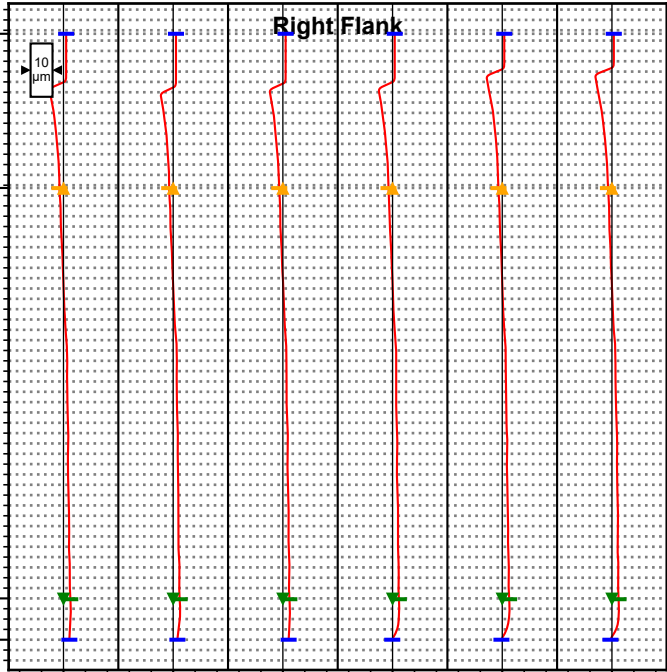
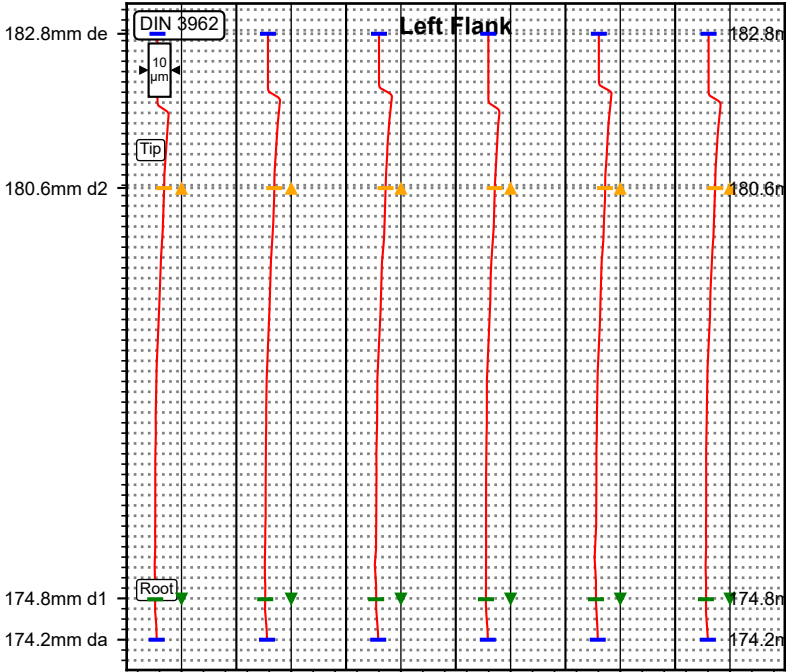
