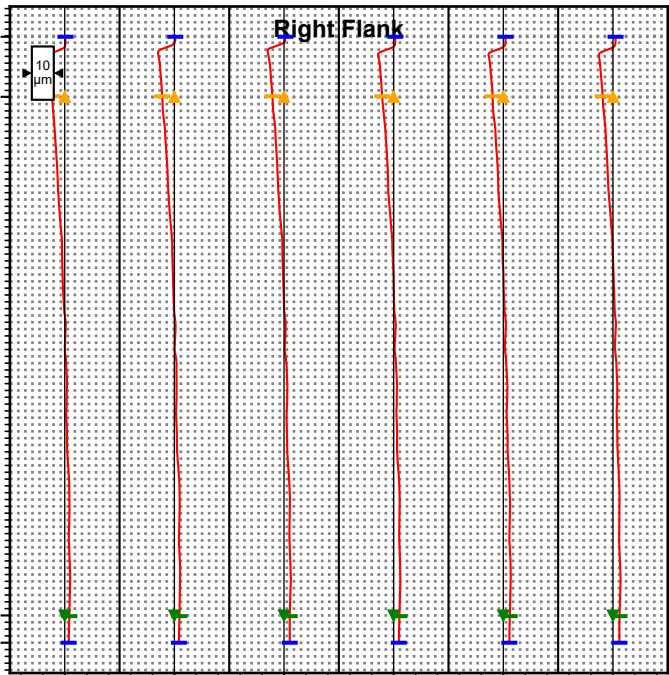
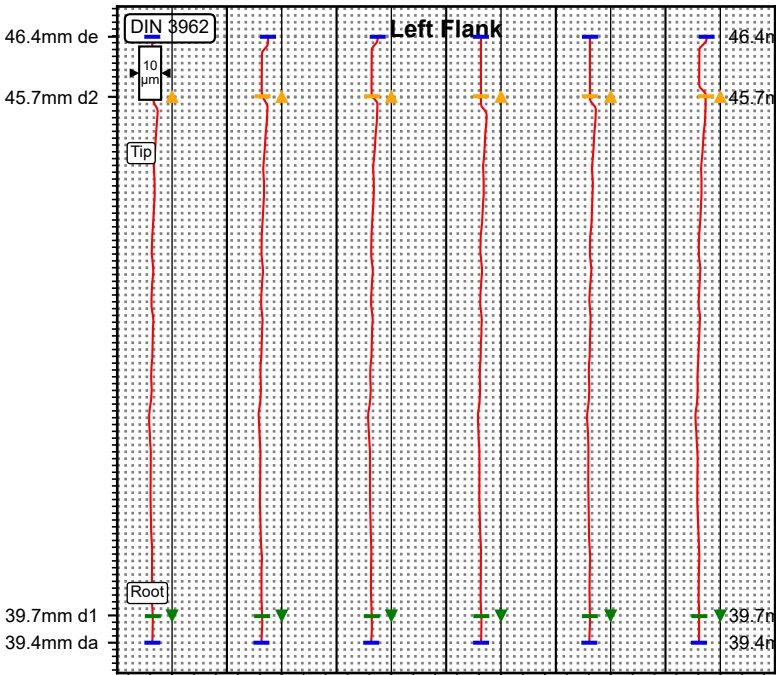
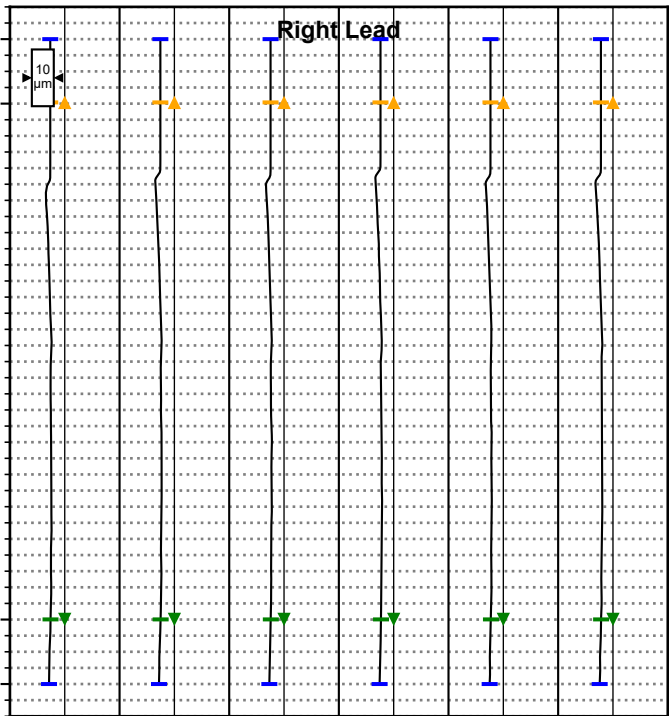
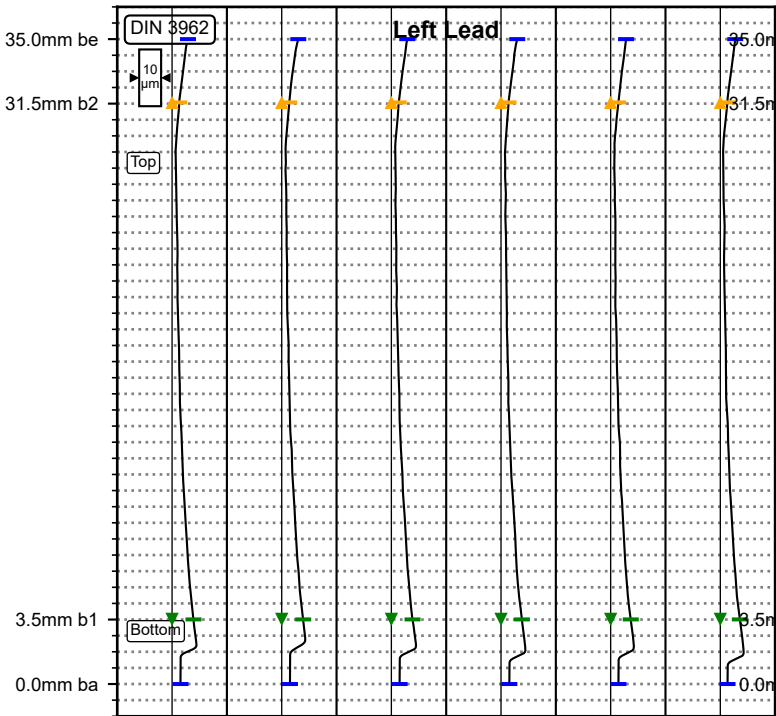


