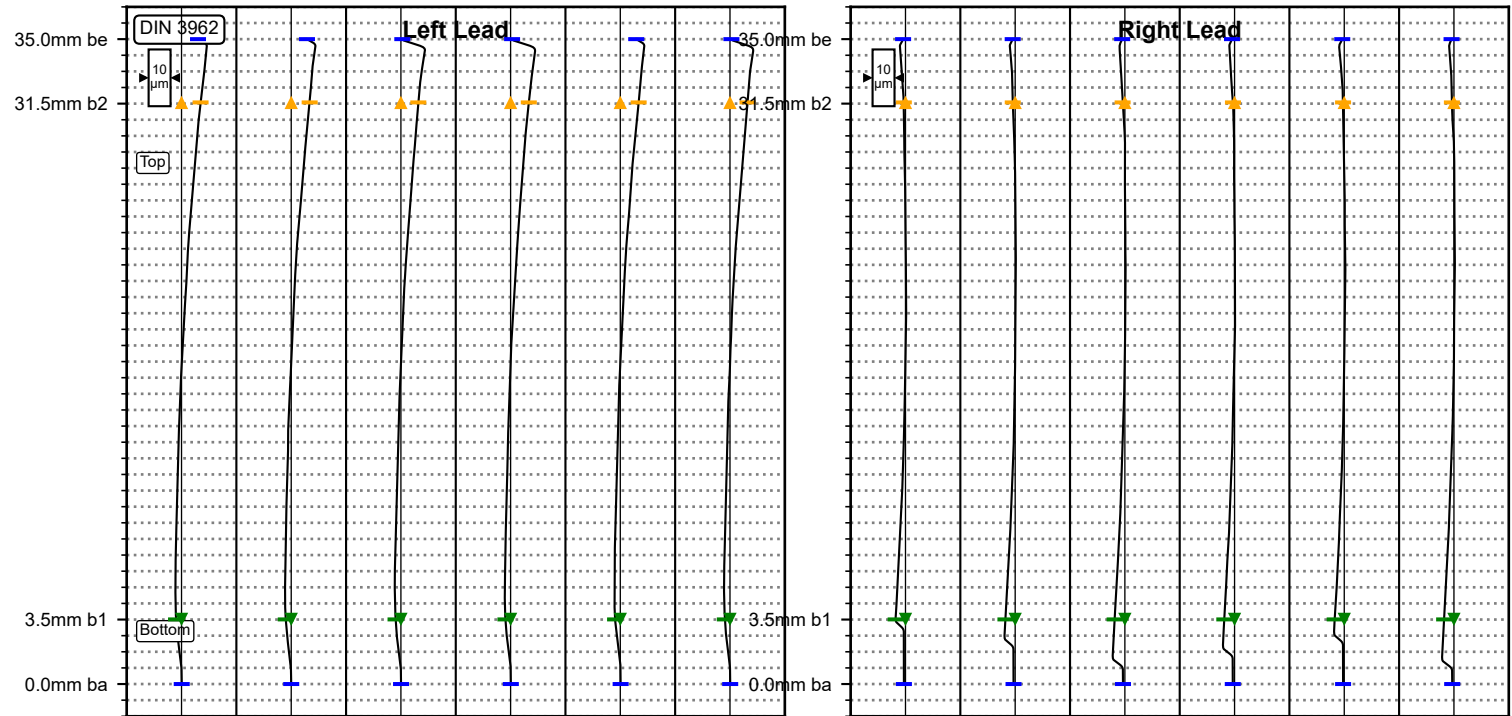
	12	11	10	9	8	7	Lim.value	Qual.	Lim.value	Qual.	7	8	9	10	11	12
fHbm	12.7 7	V 0.7					±8	5	±8	5	3.1 2	V 1.9				
fHb	12.3	12.7	13.0 7	12.8	12.7	12.8	±8	5	±8	5	4.1 3	3.1	2.6	2.2	3.5	3.0
fb	14.9 6	14.7	14.6	14.8	14.6	14.4	12	5	12	5	6.7 3	5.9	5.5	5.4	6.3	6.0
ffb	12.3	12.7	13.0 7	12.8	12.7	12.8	9	5	9	5	6.9 3	6.4	6.2	4.7	6.2	5.8
Cb	-2.3	-2.3	-2.6	-2.3	-2.3	-2.6					2.8	2.7	2.8	3.0	2.7	2.8

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L α :	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. L β :	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



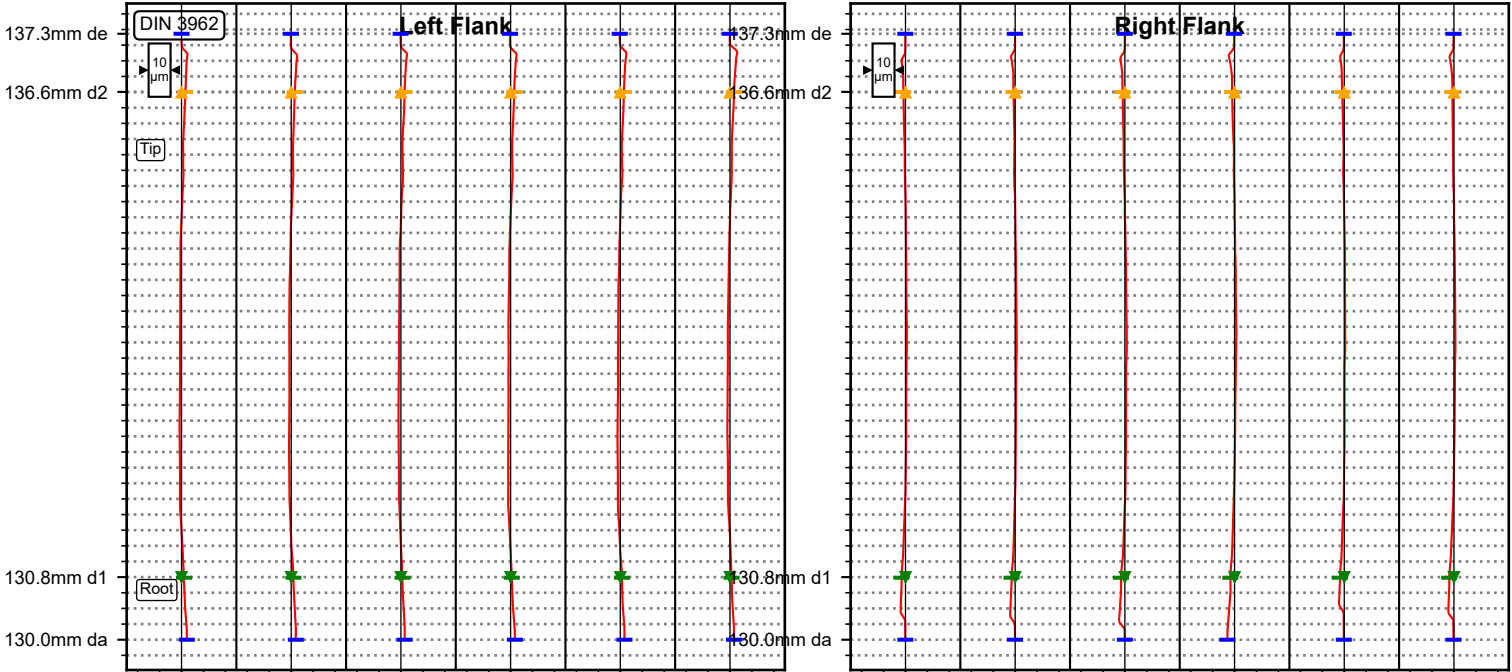
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHam	0.9 1	V 0.6					±11 5	±11 5	0.6 1	V 0.9				
fHa	0.9	1.0	1.2 1	0.9 0.8	0.6		±11 5	±11 5	0.5 0.8	0.8	0.9 1	-0.0 0.7		0.7
fa	4.1	5.5	5.7 2	4.5 5.0	4.9		20 5	20 5	3.0 3.9	3.9	3.9 2.5	4.0 1	3.9	
ffa	3.6	4.8	5.1 2	4.0 4.5	4.5		16 5	16 5	3.2 3.9	3.9	4.2 2.5	4.4 2	3.9	
Ca	-1.9	-2.0	-2.4	-2.1	-2.0	-2.1			1.6 2.0	2.0	1.9 1.6	1.9	1.9	



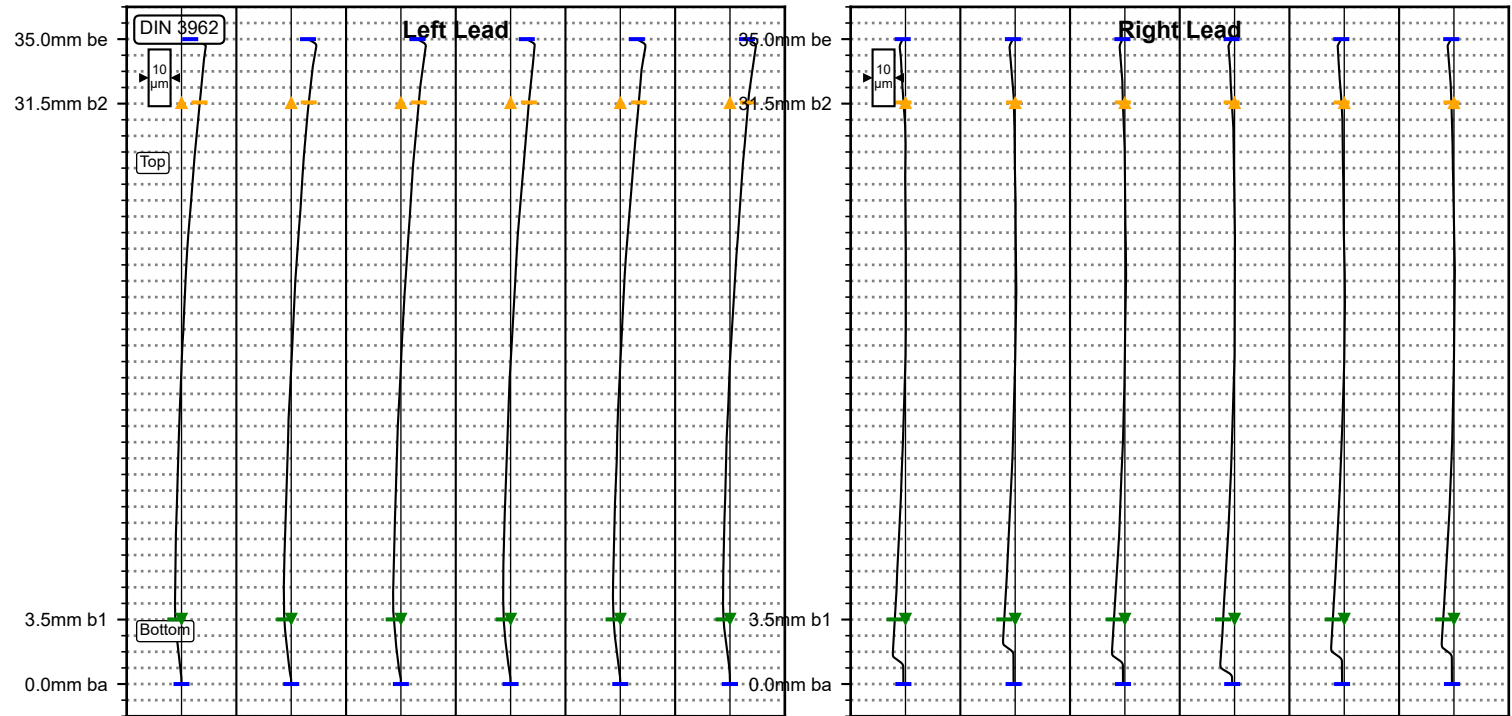
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHbm	12.3 7	V 1.5					±8 5	±8 5	2.9 2	V 1.8				
fHb	13.2 7	12.6 11.9	12.1 12.4	11.7			±8 5	±8 5	1.8 2.5	3.6 3	3.2 2.5	3.6 3		
fb	14.9 6	14.5 14.4	14.3 14.4	14.0			12 5	12 5	5.0 5.5	6.1 3	5.8 5.3	6.1 3		
ffb	13.2 7	12.6 11.9	12.2 12.4	11.7			9 5	9 5	4.8 5.7	6.7 3	6.3 5.6	6.2		
Cb	-2.7	-2.8	-2.7	-2.7	-2.7	-2.7			2.8 2.7	2.6	2.6	2.6	2.5	

