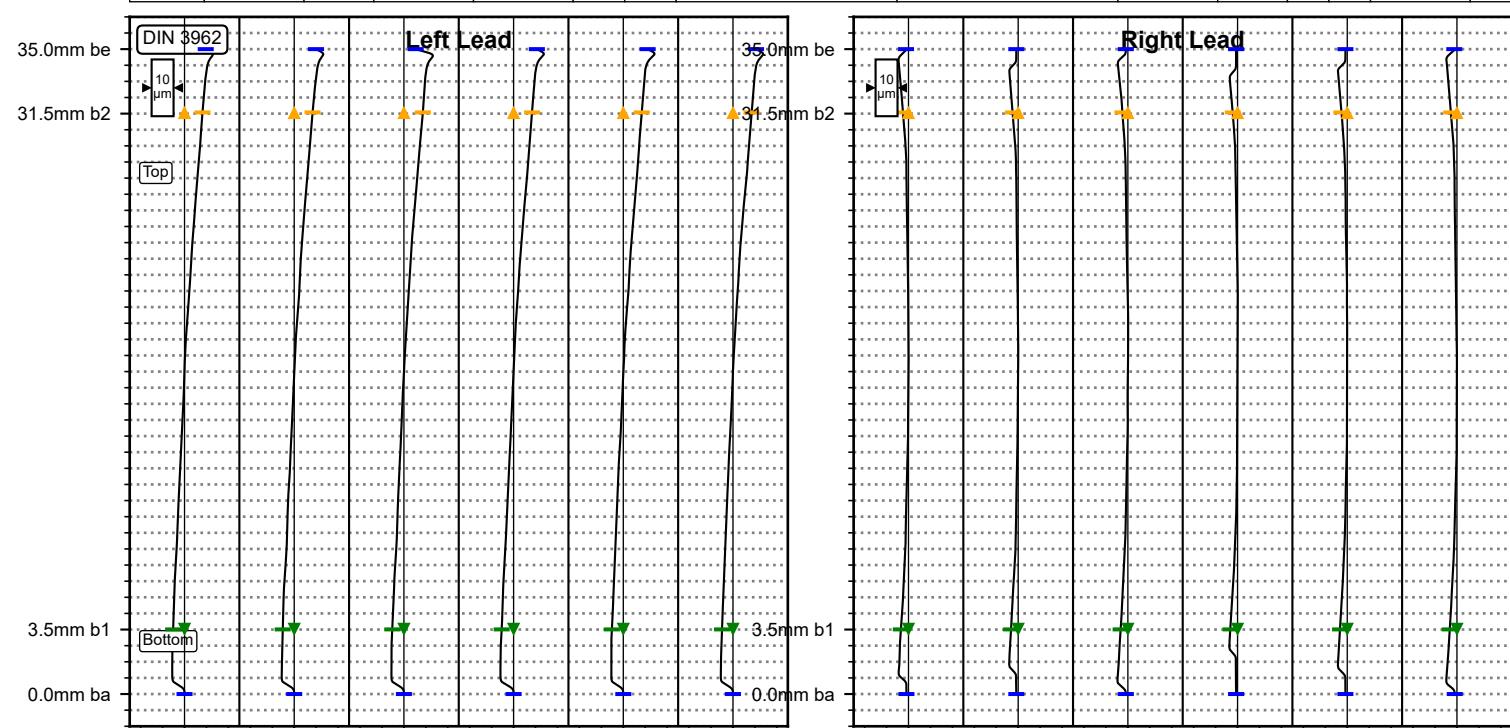
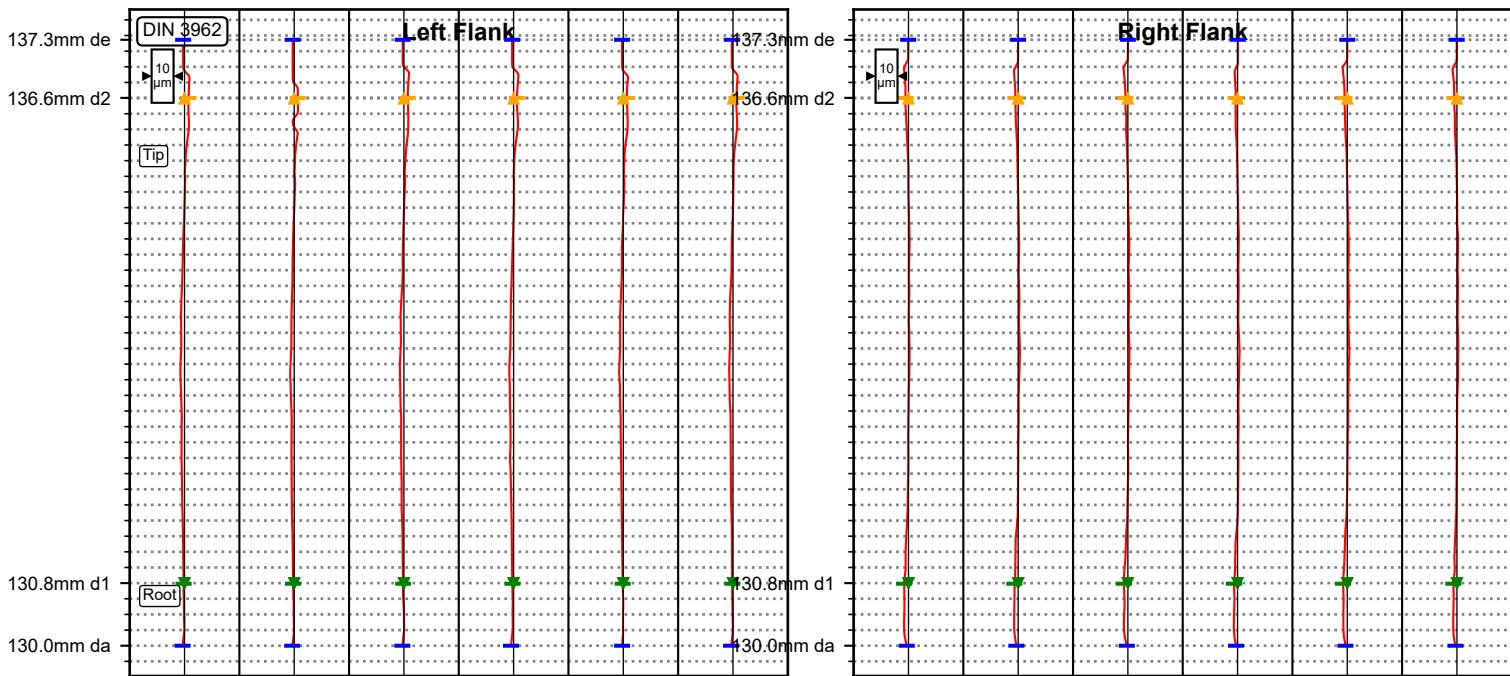


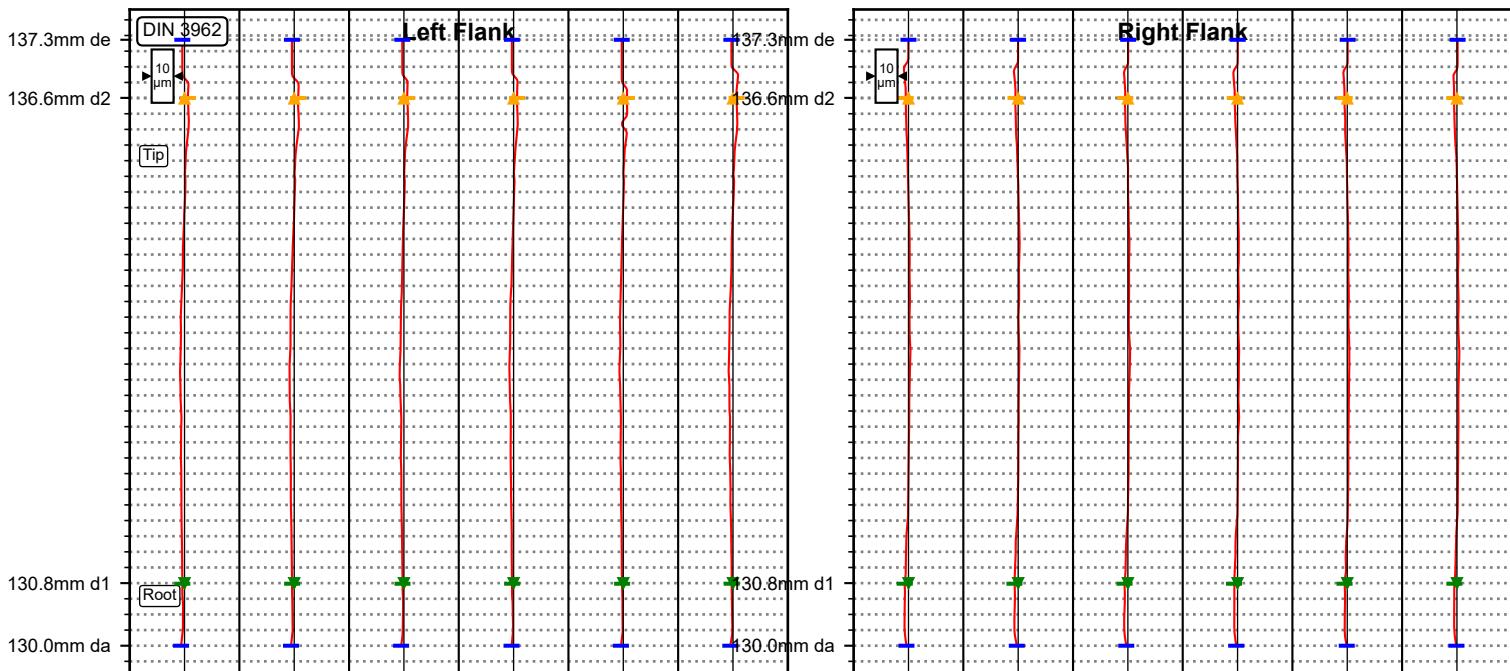
# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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