Gear Profile/Lead

Prog.No.:		Operator:	R. Romanov	Date:	20.02.25
Type:	CH	No. of teeth:	26	Face Width:	35.00mm
Drawing No.:	20250220-MC-FLY	Module m:	1.440mm	Length Ev. Lα:	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P65	Helix angle:	-25.00°	Appr. Length:	0.32mm
Loc. of check:	KLINGELNBERG	Base Cir.-Ø db:	39.1433mm	Stylus-Ø:	1.000mm
Condition:	BERTA	Base Helix ang:	-23.838°	Add.Mod.Coe:	0.540



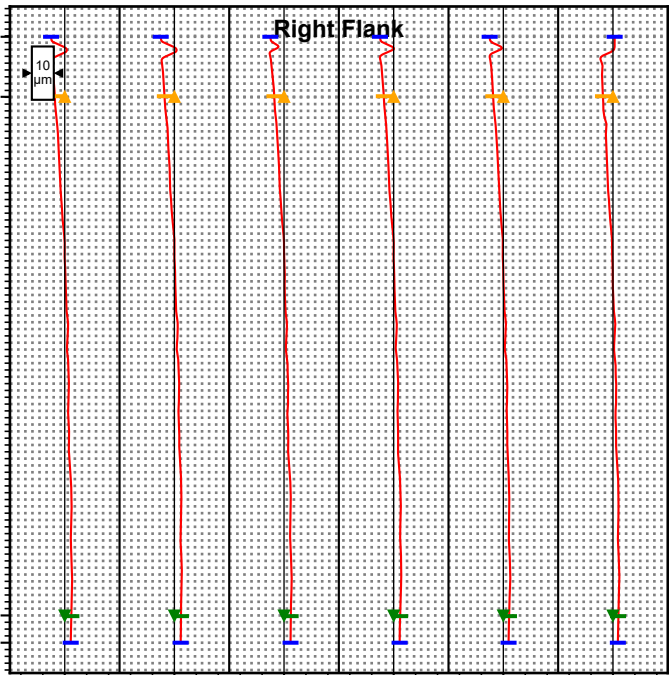
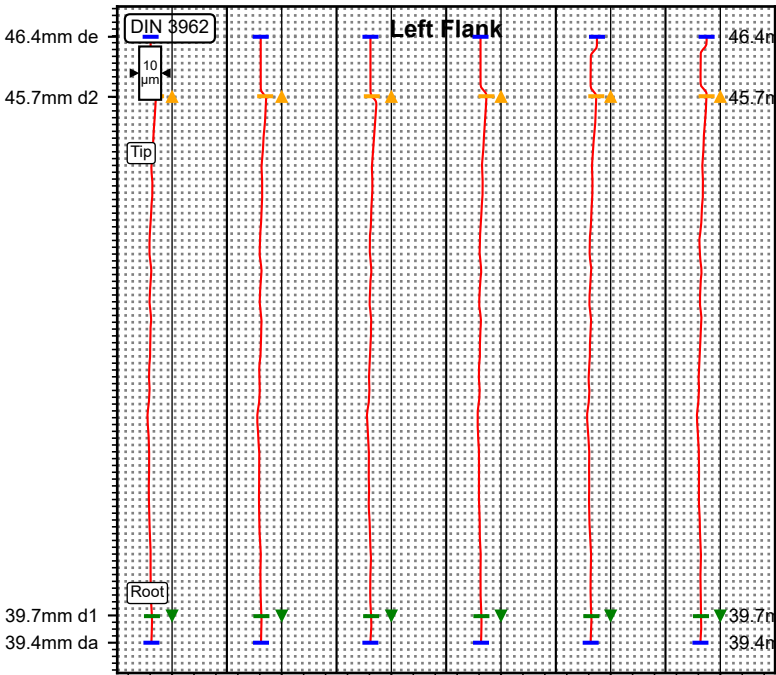
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6
fHam	1.8 1	V 1.0					±11 5	±11 5	-8.8 5	V 0.6				
fHa	1.5	1.9	1.9	1.4	1.7	2.4 1	±11 5	±11 5	-8.6	-8.9	-9.2 5	-8.7	-8.8	-8.6
fa	4.2	4.4	4.5	4.1	4.2	5.1 2	20 5	20 5	10.7	11.3	12.4 4	11.8	11.7	11.1
ffa	3.4	3.4	3.5	3.4	3.3	3.9 1	16 5	16 5	8.6	9.2	10.1 4	9.7	9.6	9.0
Ca	-1.5	-1.7	-1.7	-1.5	-1.5	-2.1			2.1	2.1	2.0	2.0	2.1	2.1



