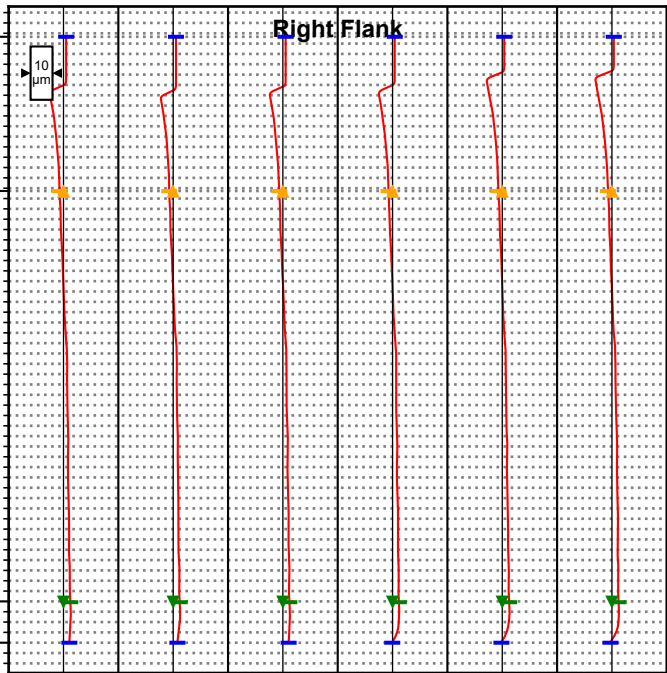
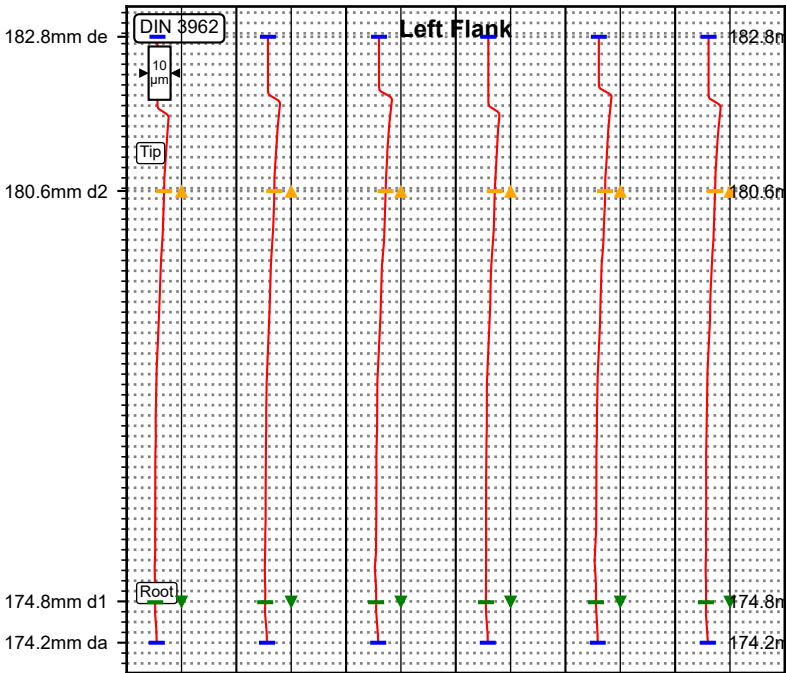
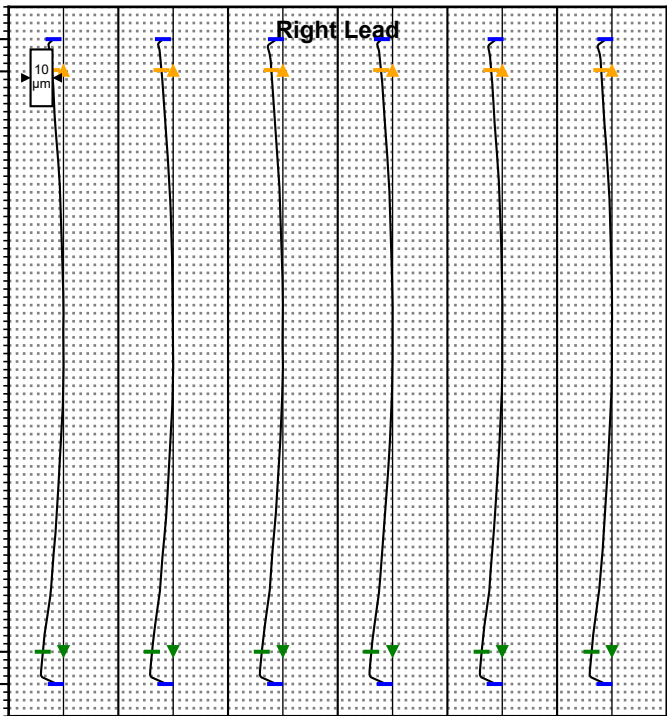
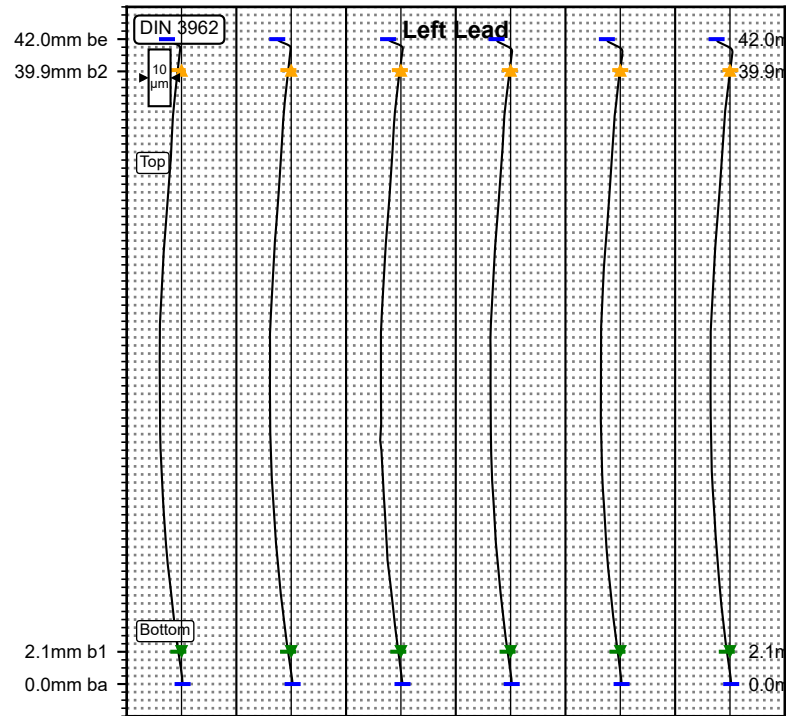


Gear Profile/Lead

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 α :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L β :	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



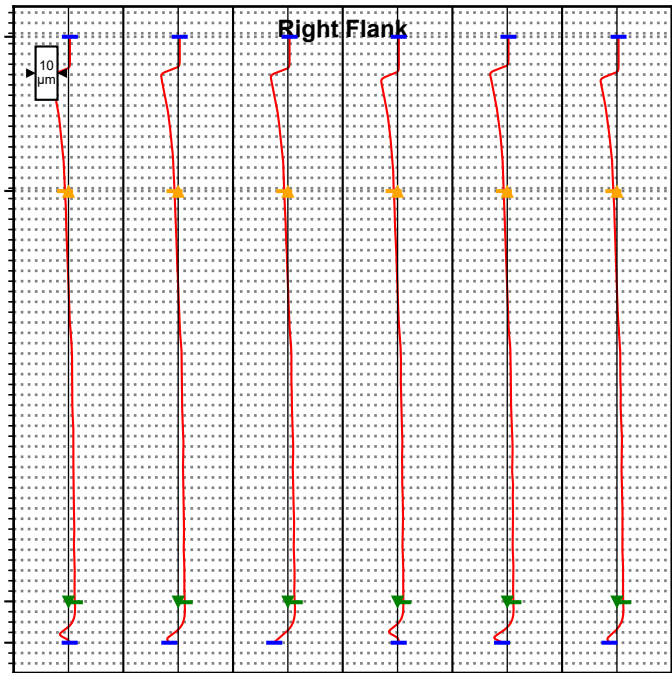
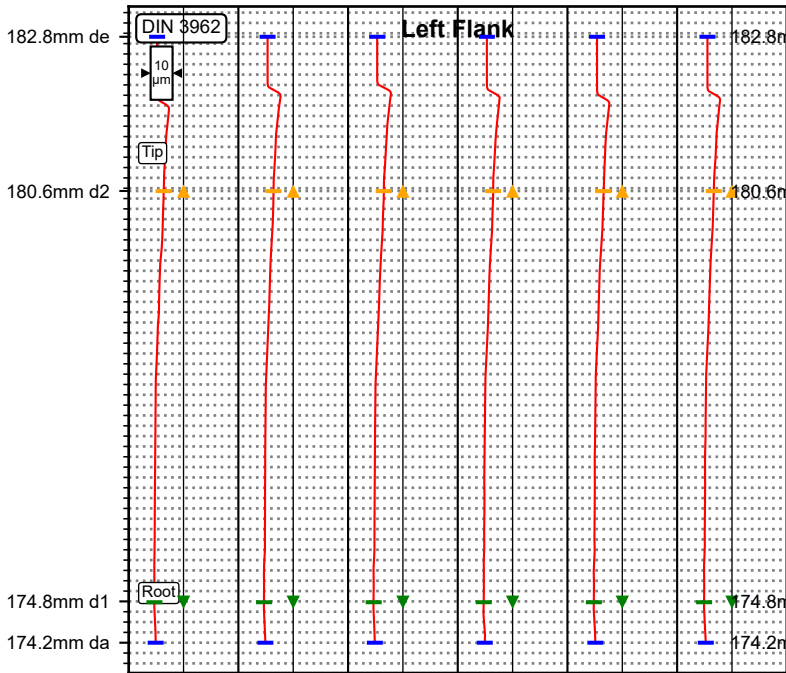
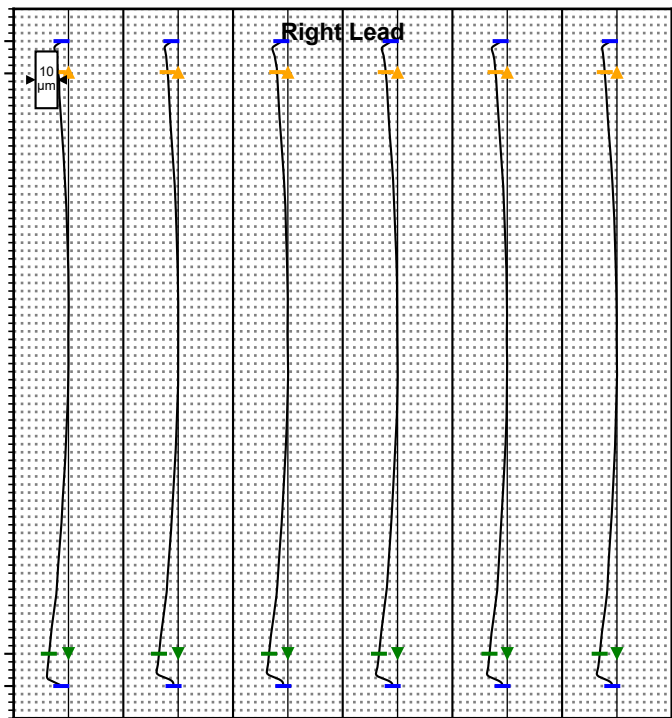
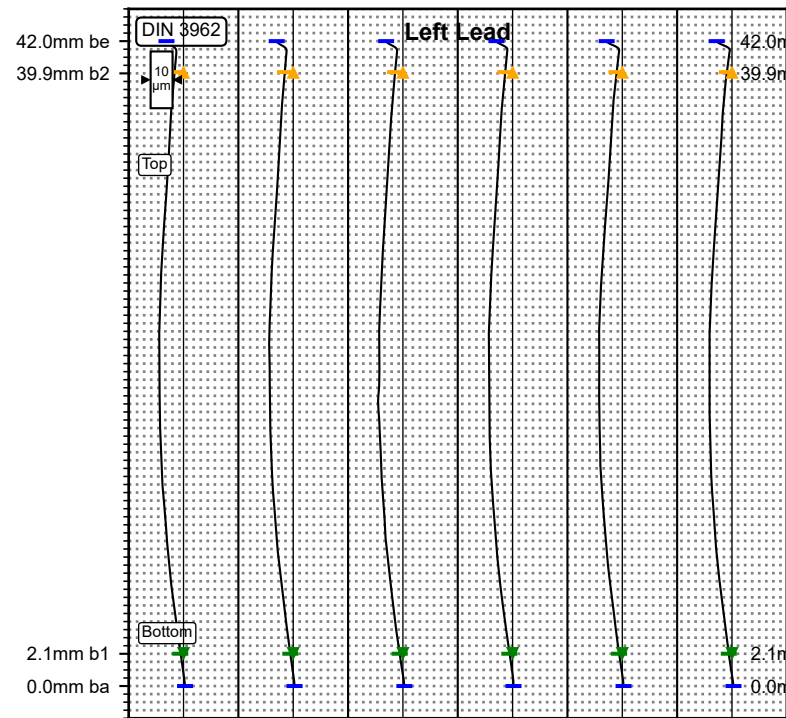
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fHam							±11 5		±11 5						
fHa							±11 5		±11 5						
fa							20 5		20 5						
ffa							16 5		16 5						
Ca	-1.6	-1.6	-1.7	-1.5	-1.7						1.3	1.3	1.2	1.4	1.1