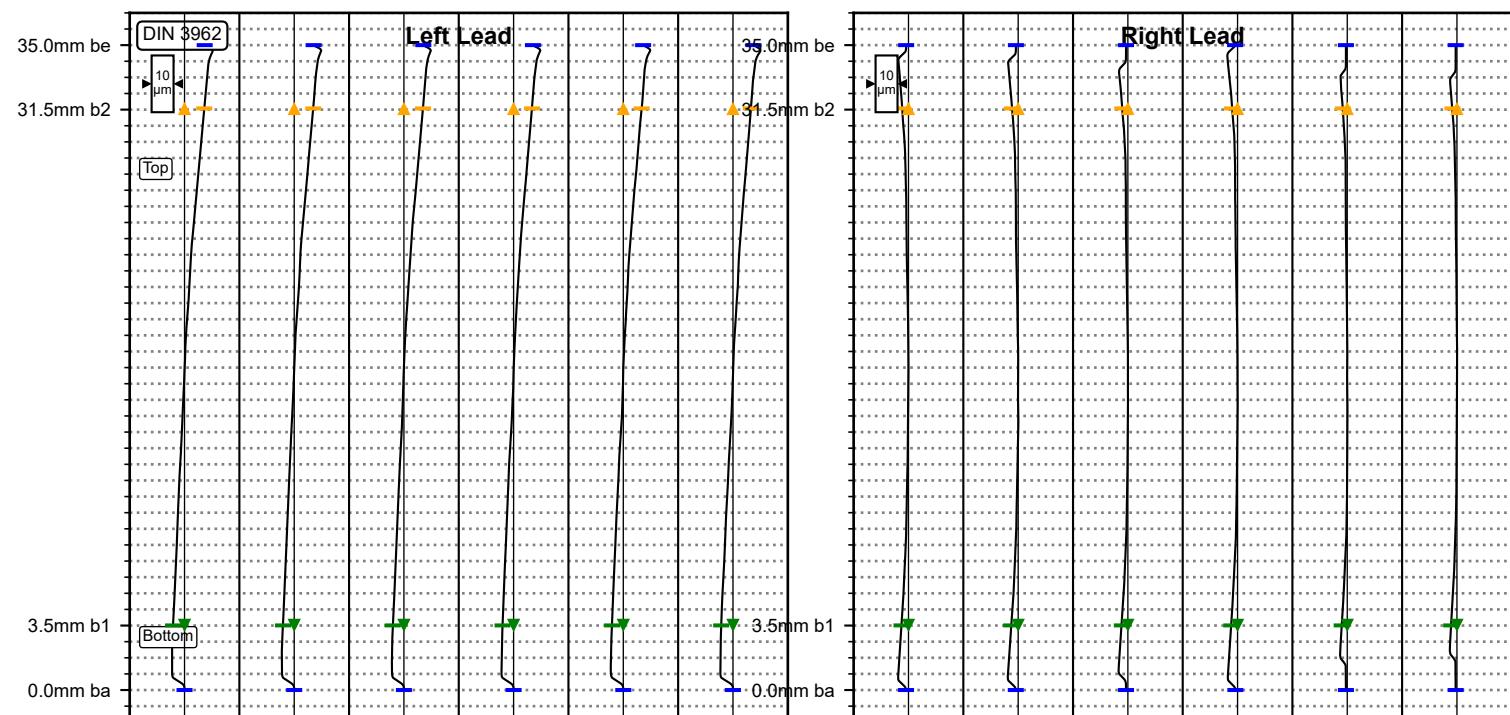


# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



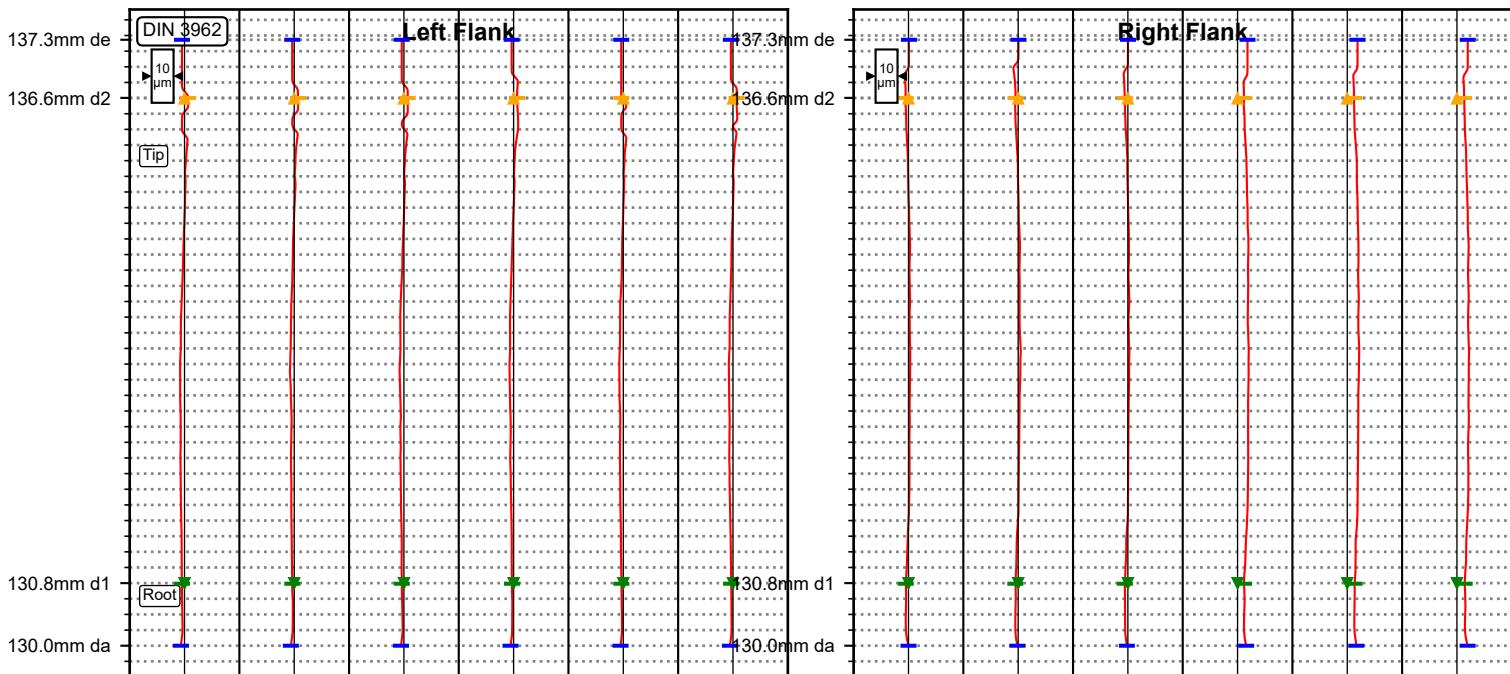
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12
fHam	1.9 1	V 1.0					±11 5	±11 5	0.4 1	V 0.6				
fHa	2.2	2.3 1	1.8	1.8	1.3	2.0	±11 5	±11 5	0.6 1	0.6 1	0.5	0.5	-0.0	0.1
fa	4.1	4.5	4.1	4.1	3.8	4.8 1	20 5	20 5	3.8 1	3.1	3.3	3.0	3.2	3.1
ffa	3.3	3.5	3.2	3.2	3.2	3.8 1	16 5	16 5	4.1 2	3.4	3.5	3.3	3.2	3.2
Ca	-2.2	-2.5	-2.2	-2.3	-1.9	-2.5				2.1	1.9	2.0	1.9	2.0



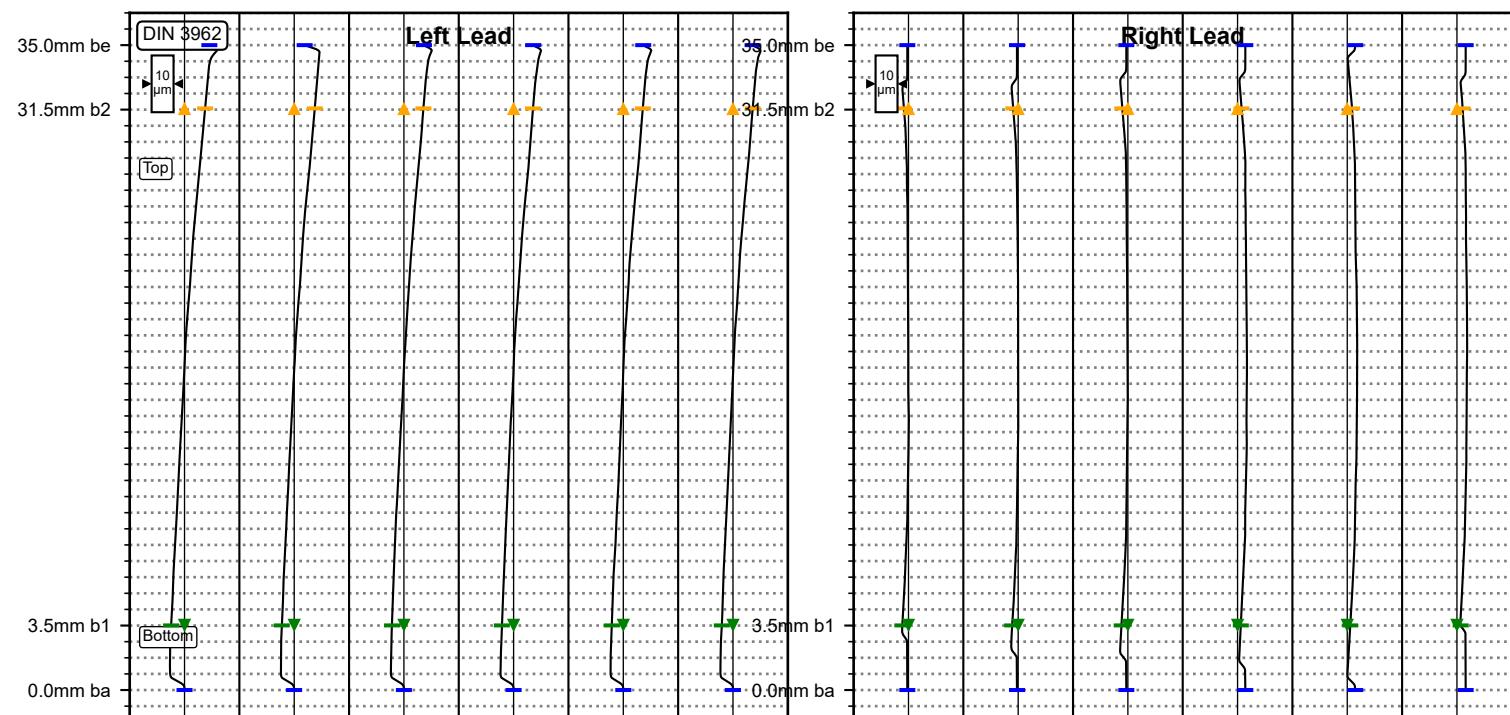
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12
fHbm	16.1 8	V 1.0					±8 5	±8 5	0.3 1	V 0.3				
fHb	16.8 8	16.2	16.1	15.8	15.9	16.0	±8 5	±8 5	0.4 1	0.3	0.3	0.1	0.1	0.3
fb	21.2	20.5	20.4	20.5	21.0	21.8 7	12 5	12 5	5.1	5.2 2	4.6	4.9	3.6	3.5
ffb	16.8 8	16.2	16.1	15.8	15.9	16.0	9 5	9 5	5.3	5.4 3	4.7	5.0	3.7	3.7
Cb	-1.9	-1.8	-1.9	-1.6	-1.5	-1.3			2.6	2.6	2.2	2.3	2.0	2.1

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



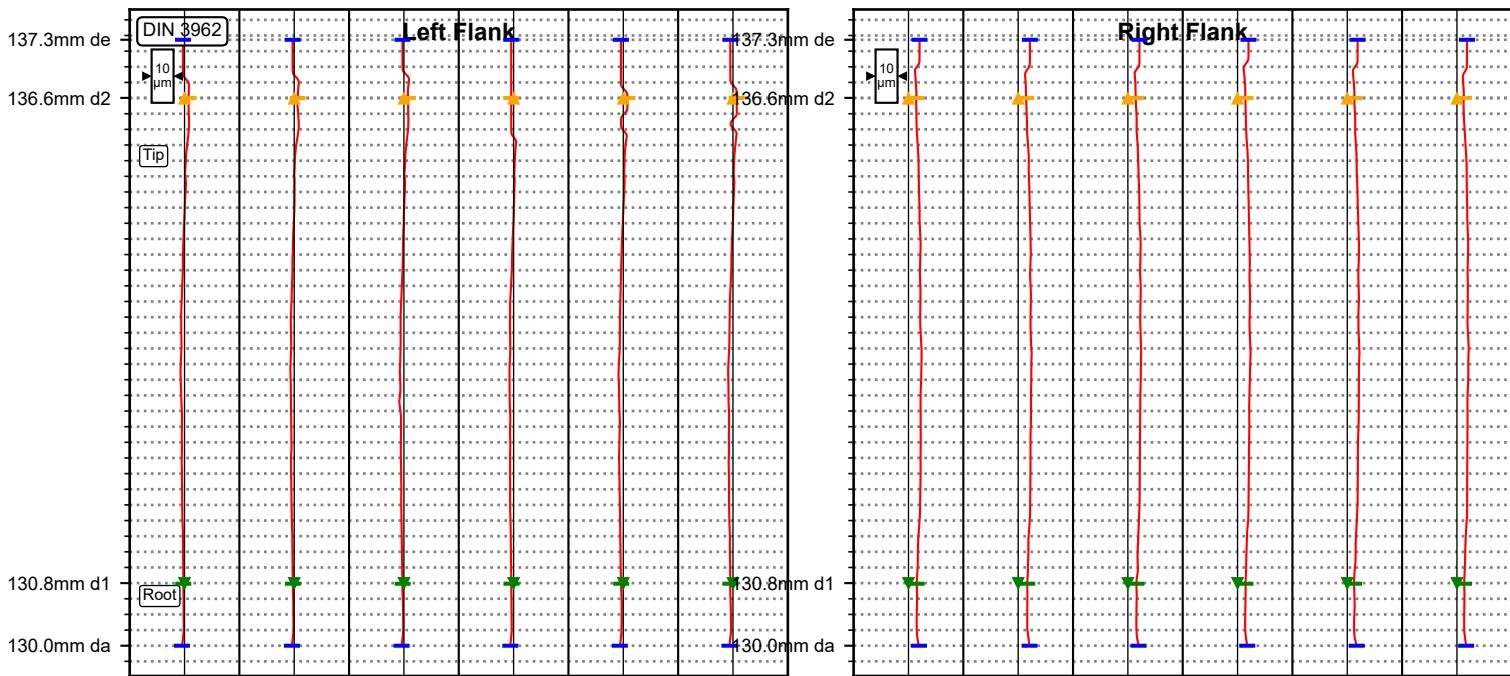
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHam	1.6	1	V 0.9				±11 5	±11 5	0.1	1	V 0.4			
fHa	1.6	1.6	1.7	2.0	1	1.1	1.8	±11 5	0.1	0.1	0.2	0.3	1	0.1
fa	4.1	3.9	4.0	4.2	1	3.7	4.1	20 5	3.0	4.2	1	3.0	2.7	3.3
ffa	3.4	1	3.2	3.3	3.3	3.3	3.4	1	16 5	3.1	4.2	2	3.1	2.8
Ca	-1.5		-1.7	-1.9	-2.4	-1.2	-2.1			1.9	2.2	1.8	2.0	2.0



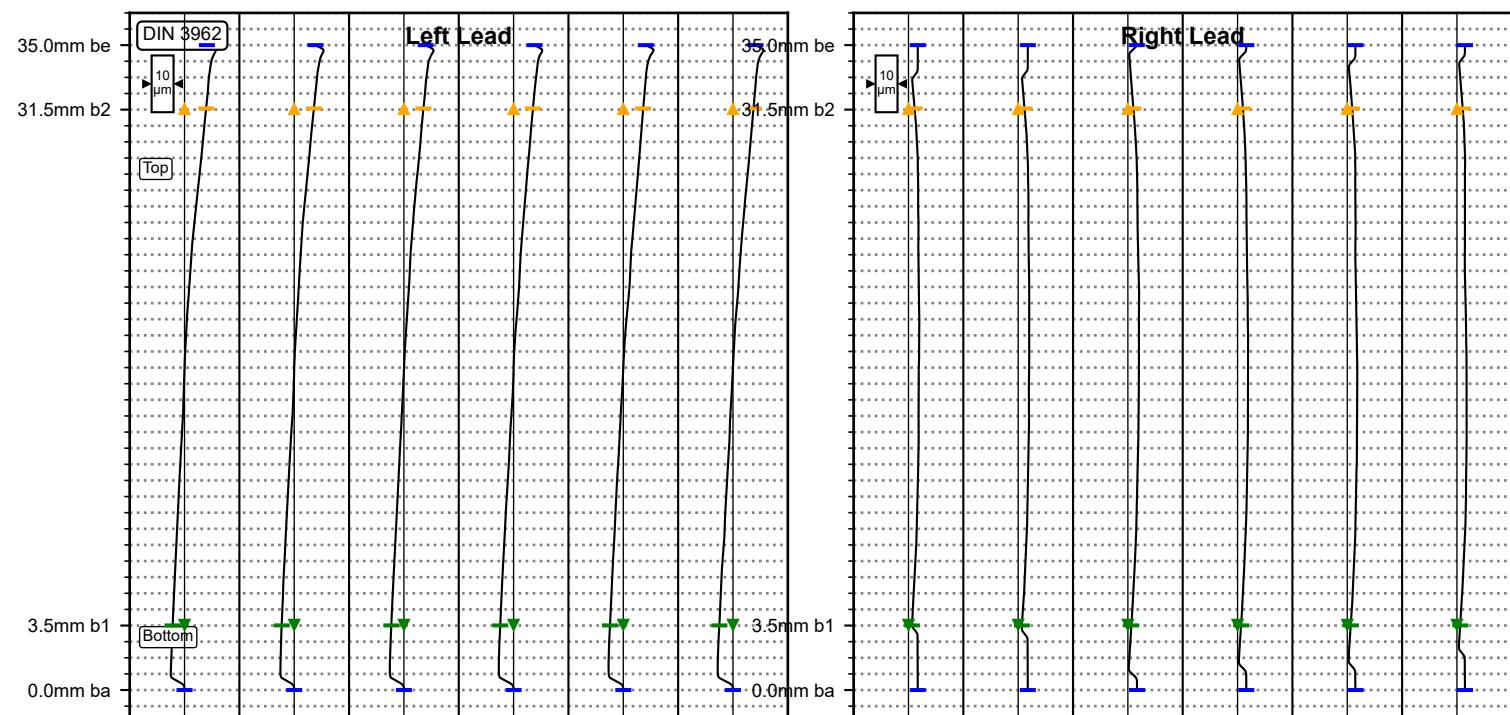
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHbm	17.3	8	V 1.6				±8 5	±8 5	0.4	1	V 0.4			
fHb	18.5	8	17.5	17.3	17.0	16.9	16.9	±8 5	0.2	0.5	0.3	0.5	0.6	1
fb	26.1	8	23.0	21.3	21.1	21.0	20.8	12 5	3.3	3.4	3.7	3.8	4.7	2
ffb	19.5	8	17.5	17.3	17.0	16.9	16.9	9 5	3.3	3.6	3.9	4.0	5.0	2
Cb	-1.7		-1.8	-1.7	-2.0	-1.8	-1.9		2.1	2.2	2.2	2.2	2.4	2.2