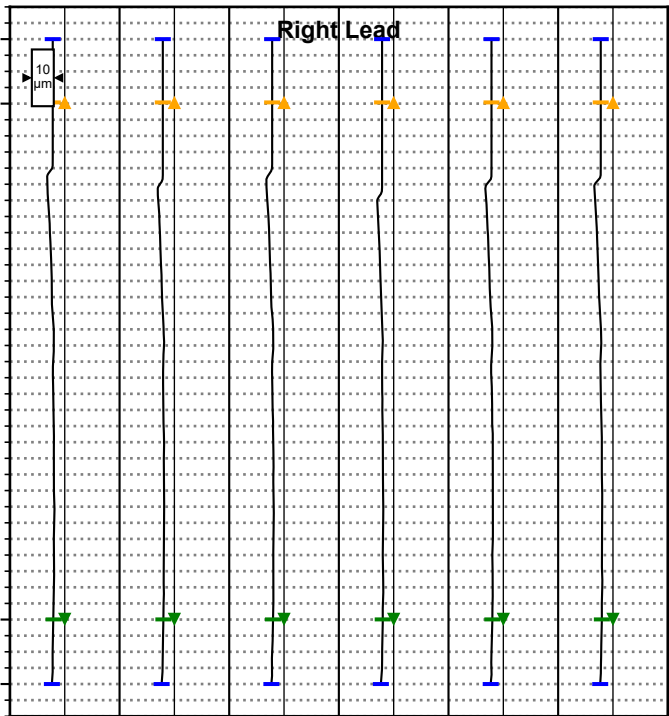
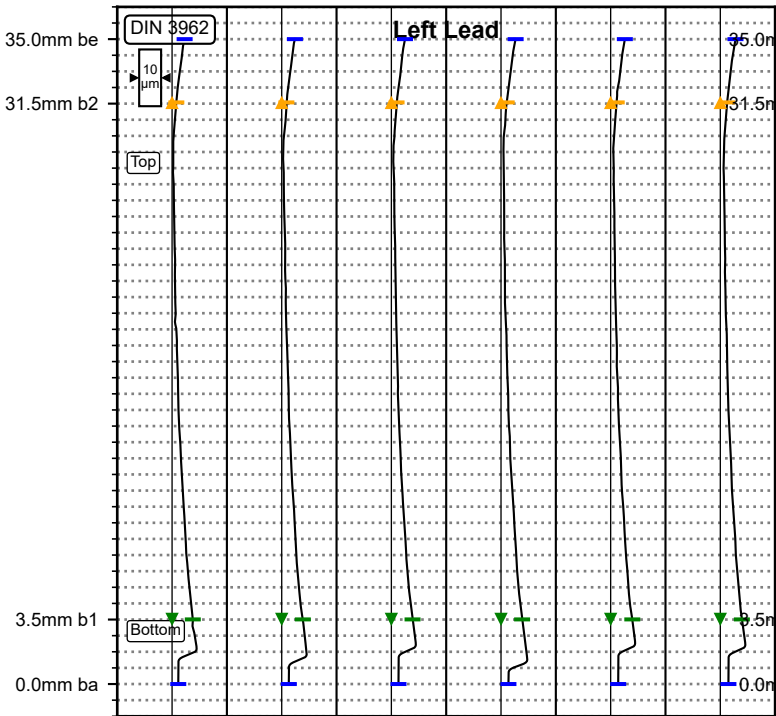
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6
fHbm	-5.1 4	V 0.6					±8 5	±8 5	-0.8 1	V 0.3				
fHb	-5.3 4	-4.9	-5.2	-5.2	-4.7	-5.1	±8 5	±8 5	-0.7	-0.8	-0.7	-1.0 1	-0.8	-0.8
fb	10.1 5	9.6	10.0	9.7	9.4	9.8	12 5	12 5	3.0	3.4	3.1	3.5 2	3.1	3.4
ffb	9.7 6	9.5	9.4	9.4	8.4	8.8	9 5	9 5	2.8	3.1	2.8	3.1	2.8	3.2 2
Cb	-2.7	-2.9	-2.9	-2.9	-2.8	-2.9			-0.0	0.2	0.1	0.2	0.0	0.2

Gear Profile/Lead

Prog.No.:		Operator:	R. Romanov	Date:	20.02.25
Type:	CH	No. of teeth:	26	Face Width:	35.00mm
Drawing No.:	20250220-MC-FLY	Module m:	1.440mm	Length Ev. Lα:	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P65	Helix angle:	-25.00°	Appr. Length:	0.32mm
Loc. of check:	KLINGELNBERG	Base Cir.-Ø db:	39.1433mm	Stylus-Ø:	1.000mm
Condition:	BERTA	Base Helix ang:	-23.838°	Add.Mod.Coe:	0.540



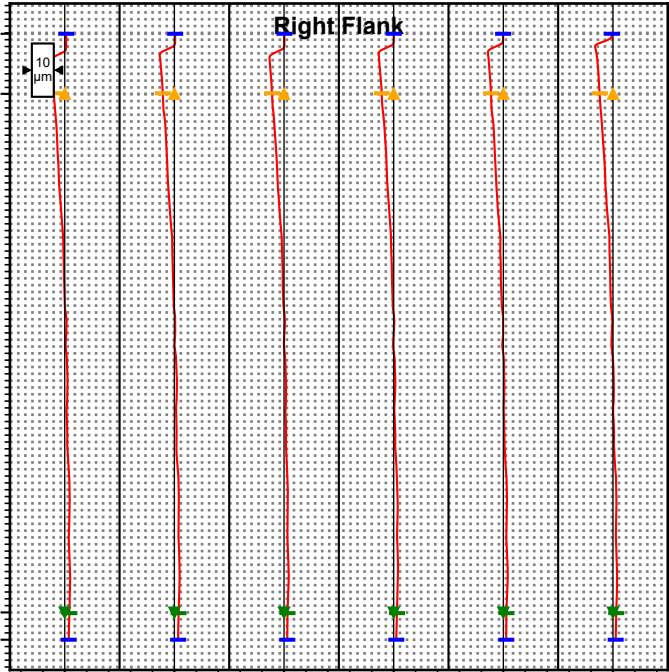
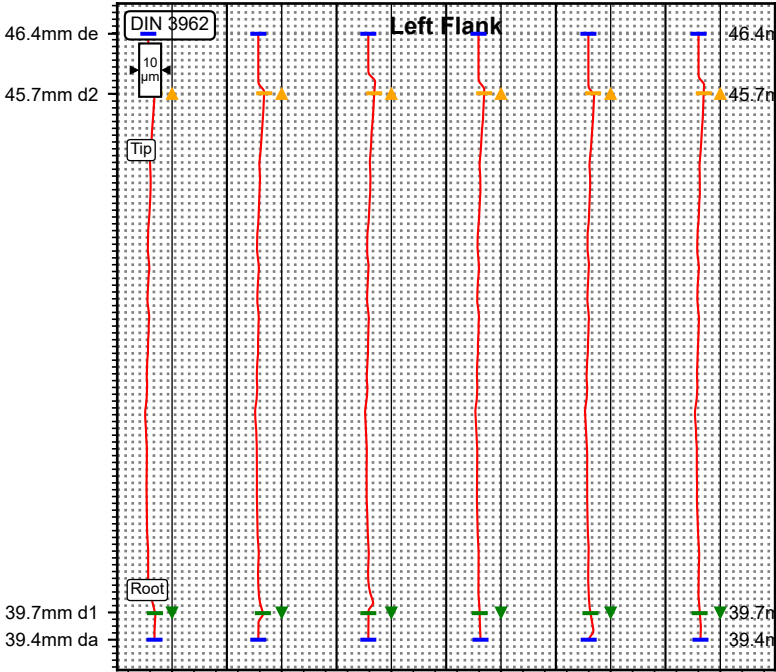
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12
fHam	1.6 1	V 0.7					±11 5	±11 5	-8.5 5	V 1.7				
fHa	1.3	1.4	1.4	1.4	1.9	2.0 1	±11 5	±11 5	-8.6	-8.6	-9.1 5	-8.9	-8.6	-7.4
fa	4.3	4.3	4.5	4.3	4.6	4.8 1	20 5	20 5	10.0	10.0	11.5 4	11.1	10.5	9.8
ffa	3.6	3.6	3.8 1	3.5	3.5	3.7	16 5	16 5	8.0	8.1	9.2 4	9.0	8.3	7.8
Ca	-1.8	-1.7	-1.9	-2.0	-2.1	-2.0			2.0	2.1	1.8	2.0	2.0	1.8