	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	-8.3	-8.2	-8.2	-8.1	-8.0						7.4	7.4	7.4	7.4	7.2

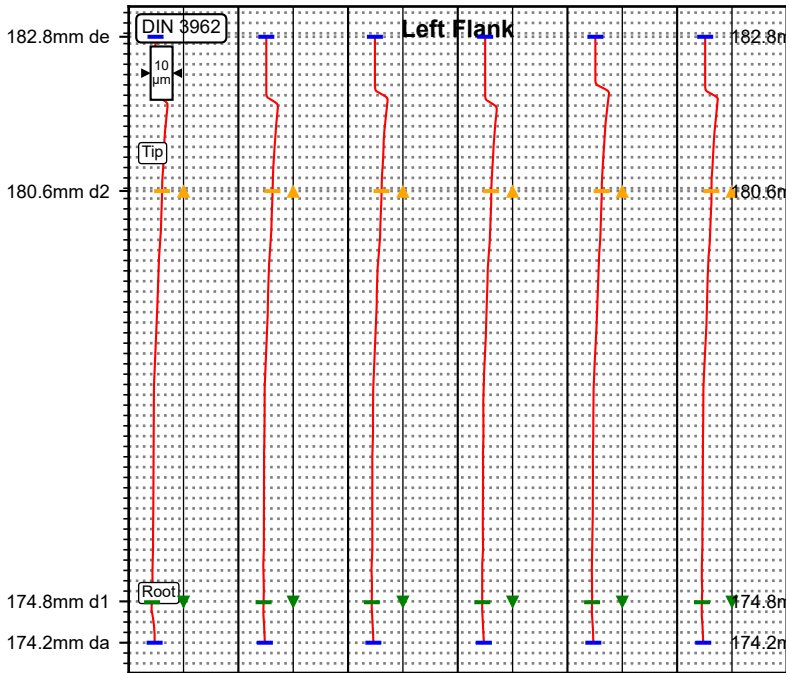
Gear Profile/Lead

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

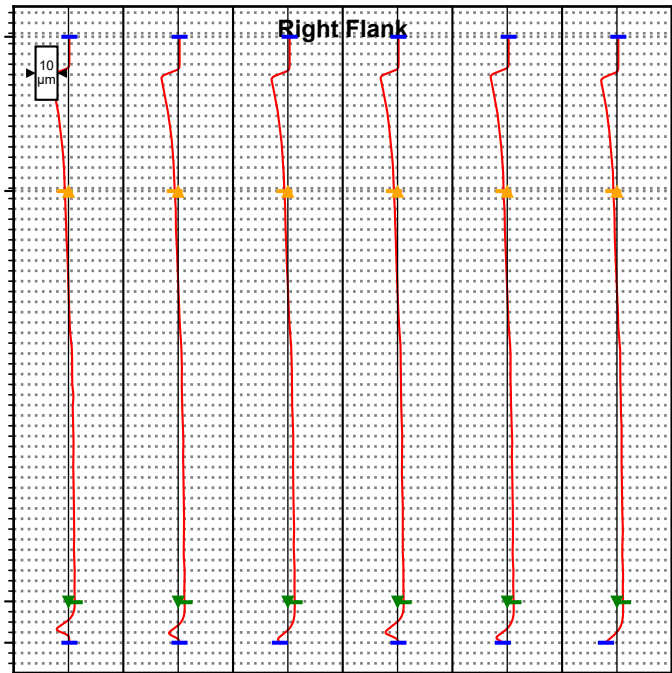
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Gear Profile/Lead

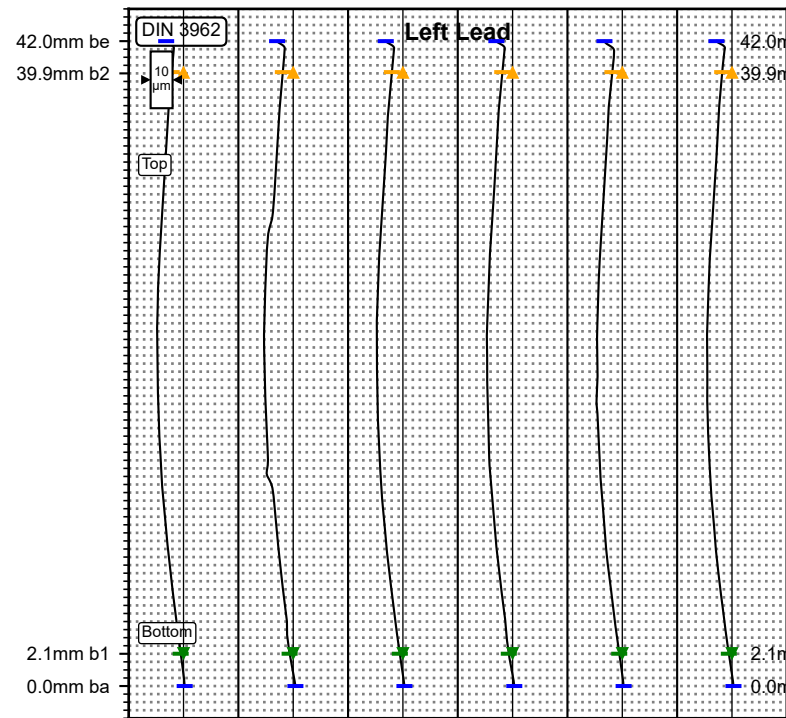
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Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. Lα:	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. Lβ:	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	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



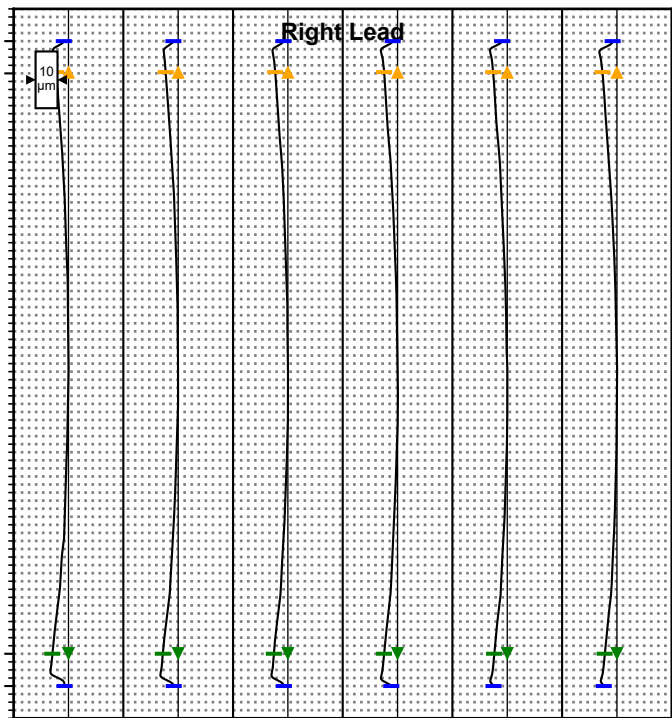
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fHam							±11 5
fHa							±11 5
fa							20 5
ffa							16 5
Ca							



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



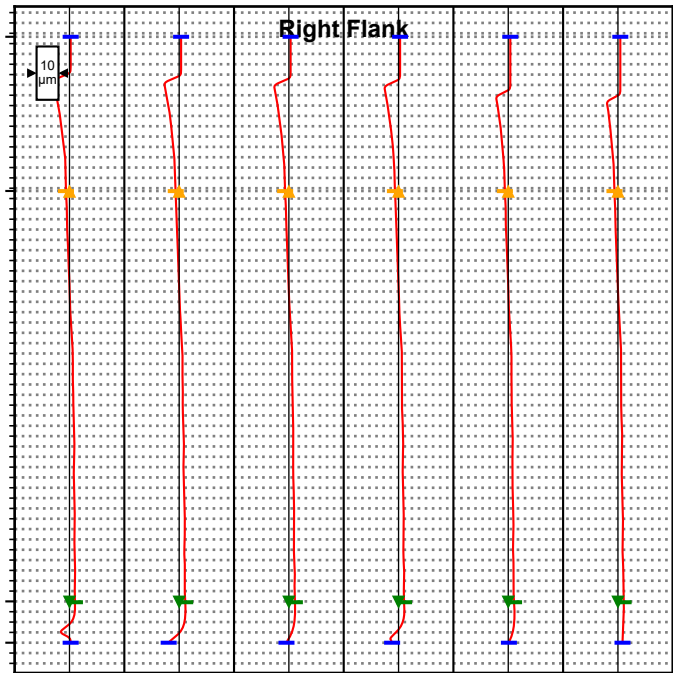
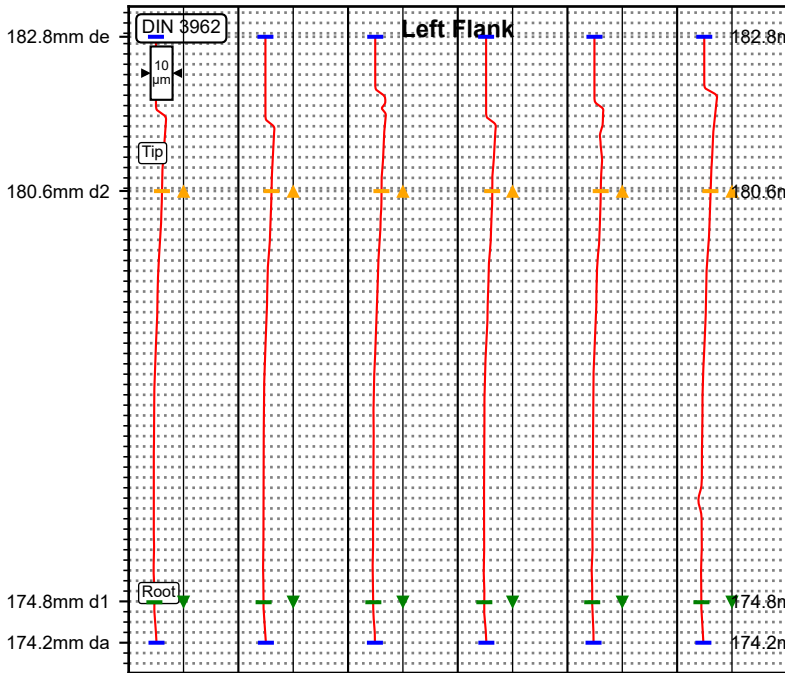
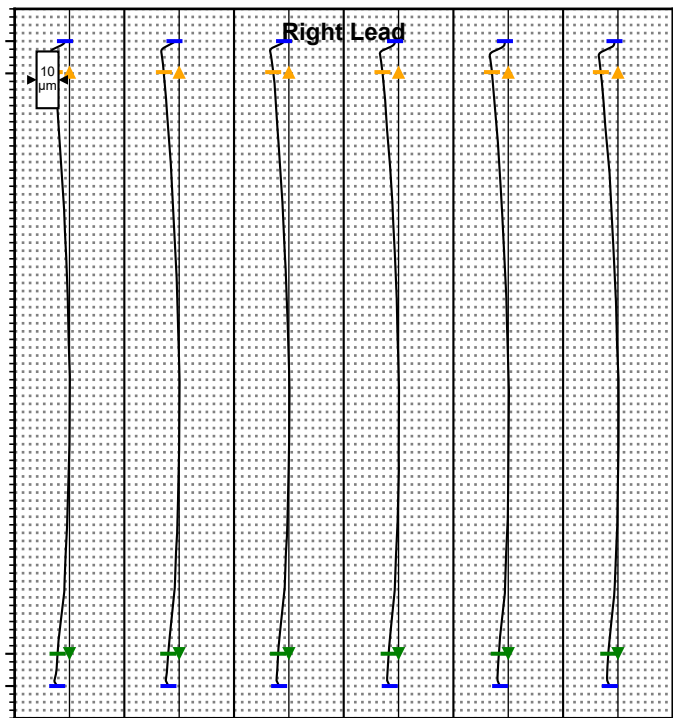
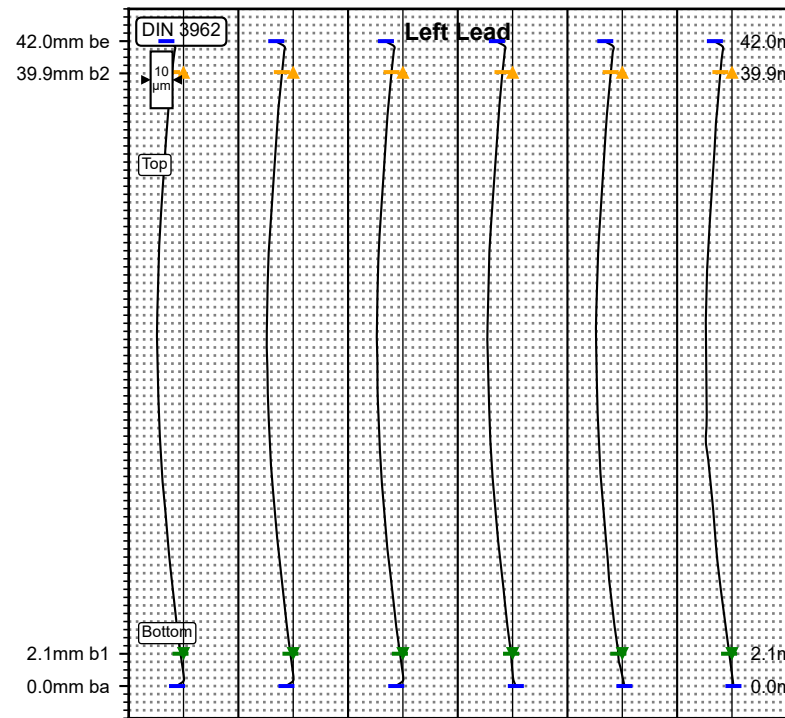
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fHbm							±8 5
fHb							±8 5
fb							12 5
ffb							9 5
Cb							