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



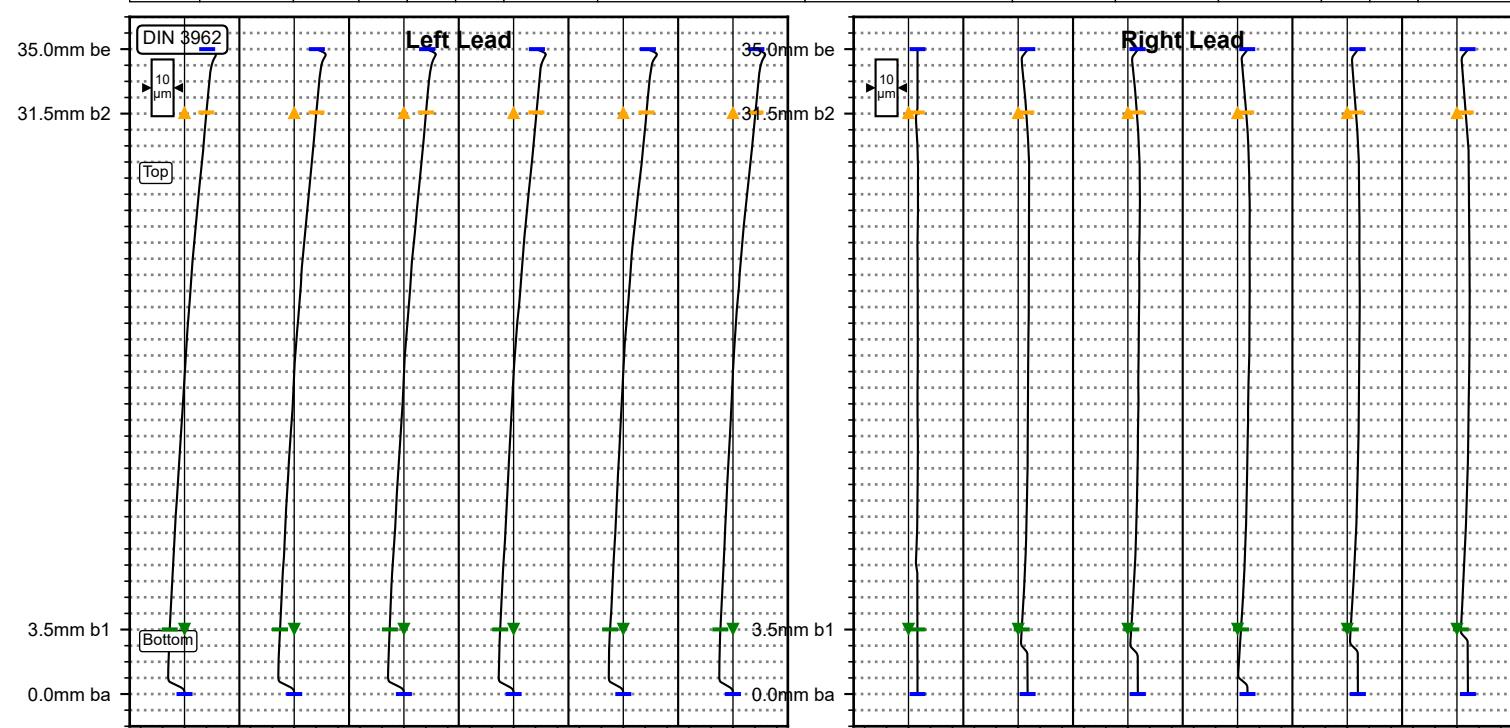
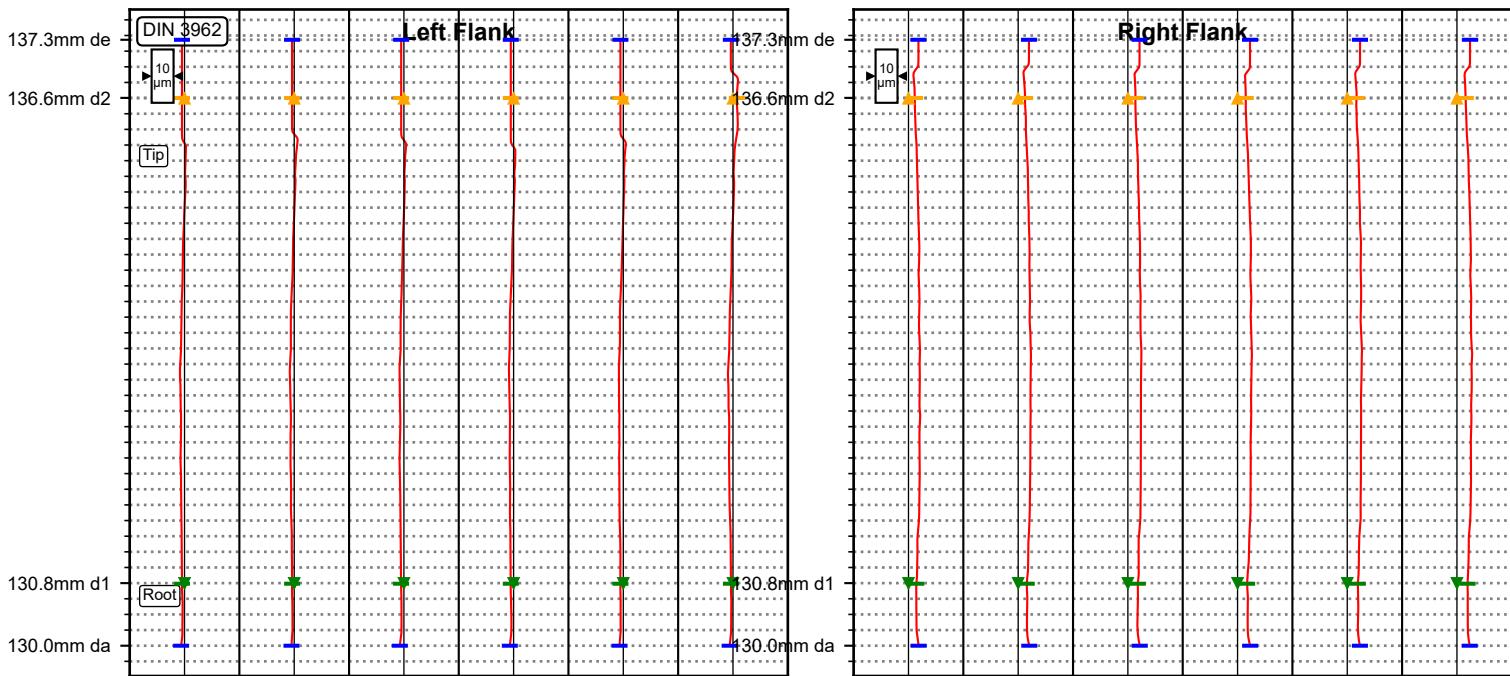
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHam	1.8	1	V 1.2				±11 5	±11 5	-0.0	1	V 0.5			
fHa	1.8	1.8	2.1	1.0	1.7	2.2	1	±11 5	±11 5	-0.3	1	-0.3	1	-0.1
fa	4.1	4.2	5.0	1	3.6	4.2	4.1	20 5	20 5	3.6	3.4	3.5	3.9	1
ffa	3.2	3.3	3.8	1	3.2	3.5	3.4	16 5	16 5	3.5	3.3	3.5	4.0	1
Ca	-2.4	-2.2	-2.4	-0.9	-1.7	-1.9			2.0	1.9	2.0	2.1	2.1	1.8



	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHbm	17.9	8	V 1.2				±8 5	±8 5	0.4	1	V 0.7			
fHb	18.0	17.4	17.4	17.8	18.3	18.6	8	±8 5	±8 5	0.4	0.4	0.7	1	0.3
fb	23.7	22.7	23.1	22.8	24.2	24.4	8	12 5	12 5	3.6	3.7	5.0	2	4.6
ffb	18.0	17.4	17.4	17.8	18.3	18.6	8	9 5	9 5	3.7	3.8	5.1	3	4.7
Cb	-2.3	-1.5	-1.4	-1.2	-1.4	-1.6			2.3	2.4	2.7	2.6	2.1	1.8

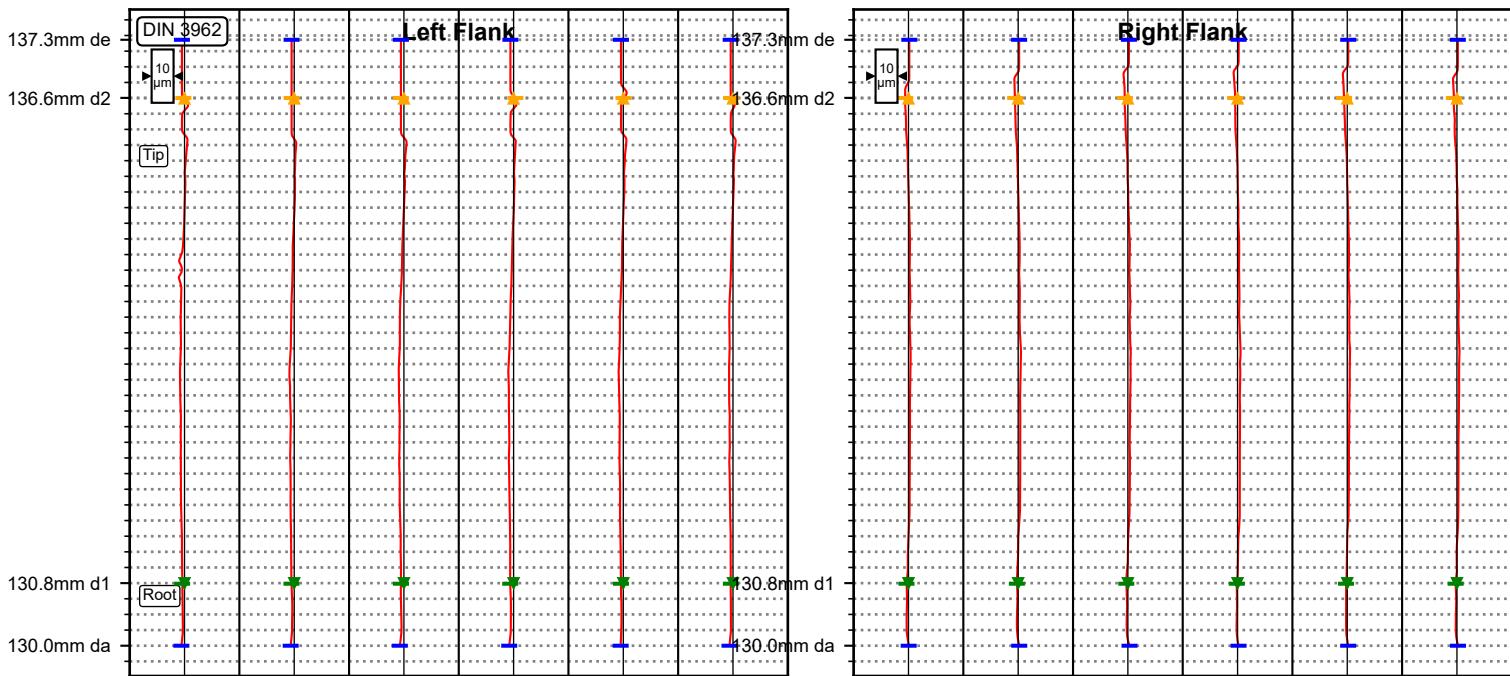
# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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