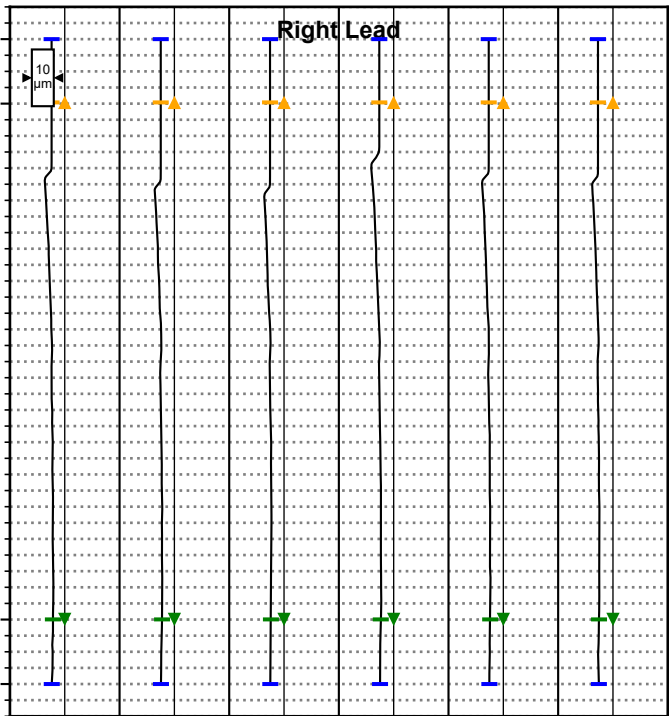
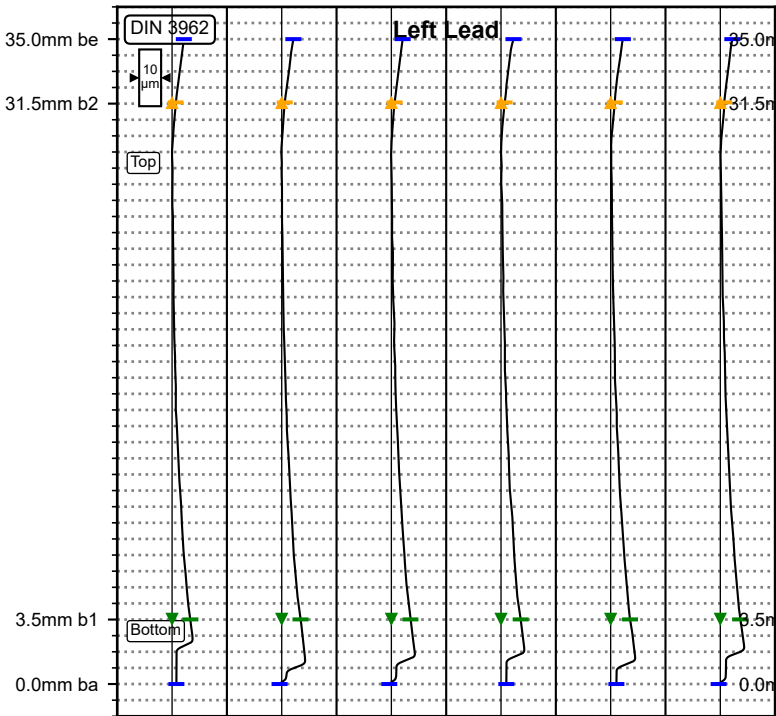
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12
fHbm	-6.3 5	V 1.3					±8 5	±8 5	-1.2 1	V 0.5				
fHb	-6.7	-6.8	-6.0	-7.0 5	-5.8	-5.7	±8 5	±8 5	-1.2	-0.9	-1.3	-0.9	-1.3	-1.4 1
fb	11.7 5	11.3	10.7	11.4	10.4	10.4	12 5	12 5	3.6	3.4	3.8	3.1	3.8	4.1 2
ffb	10.3	10.4	9.4	11.0 6	9.8	9.8	9 5	9 5	3.1	3.1	3.2	2.7	3.3	3.5 2
Cb	-2.8	-2.7	-2.8	-2.9	-2.9	-2.8			-0.0	-0.1	-0.1	-0.4	-0.3	-0.5

Gear Profile/Lead

Prog.No.:		Operator:	R. Romanov	Date:	20.02.25
Type:	CH	No. of teeth:	26	Face Width:	35.00mm
Drawing No.:	20250220-MC-FLY	Module m:	1.440mm	Length Ev. Lα:	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P65	Helix angle:	-25.00°	Appr. Length:	0.32mm
Loc. of check:	KLINGELNBERG	Base Cir.-Ø db:	39.1433mm	Stylus-Ø:	1.000mm
Condition:	BERTA	Base Helix ang:	-23.838°	Add.Mod.Coe:	0.540