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

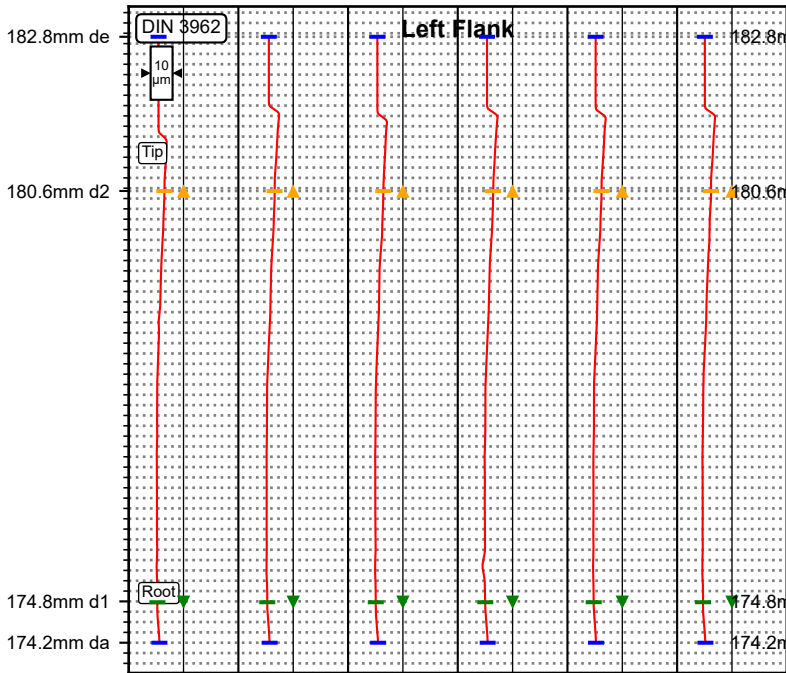
Gear Profile/Lead

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

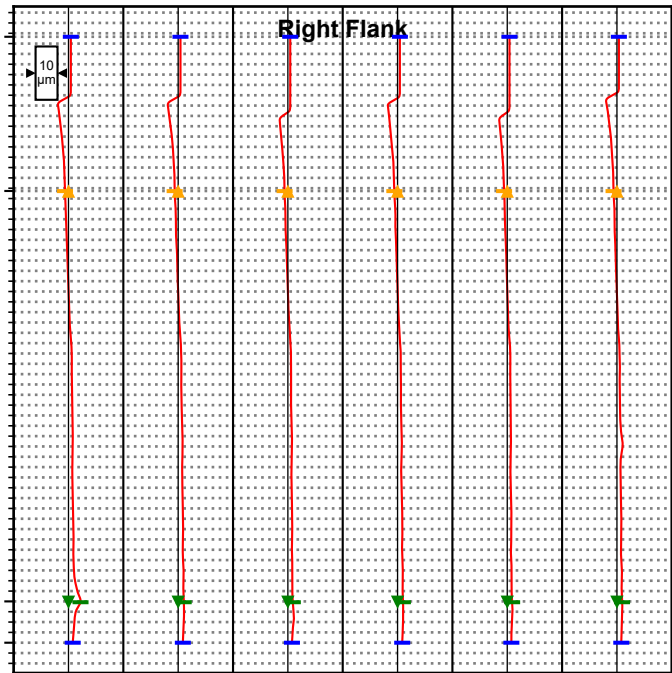
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Gear Profile/Lead

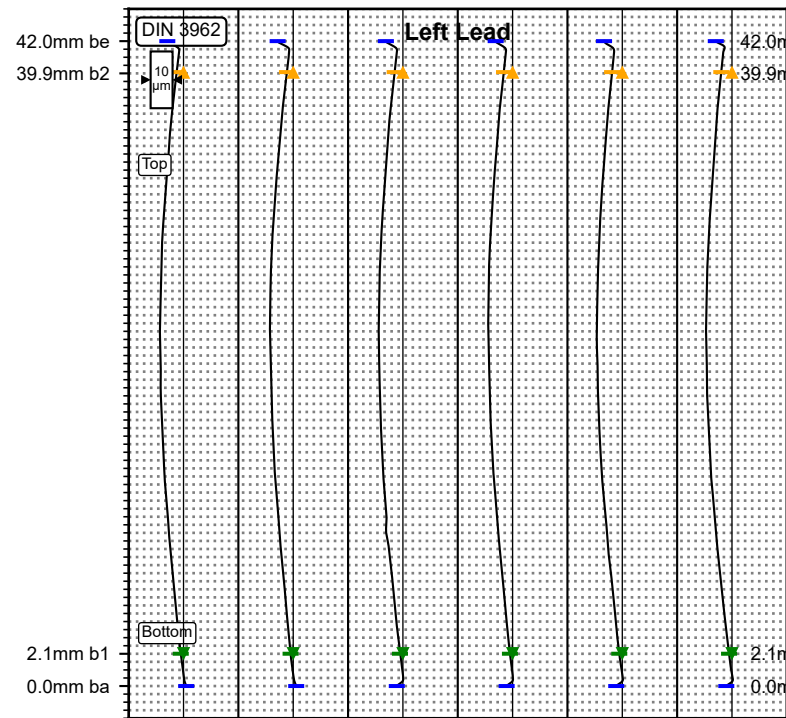
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Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. Lα:	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. Lβ:	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	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



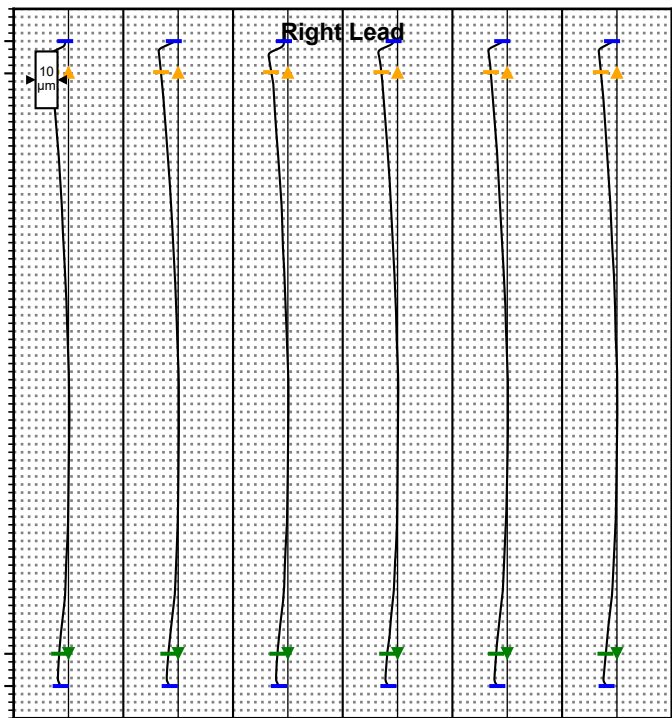
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fHam							±11 5
fHa							±11 5
fa							20 5
ffa							16 5
Ca							



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



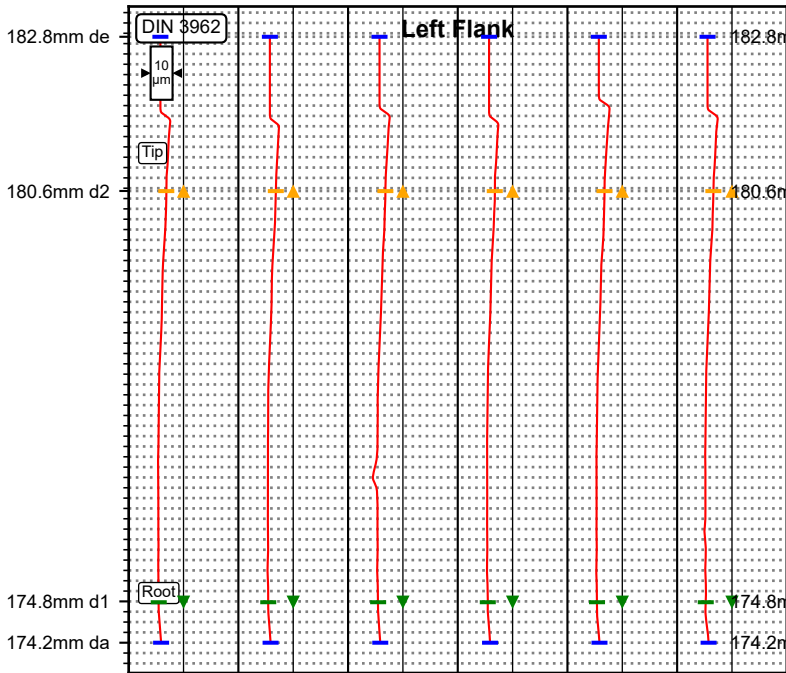
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fHbm							±8 5
fHb							±8 5
fb							12 5
ffb							9 5
Cb							



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

Gear Profile/Lead

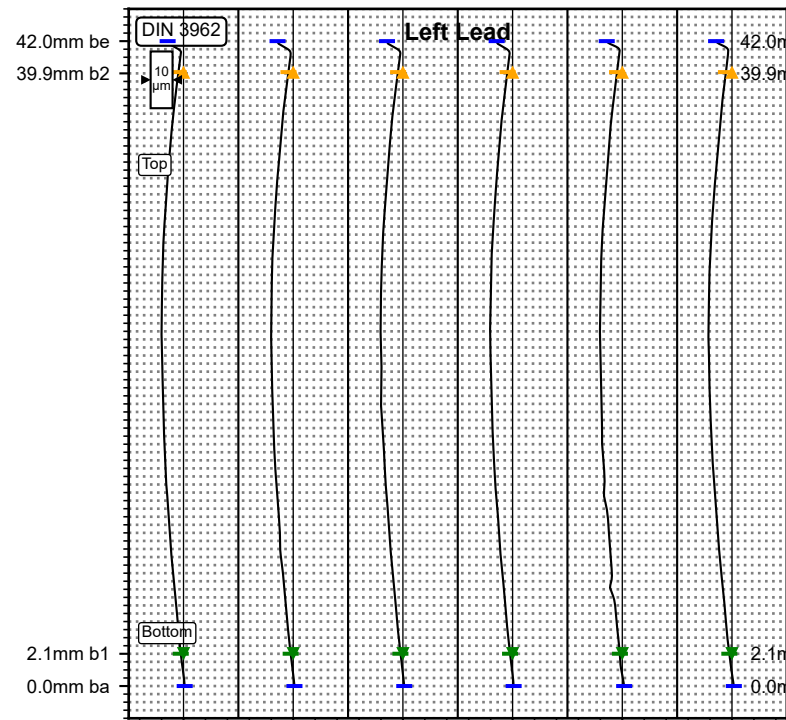
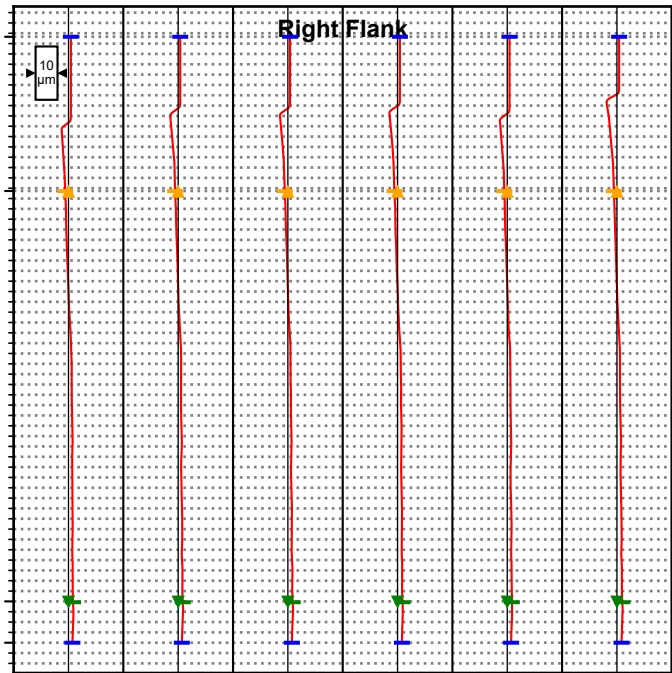
Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. Lα:	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. Lβ:	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	0.58mm
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