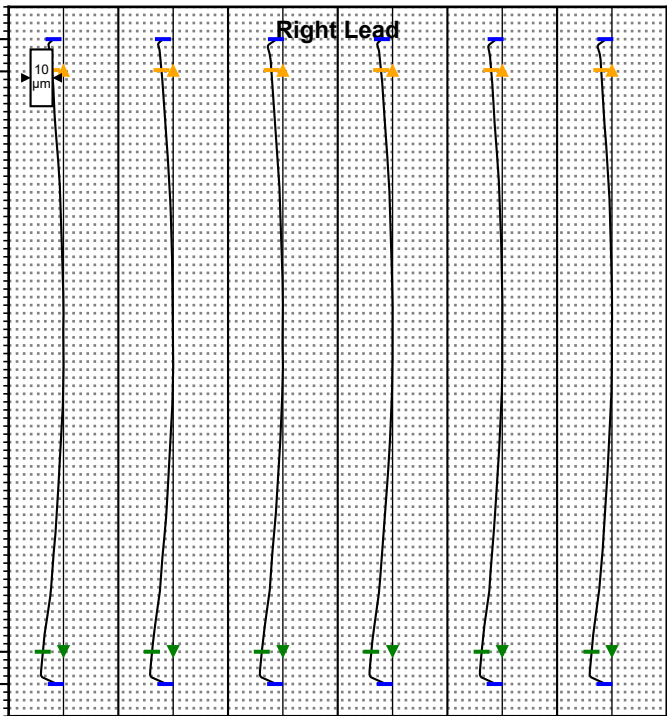
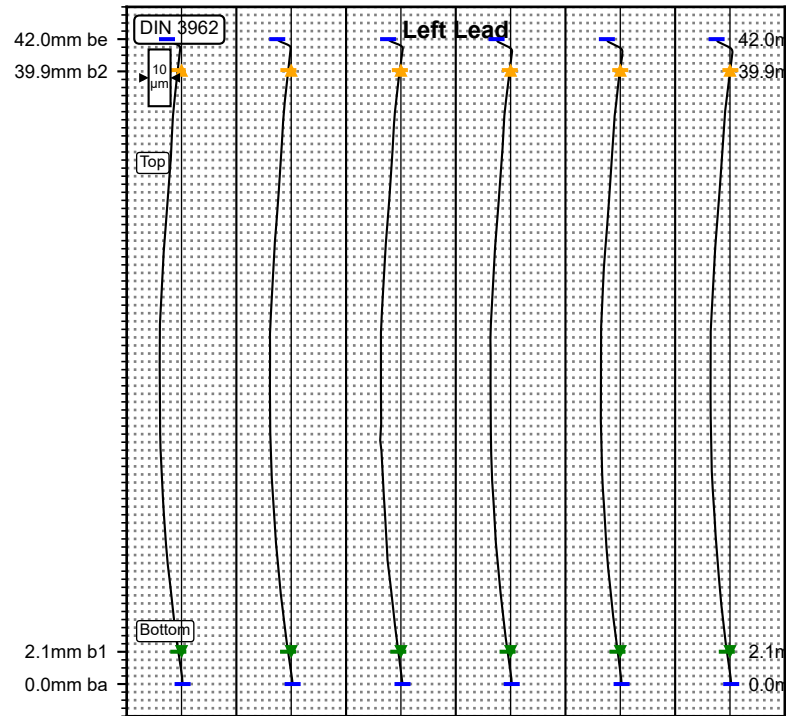