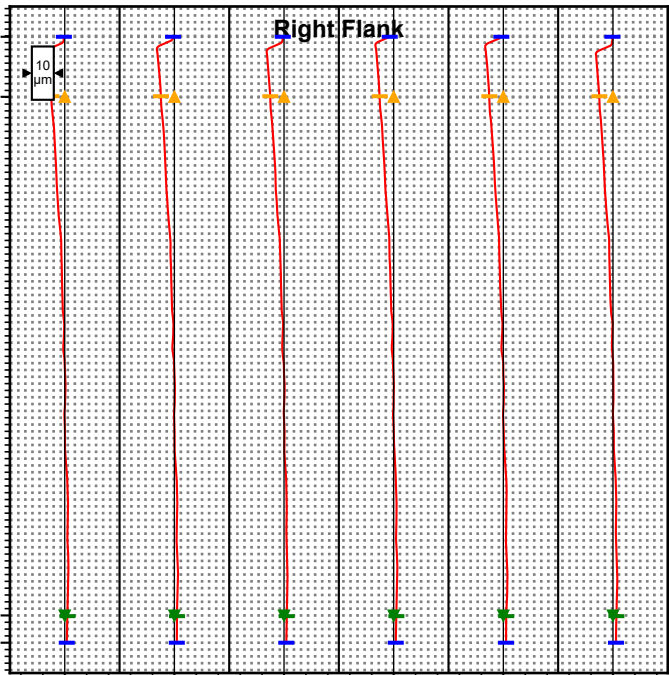
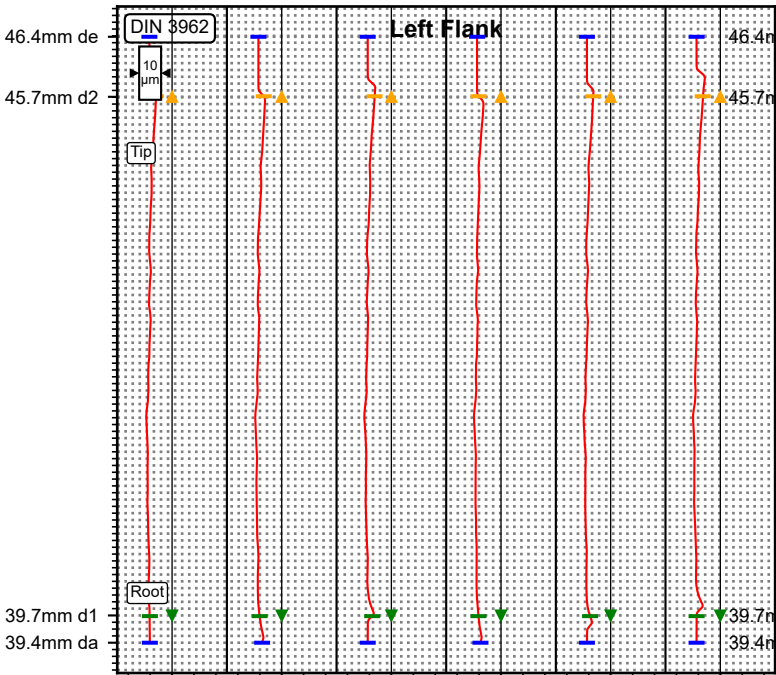
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHam	1.2 1	V 0.7					±11 5	±11 5	-7.8 4	V 1.4				
fHa	0.9	1.2	1.6 1	1.3	1.0	1.2	±11 5	±11 5	-7.3	-7.9	-7.5	-7.7	-7.9	-8.7 5
fa	5.1 2	4.5	5.0	4.5	4.5	4.7	20 5	20 5	9.0	9.9	9.4	9.9	9.8	11.8 4
ffa	5.1	4.9	5.2 2	3.7	4.7	4.0	16 5	16 5	7.4	8.1	7.6	8.1	7.9	9.5 4
Ca	-2.4	-2.1	-2.3	-1.9	-2.1	-2.0			2.1	2.0	2.2	1.9	1.9	1.9



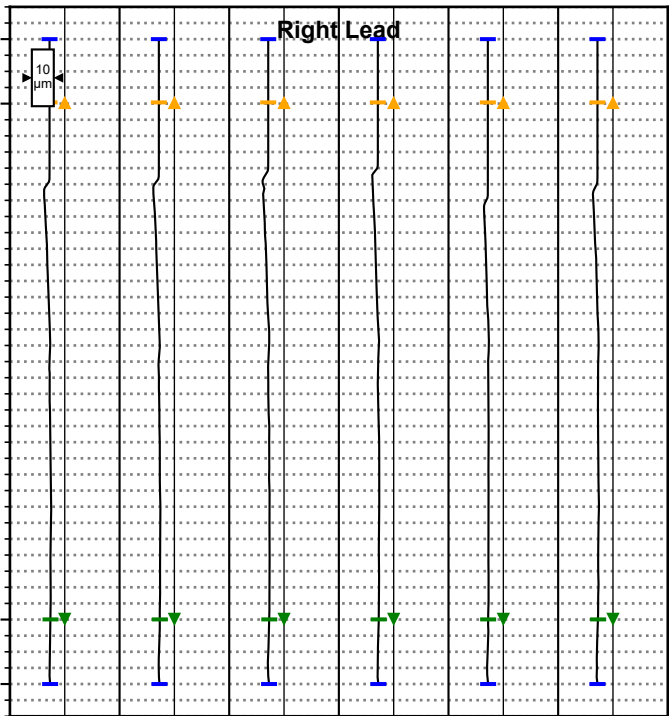
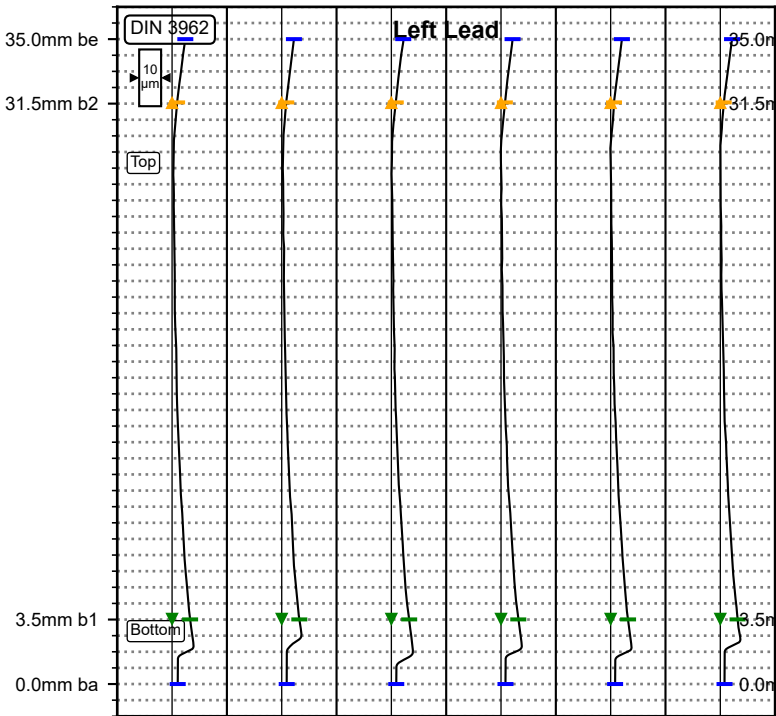
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHbm	-6.4 5	V 2.1					±8 5	±8 5	-1.6 1	V 0.9				
fHb	-5.0	-7.0	-6.7	-6.5	-7.1 5	-6.3	±8 5	±8 5	-1.7	-1.4	-1.2	-2.1 1	-1.7	-1.3
fb	9.8	17.5	17.3	11.0	11.3	17.6 7	12 5	12 5	4.3	3.8	3.6	4.8 2	4.3	3.8
ffb	8.5	19.2 8	18.4	10.5	10.7	18.7	9 5	9 5	3.7	3.3	3.1	4.2 2	3.7	3.1
Cb	-3.1	-3.0	-2.9	-2.8	-3.0	-3.0			-0.5	-0.5	-0.6	-0.3	-0.6	-0.4