	6	5	4	3	2	1
fHam						
fHa						
fa						
ffa						
Ca						

Lim.value Qual.
±11 5
±11 5
20 5
16 5

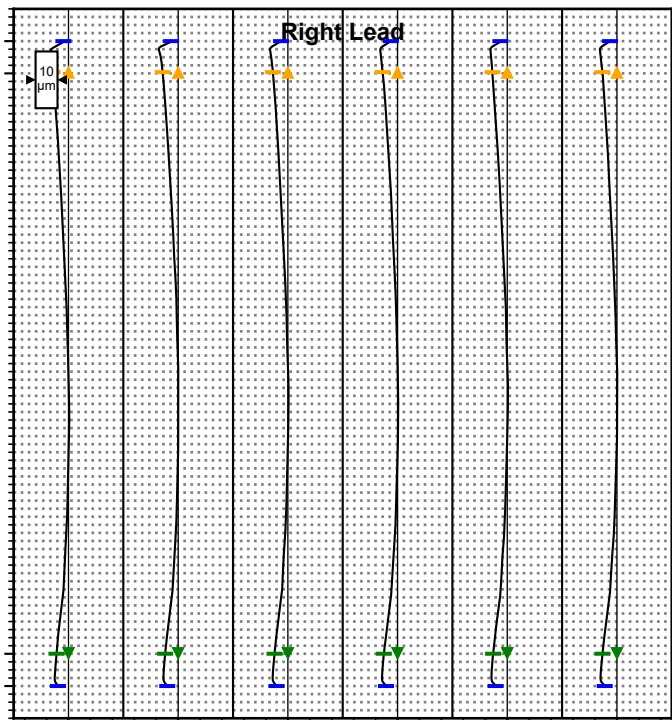
Lim.value Qual.	1	2	3	4	5	6
±11 5						
±11 5						
20 5						
16 5						



	6	5	4	3	2	1
fHbm						
fHb						
fb						
ffb						
Cb						

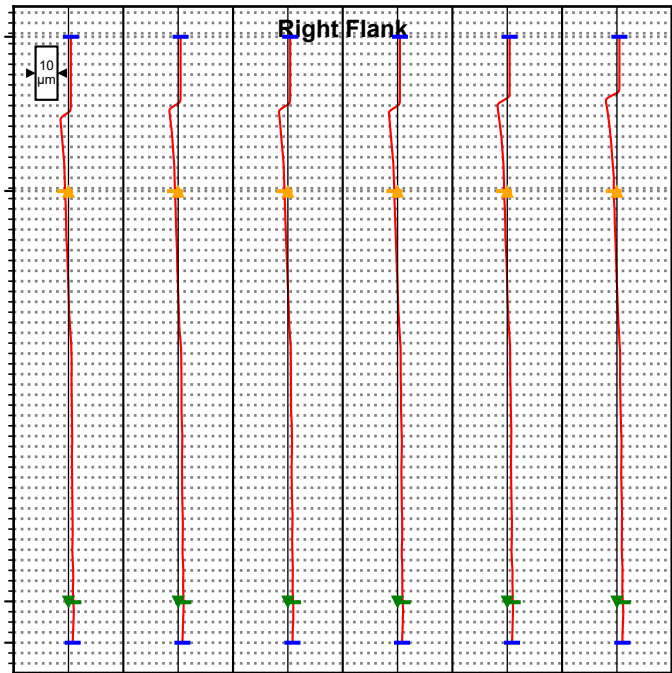
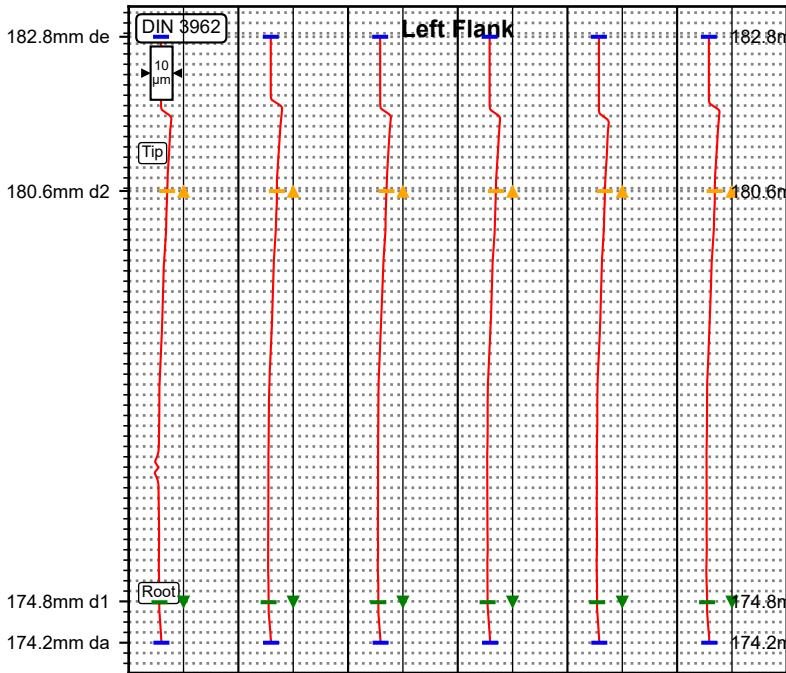
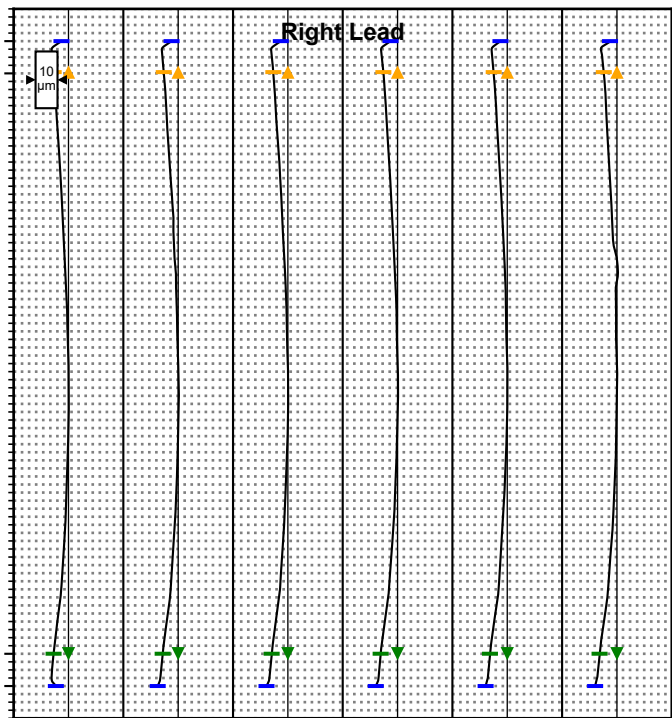
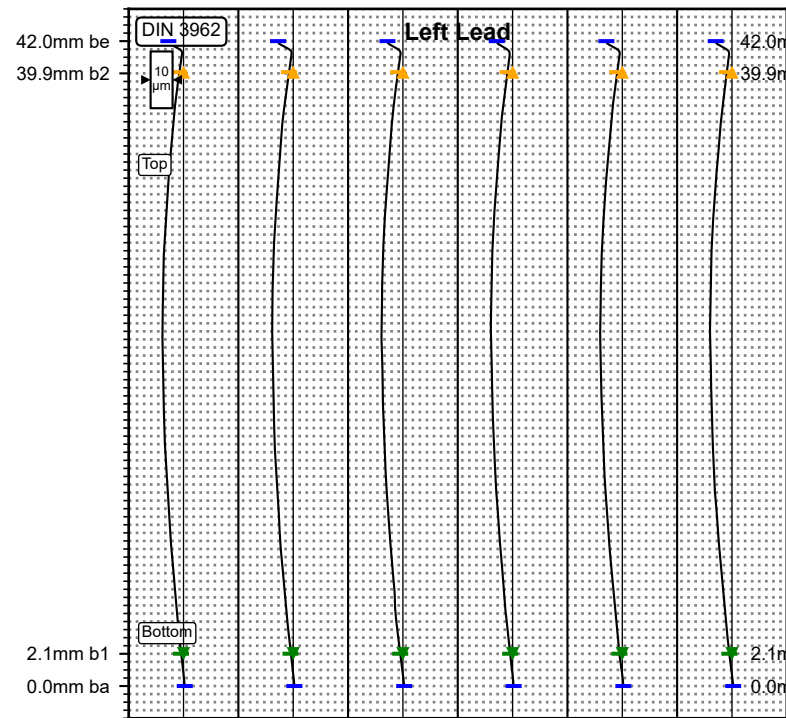
Lim.value Qual.
±8 5
±8 5
12 5
9 5

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



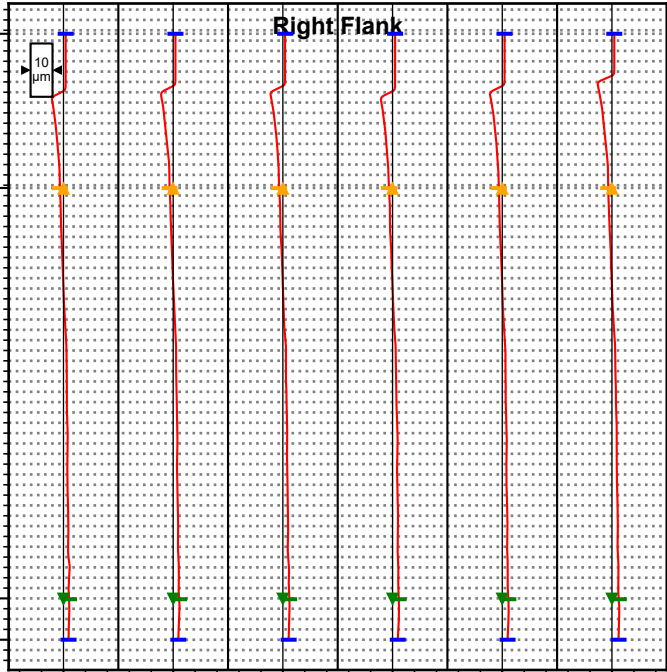
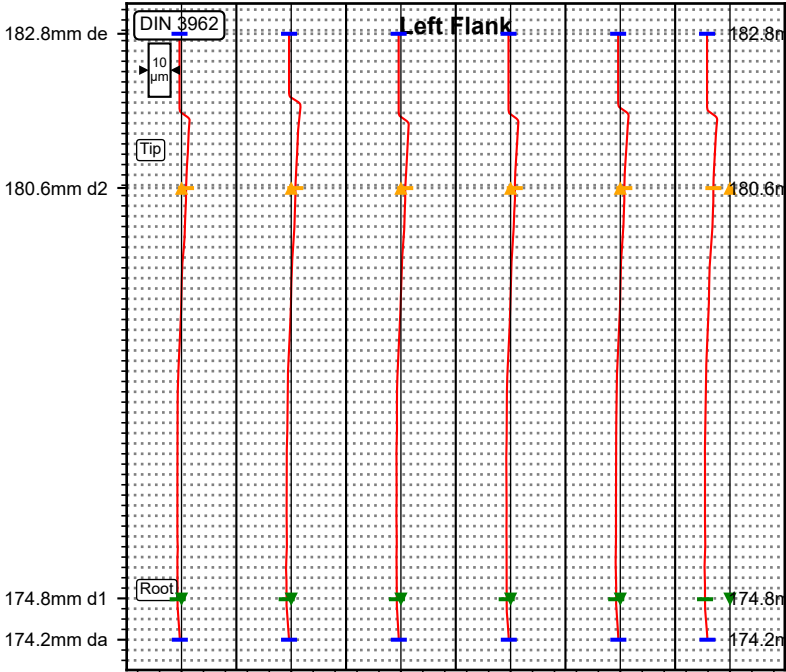
Gear Profile/Lead

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

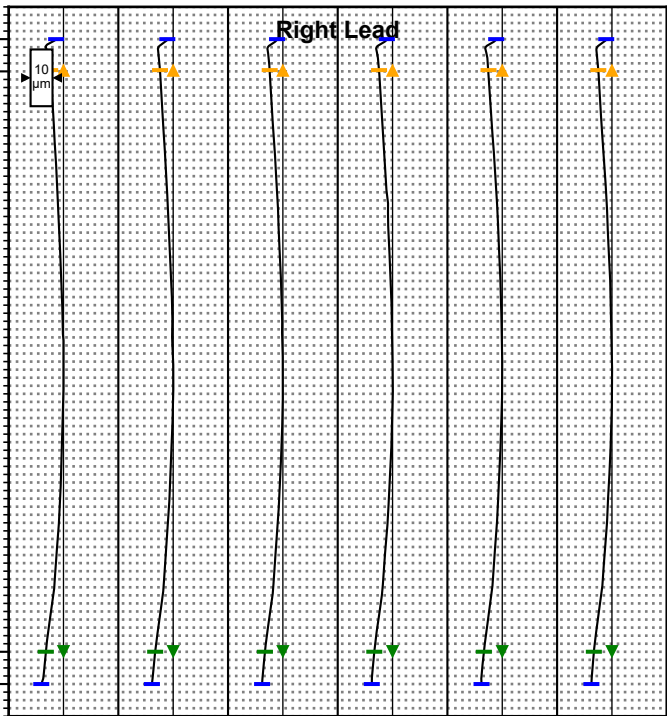
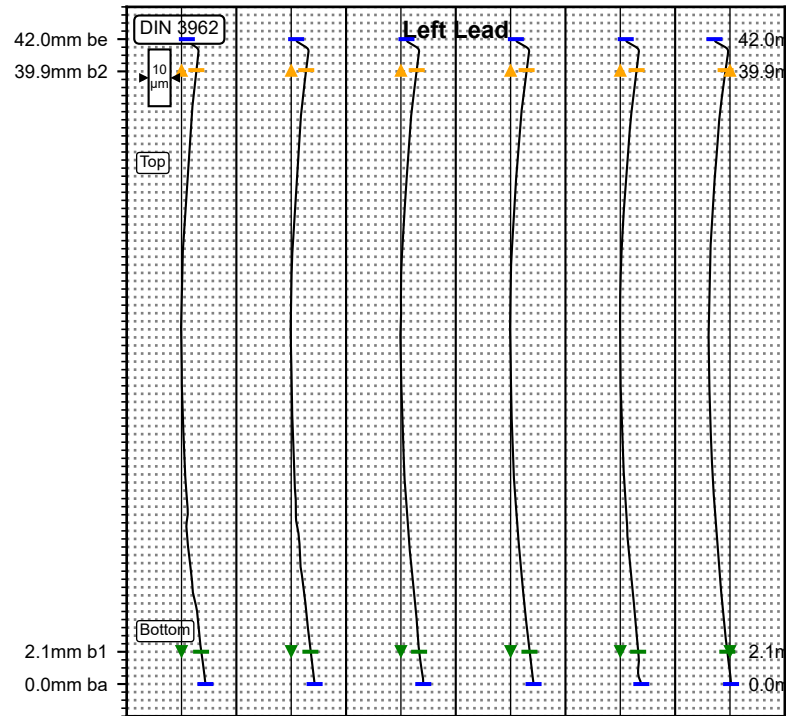
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Gear Profile/Lead