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



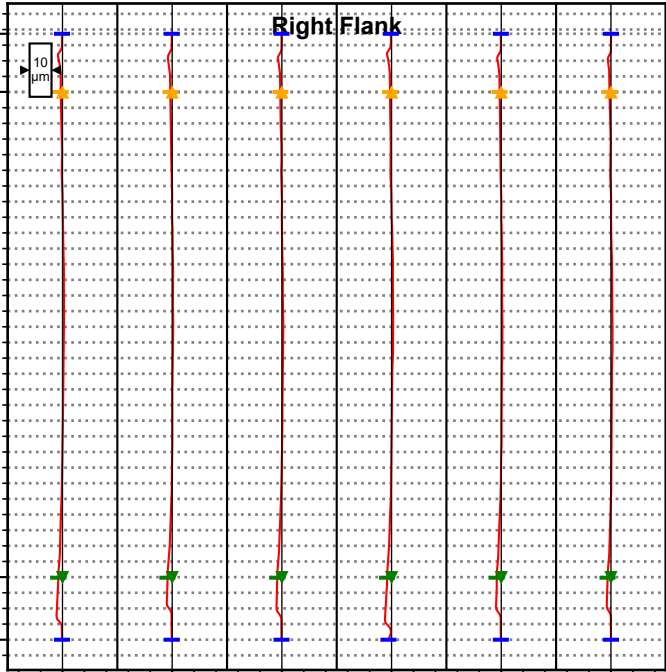
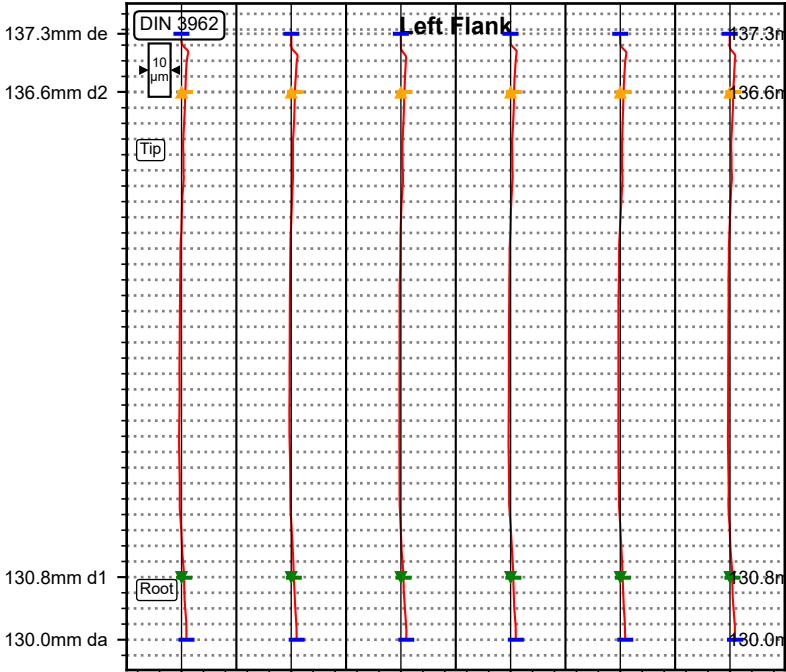
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHam	1.0 1	V 0.7					±11 5	±11 5	0.5 1	V 0.6				
fHa	0.6	0.8	1.1	1.2	1.2	1.3 1	±11 5	±11 5	0.3	0.4	0.3	0.9 1	0.5	0.7
fa	4.5	4.5	5.0	4.7	5.0	5.5 2	20 5	20 5	3.2	3.3	3.8	4.4 1	3.1	3.6
ffa	4.1	4.0	4.3	4.0	4.2	4.7 2	16 5	16 5	3.3	3.5	3.7	4.8 2	3.3	3.9
Ca	-2.0	-2.1	-2.0	-2.0	-2.1	-2.3			1.8	1.7	1.9	2.1	1.6	1.9



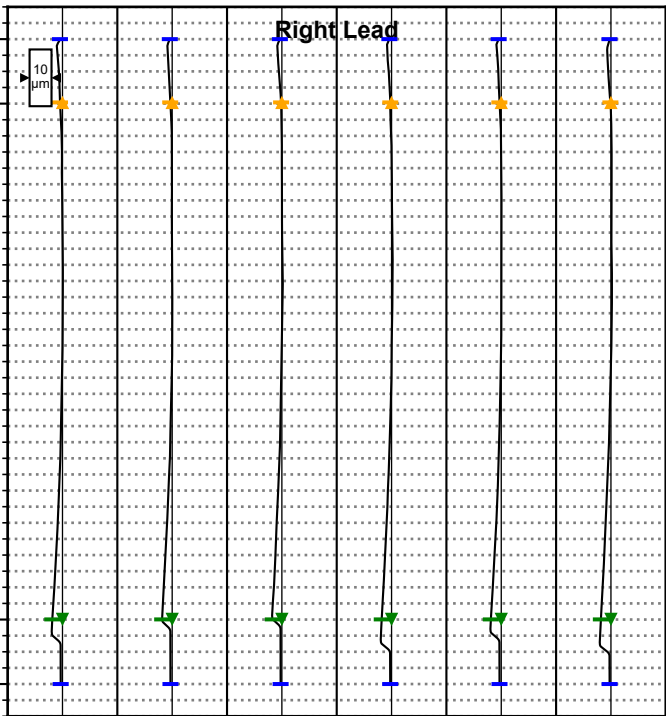
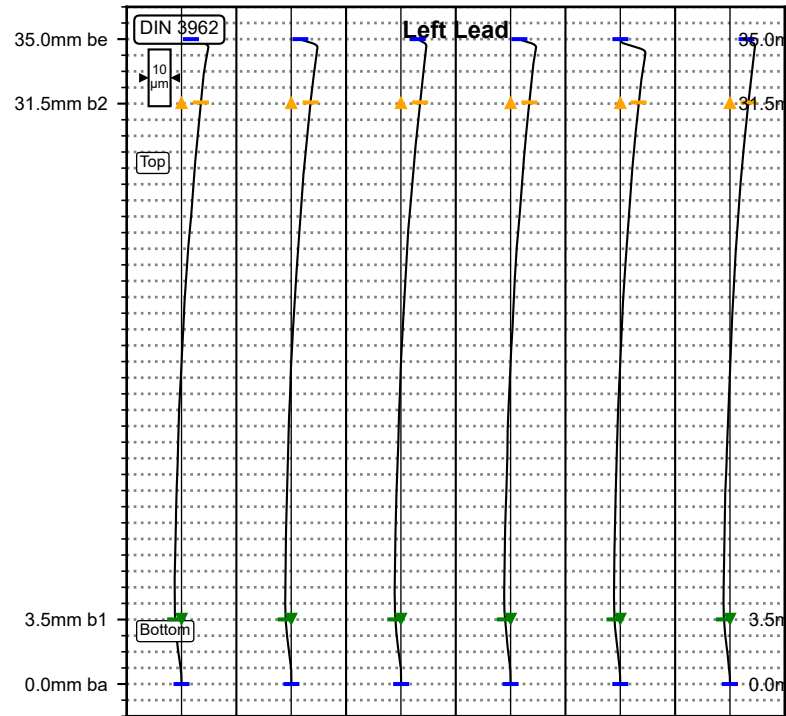
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHbm	13.3 7	V 0.9					±8 5	±8 5	3.6 3	V 1.5				
fHb	12.7	13.1	13.5	13.6 7	13.5	13.5	±8 5	±8 5	3.8	3.4	3.8	4.3 3	3.2	2.8
fb	15.3	15.9 6	15.8	15.4	15.6	15.7	12 5	12 5	6.3	6.3	6.7	7.2 3	6.6	6.2
ffb	12.7	13.1	13.5	13.6 7	13.5	13.5	9 5	9 5	6.2	5.6	5.8	6.4 3	5.7	5.3
Cb	-2.4	-2.1	-2.1	-2.4	-2.5	-2.5			2.5	2.8	3.0	3.0	3.2	3.1

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



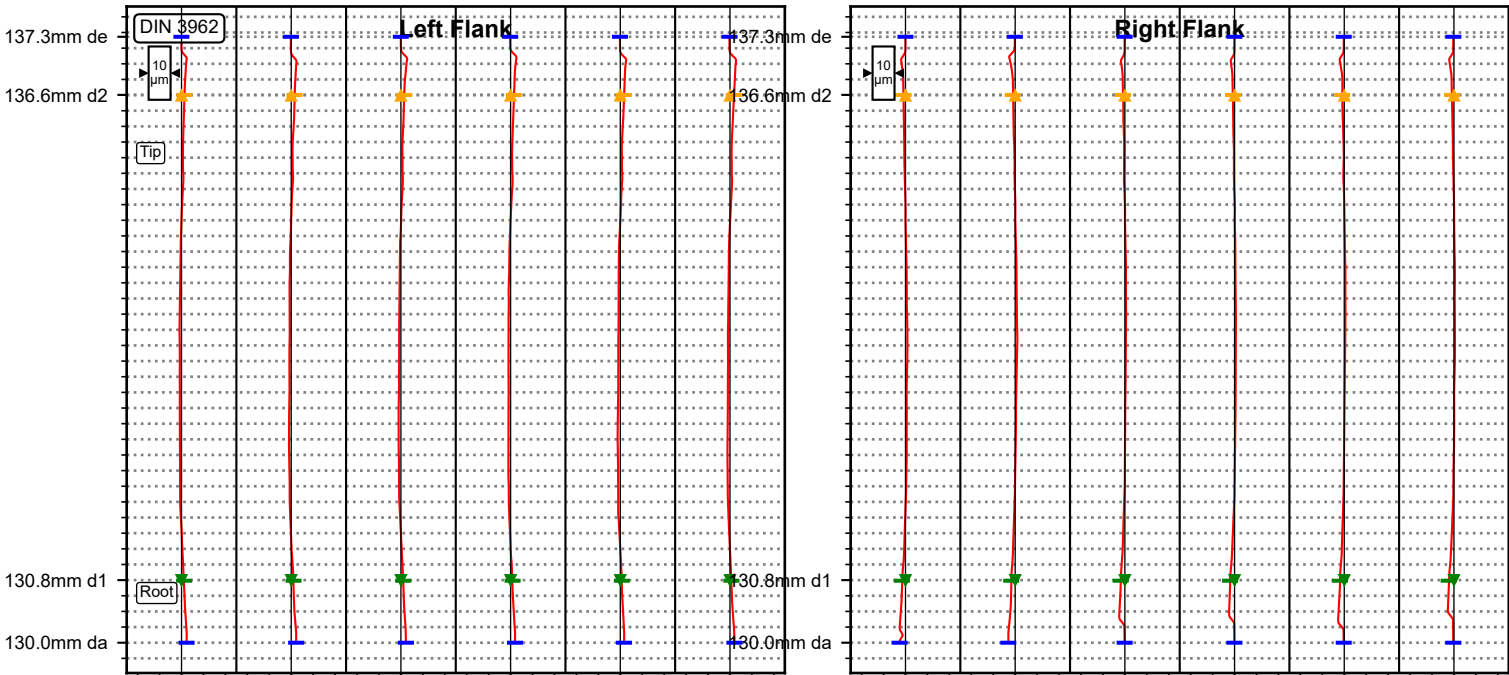
	30	29	28	27	26	25	Lim.value Qual.	Lim.value Qual.	25	26	27	28	29	30
fHam	0.6 1	V 0.5					±11 5	±11 5	0.7 1	V 0.7				
fHa	0.9 1	0.4	0.4	0.6	0.6	0.5	±11 5	±11 5	0.9	0.5	0.7	1.0 1	0.7	0.3
fa	5.4 2	4.6	3.8	4.8	4.9	4.1	20 5	20 5	3.8	3.2	3.5	4.1 1	3.2	2.9
ffa	4.8 2	4.3	3.7	4.5	4.6	3.8	16 5	16 5	4.2	3.4	3.8	4.4 2	3.4	3.0
Ca	-2.2	-2.2	-1.8	-2.1	-2.3	-1.9			1.9	1.7	1.8	1.9	1.8	1.5