Gear Profile/Lead

Prog.No.:		Operator:	R. Romanov	Date:	20.02.25
Type:	CH	No. of teeth:	26	Face Width:	35.00mm
Drawing No.:	20250220-MC-FLY	Module m:	1.440mm	Length Ev. Lα:	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P65	Helix angle:	-25.00°	Appr. Length:	0.32mm
Loc. of check:	KLINGELNBERG	Base Cir.-Ø db:	39.1433mm	Stylus-Ø:	1.000mm
Condition:	BERTA	Base Helix ang:	-23.838°	Add.Mod.Coe:	0.540



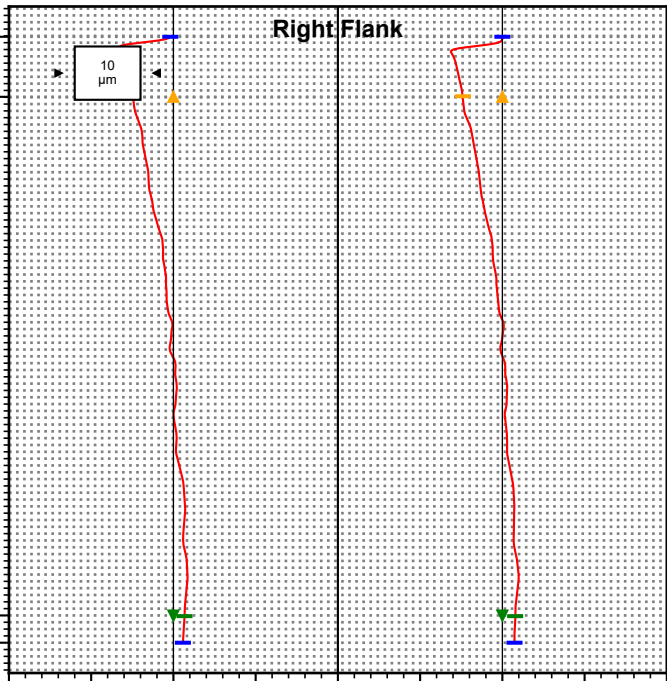
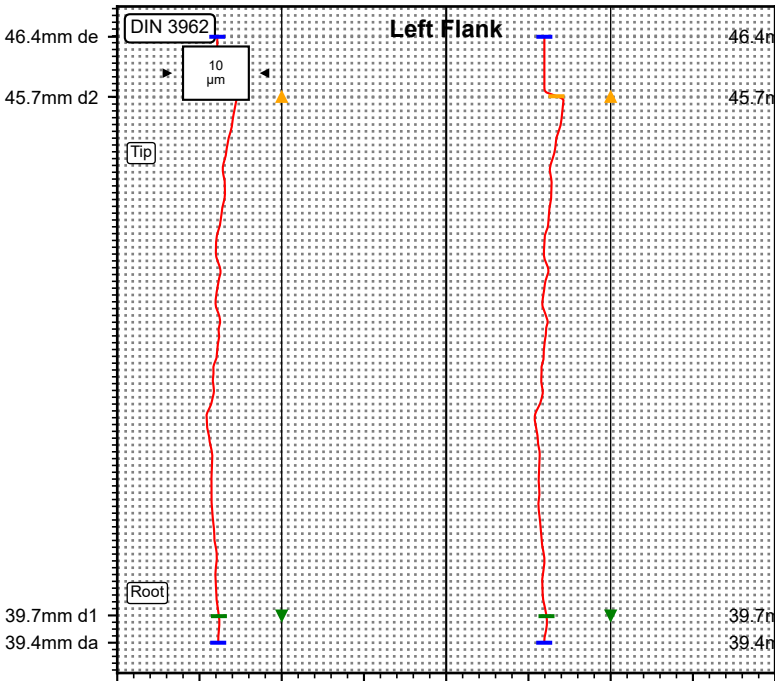
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHam	1.8 1	V 0.9					±11 5	±11 5	-8.8 5	V 0.8				
fHa	1.9	1.6	1.8	1.3	1.7	2.2 1	±11 5	±11 5	-8.5	-8.7	-8.6	-9.2	-9.3 5	-8.8
fa	4.6	4.8	5.5	4.5	4.8	5.9 2	20 5	20 5	10.2	10.7	10.6	11.2 4	11.1	10.7
ffa	3.6	4.9	6.1	4.5	5.3	6.3 3	16 5	16 5	8.2	8.5	8.5	9.0 4	8.8	8.6
Ca	-1.8	-2.0	-2.6	-1.9	-2.0	-2.3			2.0	1.9	2.0	2.0	2.0	2.0