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 α :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L β :	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



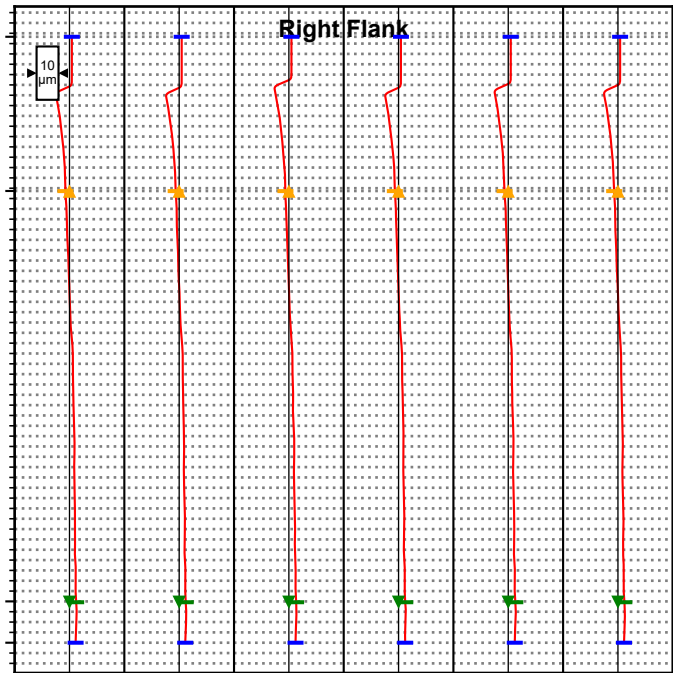
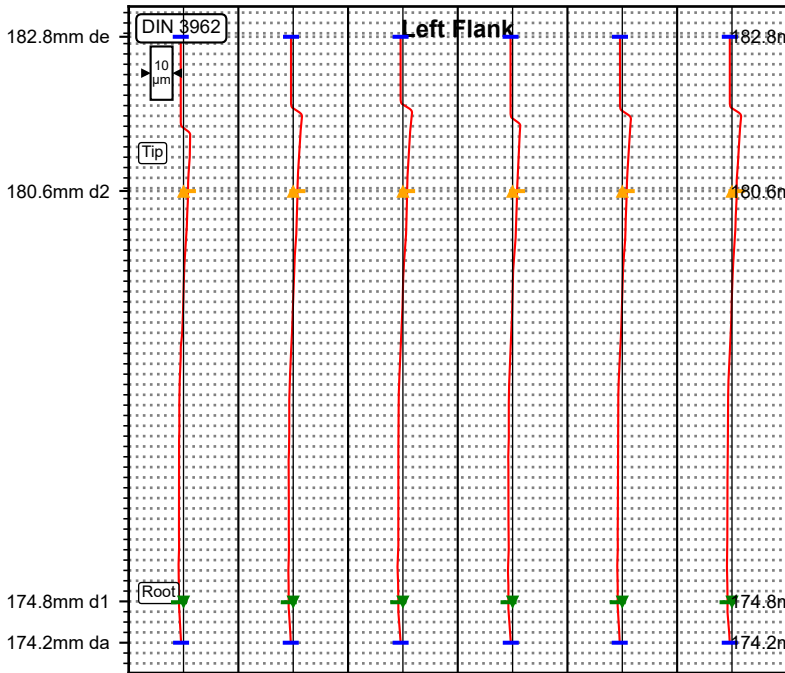
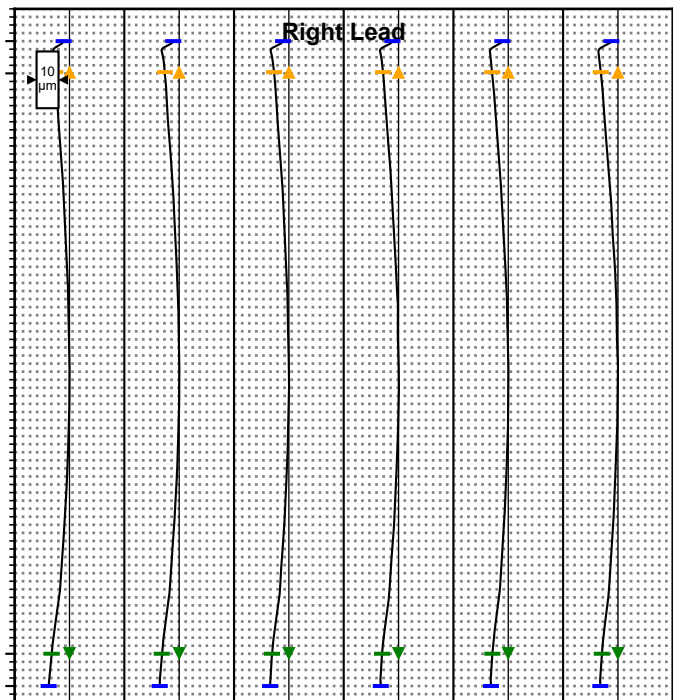
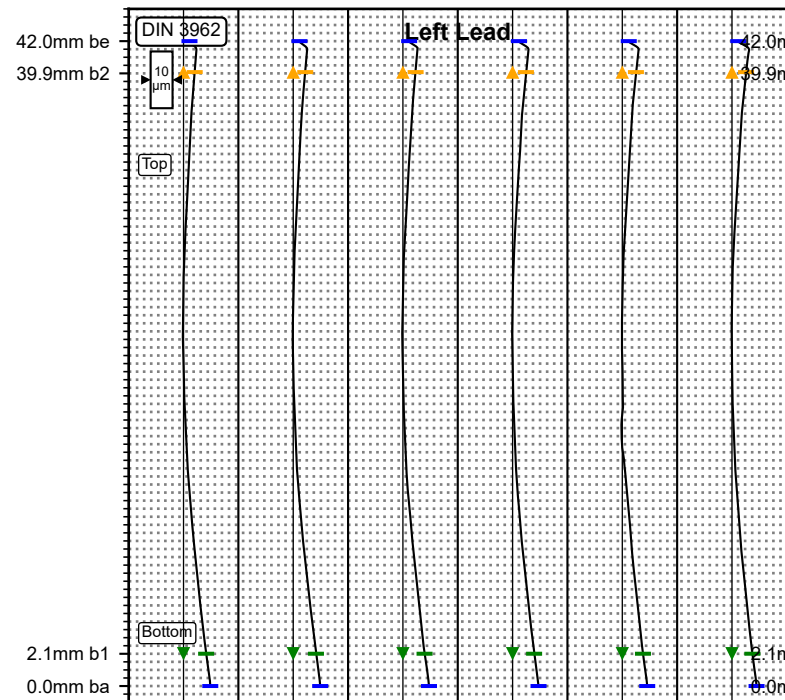
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fHam							±11 5			±11 5								
fHa							±11 5			±11 5								
fa							20 5			20 5								
ffa							16 5			16 5								
Ca																		



	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																		

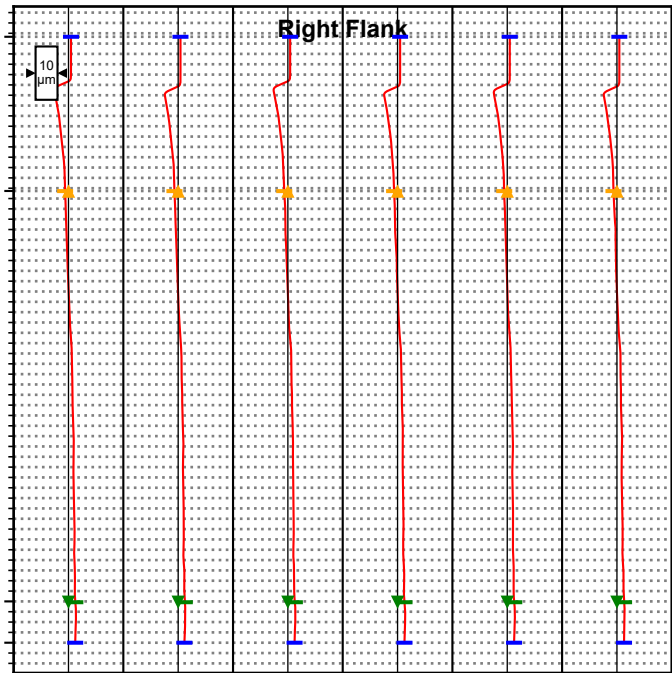
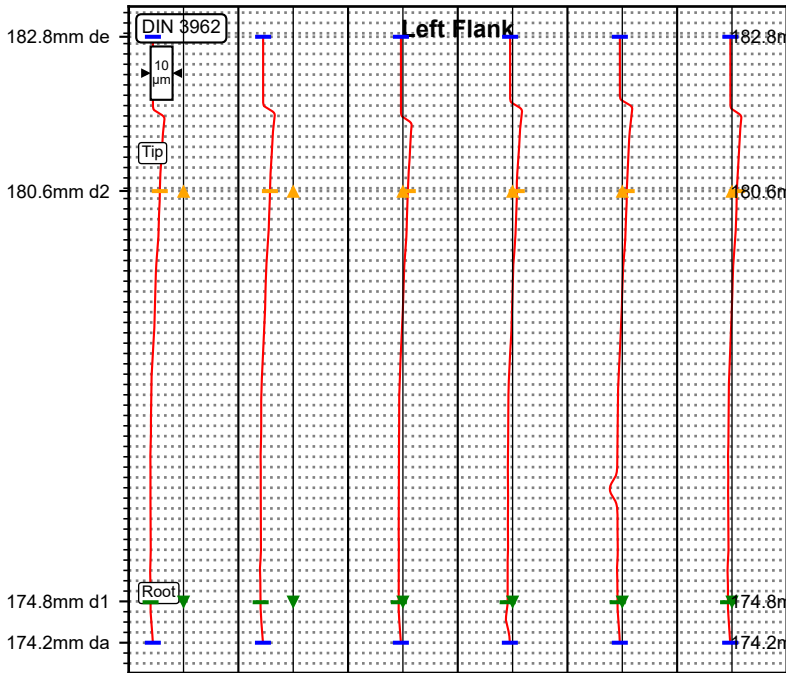
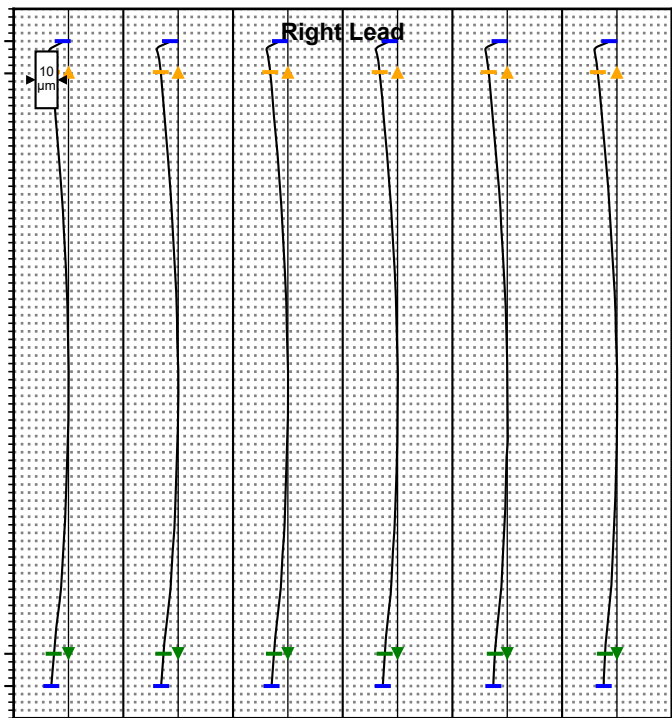
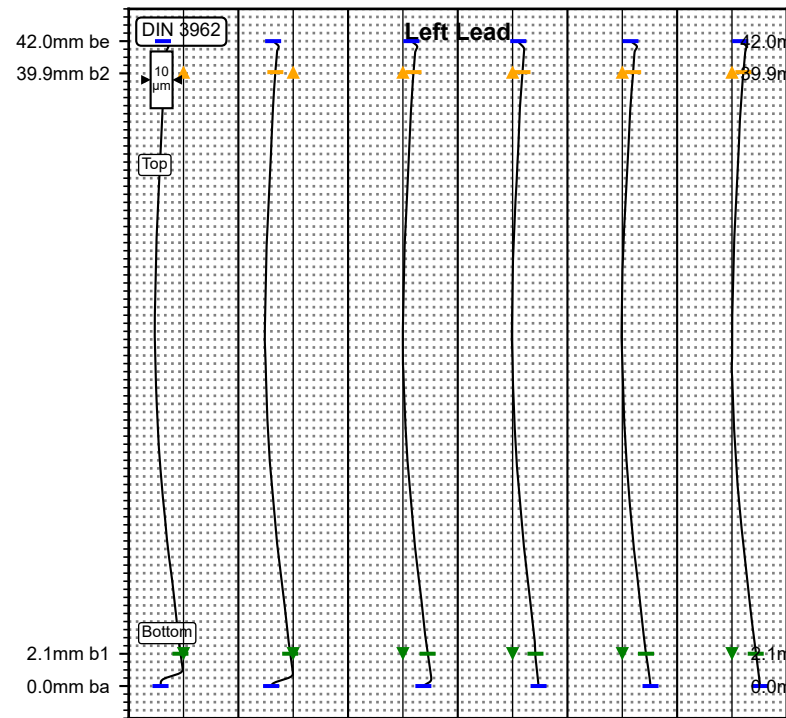
Gear Profile/Lead