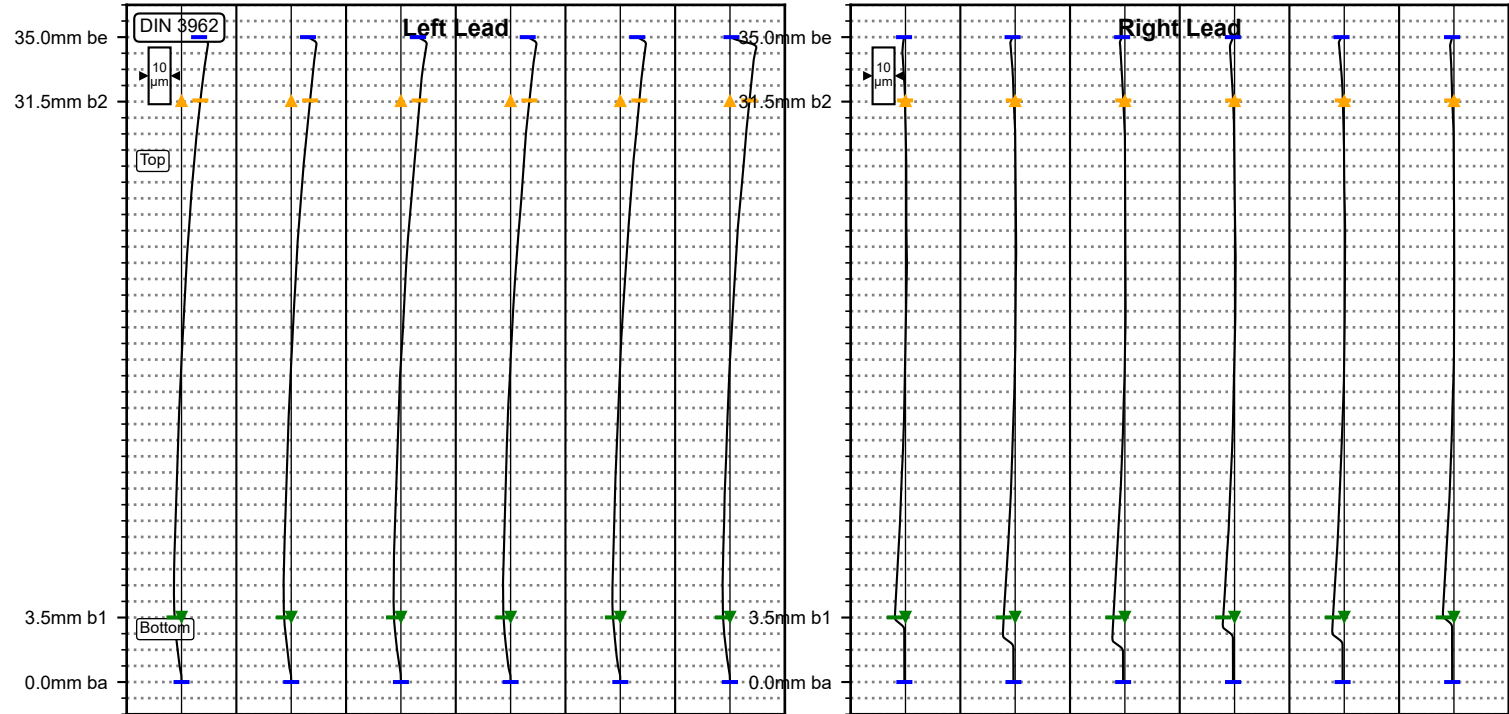
	30	29	28	27	26	25	Lim.value Qual.	Lim.value Qual.	25	26	27	28	29	30
fHbm	13.1 7	V 1.5					±8 5	±8 5	2.7 2	V 1.4				
fHb	13.8 7	13.3	13.1	12.9	12.3	12.9	±8 5	±8 5	2.3	2.2	2.2	3.0	2.8	3.6 3
fb	16.6 7	15.4	15.2	15.2	14.9	15.2	12 5	12 5	5.3	4.9	5.1	5.7	5.4	5.8 2
ffb	13.8 7	13.3	13.1	12.9	12.3	12.9	9 5	9 5	4.9	4.6	5.0	6.4 3	6.2	4.9
Cb	-2.8	-2.9	-2.7	-2.7	-2.7	-2.5			2.7	2.5	2.5	2.6	2.5	2.3

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



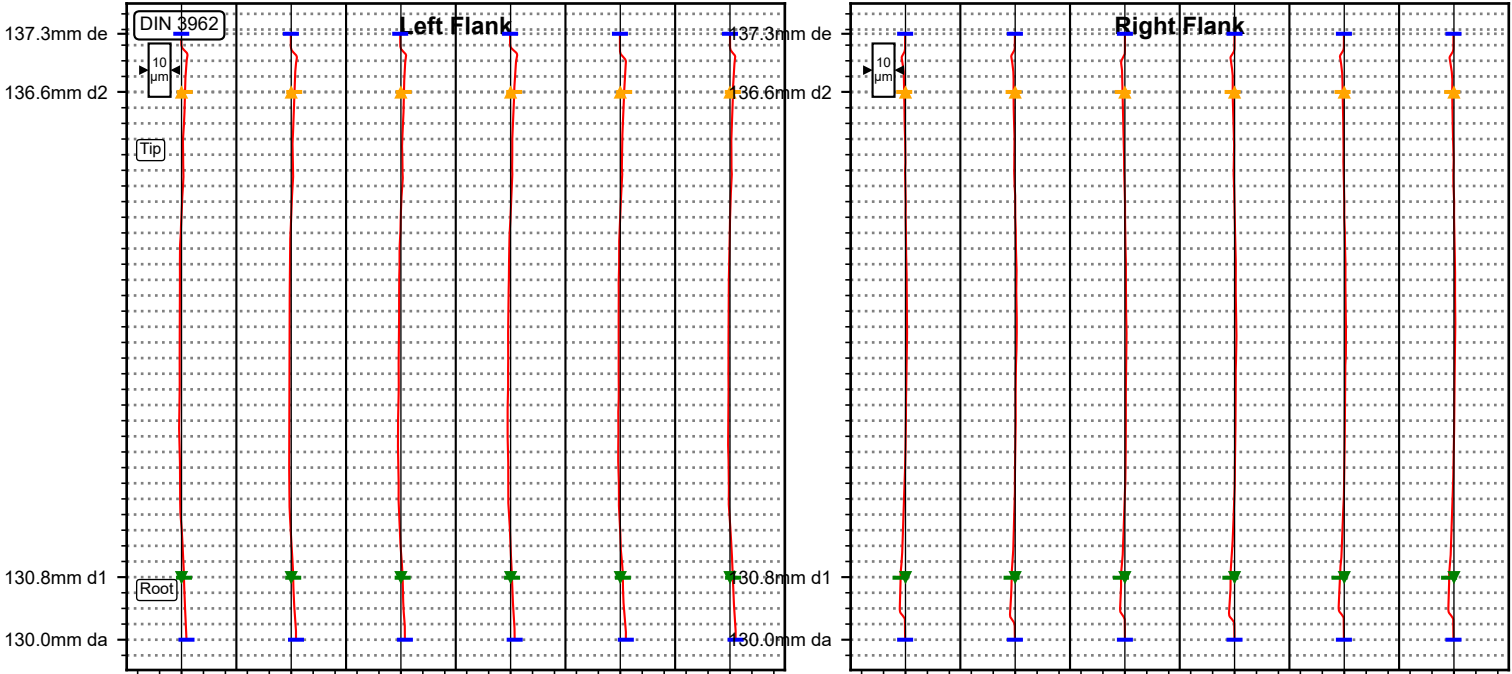
	36	35	34	33	32	31	Lim.value	Qual.	Lim.value	Qual.	31	32	33	34	35	36
fHm	0.7 1	V 0.8					±11	5	±11	5	0.7 1	V 0.4				
fHa	0.3	0.5	0.6	0.8	1.1 1	1.1 1	±11	5	±11	5	0.5	0.9 1	0.7	0.6	0.8	0.8
fa	4.2	4.2	4.9 1	4.8	4.9 1	4.7	20	5	20	5	3.8	4.9 1	3.6	3.5	3.8	3.6
ffa	4.1	3.9	4.5 2	4.4	4.2	4.0	16	5	16	5	3.9	5.3 2	3.6	3.5	4.1	3.9
Ca	-2.0	-2.0	-2.1	-2.1	-2.0	-2.0					1.8	2.1	1.8	1.9	1.9	1.8



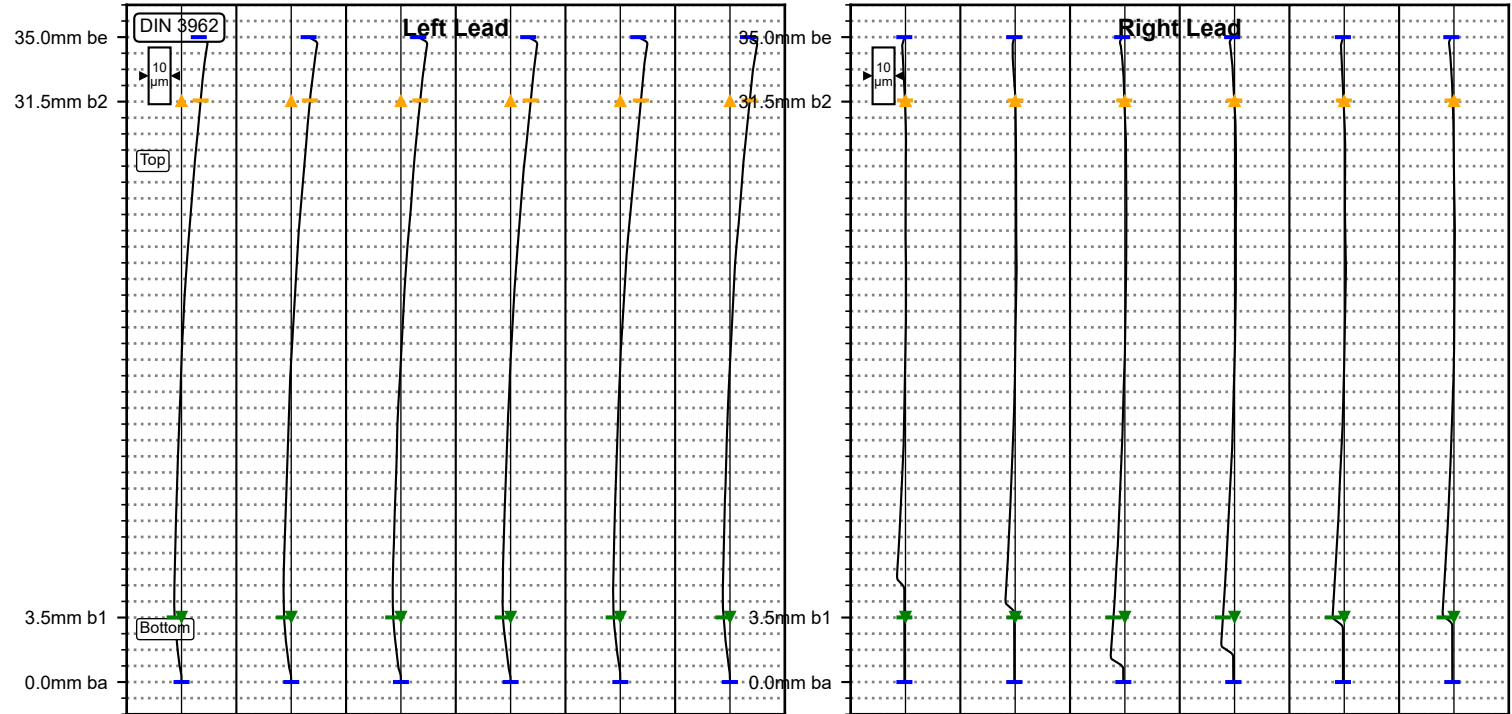
	36	35	34	33	32	31	Lim.value	Qual.	Lim.value	Qual.	31	32	33	34	35	36
fHbm	13.9 7	V 0.4					±8	5	±8	5	3.2 2	V 0.9				
fHb	13.8	13.7	13.9	14.0	14.1 7	13.7	±8	5	±8	5	3.0	3.6 3	3.6 3	3.0	3.2	2.7
fb	16.5	16.0	16.0	16.2	16.2	17.3 7	12	5	12	5	5.7	6.3 3	6.3 3	6.2	6.1	5.4
ffb	13.8	13.7	13.9	14.0	14.1 7	14.0	9	5	9	5	4.8	7.2	7.8 4	5.1	7.8 4	4.7
Cb	-2.4	-2.4	-2.5	-2.4	-2.4	-2.6					2.5	2.7	2.9	2.9	2.9	2.7