Gear Profile/Lead

Prog.No.:	temp.mka	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



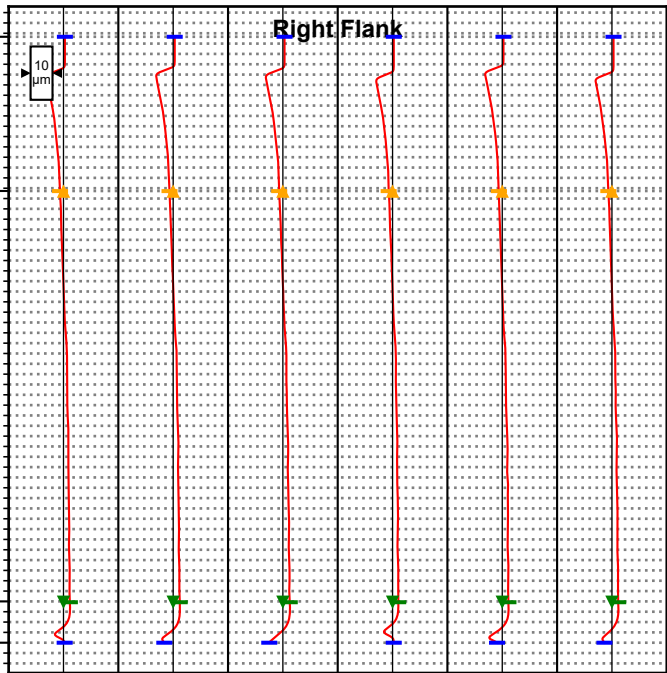
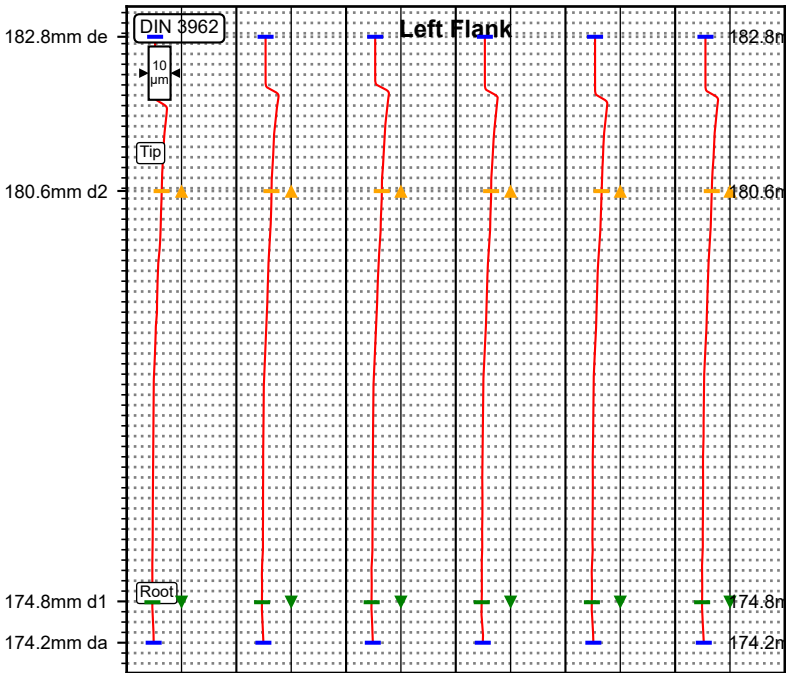
	7	6	5	4	3	2	Lim.value Qual.	Lim.value Qual.	2	3	4	5	6	7
fHam	4.7 3	V 1.1					±11 5	±11 5	-6.3 4	V 1.6				
fHa	4.1	4.8	5.2 3	4.1	5.2 3	4.6	±11 5	±11 5	-6.2	-5.6	-6.0	-6.0	-6.8	-7.2 4
fa	6.7	7.4	8.3 3	6.6	8.3 3	7.2	20 5	20 5	10.1	9.3	9.7	9.8	10.9	11.3 4
ffa	5.9	6.4	6.9 3	5.8	6.9 3	6.3	16 5	16 5	8.5	7.9	8.2	8.3	9.3	9.8 4
Ca	-1.7	-1.6	-1.6	-1.7	-1.5	-1.7			1.3	1.3	1.2	1.4	1.1	1.3