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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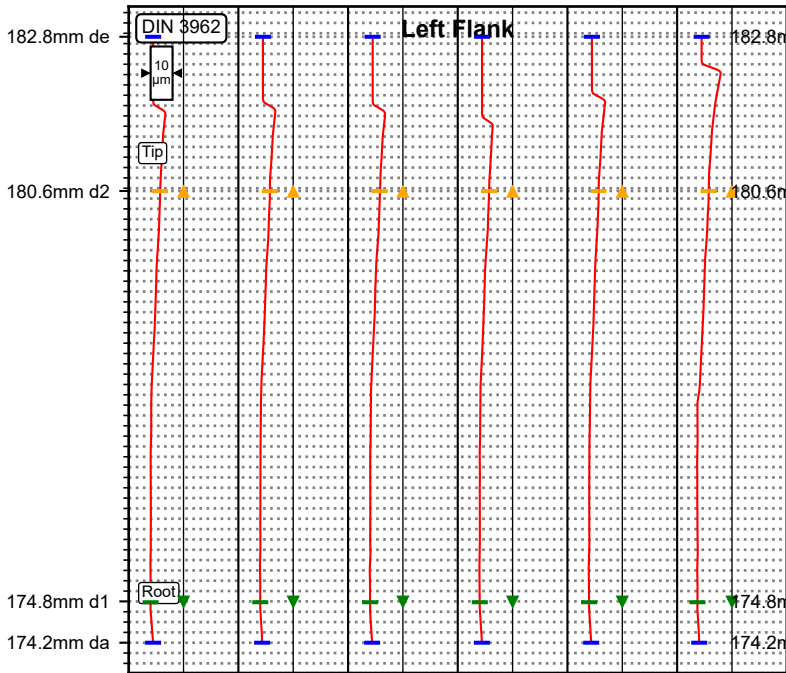
Gear Profile/Lead

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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Gear Profile/Lead

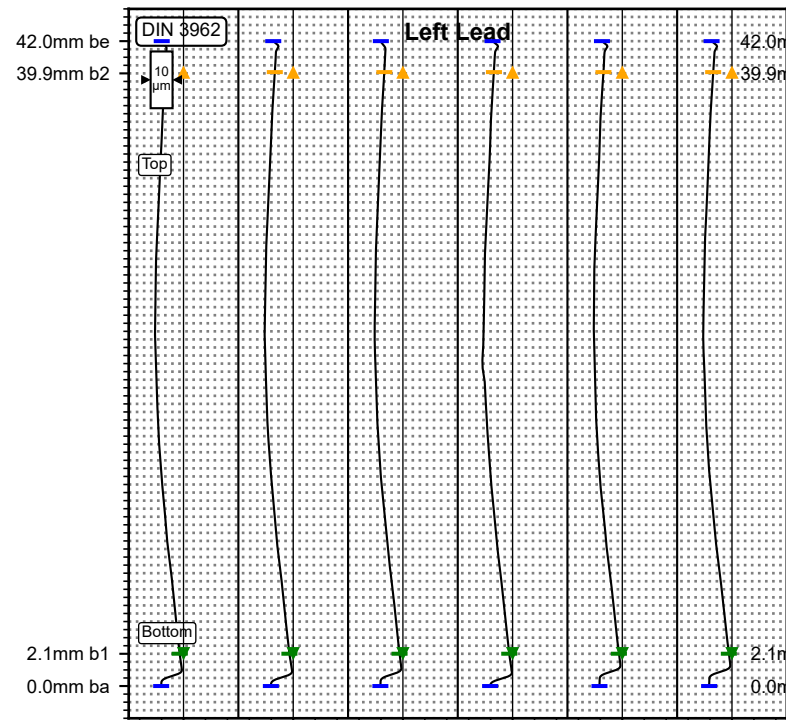
Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. Lα:	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. Lβ:	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°	Appr. Length:	0.58mm
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



	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						



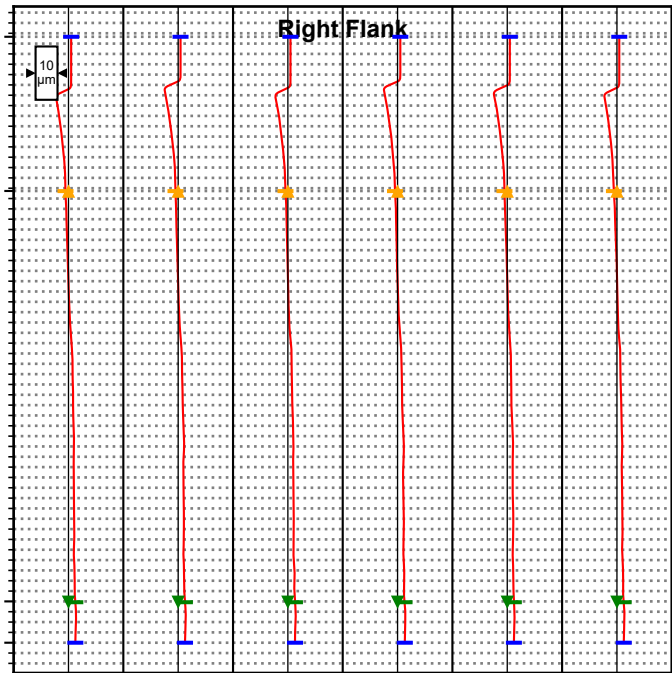
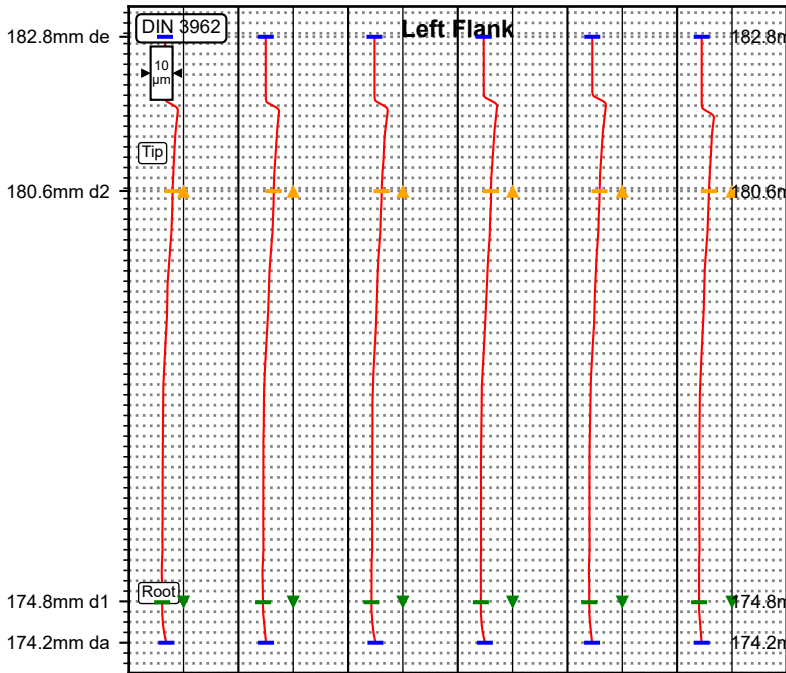
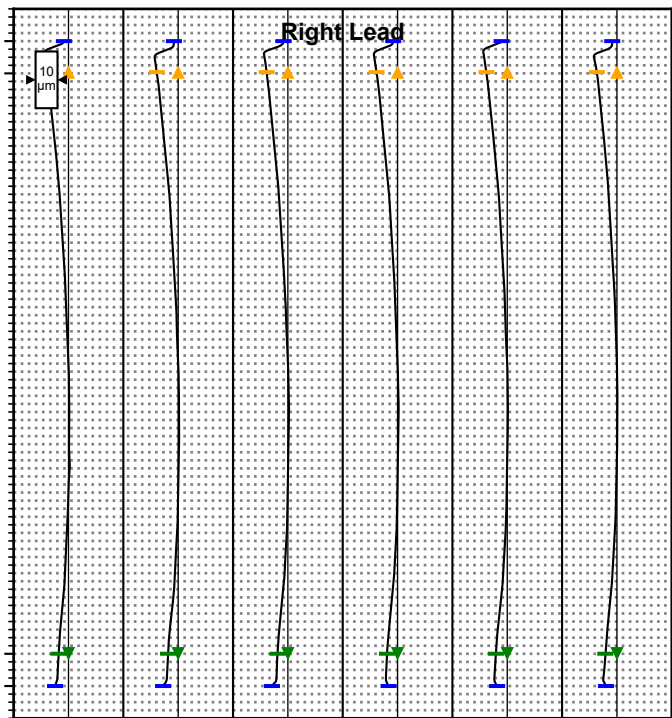
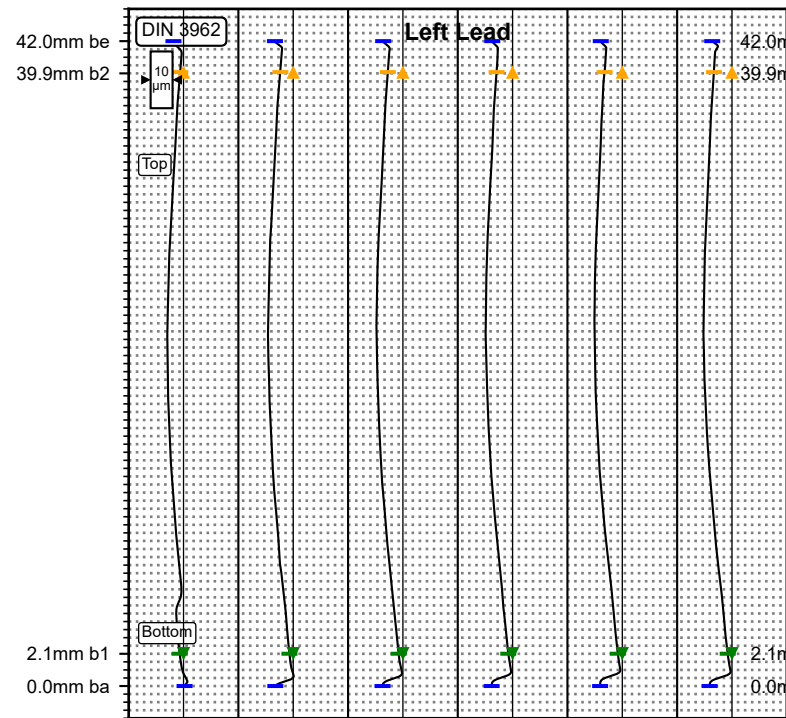
	6	5	4	3	2	1
fHbm						
fHb						
fb						
ffb						
Cb						