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



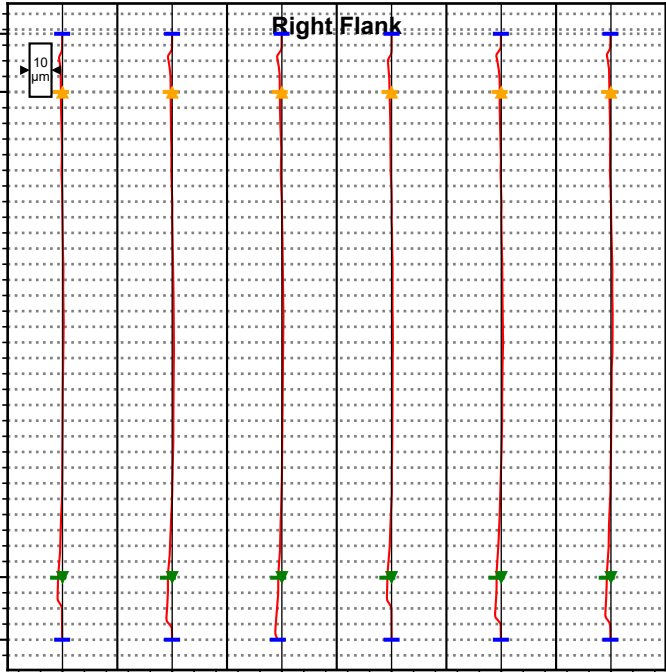
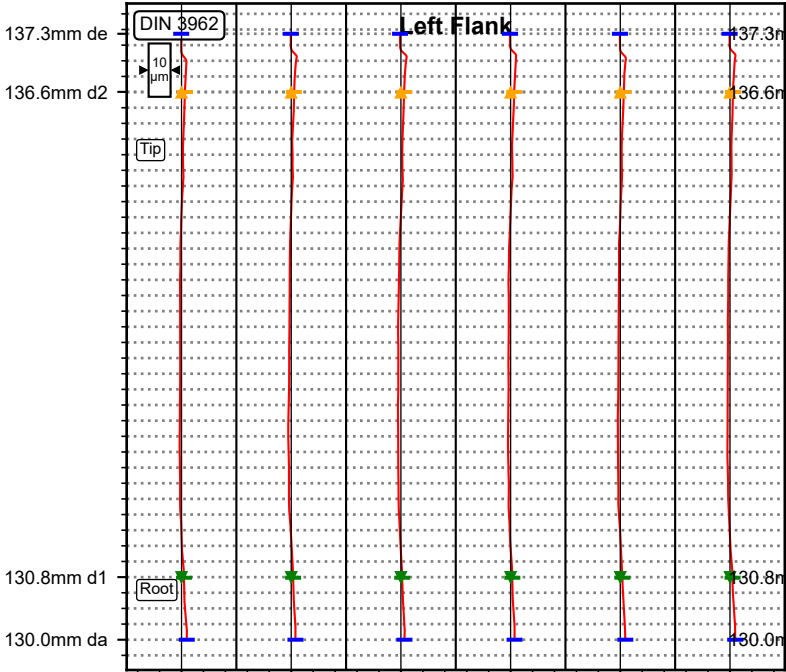
	42	41	40	39	38	37	Lim.value Qual.	Lim.value Qual.	37	38	39	40	41	42
fHam	0.6 1	V 1.1					±11 5	±11 5	0.7 1	V 0.9				
fHa	0.5	0.6	0.9	1.2 1	0.5	0.1	±11 5	±11 5	1.1 1	0.6	0.2	0.5	0.6	0.9
fa	4.6	4.4	4.7	5.3 2	4.1	4.1	20 5	20 5	3.6	3.4	3.2	3.7 1	3.6	3.5
ffa	4.4	4.1	4.2	4.6 2	3.9	4.1	16 5	16 5	3.8	3.7	3.1	3.8	3.9 1	3.9 1
Ca	-2.2	-1.9	-1.9	-2.3	-2.1	-2.0			1.9	1.7	1.8	1.9	1.9	1.9



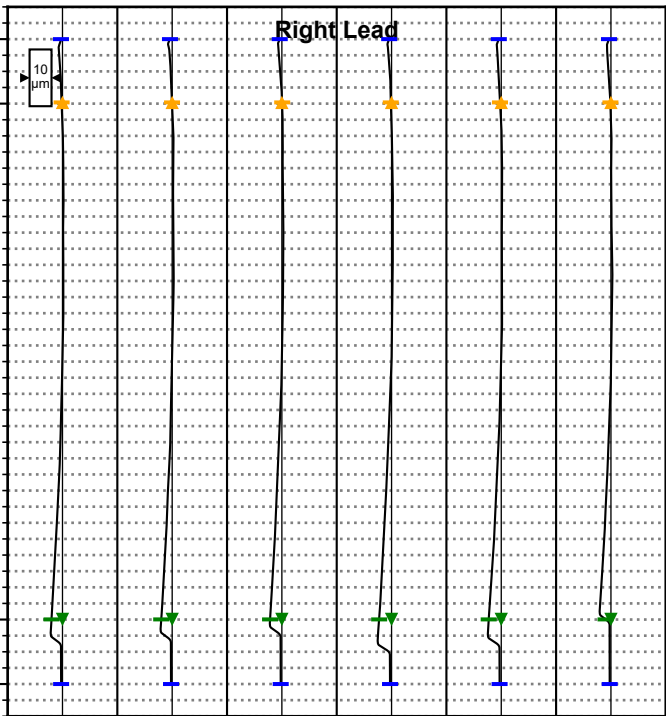
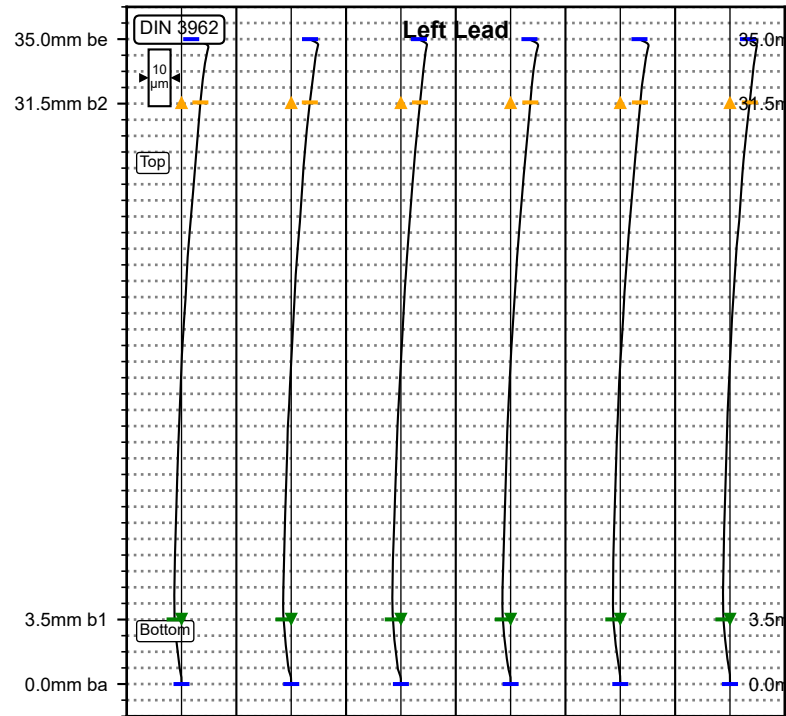
	42	41	40	39	38	37	Lim.value Qual.	Lim.value Qual.	37	38	39	40	41	42
fHbm	14.3 7	V 0.9					±8 5	±8 5	3.3 2	V 3.4				
fHb	13.8	14.0	14.5	14.7 7	14.5	14.1	±8 5	±8 5	1.7	2.6	5.1 4	4.6	3.3	2.8
fb	16.2	16.4	16.6 7	16.6 7	16.6 7	16.6 7	12 5	12 5	4.3	5.3	7.4 3	7.0	6.2	5.9
ffb	13.8	14.0	14.5	14.7 7	14.5	14.1	9 5	9 5	3.8	4.5	10.3 6	9.9	5.2	7.3
Cb	-2.6	-2.5	-2.5	-2.7	-2.9	-2.7			0.9	1.8	2.4	2.6	2.8	2.8

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



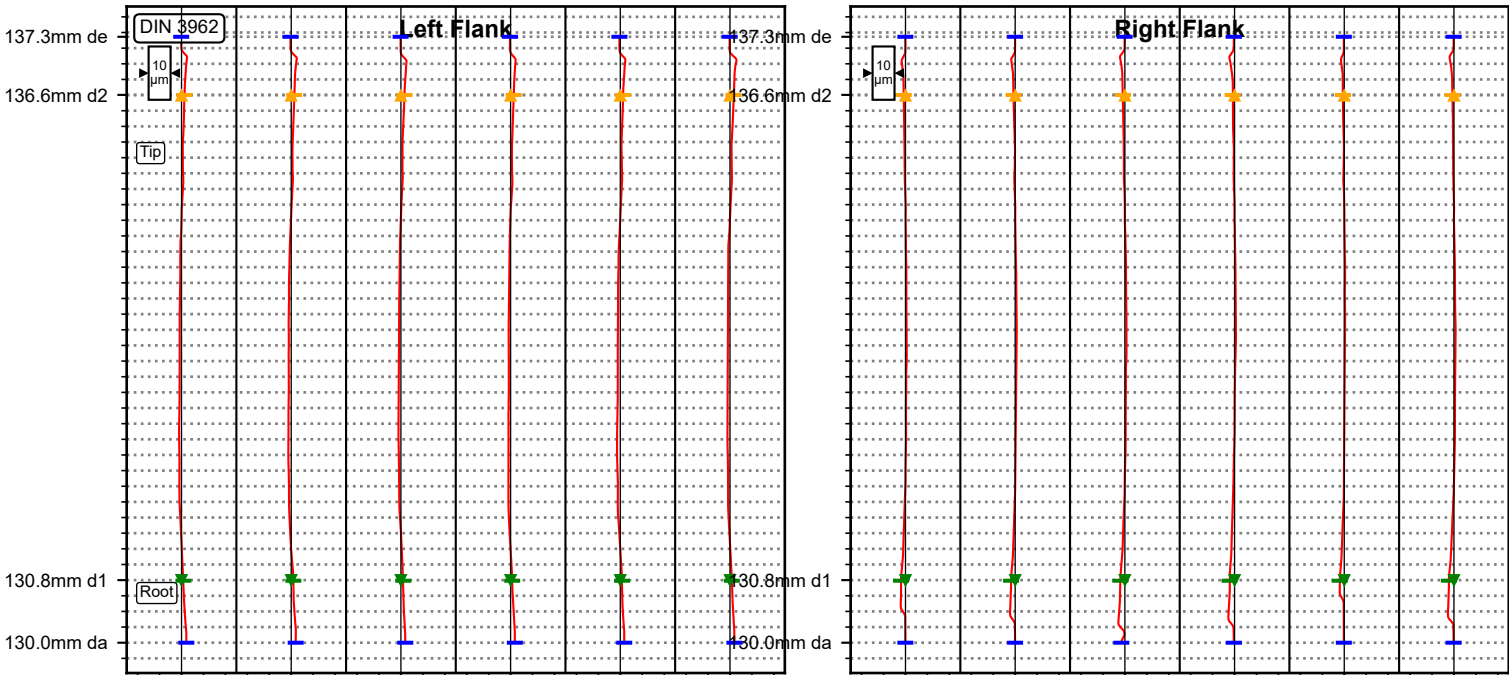
	48	47	46	45	44	43	Lim.value Qual.	Lim.value Qual.	43	44	45	46	47	48
fHam	0.7 1	V 0.7					±11 5	±11 5	0.6 1	V 0.8				
fHa	0.3	0.7	1.0 1	1.0 1	0.6	0.4	±11 5	±11 5	0.5	0.6	0.8 0.1	0.9 1	0.8	0.8
fa	3.6	5.0	5.1 2	4.6	4.5	4.7	20 5	20 5	2.9	3.8	3.9 2.8	4.0 1	3.7	3.7
ffa	3.7	4.6 2	4.5	4.0	4.1	4.4	16 5	16 5	3.1	3.8	4.2 2.8	4.3 2	3.9	3.9
Ca	-1.9	-1.9	-2.2	-2.1	-2.0	-2.2			1.6	2.0	1.9 1.7	2.1	1.9	1.9



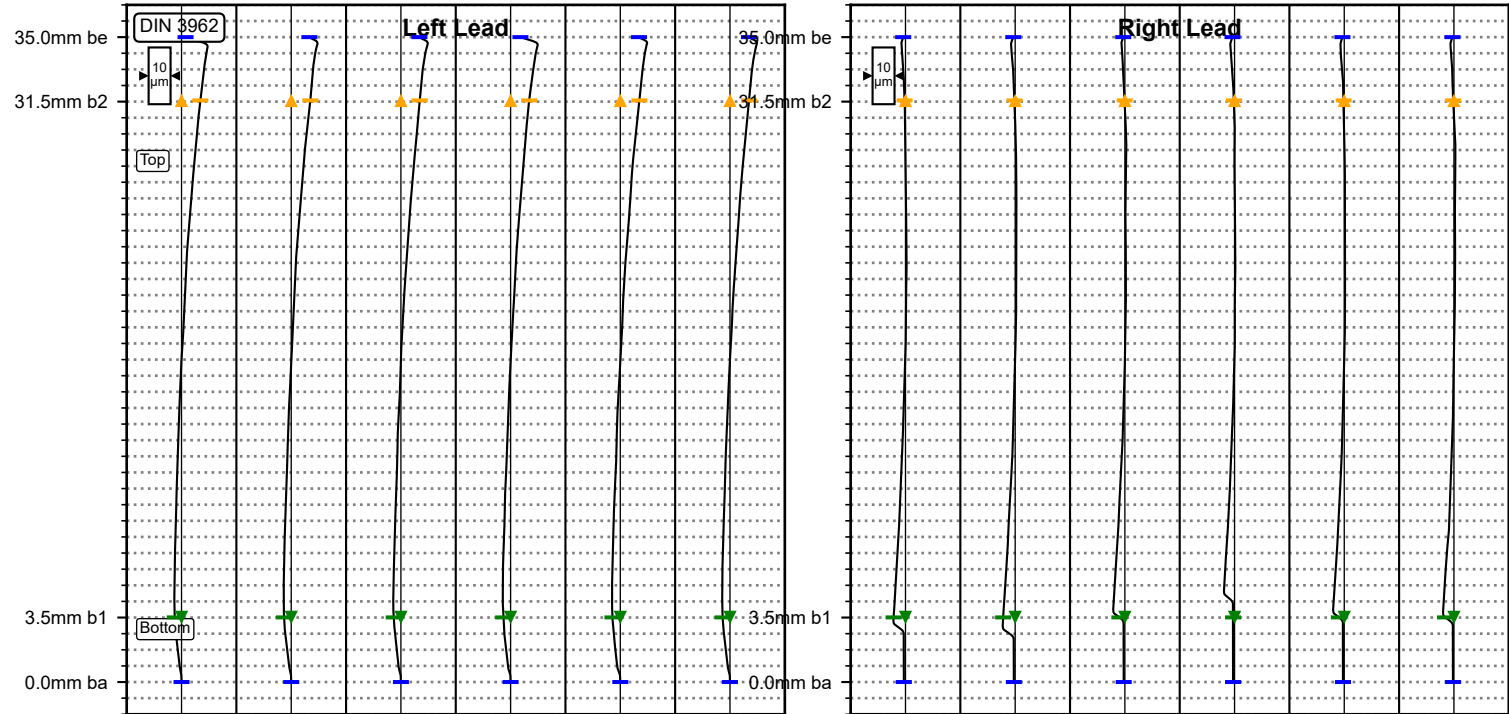
	48	47	46	45	44	43	Lim.value Qual.	Lim.value Qual.	43	44	45	46	47	48
fHbm	14.3 7	V 0.9					±8 5	±8 5	3.8 3	V 1.8				
fHb	13.9	14.1	14.6	14.8 7	14.6	13.9	±8 5	±8 5	3.5	3.6	3.8	4.7 4	4.1	2.9
fb	17.1	17.8	17.5	17.9 7	17.7	16.6	12 5	12 5	6.0	6.3	6.4	7.2 3	6.8	6.0
ffb	13.9	14.2	14.6	14.8 7	14.6	13.9	9 5	9 5	5.2	8.4 5	8.1	8.4 5	7.3	5.8
Cb	-2.5	-2.2	-2.3	-2.6	-2.7	-2.8			2.6	2.4	2.6	2.8	2.9	2.7