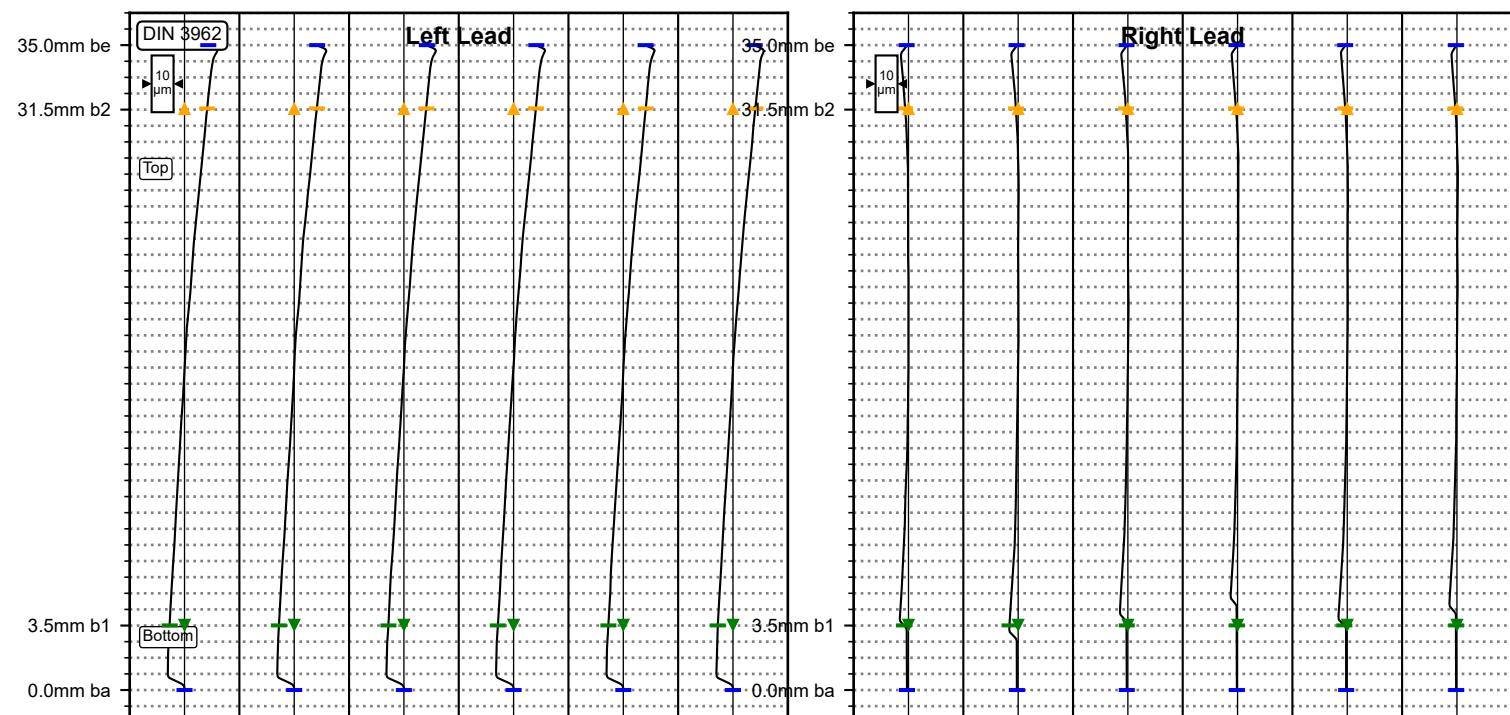


# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



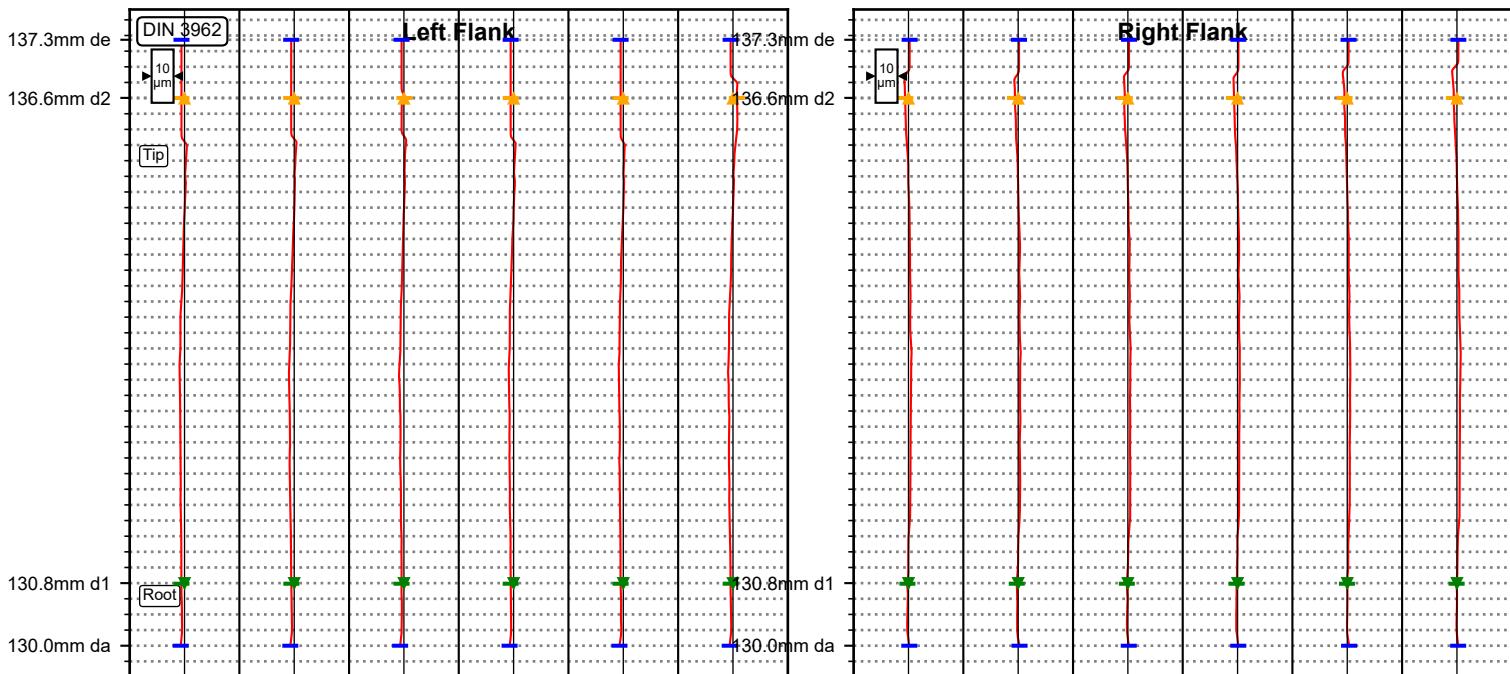
	36	35	34	33	32	31	Lim.value Qual.	Lim.value Qual.	31	32	33	34	35	36
fHam	1.2 1	V 0.5					±11 5	±11 5	-0.6 1	V 0.8				
fHa	1.1	1.1	1.2	1.6 1	1.3	1.1	±11 5	±11 5	-0.1	-0.7	-0.7	-0.9 1	-0.6	-0.6
fa	5.7 2	3.6	3.9	3.9	4.0	3.6	20 5	20 5	2.7	3.5	3.9 1	3.6	3.8	3.3
ffa	5.3 2	3.1	3.5	3.3	3.4	3.1	16 5	16 5	2.7	3.2	3.4	3.2	3.5 1	3.0
Ca	-1.6	-0.6	-1.0	-1.1	-0.9	-1.2			1.9	1.9	2.1	1.8	2.0	1.8



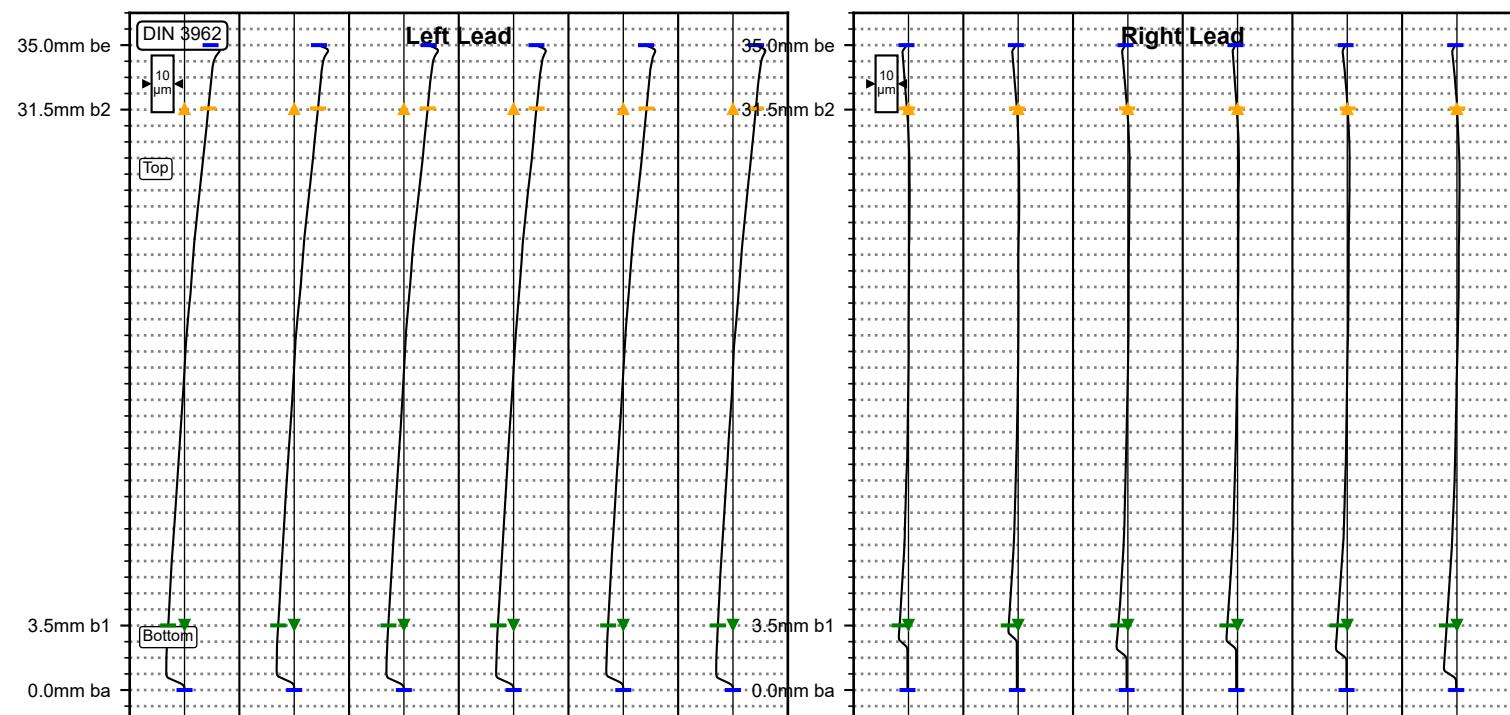
	36	35	34	33	32	31	Lim.value Qual.	Lim.value Qual.	31	32	33	34	35	36
fHbm	20.4 8	V 0.4					±8 5	±8 5	1.0 1	V 0.5				
fHb	20.5	20.4	20.5	20.6 8	20.3	20.2	±8 5	±8 5	0.8	1.3 1	1.0	0.8	1.3 1	1.0
fb	26.0 8	25.4	25.7	25.5	24.8	24.3	12 5	12 5	4.3	4.6 2	4.1	3.8	4.6 2	4.1
ffb	20.5	20.4	20.5	20.6 8	20.3	20.2	9 5	9 5	4.5	4.2	4.0	3.4	4.8 2	3.5
Cb	-1.8	-1.6	-1.5	-1.7	-1.7	-1.6			2.4	2.1	1.9	1.1	2.1	1.3

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



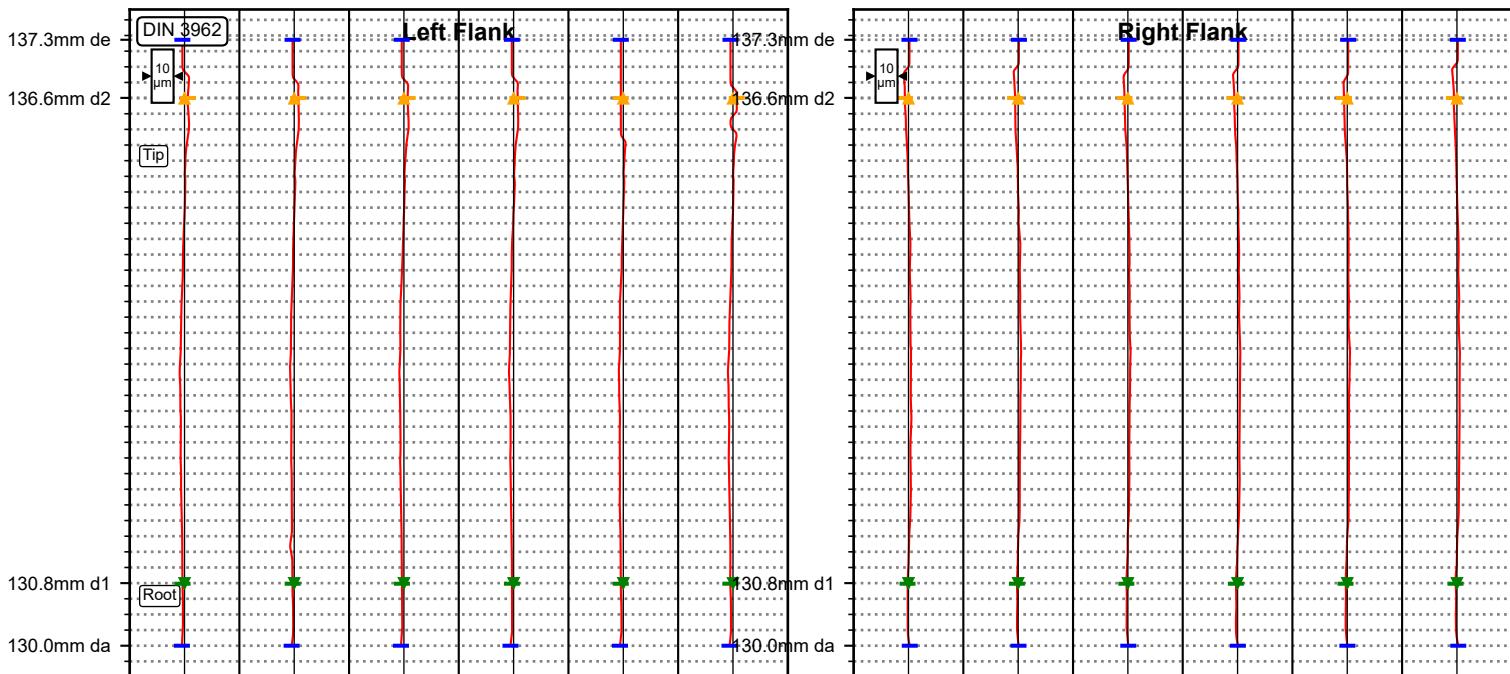
	42	41	40	39	38	37	Lim.value Qual.	Lim.value Qual.	37	38	39	40	41	42
fHam	1.3 1	V 1.5					±11.5	±11.5	-0.9 1	V 0.6				
fHa	1.2	1.2	1.1	1.1	0.9	2.4 1	±11.5	±11.5	-0.7	-0.7	-1.0	-0.7	-1.3 1	-1.3 1
fa	3.8	3.9	3.8	3.7	3.4	4.6 1	20.5	20.5	3.6	3.3	3.7	3.4	3.9	4.4 1
ffa	3.4	3.5	3.3	3.2	3.0	3.6 1	16.5	16.5	3.3	3.0	3.2	3.1	3.3	3.8 1
Ca	-0.7	-0.9	-0.9	-0.8	-0.8	-2.4			2.0	1.8	2.0	2.0	1.9	2.1



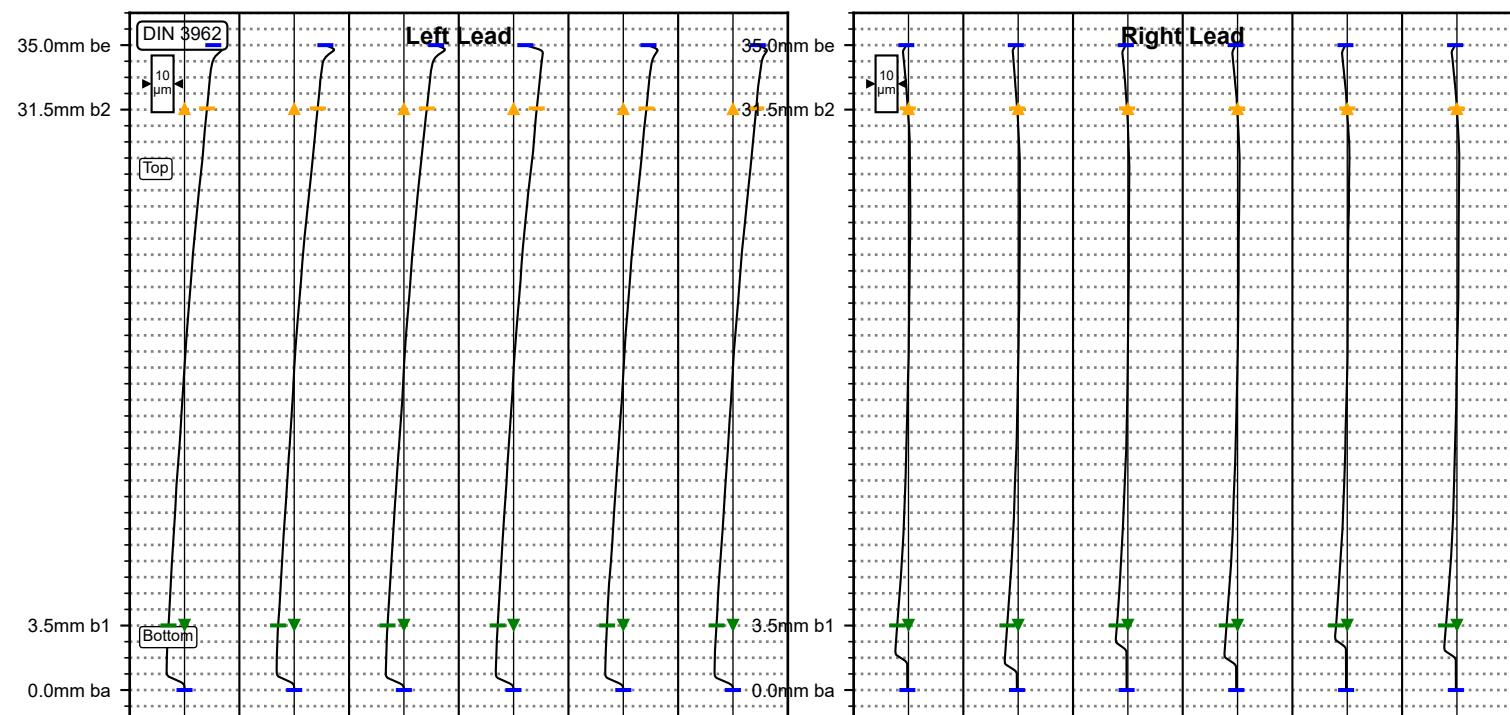
	42	41	40	39	38	37	Lim.value Qual.	Lim.value Qual.	37	38	39	40	41	42
fHbm	21.2 8	V 1.3					±8.5	±8.5	3.1 2	V 2.7				
fHb	21.9 8	21.5	21.3	21.0	20.7	20.6	±8.5	±8.5	2.1	2.1	3.0	2.9	3.5	4.8 4
fb	28.5 8	27.0	27.2	25.5	25.1	25.5	12.5	12.5	5.2	5.3	6.2	6.0	6.5	7.4 3
ffb	21.9 8	21.5	21.3	21.0	20.7	20.6	9.5	9.5	5.8	6.2	7.7	6.3	7.5	8.6 5
Cb	-1.7	-1.9	-1.9	-1.7	-1.8	-1.7			2.0	2.0	1.9	2.1	1.8	2.1