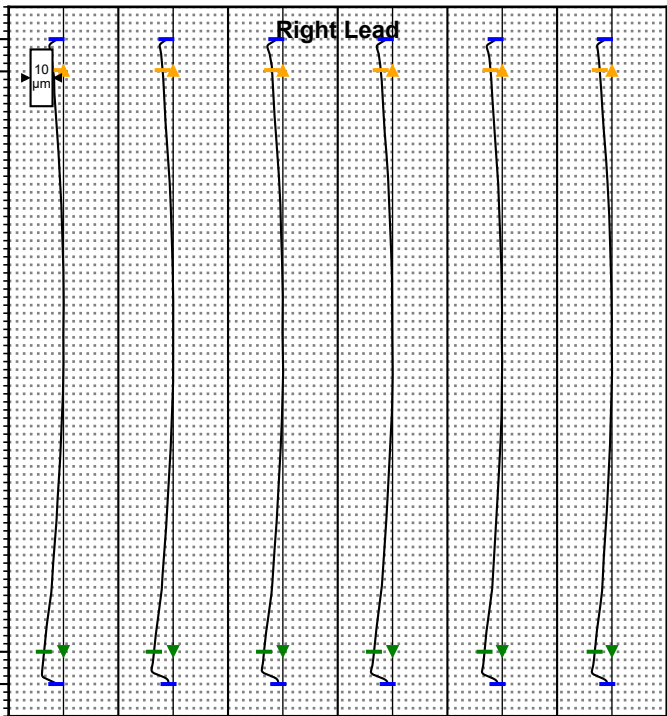
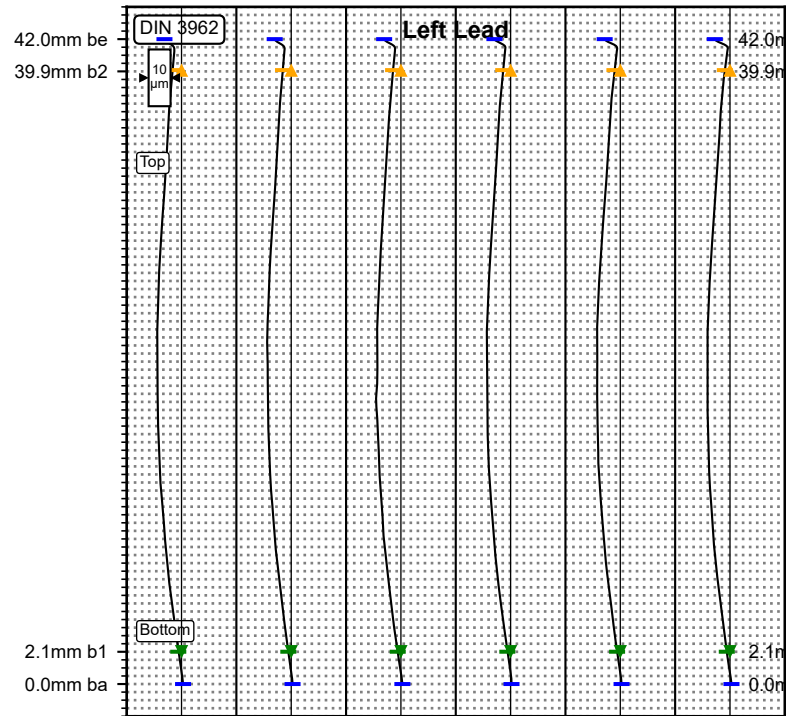
	7	6	5	4	3	2	Lim.value Qual.	Lim.value Qual.	2	3	4	5	6	7
fHbm	1.2 1	V 1.3					±8 5	±8 5	4.2 3	V 0.6				
fHb	0.4	0.8	1.3	1.4	1.5	1.7 1	±8 5	±8 5	3.8	4.1	4.3	4.3	4.4 3	4.3
fb	14.7	14.8	15.5 6	10.4	10.4	10.7	12 5	12 5	10.8	11.3	10.9	12.2 6	10.6	10.6
ffb	14.5	14.4	14.7 7	10.5	10.4	10.5	9 5	9 5	12.7	13.4	10.6	14.4 7	9.7	10.3
Cb	-8.4	-8.3	-8.2	-8.2	-8.1	-8.0			7.4	7.4	7.4	7.4	7.2	7.1