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



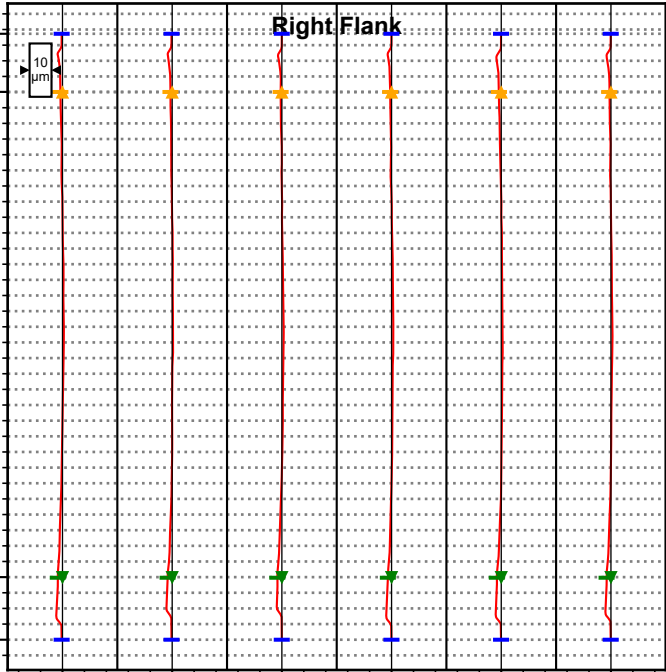
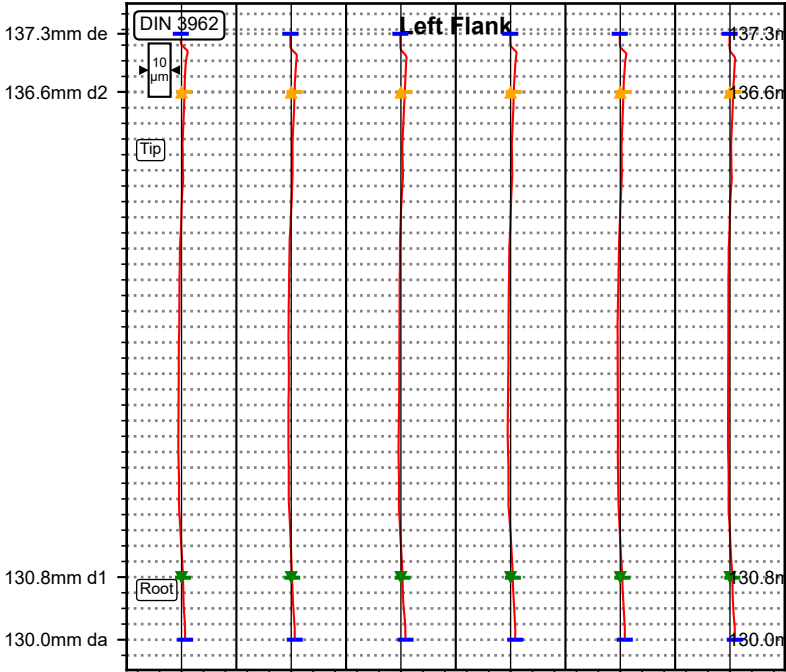
	54	53	52	51	50	49	Lim.value Qual.	Lim.value Qual.	49	50	51	52	53	54
fHam	0.7 1	V 0.2					±11 5	±11 5	0.7 1	V 0.6				
fHa	0.7	0.7	0.6	0.8 1	0.8 1	0.8 1	±11 5	±11 5	0.4	0.5	0.8	1.0 1	0.5	0.8
fa	4.6	5.0	4.5	4.2	4.8	5.3 2	20 5	20 5	3.0	3.4	4.1 1	3.8	2.8	3.9
ffa	4.2	4.6	4.1	3.7	4.3	4.8 2	16 5	16 5	3.1	3.5	4.4 2	4.2	2.8	4.0
Ca	-1.9	-2.2	-2.2	-1.8	-2.1	-2.3			1.8	1.8	2.0	2.0	1.5	2.0



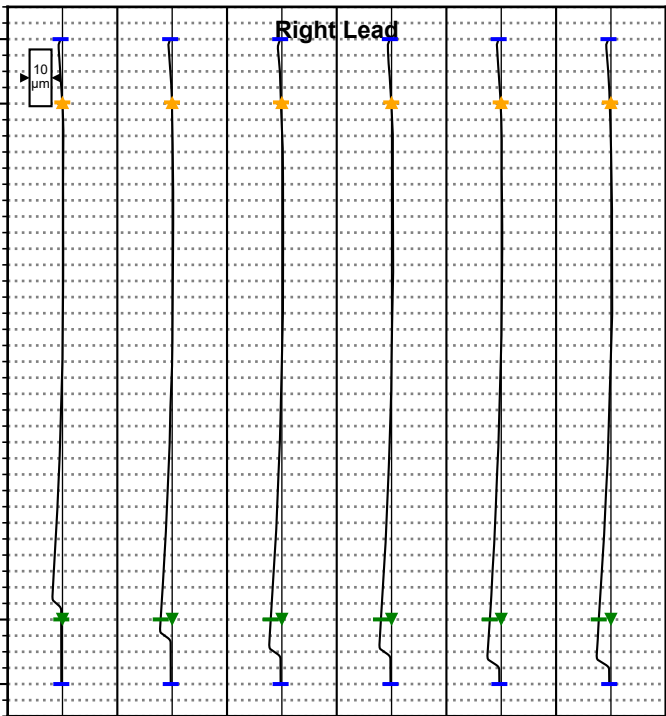
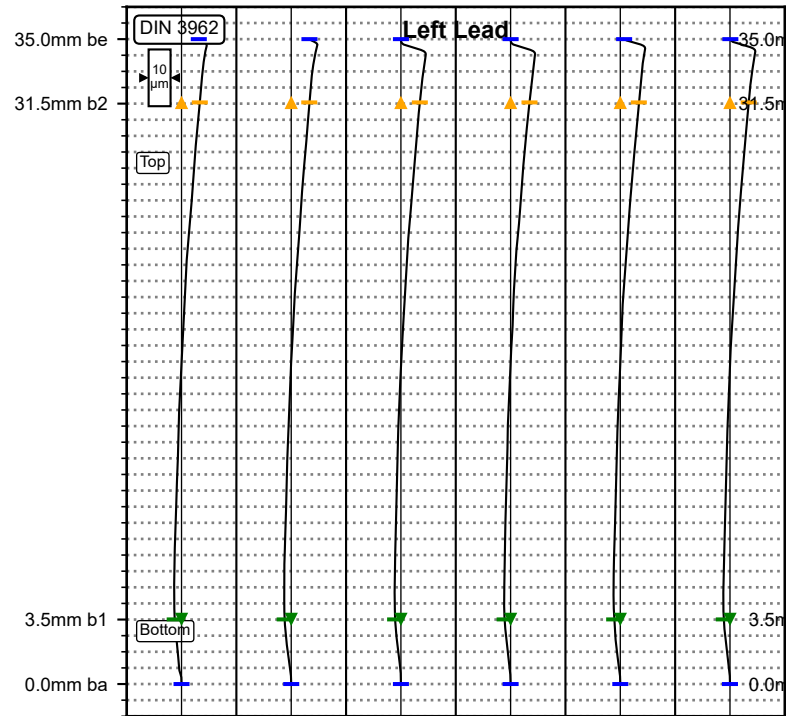
	54	53	52	51	50	49	Lim.value Qual.	Lim.value Qual.	49	50	51	52	53	54
fHbm	13.9 7	V 0.9					±8 5	±8 5	3.1 2	V 1.3				
fHb	13.4	13.7	13.9	14.0	14.3 7	14.2	±8 5	±8 5	3.4	3.7 3	3.3	2.4	2.9	2.9
fb	16.5	17.1	17.4	17.6	17.9 7	17.8	12 5	12 5	6.2	6.4 3	6.2	5.4	5.8	5.9
ffb	13.4	13.7	13.9	14.1	14.3 7	14.3 7	9 5	9 5	6.0 3	5.9	5.3	4.7	5.0	5.0
Cb	-2.5	-2.5	-2.5	-2.3	-2.3	-2.5			2.8	2.8	2.6	1.6	2.7	2.6

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



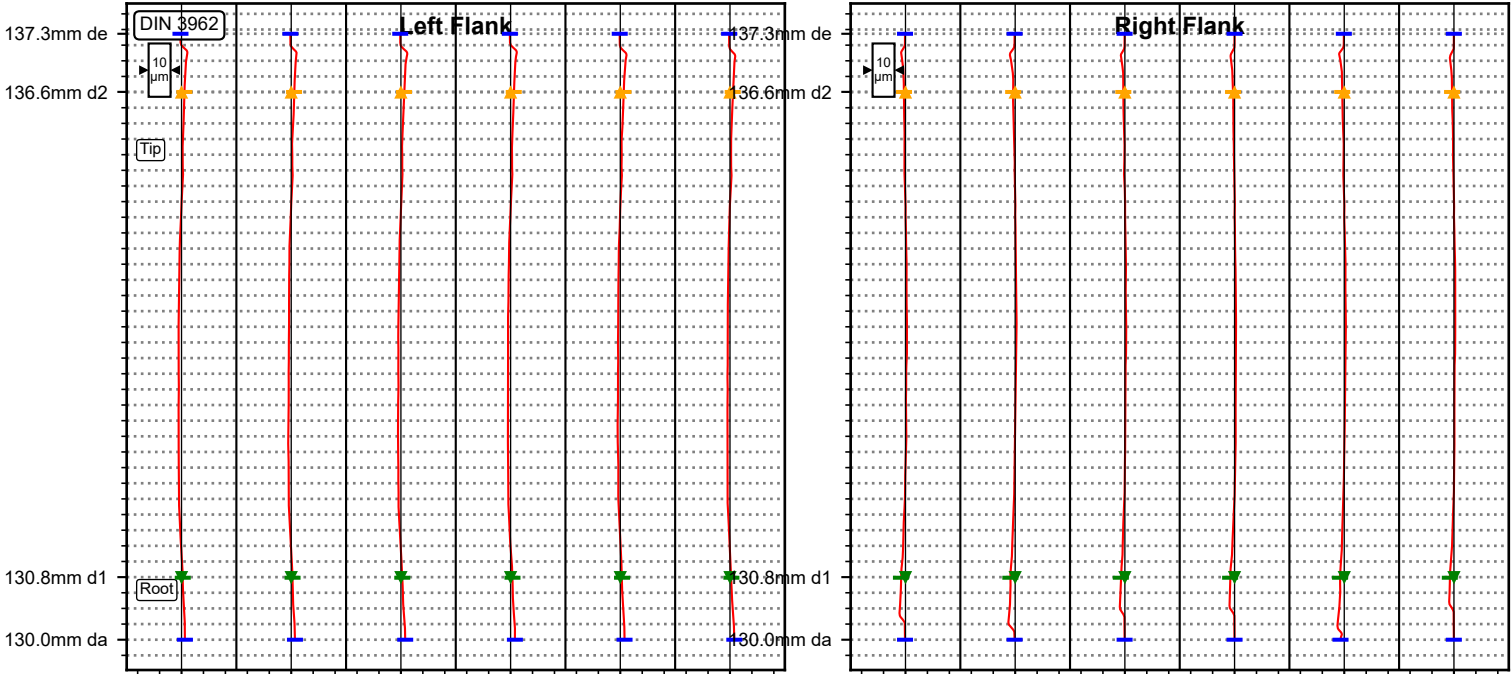
	60	59	58	57	56	55	Lim.value Qual.	Lim.value Qual.	55	56	57	58	59	60
fHam	0.8 1	V 0.7					±11 5	±11 5	0.7 1	V 0.6				
fHa	1.1 1	1.1 1	0.9	0.7	0.7	0.4	±11 5	±11 5	1.0 1	0.6	0.7	0.6	0.4	0.7
fa	5.5 2	4.8	4.3	5.1	5.1	3.9	20 5	20 5	3.8 1	3.2	3.4	3.5	3.5	3.5
ffa	4.8 2	4.2	3.8	4.7	4.8	3.6	16 5	16 5	4.1 2	3.4	3.7	3.6	3.6	3.7
Ca	-2.1	-2.2	-1.9	-2.2	-2.3	-1.9			1.9	1.6	1.9	1.8	1.9	1.8