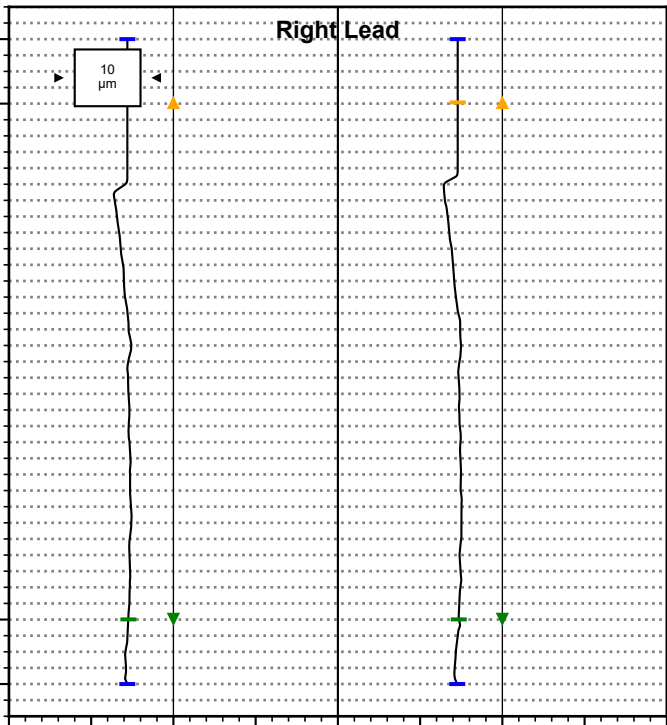
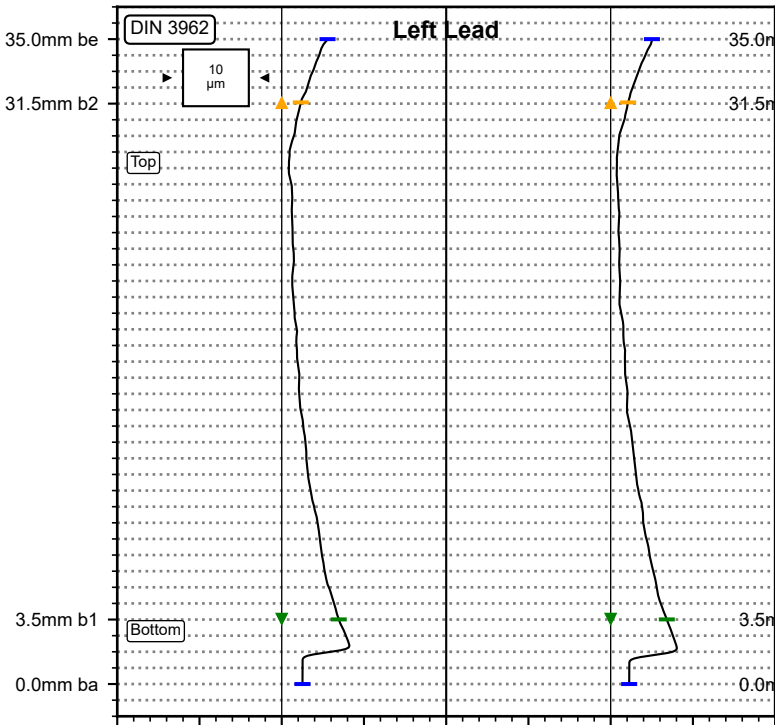
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHbm	-5.0 4	V 1.4					±8 5	±8 5	-1.1 1	V 0.7				
fHb	-4.9	-4.2	-5.6 4	-5.2	-5.4	-4.8	±8 5	±8 5	-1.2	-1.2	-1.3 1	-1.3 1	-0.6	-0.7
fb	9.7	9.1	10.4 5	10.2	10.2	9.7	12 5	12 5	4.3 2	3.6	4.2	4.0	2.7	3.2
ffb	8.4	7.8	8.9 5	8.5	8.6	8.6	9 5	9 5	3.9 2	3.0	3.9 2	3.3	2.3	2.8
Cb	-2.9	-2.9	-2.9	-2.9	-2.9	-2.9			-0.4	-0.4	-0.2	-0.1	-0.2	-0.0

Gear Profile/Lead

Prog.No.:		Operator:	R. Romanov	Date:	20.02.25
Type:	CH	No. of teeth:	26	Face Width:	35.00mm
Drawing No.:	20250220-MC-FLY	Module m:	1.440mm	Length Ev. Lα:	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. Lβ:	28.00mm
Cust./Mach. N:	P65	Helix angle:	-25.00°	Appr. Length:	0.32mm
Loc. of check:	KLINGELNBERG	Base Cir.-Ø db:	39.1433mm	Stylus-Ø:	1.000mm
Condition:	BERTA	Base Helix ang:	-23.838°	Add.Mod.Coe:	0.540