Gear Profile/Lead

Prog.No.:	temp.mka	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



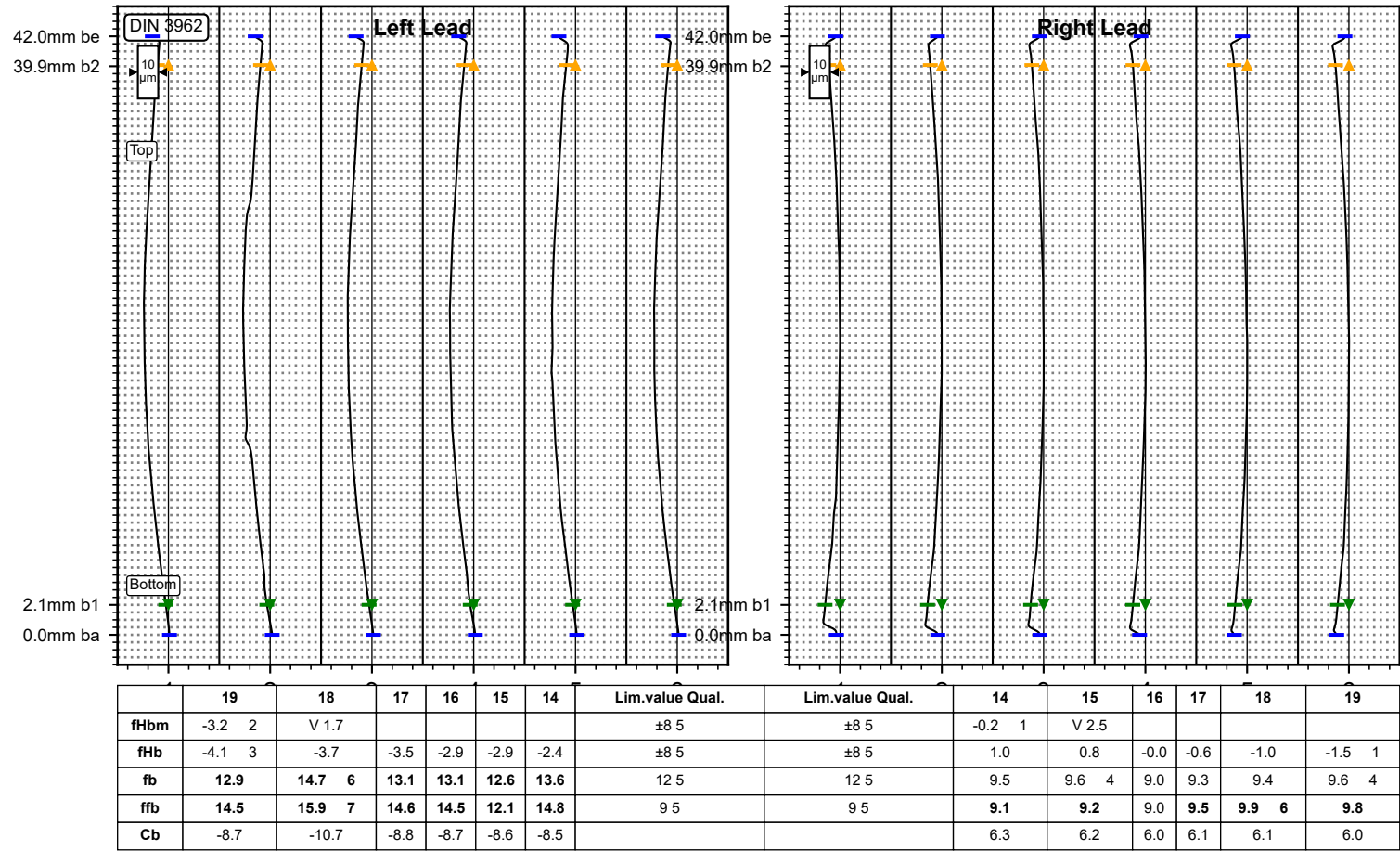
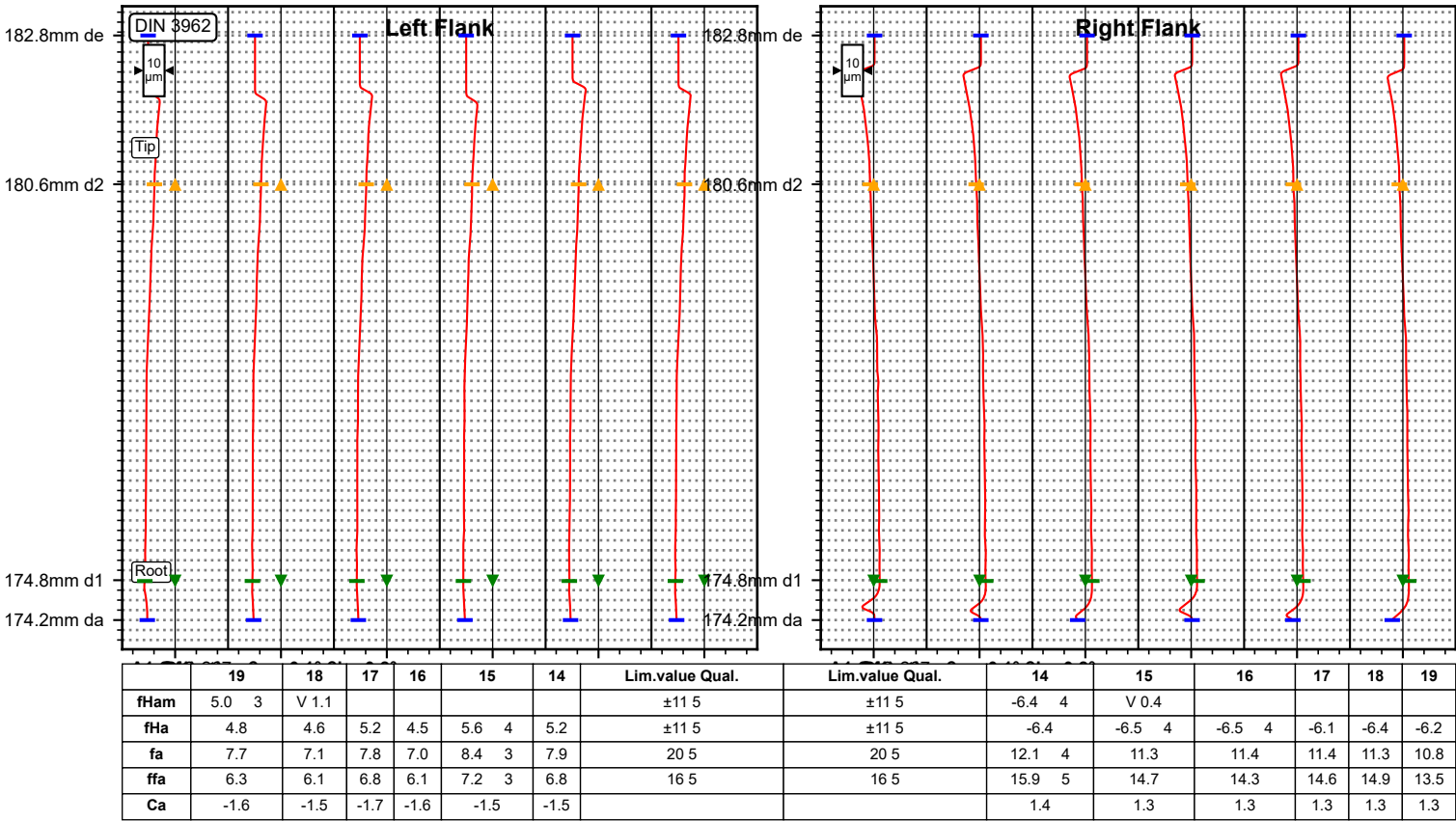
	13	12	11	10	9	8	Lim.value	Qual.	Lim.value	Qual.	8	9	10	11	12	13
fHam	5.1 3	V 1.1					±11	5	±11	5	-6.4 4	V 0.6				
fHa	4.6	5.3	5.7 4	5.2	4.9	5.2	±11	5	±11	5	-6.6	-6.6	-6.7 4	-6.1	-6.4	-6.2
fa	7.1	8.1	8.4 3	8.0	7.6	7.9	20	5	20	5	11.4	11.5	11.7	10.7	11.9 4	11.2
ffa	6.3	6.9	7.2 3	6.9	6.5	6.7	16	5	16	5	14.4	14.9	15.8	13.7	16.0 5	13.4
Ca	-1.7	-1.4	-1.6	-1.6	-1.6	-1.5					1.3	1.3	1.2	1.4	1.3	1.2