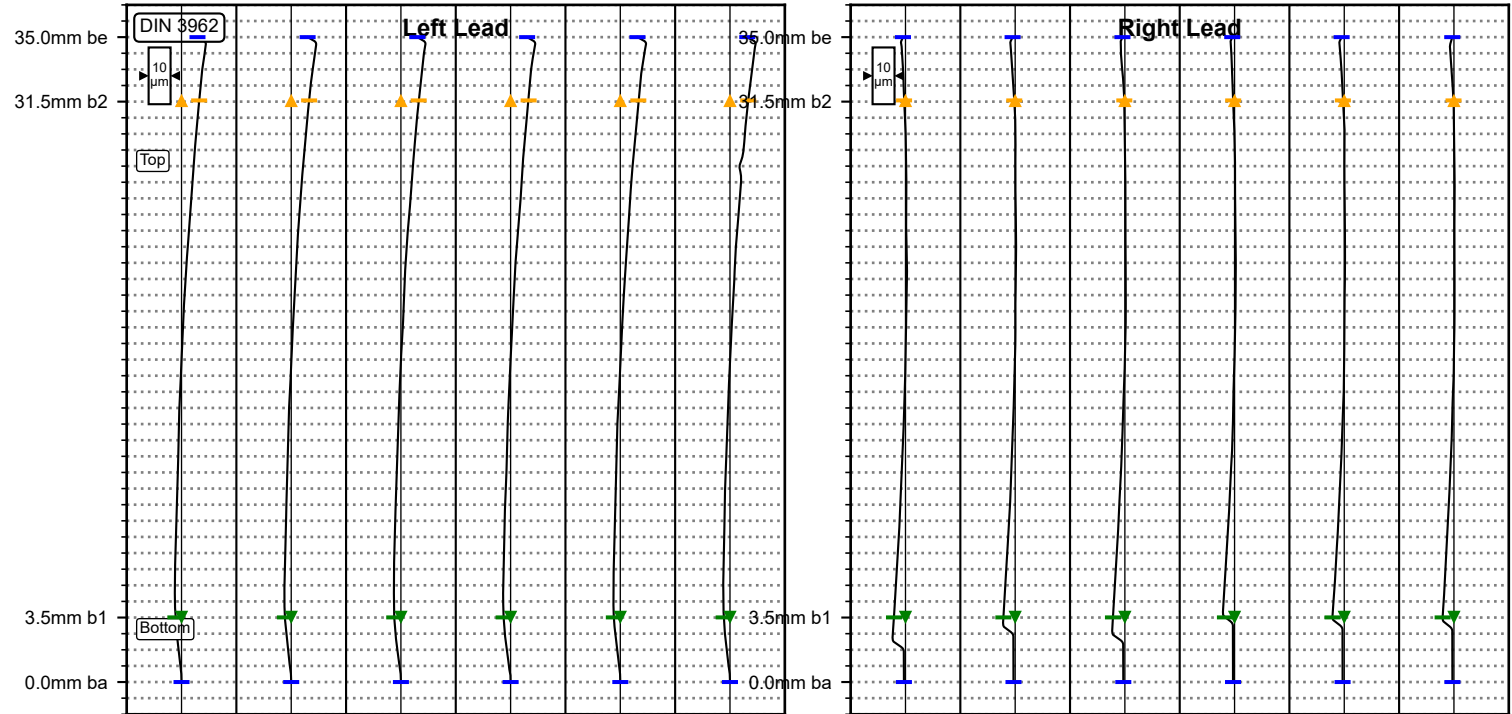
	60	59	58	57	56	55	Lim.value Qual.	Lim.value Qual.	55	56	57	58	59	60
fHbm	12.9 7	V 1.2					±8 5	±8 5	4.0 3	V 2.5				
fHb	13.5 7	13.5 7	12.5	12.3	12.9	12.8	±8 5	±8 5	2.4	3.7	4.1	4.1	4.8	4.9 4
fb	16.4	16.9 7	14.9	15.1	15.6	15.5	12 5	12 5	5.3	6.3	6.7	6.6	7.0	7.4 3
ffb	13.5	13.7 7	12.5	12.4	12.9	12.8	9 5	9 5	5.3	6.1	5.7	6.7	7.6	8.1 5
Cb	-2.4	-2.5	-2.7	-2.8	-2.7	-2.7			1.5	2.6	2.7	2.4	2.5	3.0

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



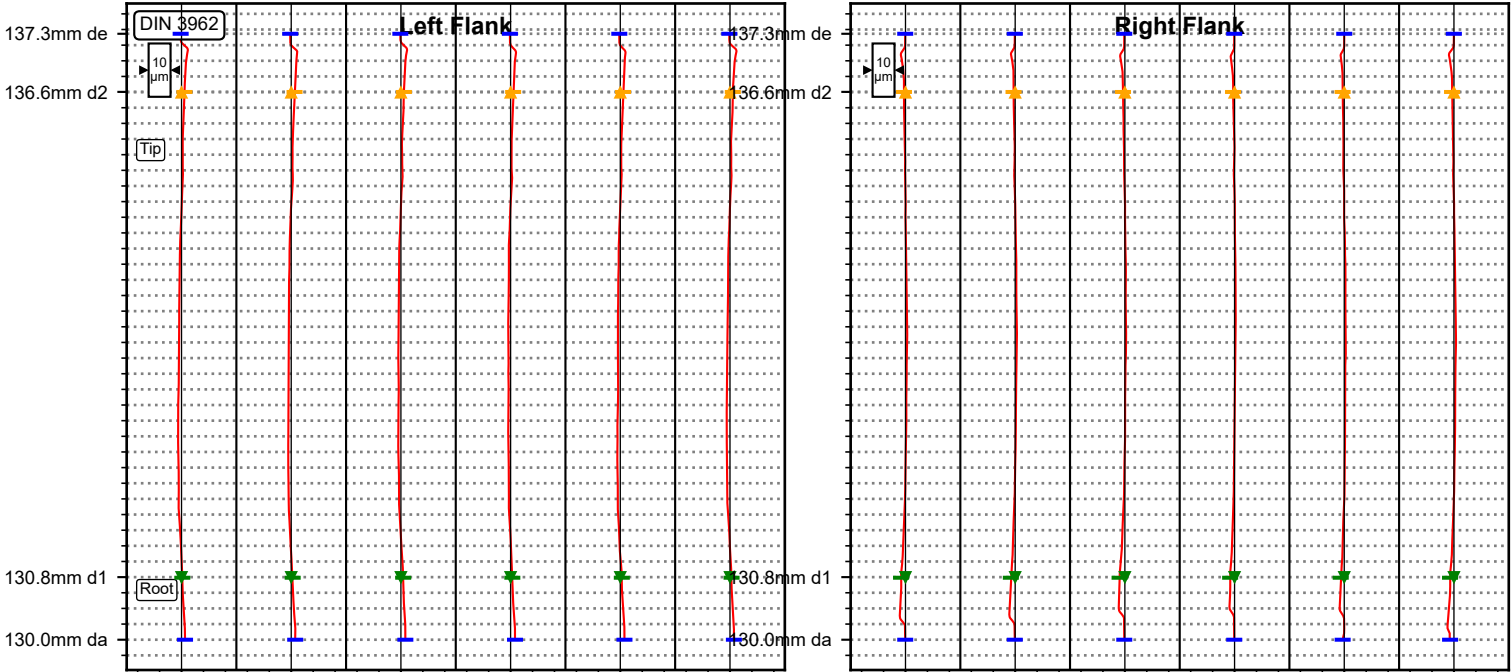
	66	65	64	63	62	61	Lim.value Qual.	Lim.value Qual.	61	62	63	64	65	66
fHam	0.9 1	V 0.3					±11 5	±11 5	0.7 1	V 0.7				
fHa	1.1 1	1.0	1.0	1.0	0.8	0.8	±11 5	±11 5	0.7	1.0 1	0.6	0.4	1.0 1	0.3
fa	4.9	4.8	5.3 2	5.2	5.0	4.5	20 5	20 5	3.7	4.0	3.1	3.2	4.1 1	3.0
ffa	4.4	4.1	4.6 2	4.6 2	4.4	4.0	16 5	16 5	3.8	4.3	3.4	3.3	4.4 2	3.1
Ca	-2.1	-2.0	-2.1	-2.2	-2.1	-1.9			1.8	2.0	1.6	1.8	1.9	1.7



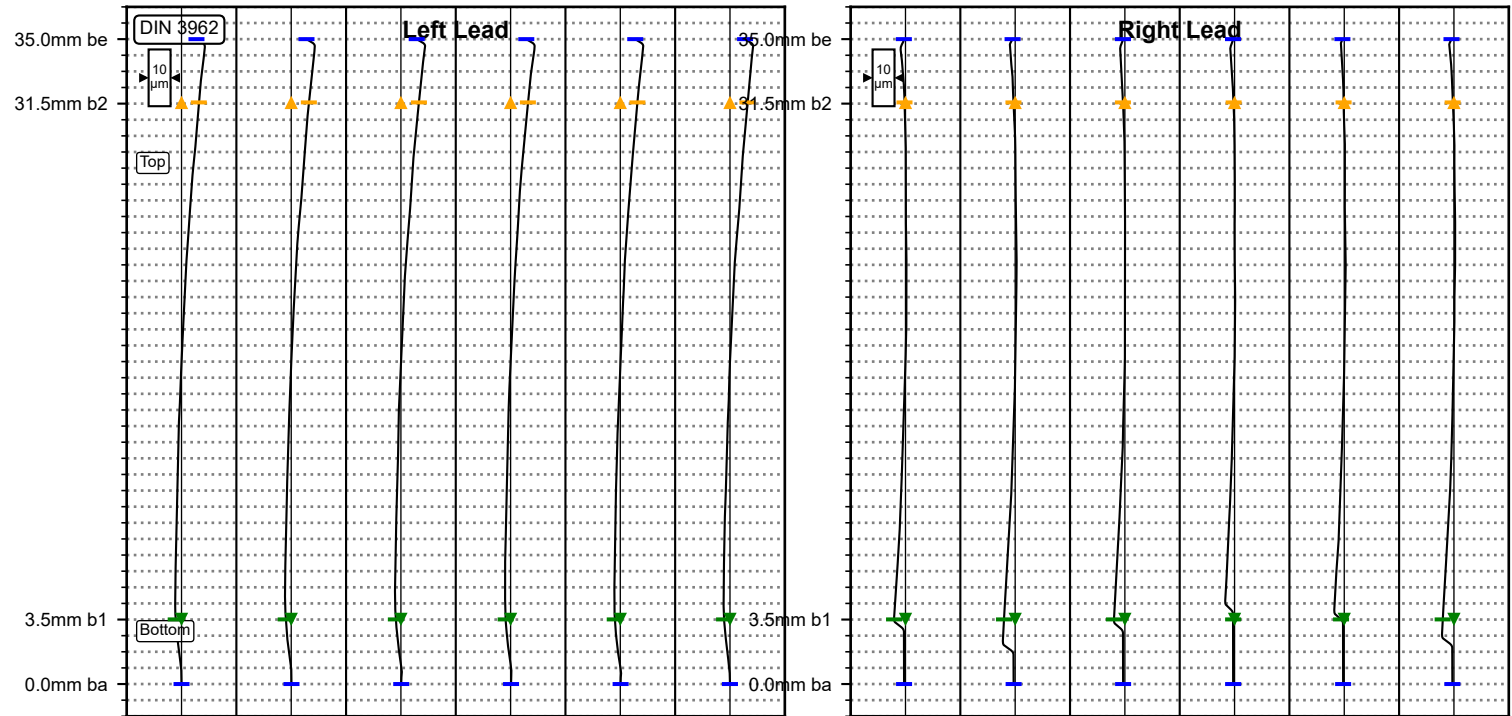
	66	65	64	63	62	61	Lim.value Qual.	Lim.value Qual.	61	62	63	64	65	66
fHbm	13.1 7	V 0.6					±8 5	±8 5	3.4 2	V 1.0				
fHb	12.7	12.9	13.1	13.3 7	13.3 7	13.2	±8 5	±8 5	4.0 3	3.4	3.8	3.0	3.0	3.1
fb	14.8	15.3	15.5	15.7	15.9	16.0 6	12 5	12 5	6.8 3	6.1	6.4	6.2	6.0	5.8
ffb	12.7	12.9	13.1	13.3 7	13.3 7	13.2	9 5	9 5	8.1 5	7.1	7.2	6.4	7.0	5.0
Cb	-2.4	-2.4	-2.4	-2.3	-2.5	-2.4			2.9	2.7	2.9	3.0	2.8	2.5