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



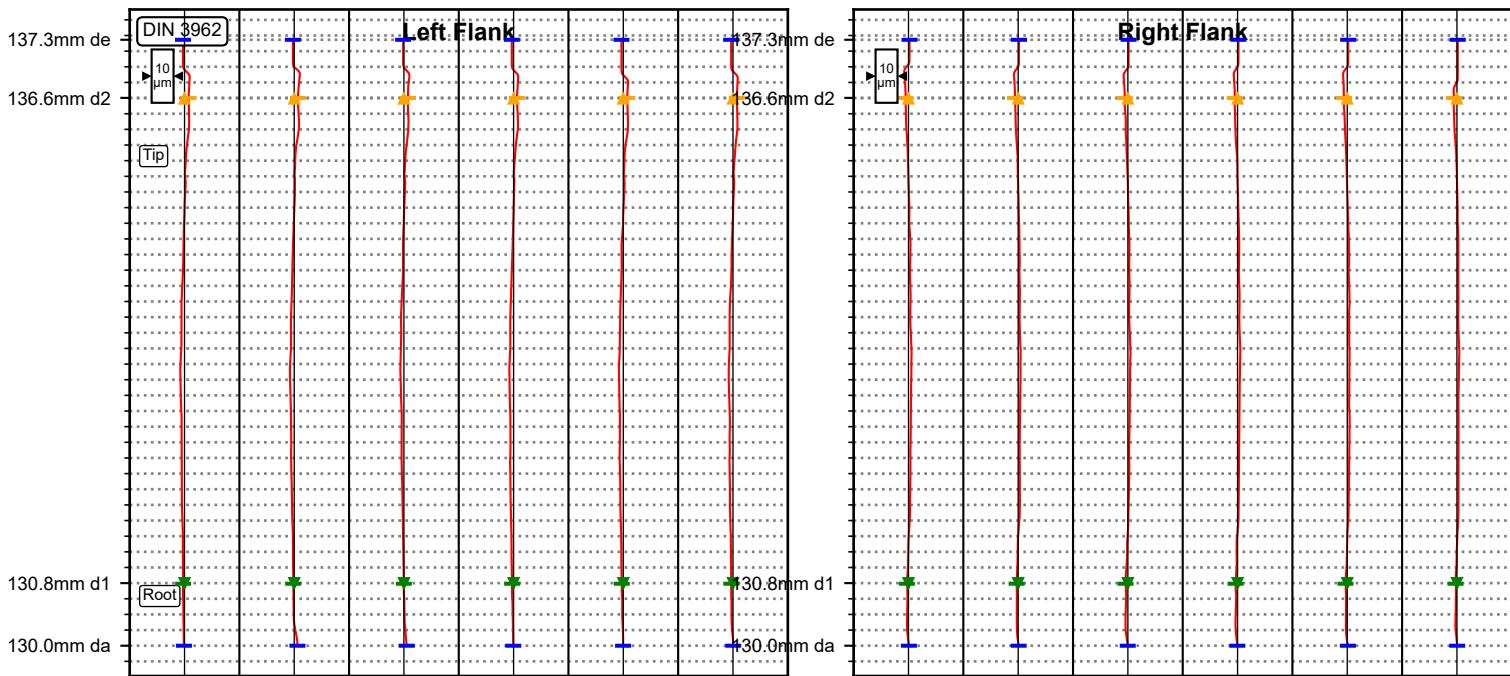
	48	47	46	45	44	43	Lim.value Qual.	Lim.value Qual.	43	44	45	46	47	48
fHam	1.9 1	V 1.3					±11 5	±11 5	-0.7 1	V 0.7				
fHa	2.3 1	2.1	2.2	2.0	1.0	1.8	±11 5	±11 5	-1.1 1	-0.8	-0.6	-0.6	-0.4	-0.9
fa	4.7 1	4.2	4.3	4.4	3.5	4.3	20 5	20 5	3.9	3.9	3.5	3.6	3.2	4.1 1
ffa	3.6 1	3.3	3.5	3.5	3.1	3.6 1	16 5	16 5	3.3	3.5	3.2	3.3	3.0	3.7 1
Ca	-2.3	-2.1	-2.4	-2.5	-0.8	-1.7			2.0	2.2	2.0	2.1	1.9	2.1



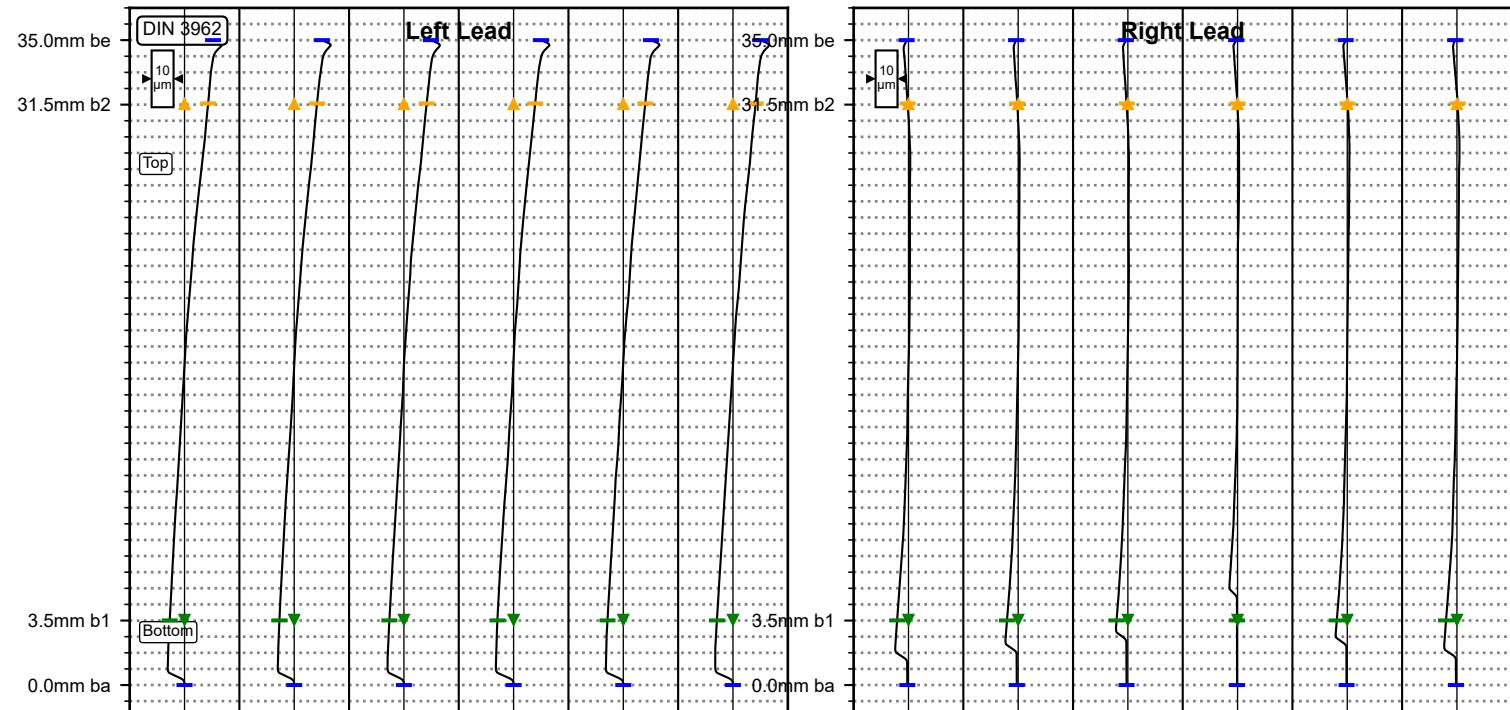
	48	47	46	45	44	43	Lim.value Qual.	Lim.value Qual.	43	44	45	46	47	48
fHbm	21.4 8	V 0.7					±8 5	±8 5	3.9 3	V 1.0				
fHb	21.2	21.5	21.7 8	21.0	21.4	21.6	±8 5	±8 5	4.0	4.3 3	3.3	4.2	3.5	3.9
fb	30.9	32.7	34.0 9	26.8	27.7	27.6	12 5	12 5	7.1	7.2 3	6.5	7.2 3	6.8	7.1
ffb	22.7	24.7	25.7 9	21.0	21.4	21.6	9 5	9 5	8.1	9.0 5	5.9	6.3	5.6	6.9
Cb	-1.5	-1.7	-1.4	-1.6	-1.4	-1.5			2.3	2.4	2.4	2.1	2.1	2.1

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



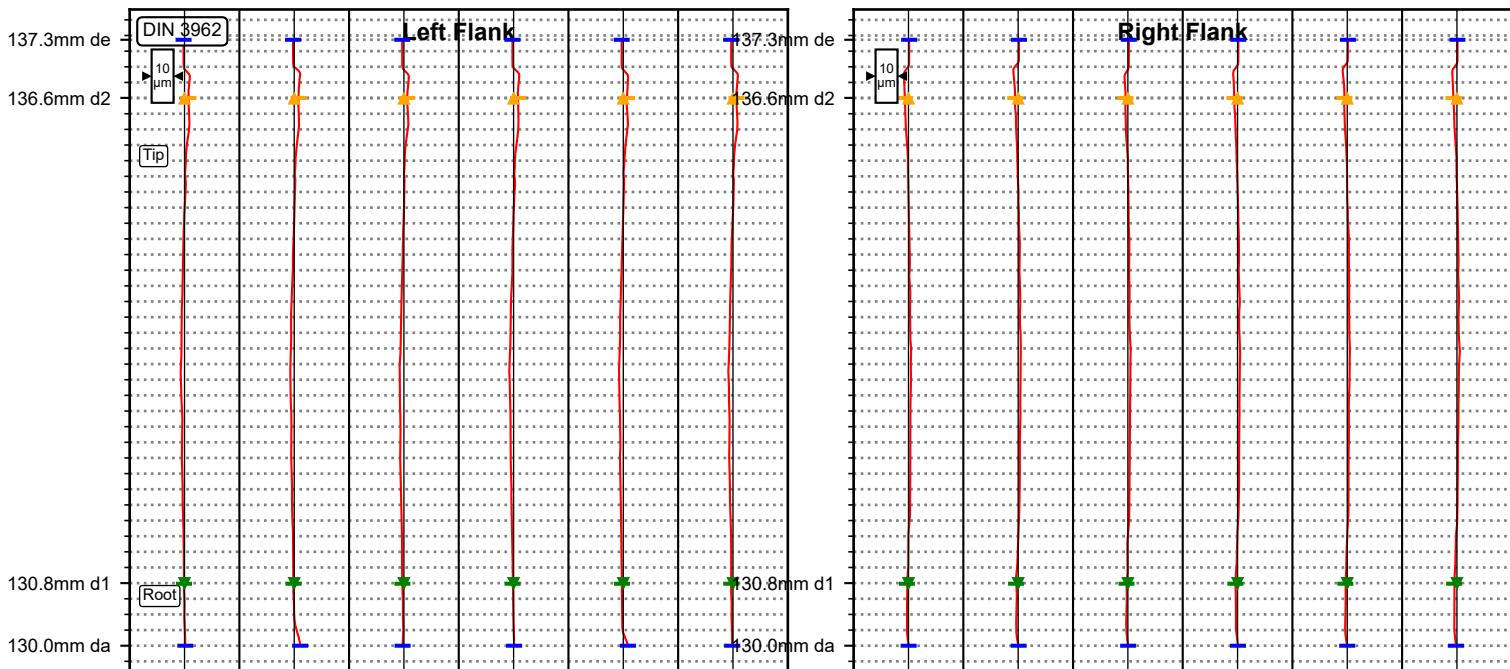
	54	53	52	51	50	49	Lim.value Qual.	Lim.value Qual.	49	50	51	52	53	54	
fHam	1.9 1	V 0.8					±11 5	±11 5	-0.4 1	V 0.4					
fHa	2.2 1	1.7	1.4	2.1	2.0	2.2 1	±11 5	±11 5	-0.6 1	-0.6 1	-0.2	-0.2	-0.6 1	-0.3	
fa	4.8	5.2 2	4.7	4.6	4.7	4.6	20 5	20 5	3.8 1	3.5	3.5	3.5	3.4	2.8	
ffa	3.7	4.4 2	3.9	3.5	3.7	3.5	16 5	16 5	3.6 1	3.2	3.4	3.4	3.1	2.7	
Ca	-2.4	-2.5	-2.4	-2.2	-2.4	-2.3				2.1	1.9	2.1	2.0	2.1	1.8