	13	12	11	10	9	8	Lim.value	Qual.	Lim.value	Qual.	8	9	10	11	12	13
fHbm	-1.2 1	V 2.1					±8	5	±8	5	2.8 2	V 2.2				
fHb	-2.2 1	-1.9	-1.4	-1.2	-0.5	-0.1	±8	5	±8	5	4.0 3	3.3	2.9	2.6	2.2	1.8
fb	12.0	11.8	12.7	14.7 6	14.1	14.3	12	5	12	5	11.1	11.5	11.3	11.8 5	11.0	11.3
ffb	11.3	12.3	13.4	15.3 7	14.4	14.3	9	5	9	5	13.0 7	12.6	10.4	10.6	10.0	12.2
Cb	-8.4	-8.4	-8.4	-8.4	-8.6	-8.4					6.9	6.8	6.8	6.9	6.7	6.6

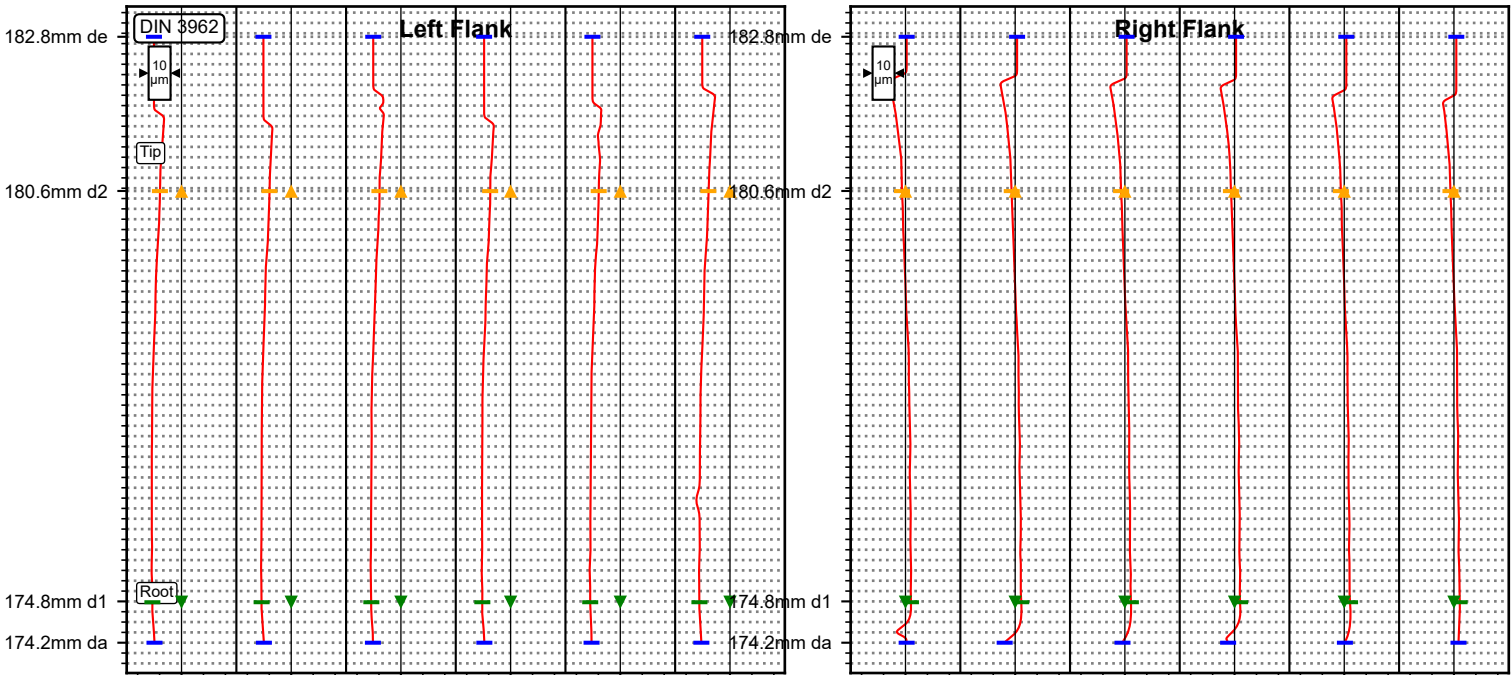
Gear Profile/Lead

Prog.No.:	temp.mka	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