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						

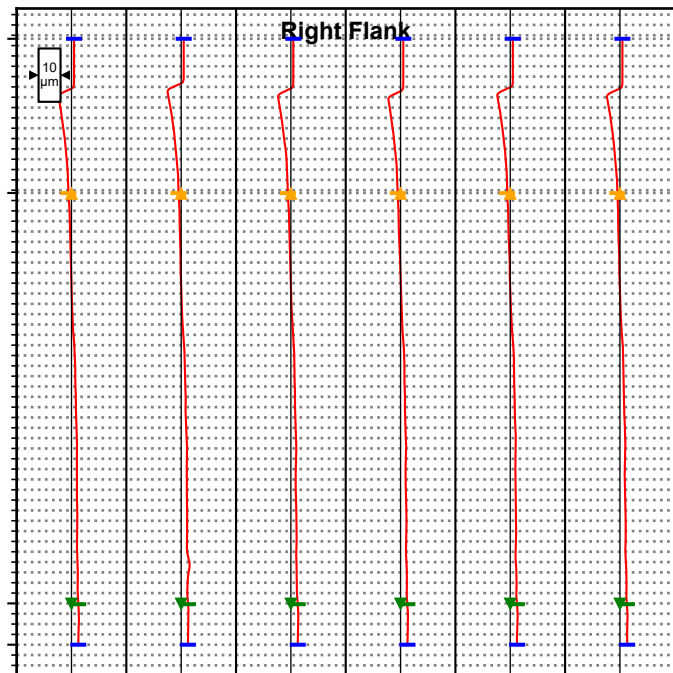
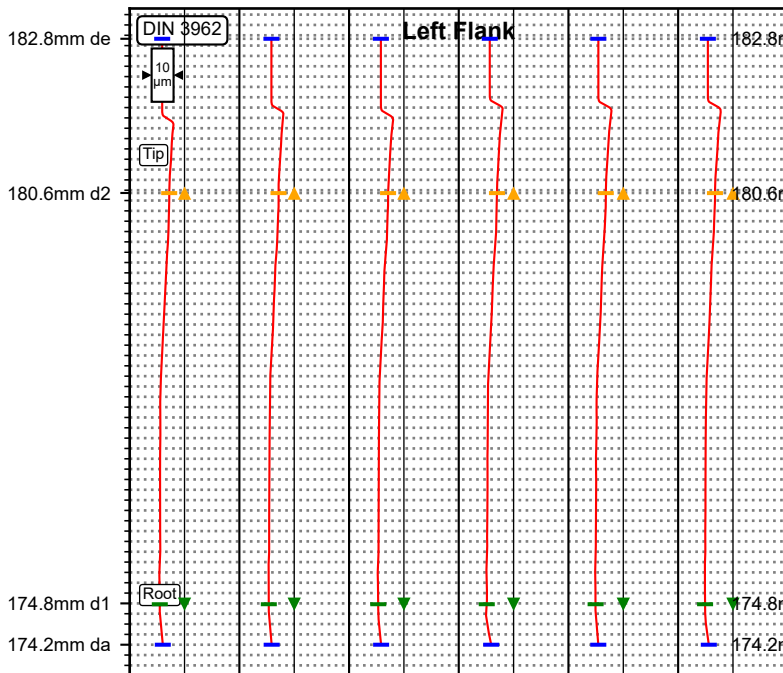
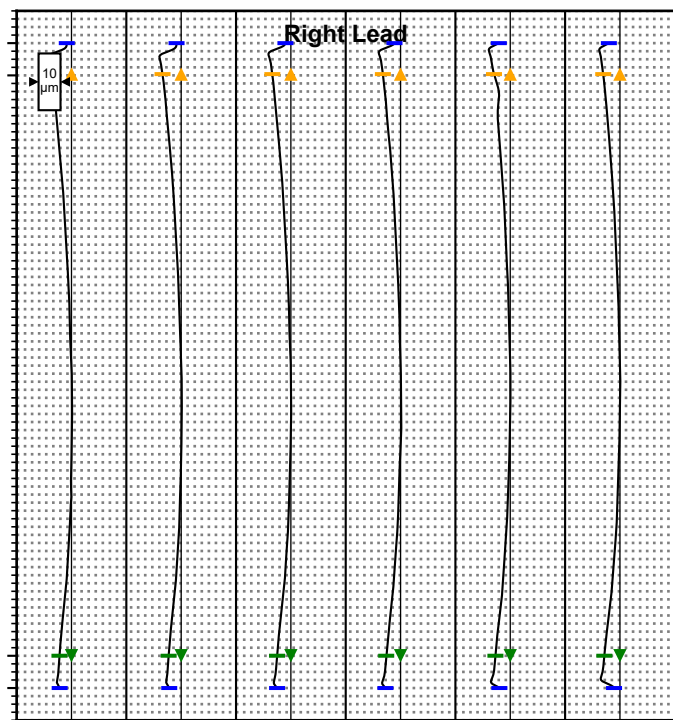
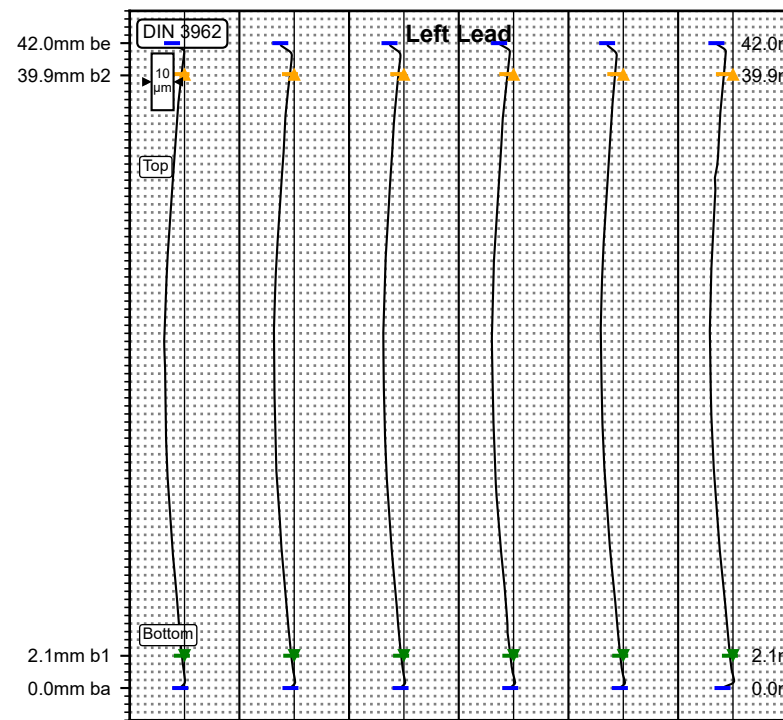
Gear Profile/Lead

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

[illegible][illegible]

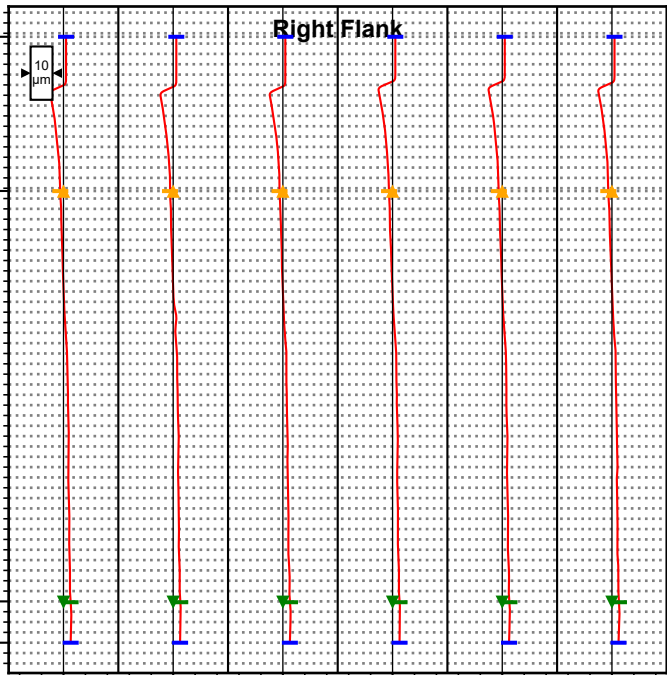
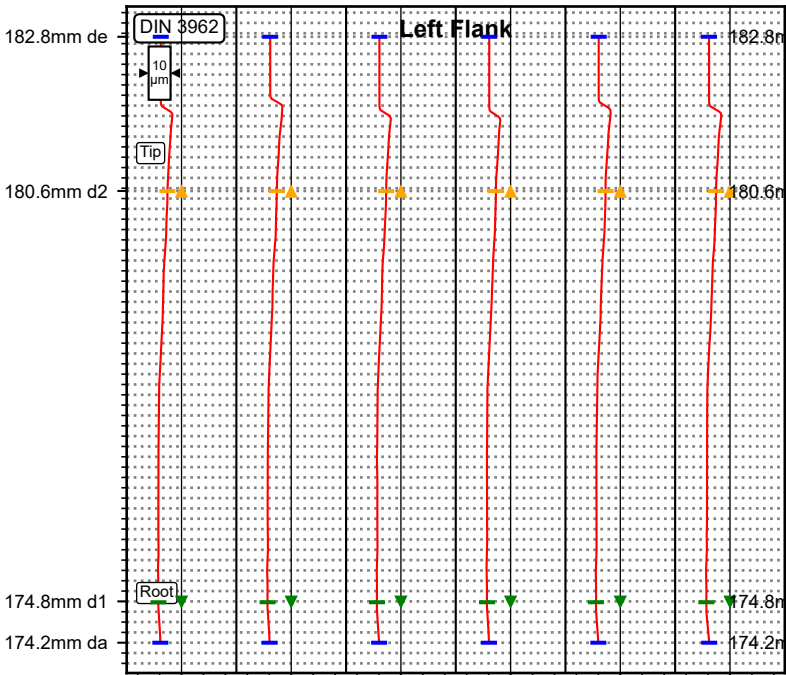
Gear Profile/Lead

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

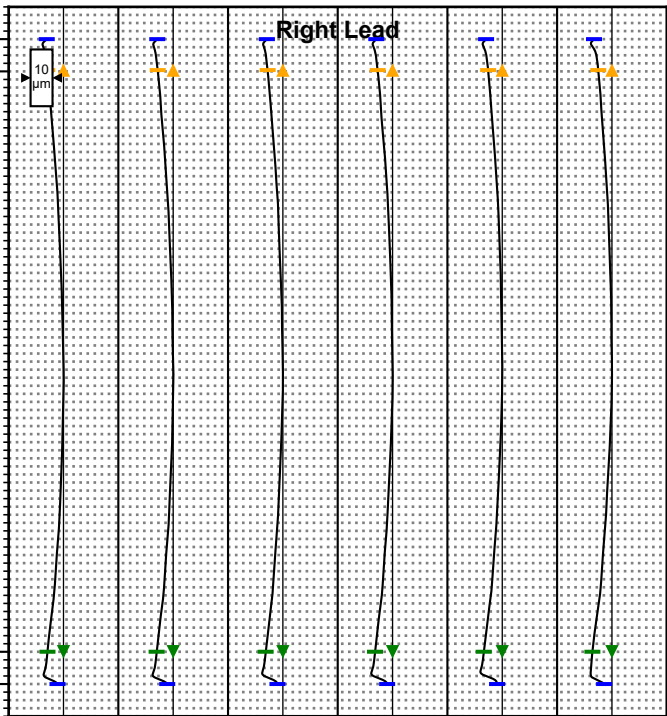
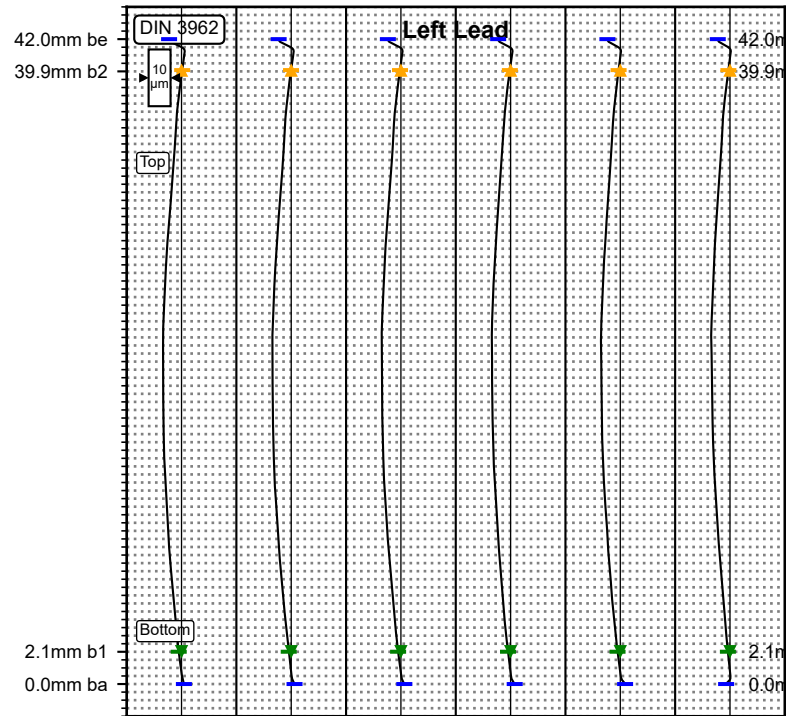
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Gear Profile/Lead

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 α :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L β :	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