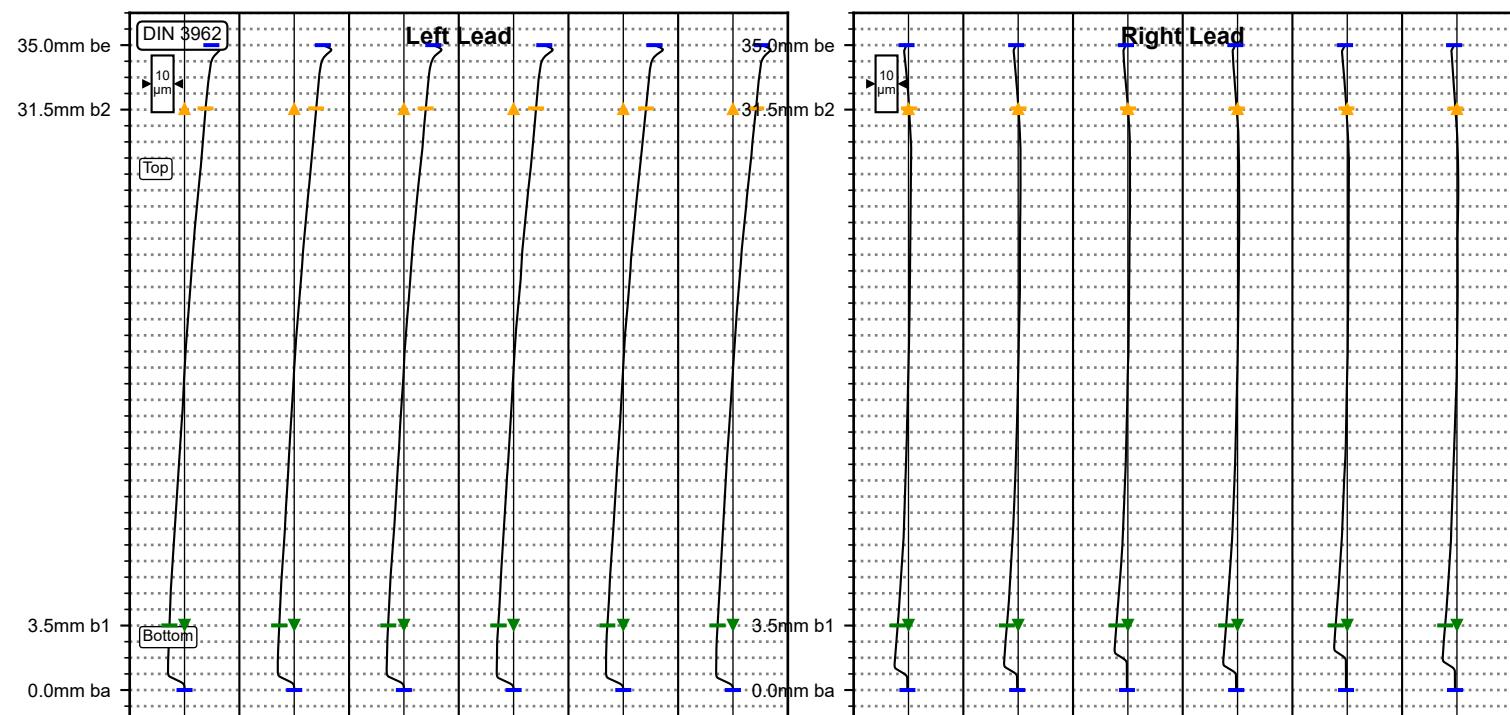
	54	53	52	51	50	49	Lim.value Qual.	Lim.value Qual.	49	50	51	52	53	54
fHbm	20.7 8	V 0.7					±8 5	±8 5	3.4 2	V 2.8				
fHb	21.0	20.7	20.4	20.5	20.7	21.1 8	±8 5	±8 5	4.2	3.7	3.0	1.5	3.4	3
fb	30.2 8	29.3	28.6	29.7	29.9	29.5	12 5	12 5	7.1	6.8	6.2	4.9	6.6	7.3 3
ffb	22.4 8	21.6	21.1	21.5	21.8	21.4	9 5	9 5	6.4	6.3	5.4	5.3	6.7	7.8 4
Cb	-2.0	-1.8	-1.8	-1.2	-1.3	-1.5			2.6	2.4	2.5	0.7	1.8	1.9

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



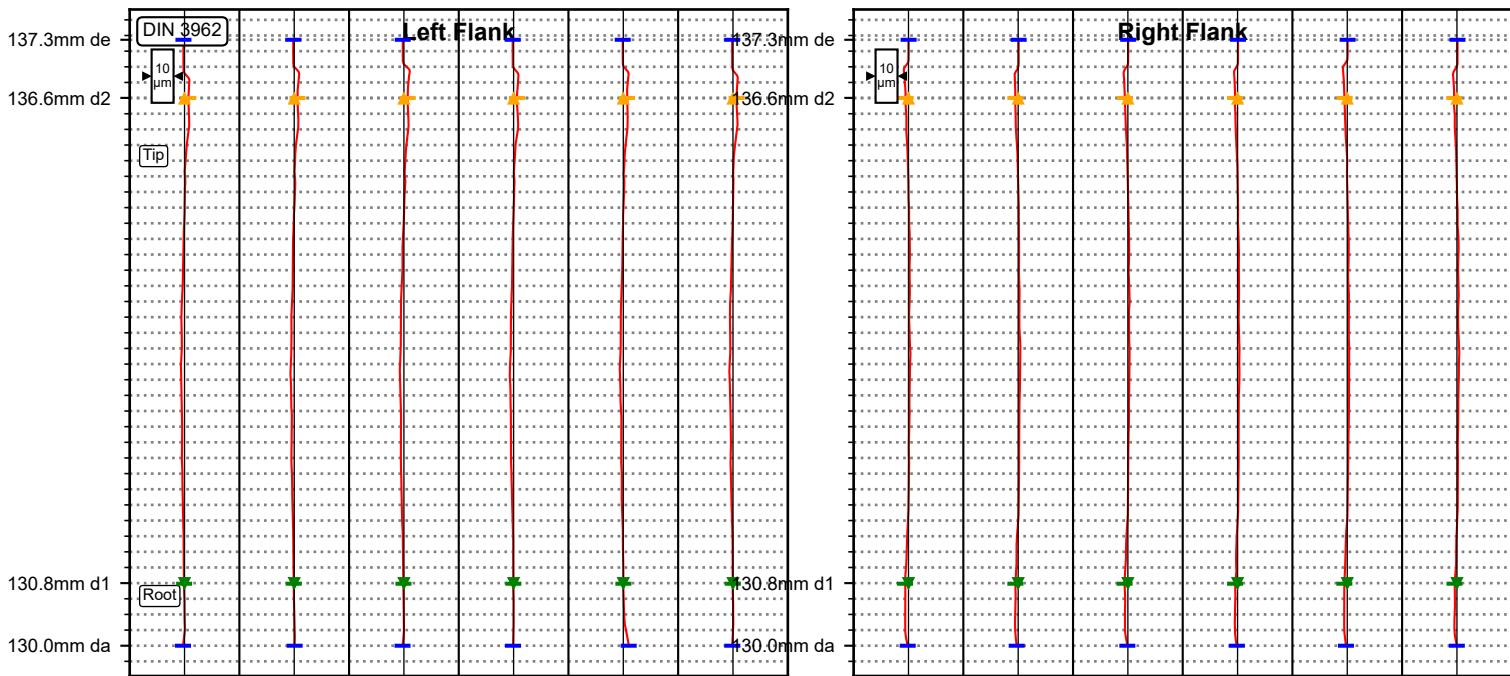
	60	59	58	57	56	55	Lim.value Qual.	Lim.value Qual.	55	56	57	58	59	60
fHam	1.9 1	V 0.6					±11 5	±11 5	-0.4 1	V 0.8				
fHa	1.6	1.6	2.1	2.0	1.9	2.2 1	±11 5	±11 5	-0.8 1	-0.5	-0.4	-0.4	-0.4	-0.0
fa	4.7	5.1 2	4.8	5.1 2	4.7	4.9	20 5	20 5	3.8	4.0 1	3.3	3.5	3.9	4.0 1
ffa	3.9	5.3	3.7	4.1	5.5 2	3.8	16 5	16 5	3.4	3.8	3.1	3.3	3.6	4.0 1
Ca	-2.5	-2.5	-2.2	-2.6	-2.3	-2.4			2.0	2.2	1.8	2.0	2.0	2.2



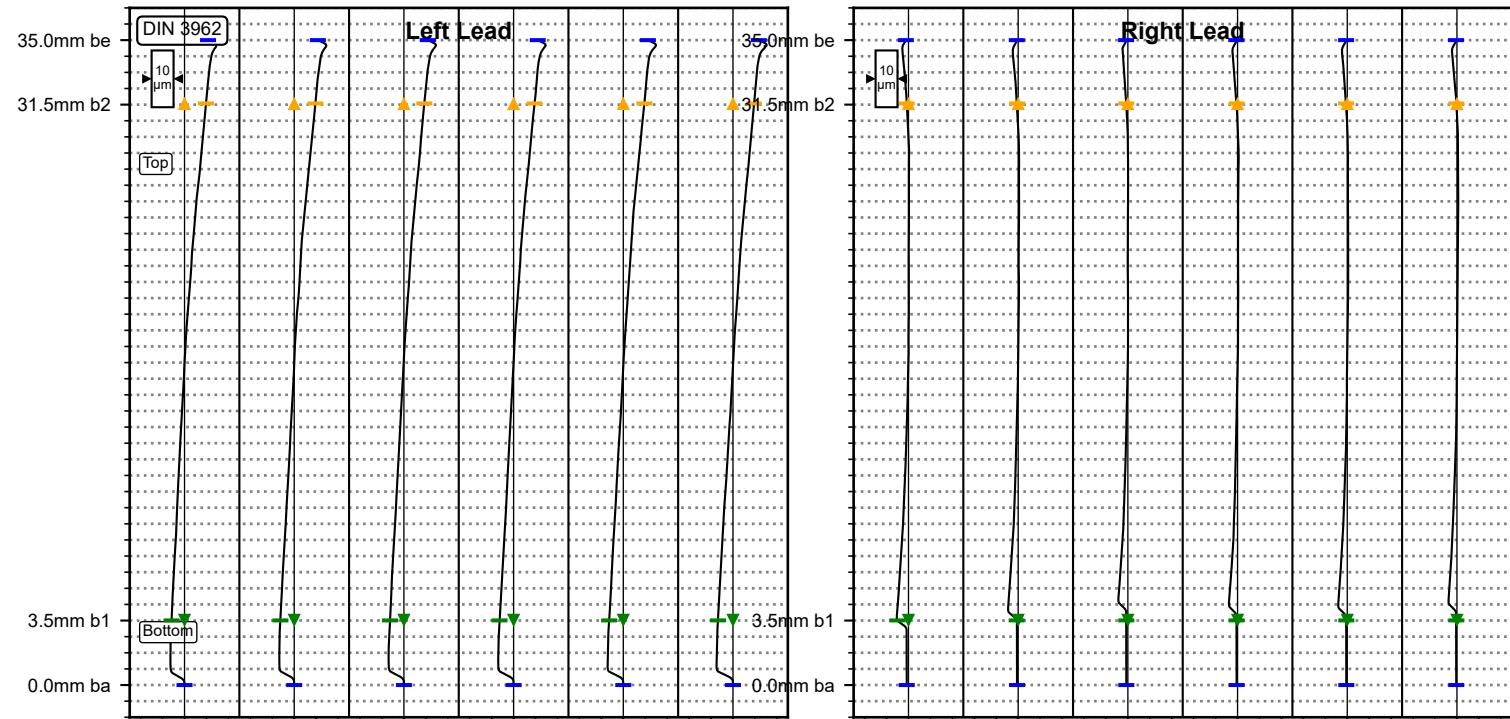
	60	59	58	57	56	55	Lim.value Qual.	Lim.value Qual.	55	56	57	58	59	60
fHbm	20.7 8	V 1.1					±8 5	±8 5	4.6 4	V 1.3				
fHb	20.0	20.3	20.6	20.9	21.1 8	21.1 8	±8 5	±8 5	5.2 4	5.2 4	4.3 4.7	3.9 4.4		
fb	28.8	30.2	31.2	32.3	32.8 9	30.8	12 5	12 5	8.0 3	8.0 3	7.4 7.6	7.0 7.5		
ffb	21.1	22.7	23.3	24.4	24.8 8	22.9	9 5	9 5	8.8	9.6 6	8.2 7.9	7.7 8.1		
Cb	-1.1	-1.5	-1.5	-1.6	-1.6	-1.8			1.9	2.2	2.3 2.4	2.6 2.5		

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



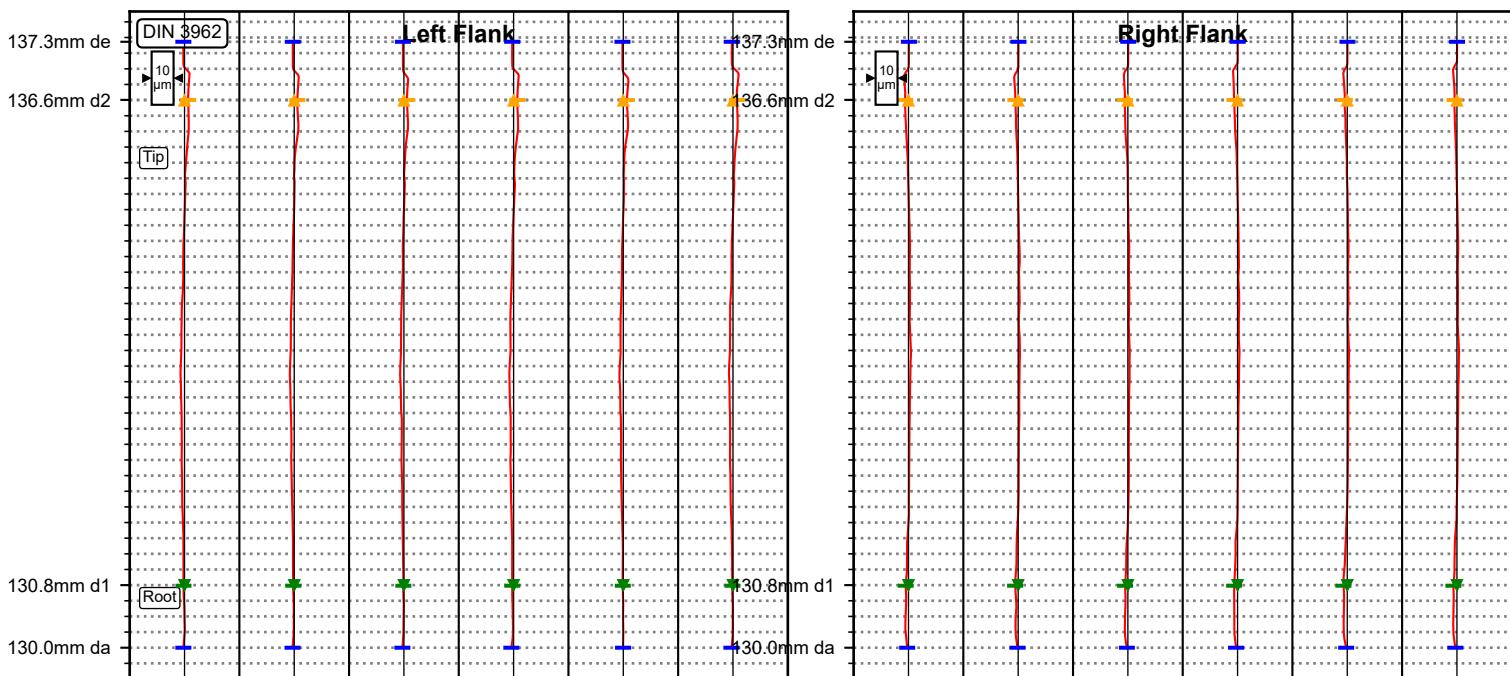
	66	65	64	63	62	61	Lim.value Qual.	Lim.value Qual.	61	62	63	64	65	66
fHam	1.5 1	V 0.8					±11 5	±11 5	0.2 1	V 0.4				
fHa	1.5	1.5	1.9 1	1.6	1.1	1.4	±11 5	±11 5	0.3 1	0.2	0.3 1	0.1	0.2	-0.1
fa	4.3	4.6	5.4 2	4.5	4.6	4.3	20 5	20 5	3.5	3.2	3.2	3.1	3.8 1	3.2
ffa	3.6	3.8	4.4	3.7	4.7 2	3.6	16 5	16 5	3.7	3.3	3.3	3.1	3.9 1	3.1
Ca	-2.4	-2.2	-2.6	-2.3	-2.4	-2.4			2.0	2.0	2.0	1.8	2.0	1.8