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L α :	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. L β :	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



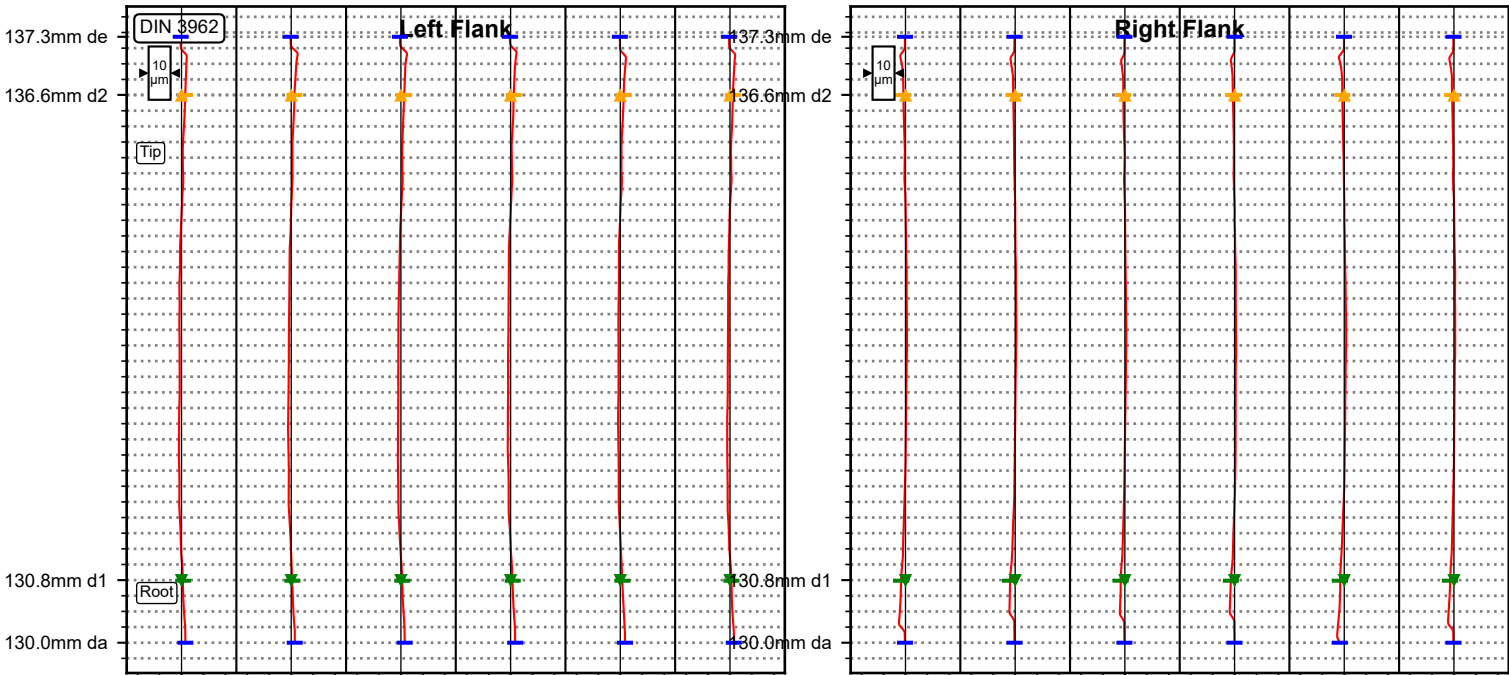
	72	71	70	69	68	67	Lim.value Qual.	Lim.value Qual.	67	68	69	70	71	72
fHam	1.0 1	V 0.8					±11 5	±11 5	0.7 1	V 0.5				
fHa	1.4 1	1.1	0.6	0.6	0.9	1.1	±11 5	±11 5	0.7	0.8 1	0.8 1	0.8 1	0.3	0.7
fa	5.5	5.1	5.1	4.3	4.5	5.6 2	20 5	20 5	3.7	3.8	3.6	3.2	3.1	4.1 1
ffa	4.6	4.4	4.7	4.0	3.9	4.9 2	16 5	16 5	4.0	3.9	3.8	3.4	3.2	4.3 2
Ca	-2.0	-2.2	-2.3	-2.0	-1.9	-2.2			1.9	1.9	1.9	1.7	1.6	2.0



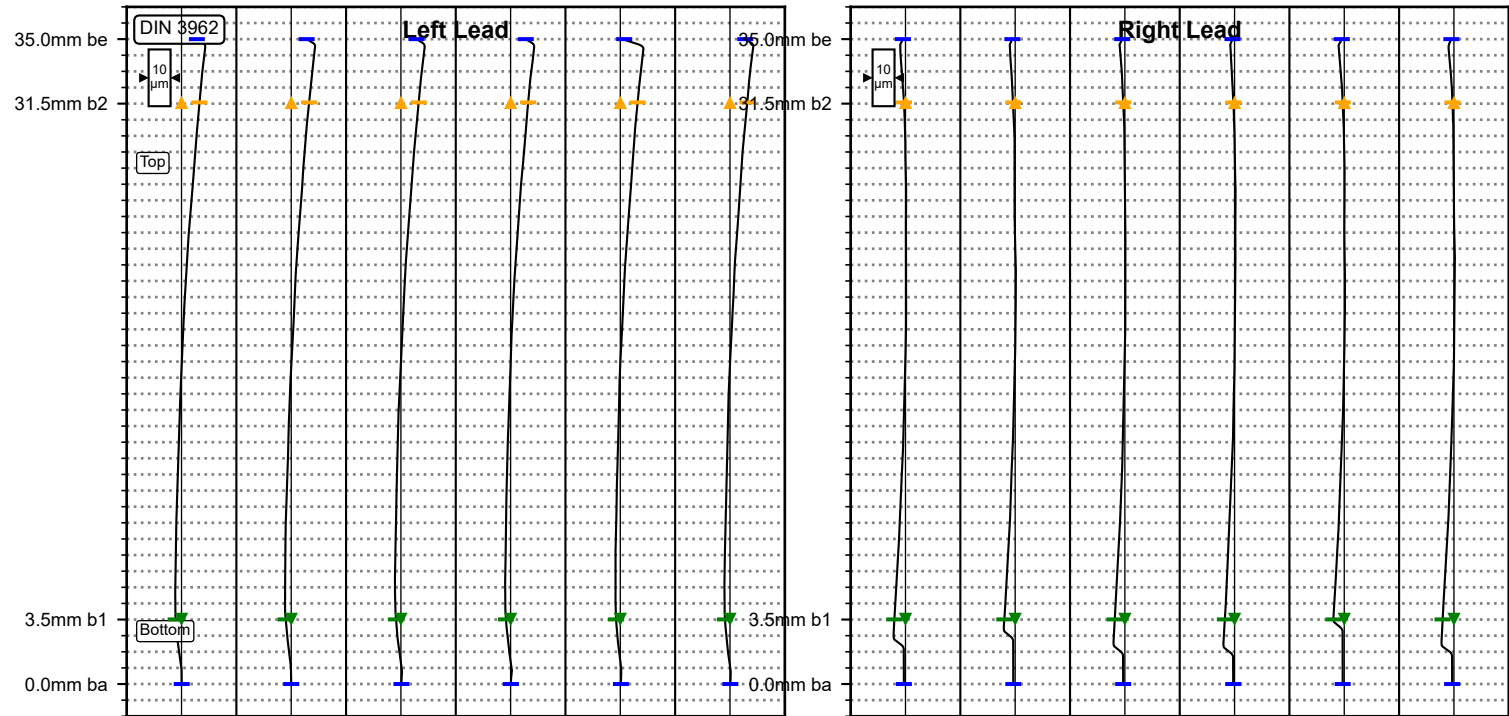
	72	71	70	69	68	67	Lim.value Qual.	Lim.value Qual.	67	68	69	70	71	72
fHbm	12.2 7	V 0.5					±8 5	±8 5	2.8 2	V 1.5				
fHb	12.3	12.4 7	12.2	11.9	11.9	12.4 7	±8 5	±8 5	2.9	3.5 2	2.5	2.0	2.6	3.5 2
fb	13.9	14.0	14.2 6	14.0	13.7	14.1	12 5	12 5	6.0	6.6 3	5.4	4.8	5.5	6.3
ffb	12.3	12.4	12.5 7	12.0	12.3	12.4	9 5	9 5	5.1	7.9 4	4.6	4.1	5.5	7.3
Cb	-2.6	-2.6	-2.7	-2.6	-2.5	-2.4			2.8	3.0	2.7	1.8	2.4	2.7

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L α :	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. L β :	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



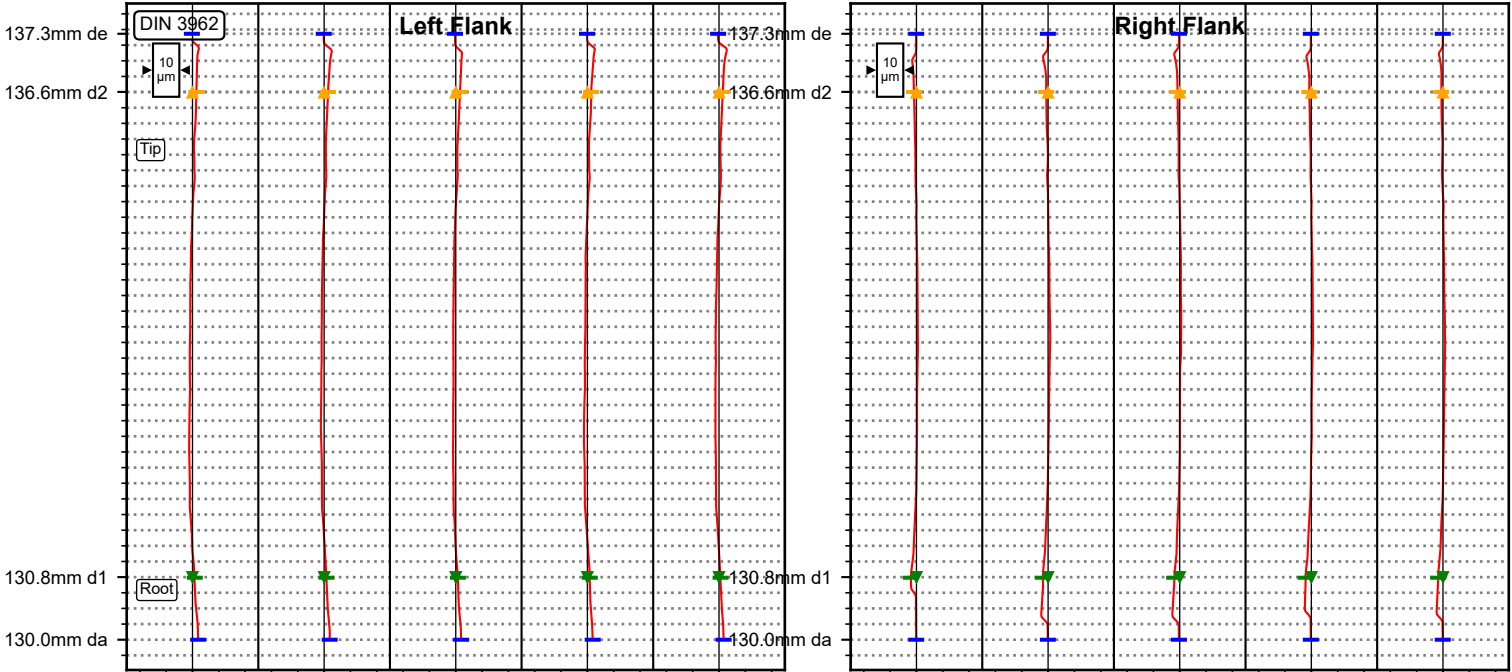
	78	77	76	75	74	73	Lim.value	Qual.	Lim.value	Qual.	73	74	75	76	77	78
fHam	1.0 1	V 0.7					±11	5	±11	5	0.7 1	V 0.8				
fHa	1.1	1.2 1	1.2 1	0.8	0.5	1.0	±11	5	±11	5	0.8	0.7	0.7	0.2	1.0 1	0.7
fa	4.2	5.3 2	5.1	5.0	4.3	4.5	20	5	20	5	4.0	3.4	3.3	3.3	4.3 1	3.7
ffa	3.7	4.5 2	4.4	4.5 2	3.9	3.8	16	5	16	5	4.4	3.7	3.4	3.2	4.8 2	4.0
Ca	-2.0	-2.0	-2.1	-2.3	-2.0	-1.8					1.9	1.9	1.7	1.7	2.1	1.8