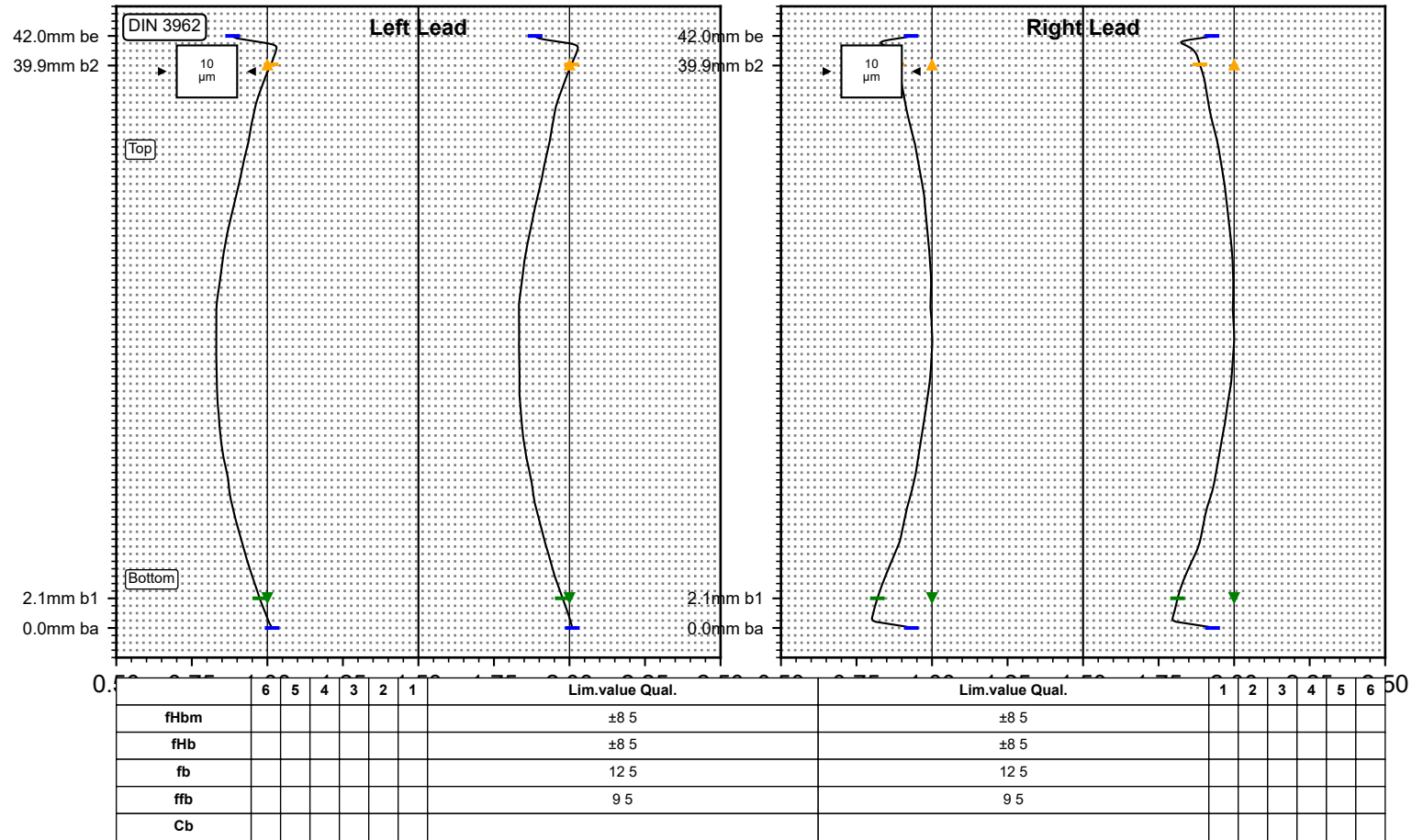
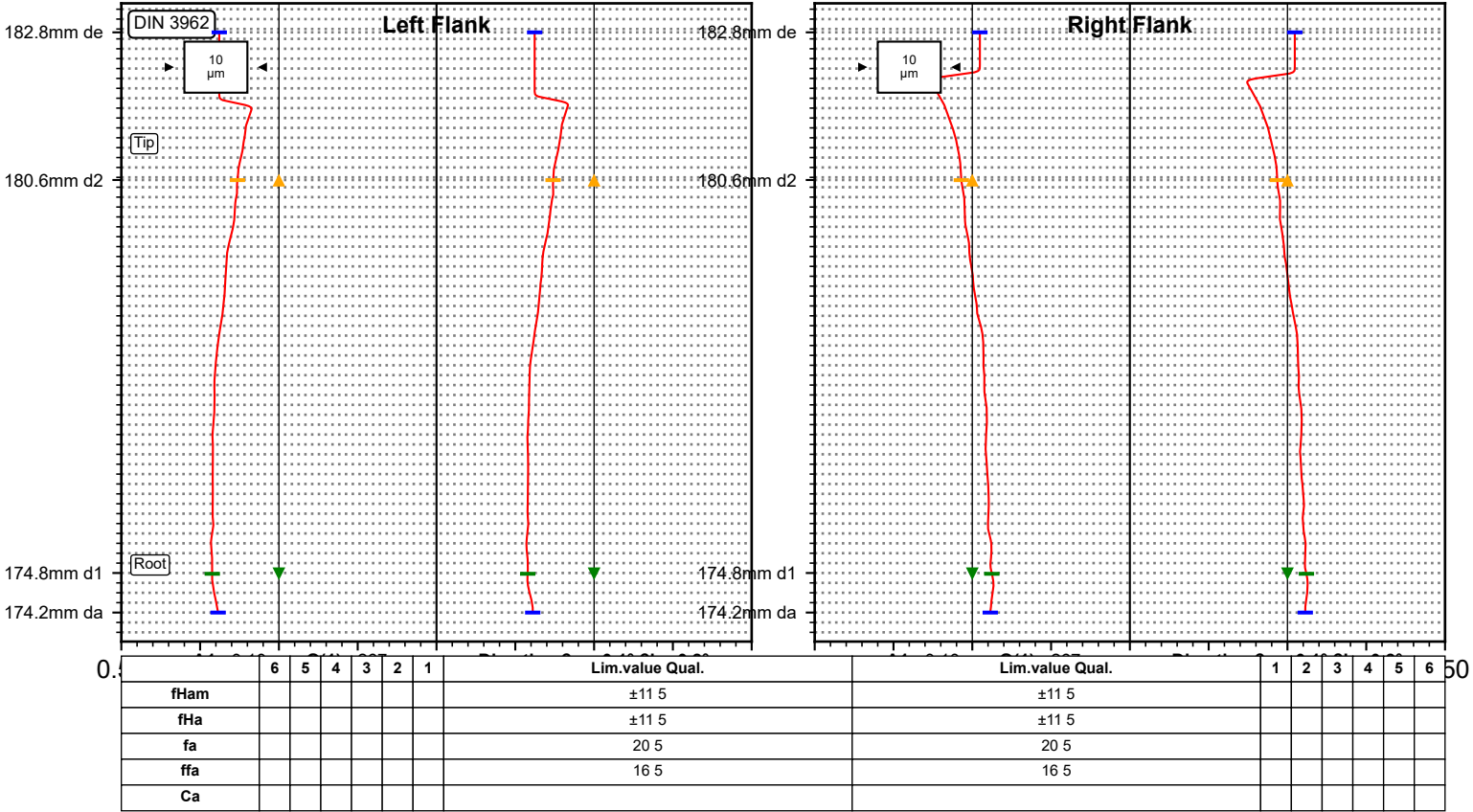
	6	5	4	3	2	1	Lim.value Qual.			Lim.value Qual.			1	2	3	4	5	6
fHam							±11 5			±11 5								
fHa							±11 5			±11 5								
fa							20 5			20 5								
ffa							16 5			16 5								
Ca																		



	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																		

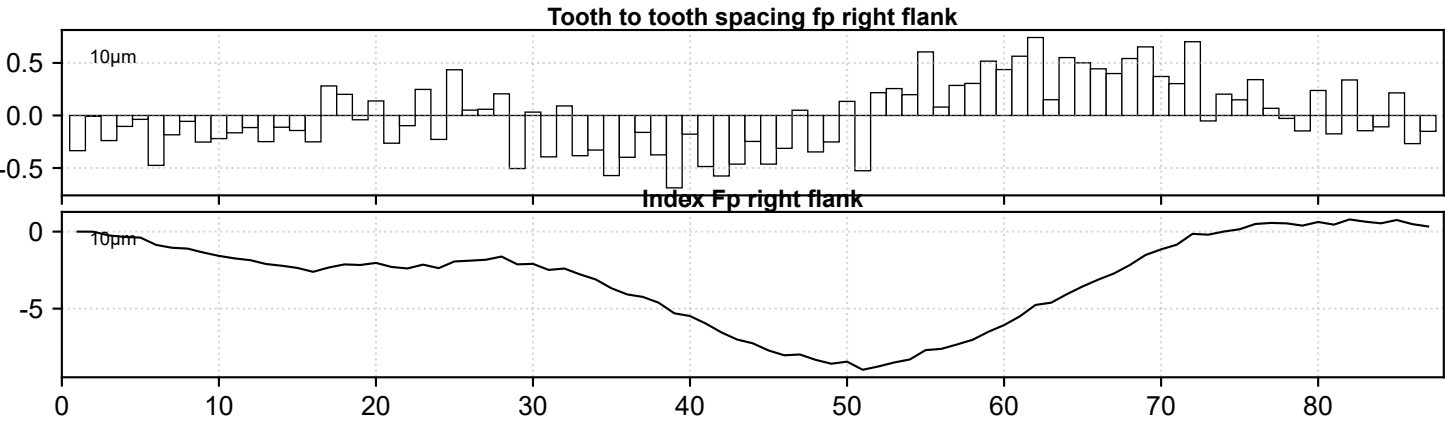
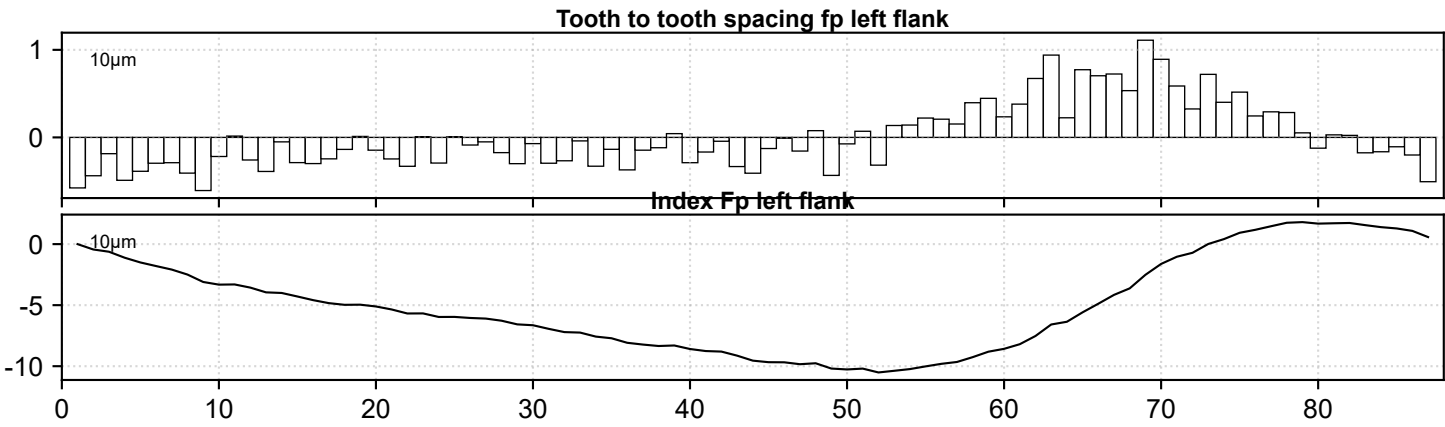
Gear Profile/Lead

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

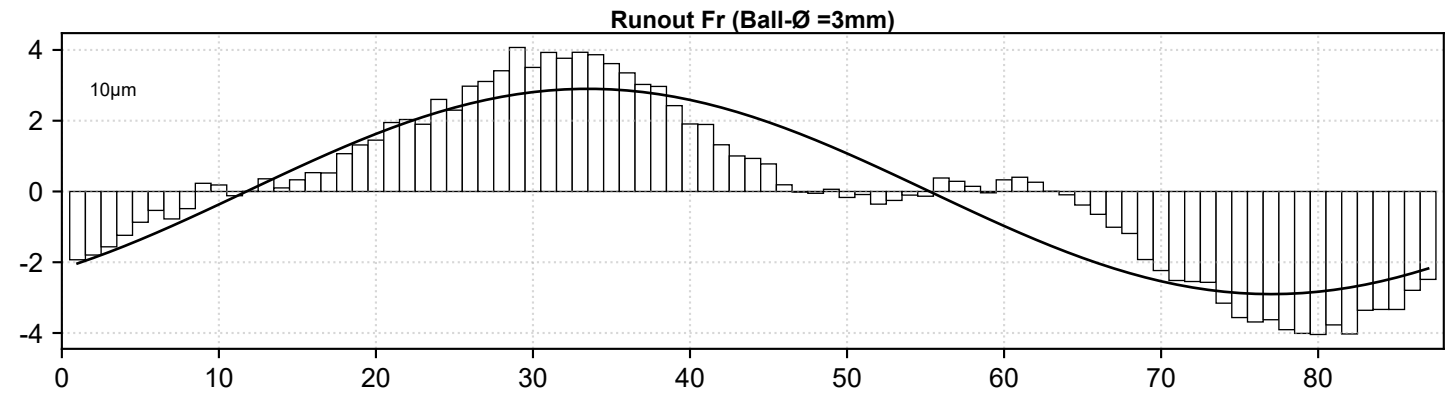


Gear Spacing

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



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 thickn	Rs					Act.	181.395	183.240 179.571