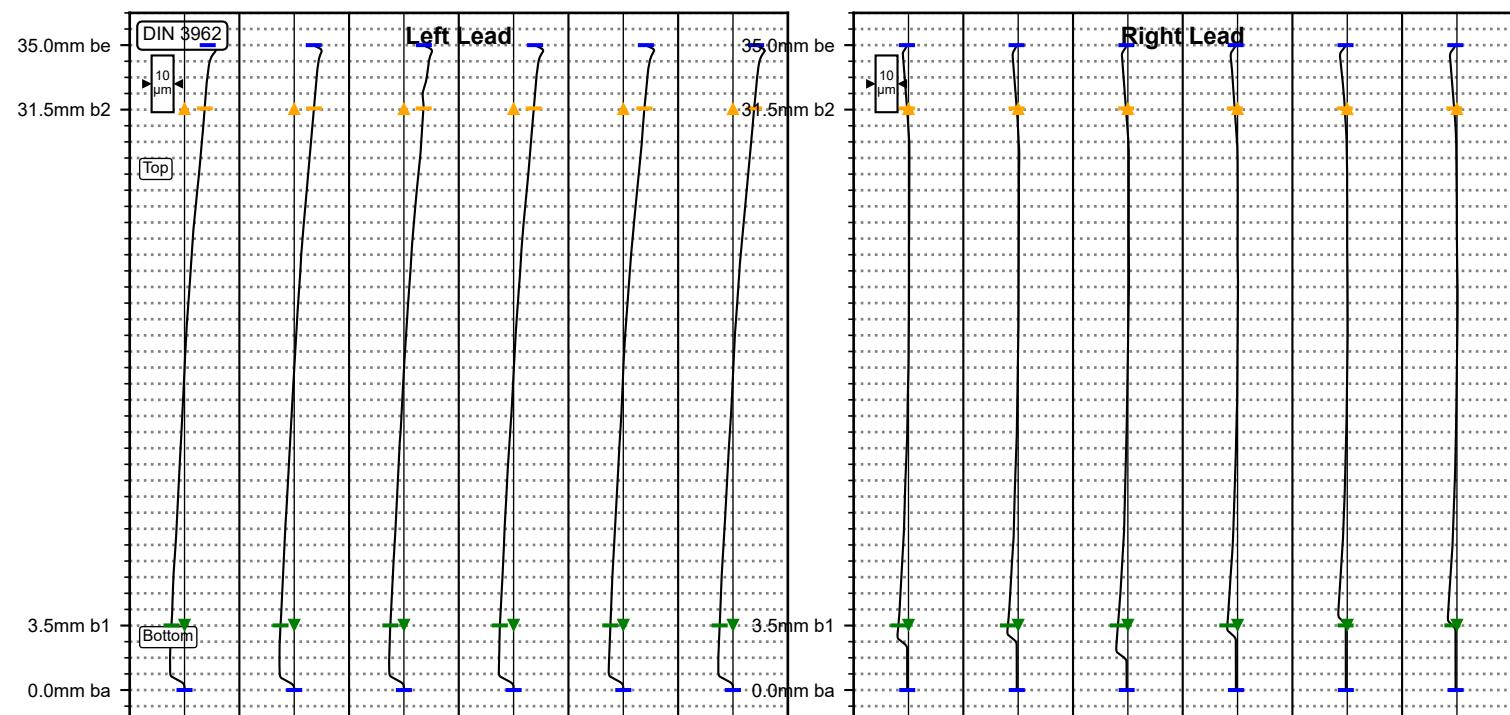
	66	65	64	63	62	61	Lim.value Qual.	Lim.value Qual.	61	62	63	64	65	66
fHbm	18.9 8	V 0.8					±8 5	±8 5	1.8 1	V 0.9				
fHb	18.7	18.8	18.7	18.8	19.0	19.5 8	±8 5	±8 5	2.5 1	2.1	1.6	1.6	1.6	1.6
fb	24.6	25.1	25.6	25.8	26.5	27.7 8	12 5	12 5	6.0 2	5.3	4.7	4.7	4.8	4.8
ffb	18.7	18.8	18.7	18.8	19.2	20.2 8	9 5	9 5	5.9 3	4.5	4.0	3.9	4.1	4.0
Cb	-1.9	-1.7	-1.6	-1.5	-1.4	-1.3			2.7	2.2	1.7	1.6	1.9	1.4

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



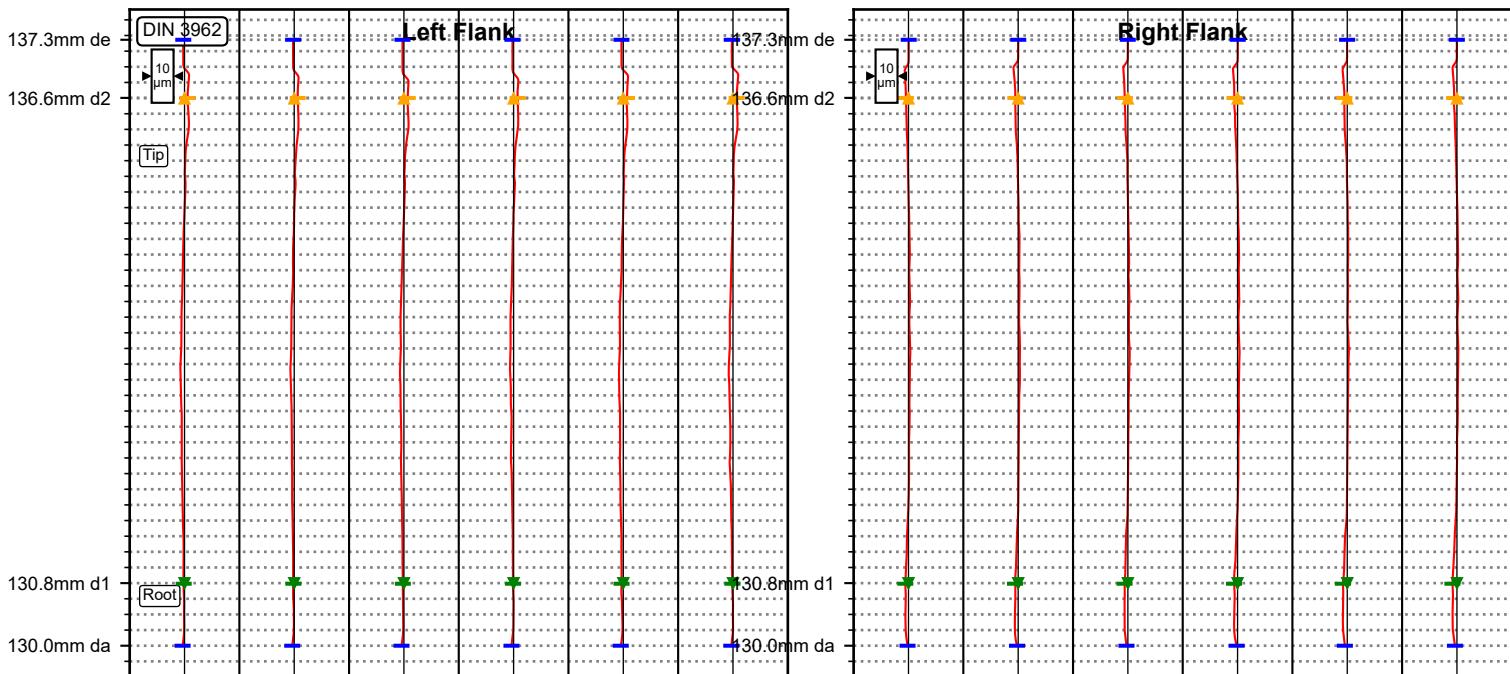
	72	71	70	69	68	67	Lim.value Qual.	Lim.value Qual.	67	68	69	70	71	72
fHam	1.8 1	V 0.6					±11 5	±11 5	0.3 1	V 0.5				
fHa	1.9	1.7	1.5	2.1 1	1.6	2.0	±11 5	±11 5	0.1	0.2	0.1	0.3	0.5	0.6 1
fa	4.8	4.6	4.0	4.8	4.5	5.1 2	20 5	20 5	3.5	2.9	3.0	3.7 1	3.0	3.4
ffa	3.9	3.8	3.3	3.8	3.7	4.1 2	16 5	16 5	3.5	3.0	3.0	3.8 1	3.3	3.7
Ca	-2.3	-2.4	-2.1	-2.4	-2.4	-2.6			2.1	1.8	1.9	2.1	1.9	2.0



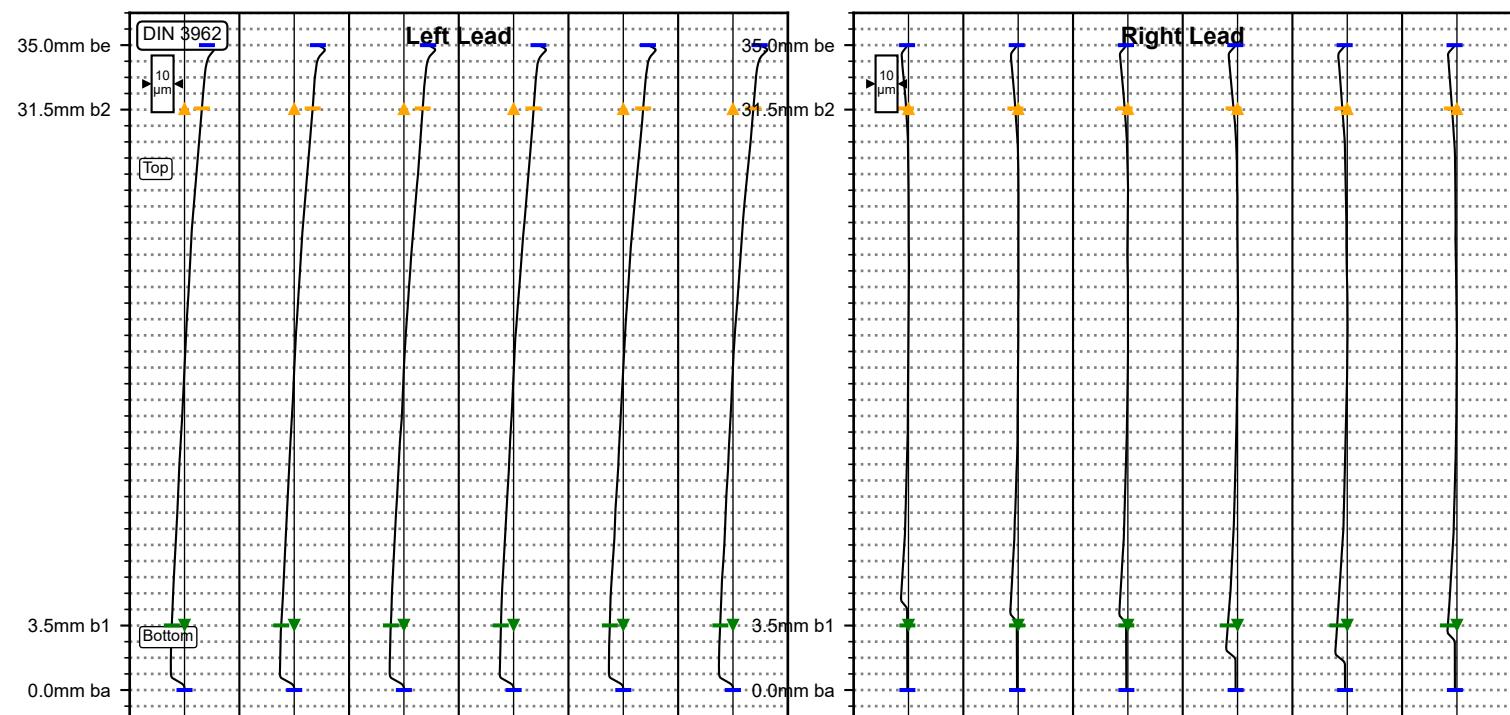
	72	71	70	69	68	67	Lim.value Qual.	Lim.value Qual.	67	68	69	70	71	72
fHbm	18.3 8	V 0.8					±8 5	±8 5	2.0 1	V 1.9				
fHb	18.0	18.1	18.0	18.4	18.7	18.8 8	±8 5	±8 5	2.7	2.5	2.9 2	1.7	1.1	1.0
fb	24.6 8	21.6	21.9	23.4	24.1	24.5	12 5	12 5	5.8	5.8	6.1 3	5.2	4.6	4.6
ffb	18.0	18.1	18.0	18.4	18.7	18.8 8	9 5	9 5	5.1	4.8	5.2 3	4.4	4.2	4.1
Cb	-1.6	-1.4	-1.5	-1.5	-1.9	-1.7			2.2	2.2	2.3	2.6	2.3	2.5

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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