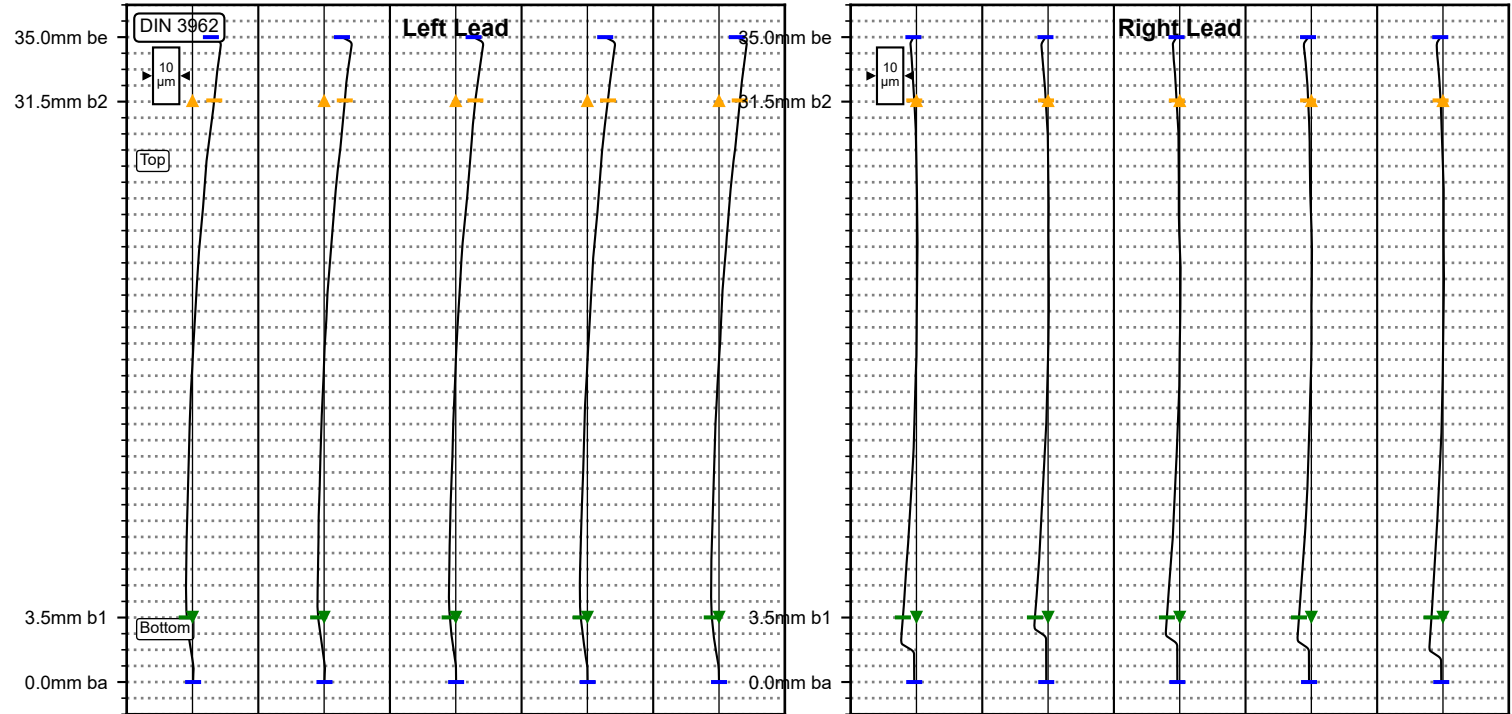
	78	77	76	75	74	73	Lim.value	Qual.	Lim.value	Qual.	73	74	75	76	77	78
fHbm	12.0 7	V 1.3					±8	5	±8	5	3.1 2	V 1.1				
fHb	12.6 7	12.6 7	12.2	11.8	11.3	11.8	±8	5	±8	5	3.2	2.6	3.0	3.4	2.5	3.6 3
fb	14.1	14.2 6	14.0	13.5	13.3	13.7	12	5	12	5	6.0	5.8	5.8	5.9	5.5	6.4 3
ffb	12.6 7	12.6 7	12.4	12.4	11.4	11.9	9	5	9	5	6.9 3	6.4	6.6	6.3	5.7	6.7
Cb	-2.6	-2.5	-2.7	-2.9	-2.7	-2.5					2.7	2.7	2.6	2.5	2.6	2.9

Gear Profile/Lead

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. Lα:	5.85mm
Order No.:	153025-0009-wav.	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P26 B 7549	Helix angle:	-29.00°	Appr. Length:	0.75mm
Loc. of check:	Jintan	Base Cir.-Ø db:	125.4161mm	Stylus-Ø:	1.000mm
Condition:	Grinding-0403	Base Helix ang:	-27.621°	Add.Mod.Coe:	0.063



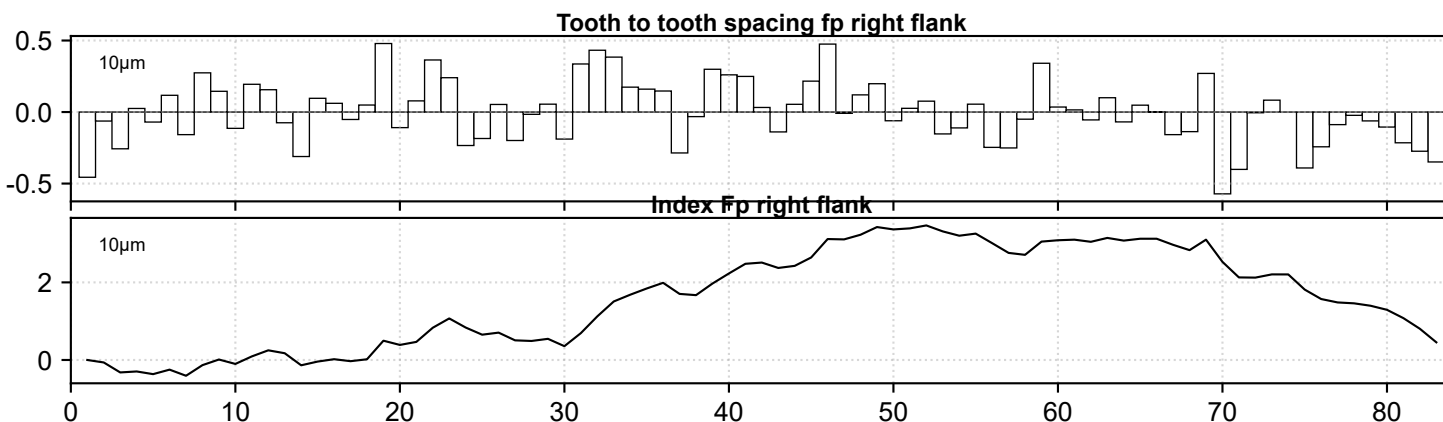
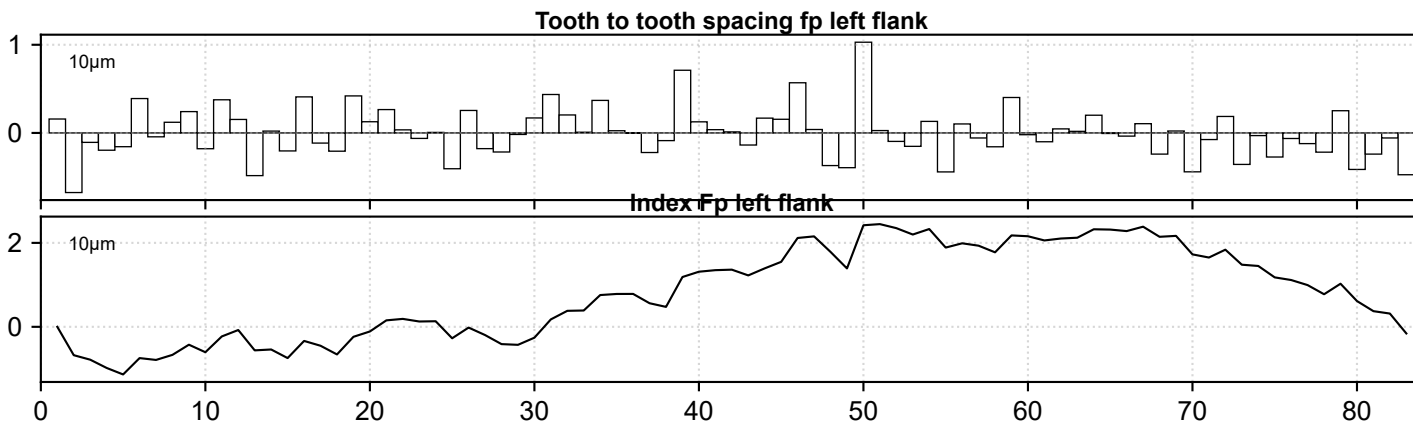
	83	82	81	80	79	Lim.value Qual.	Lim.value Qual.	79	80	81	82	83
fHam	0.9 1	V 0.3				±11 5	±11 5	0.6 1	V 0.7			
fHa	1.0	0.8	0.8	1.0	1.1 1	±11 5	±11 5	0.1	0.8 1	0.8 1	0.8 1	0.7
fa	4.7	4.9	4.0	5.1	5.3 2	20 5	20 5	2.7	3.7	3.8 1	3.4	3.6
ffa	4.1	4.4	3.6	4.5	4.7 2	16 5	16 5	2.7	3.9	4.0 1	3.5	3.6
Ca	-2.0	-2.2	-2.0	-2.0	-2.1			1.7	1.9	1.8	1.8	1.8



	83	82	81	80	79	Lim.value Qual.	Lim.value Qual.	79	80	81	82	83
fHbm	11.9 7	V 0.9				±8 5	±8 5	2.9 2	V 1.3			
fHb	11.9	11.7	11.6	12.0	12.5 7	±8 5	±8 5	3.7 3	2.8	2.6	2.4	3.0
fb	13.6	13.4	13.4	13.7	14.0 6	12 5	12 5	6.4 3	5.6	5.9	5.7	5.8
ffb	12.0	11.8	11.6	12.0	12.5 7	9 5	9 5	6.4 3	5.0	5.0	5.5	6.1
Cb	-2.7	-2.8	-2.4	-2.3	-2.5			2.8	2.7	2.9	2.9	2.7

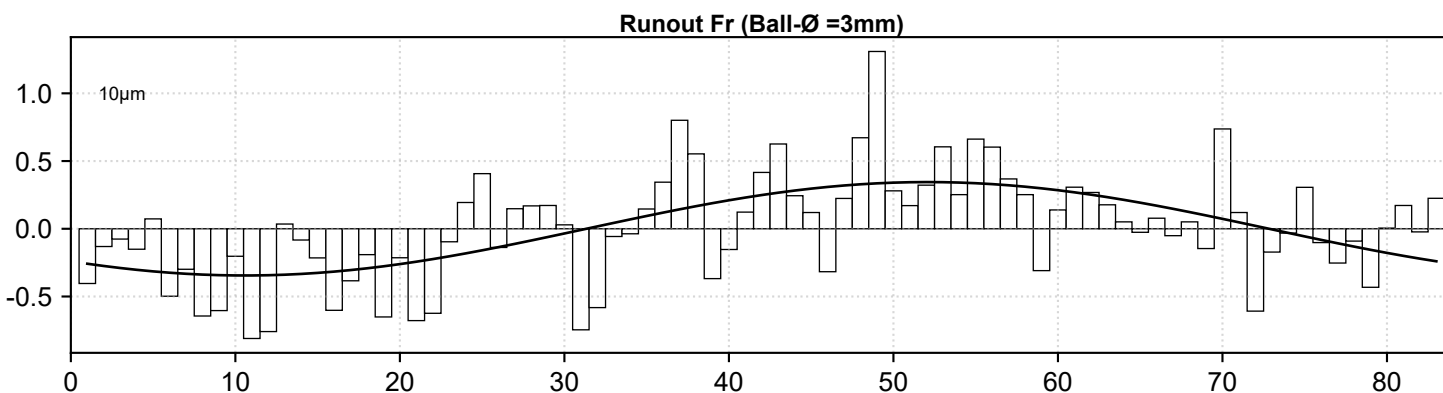
Gear Spacing

Prog.No.:		Operator:	tang	Date:	05.06.23
Type:	assembly	No. of teeth:	83	Pressure angle:	17°
Drawing No.:	056-Li-20400125-G-1	Module m:	1.40mm	Helix angle:	-29°
Order No.:	153025-0009-wav.	Loc. of check:	Jintan		
Cust./Mach. No.:	P26 B 7549	Condition:	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	1.0		12 5	0.6		12 5
Worst spacing deviation fu max	1.4			0.8		
Range of Pitch Error Rp	1.7			1.1		
Total cum. pitch dev. Fp	3.6		36 5	3.9		36 5
Cum. pitch deviation Fp10	2.0			2.2		



									MdK 138.581[mm]/Ball-Ø 1
Pitch Line Runout	Fr	2.1				Lim.value	138.666	138.496	
Variation of tooth thickness	Rs					Act.	136.910	138.584	135.256