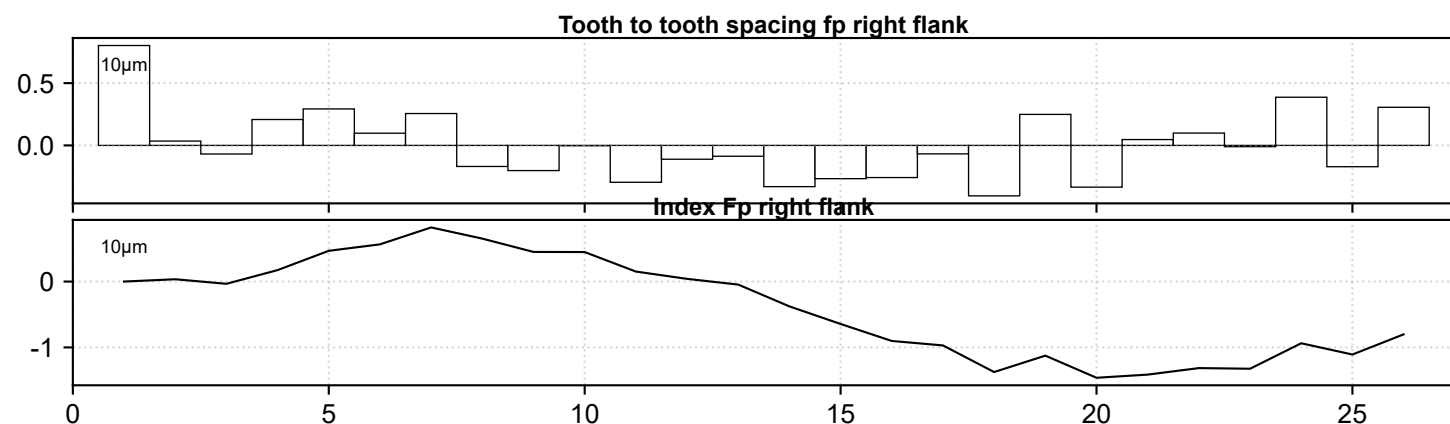
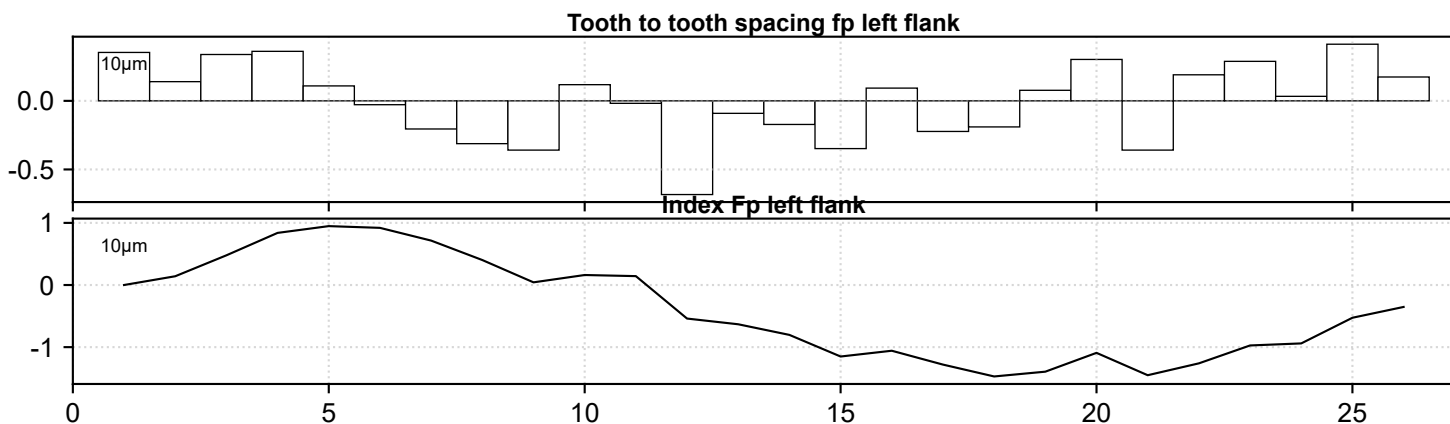
0.	26	25	Lim.value Qual.	Lim.value Qual.	25	26	50
fHam	1.9 1	V 0.1	±11 5	±11 5	-9.2 5	V 0.2	
fHa	2.0 1	1.9	±11 5	±11 5	-9.3 5	-9.1	
fa	5.0 1	4.6	20 5	20 5	11.9 4	11.5	
ffa	3.9 1	3.6	16 5	16 5	9.5 4	9.1	
Ca	-1.9	-1.9			1.9	2.0	



0.	26	25	Lim.value Qual.	Lim.value Qual.	25	26	50
fHbm	-4.8 4	V 0.3	±8 5	±8 5	-0.8 1	V 0.0	
fHb	-4.7	-5.0 4	±8 5	±8 5	-0.8 1	-0.8 1	
fb	9.7 4	9.6	12 5	12 5	3.0	3.1 2	
ffb	9.2 6	8.5	9 5	9 5	2.8 2	2.7	
Cb	-2.9	-2.9			-0.1	0.0	

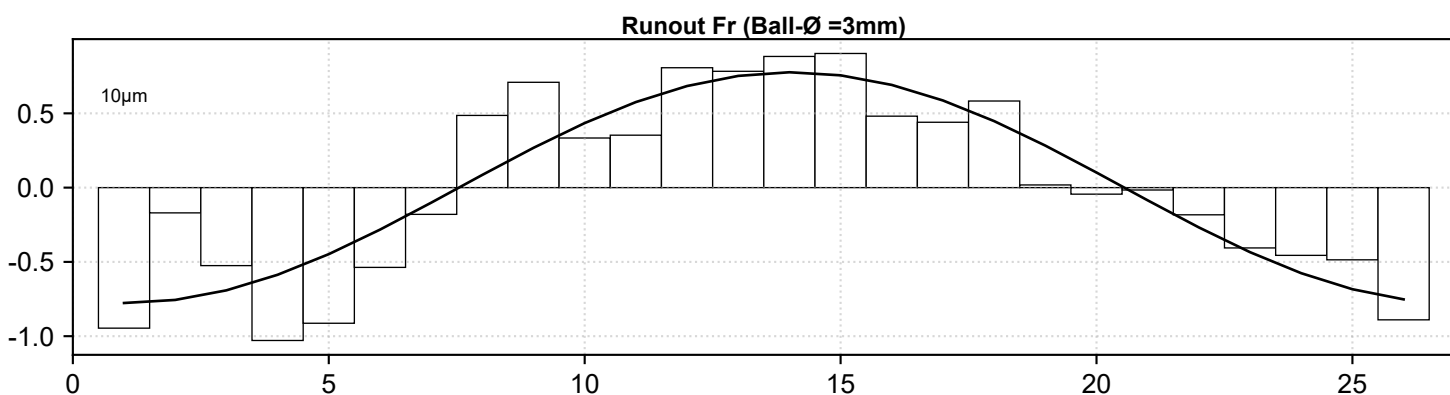
## Gear Spacing

<b>Prog.No.:</b>		<b>Operator:</b>	R. Romanov	<b>Date:</b>	20.02.25
<b>Type:</b>	CH	<b>No. of teeth:</b>	26	<b>Pressure angle:</b>	17°
<b>Drawing No.:</b>	20250220-MC-FLY	<b>Module m:</b>	1.44mm	<b>Helix angle:</b>	-25°
<b>Order No.:</b>	1	<b>Loc. of check:</b>	KLINGELNBERG		
<b>Cust./Mach. No.:</b>	P65	<b>Condition:</b>	BERTA		



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	0.7		12 5	0.8		12 5
Worst spacing deviation fu max	0.7			0.8		
Range of Pitch Error Rp	1.1			1.2		
Total cum. pitch dev. Fp	2.4		36 5	2.3		36 5
Cum. pitch deviation Fp10	2.4			2.1		



							MdK 47.347[mm]/Ball-Ø 1		
Pitch Line Runout	Fr	1.9				Lim.value	47.393	47.301	
Variation of tooth thickness	Rs					Act.	46.207	47.348	45.110