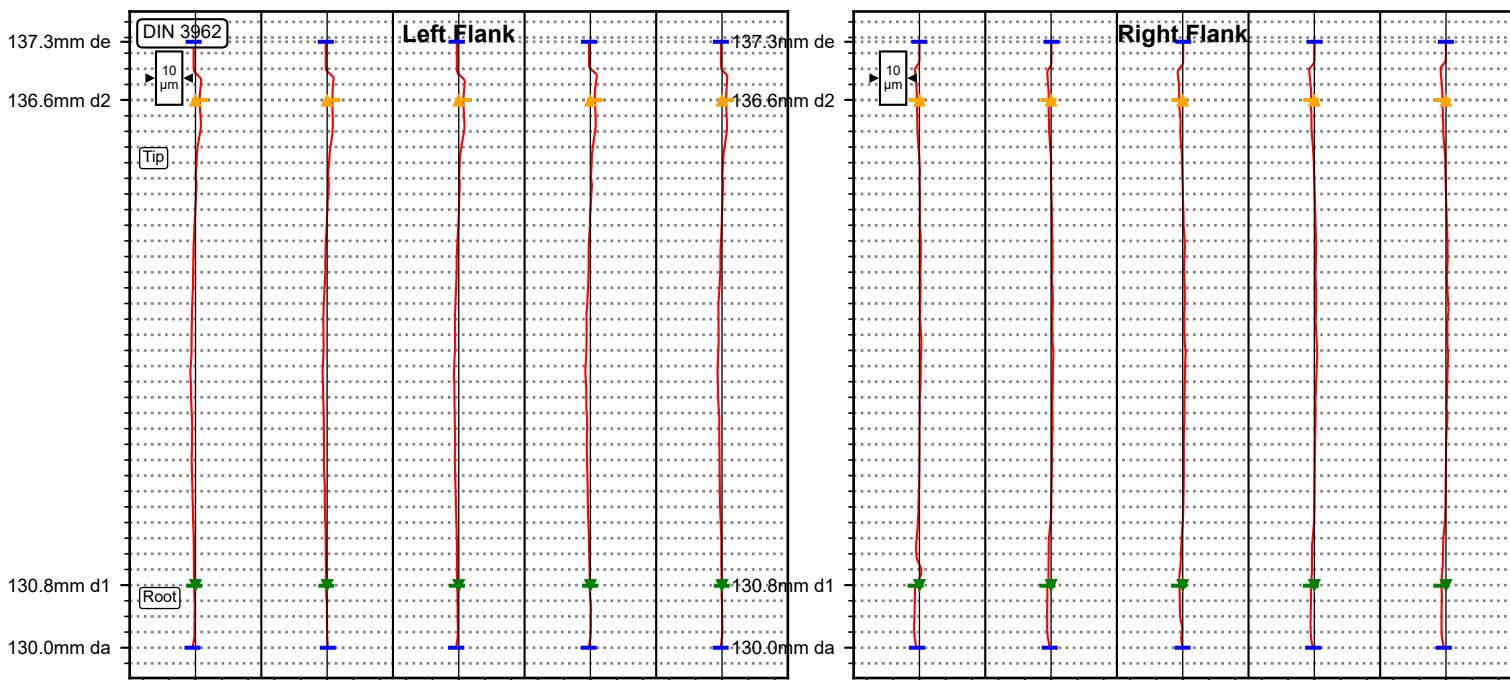
	78	77	76	75	74	73	Lim.value Qual.	Lim.value Qual.	73	74	75	76	77	78
fHam	1.8 1	V 0.5					±11.5	±11.5	0.4 1	V 0.6				
fHa	1.7	1.7	1.8	1.6	2.1 1	1.7	±11.5	±11.5	0.3	0.2	0.3	0.2	0.7	0.8 1
fa	4.5	4.2	4.2	4.1	4.6	4.9 1	20.5	20.5	3.1	3.9 1	3.7	3.7	3.4	3.5
ffa	3.6	3.3	3.3	3.4	3.5	4.0 1	16.5	16.5	3.3	4.0 1	3.9	3.8	3.7	3.9
Ca	-2.4	-2.2	-2.4	-2.4	-2.3	-2.5			1.9	2.1	2.0	2.2	2.0	2.1



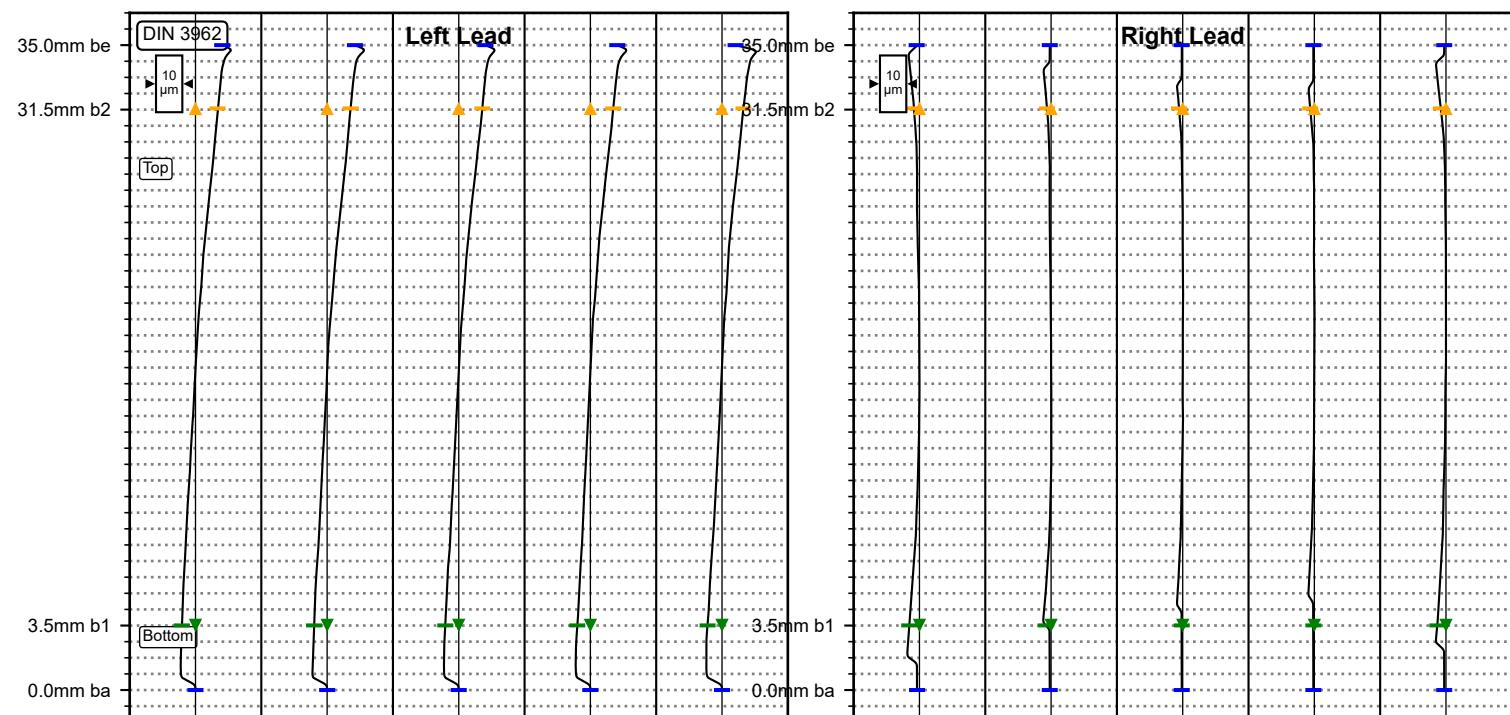
	78	77	76	75	74	73	Lim.value Qual.	Lim.value Qual.	73	74	75	76	77	78
fHbm	17.6 8	V 1.8					±8.5	±8.5	0.9 1	V 1.4				
fHb	16.4	17.1	17.7	18.1	18.2 8	18.2 8	±8.5	±8.5	0.6	0.7	0.7	1.7 1	1.5	0.3
fb	23.9	25.4	25.6	26.1	25.9	27.3 8	12.5	12.5	3.9	4.0	4.3	5.8 2	5.8 2	4.6
ffb	17.6	18.7	19.1	19.6	19.4	20.9 8	9.5	9.5	3.8	3.9	4.4	5.2 3	5.1	4.5
Cb	-1.1	-1.3	-1.3	-1.6	-1.5	-1.8			1.5	2.0	2.1	2.7	3.1	2.7

# Gear Profile/Lead

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
Type:	assembly	No. of teeth:	83	Face Width:	35.00mm
Drawing No.:	056-Li-20400125-G-1wav	Module m:	1.400mm	Length Ev. L $\alpha$ :	5.85mm
Order No.:	104477-0013-wav	Pressure angle:	17°	Length Ev. L $\beta$ :	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	1.7 1	V 0.6				±11 5	±11 5	0.4 1	V 0.8			
fHa	1.8	1.8	2.0 1	1.7	1.4	±11 5	±11 5	0.8 1	0.6	-0.0	0.2	0.5
fa	4.5	4.7	4.4	5.0 1	4.3	20 5	20 5	3.3	2.9	3.5	3.8	3.9 1
ffa	3.6	3.8	3.5	4.2 2	3.6	16 5	16 5	3.9	3.2	3.5	3.9	4.1 2
Ca	-2.4	-2.6	-2.4	-2.5	-2.4			1.3	1.8	2.1	2.0	2.2

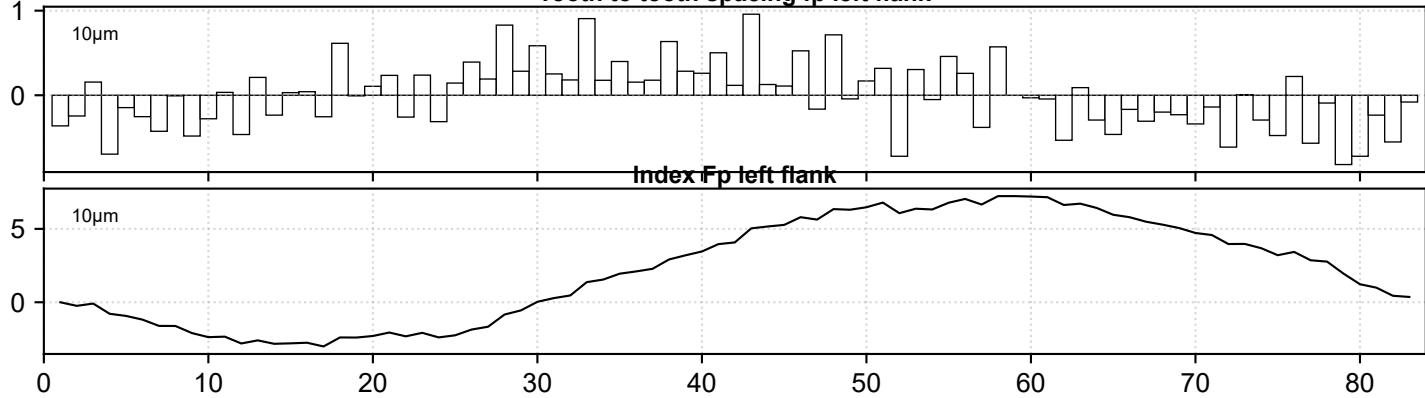


	83	82	81	80	79	Lim.value Qual.	Lim.value Qual.	79	80	81	82	83
fHbm	16.4 8	V 0.9				±8 5	±8 5	0.3 1	V 0.8			
fHb	16.5	16.8 8	16.6	16.2	15.9	±8 5	±8 5	0.7 1	-0.1	0.2	0.3	0.6
fb	23.0	23.9 8	23.0	23.0	22.5	12 5	12 5	5.0 2	3.4	2.6	2.6	4.2
ffb	17.4	18.1 8	17.3	17.4	16.6	9 5	9 5	4.7 2	3.4	2.7	2.7	4.4
Cb	-1.7	-1.9	-1.9	-2.0	-1.4			2.8	2.1	1.3	1.2	2.2

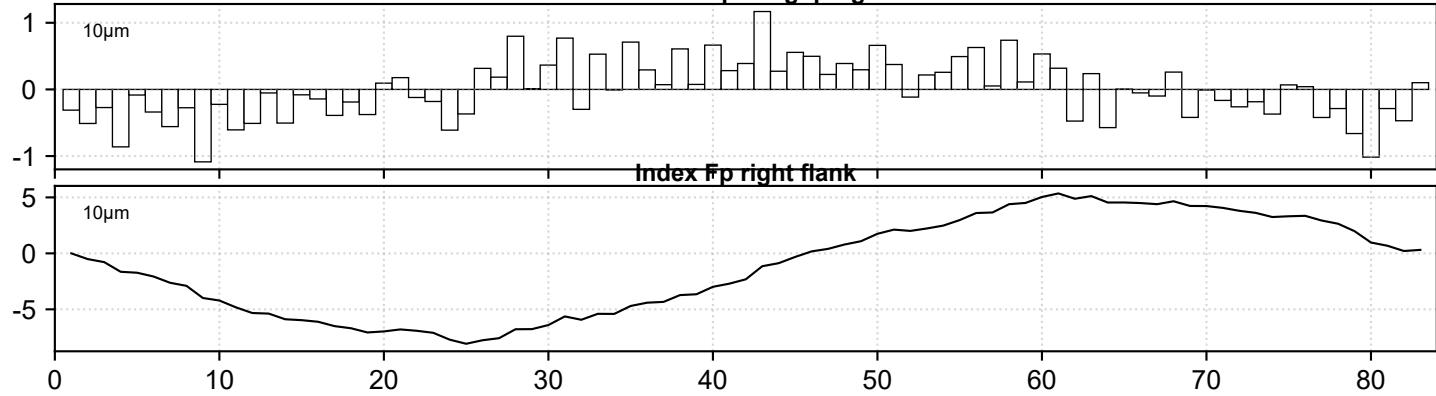
# Gear Spacing

Prog.No.:	temp.mka	Operator:	wang	Date:	31.12.23
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.:	104477-0013-wav	Loc. of check:	Jintan		
Cust./Mach. No.:	P26 B 7549	Condition:	Grinding-0403		

Tooth to tooth spacing fp left flank



Tooth to tooth spacing fp right flank



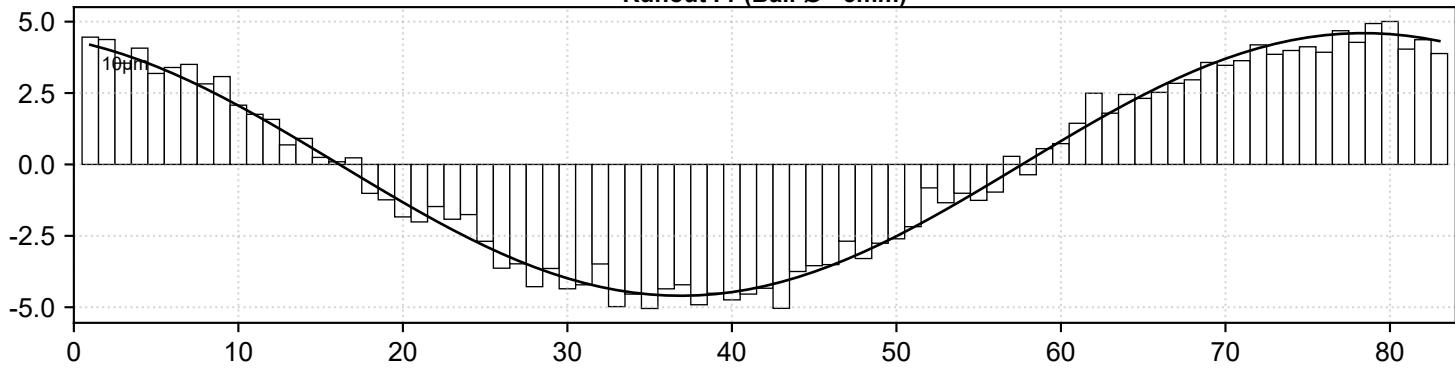
Pitch measuring circle:

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	1.2		12.5
Worst spacing deviation fu max	1.0			1.1		
Range of Pitch Error Rp	1.8			2.3		
Total cum. pitch dev. Fp	10.2		36.5	13.4		36.5
Cum. pitch deviation Fp10	4.2			4.8		

Runout Fr (Ball-Ø =3mm)



MdK 138.581[mm]/Ball-Ø 1

Pitch Line Runout	Fr	10.1			Lim.value	138.666	138.496	
Variation of tooth thickn	Rs				Act.	136.912	138.588	135.254