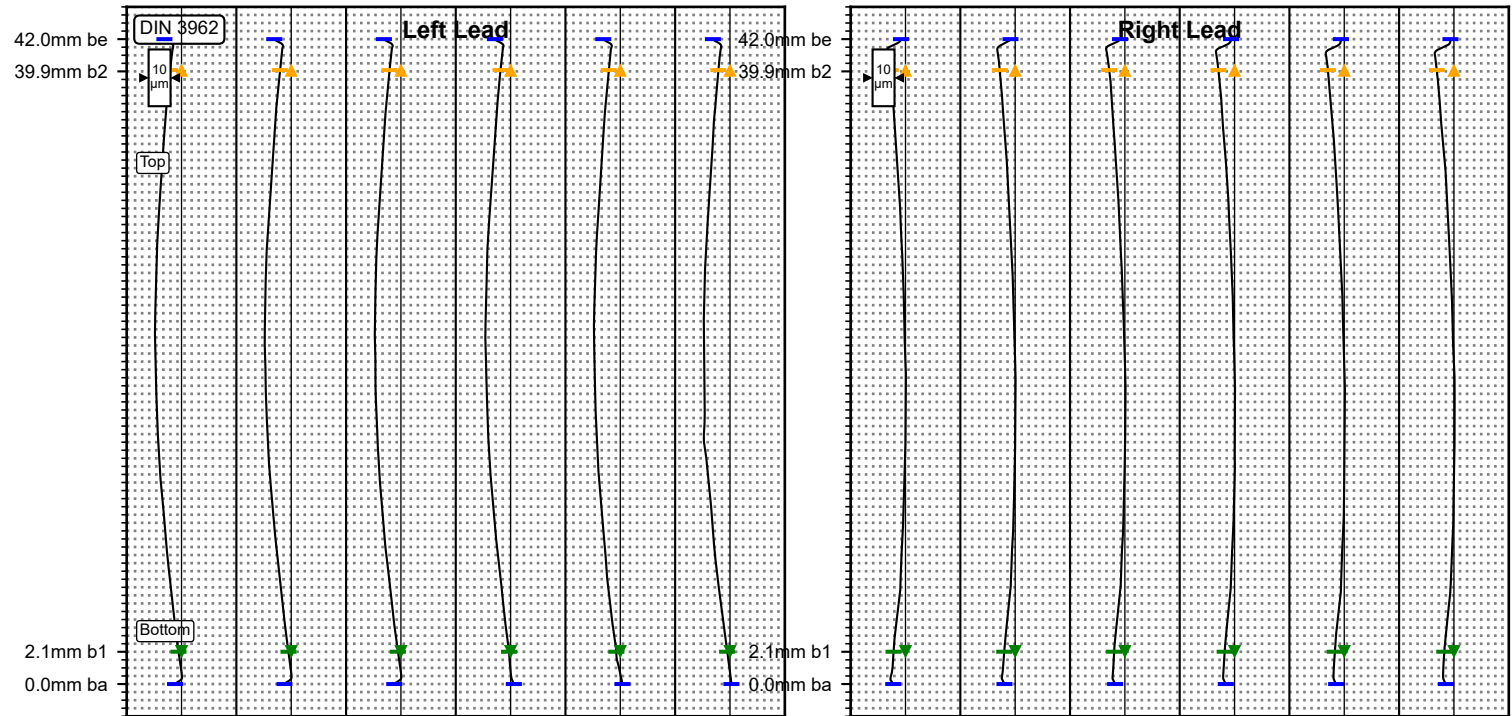


Gear Profile/Lead

Prog.No.:	temp.mka	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



	25	24	23	22	21	20	Lim.value Qual.	Lim.value Qual.	20	21	22	23	24	25
fHam	3.9 2	V 2.0					±11 5	±11 5	-5.4 3	V 1.2				
fHa	3.5	3.2	4.4	3.4	3.8	5.2 3	±11 5	±11 5	-5.8	-5.8	-6.0 4	-5.2	-5.1	-4.8
fa	6.0	5.5	6.2	5.8	6.1	9.1 3	20 5	20 5	10.4 4	10.2	10.1	9.6	8.8	8.2
ffa	5.3	4.9	5.5	5.2	5.3	6.8 3	16 5	16 5	13.5	13.7 5	9.2	11.5	7.4	7.1
Ca	-1.8	-1.7	-1.7	-1.7	-1.5	-1.6			1.4	1.2	1.3	1.3	1.2	1.2

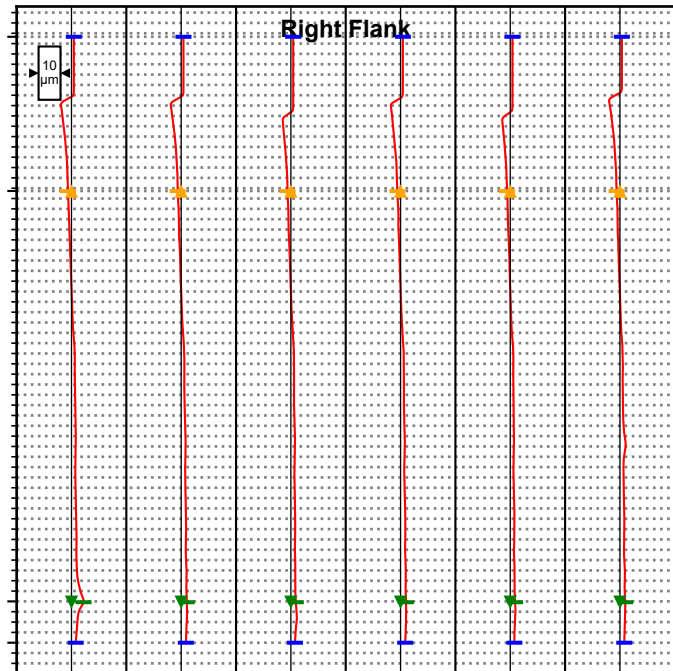
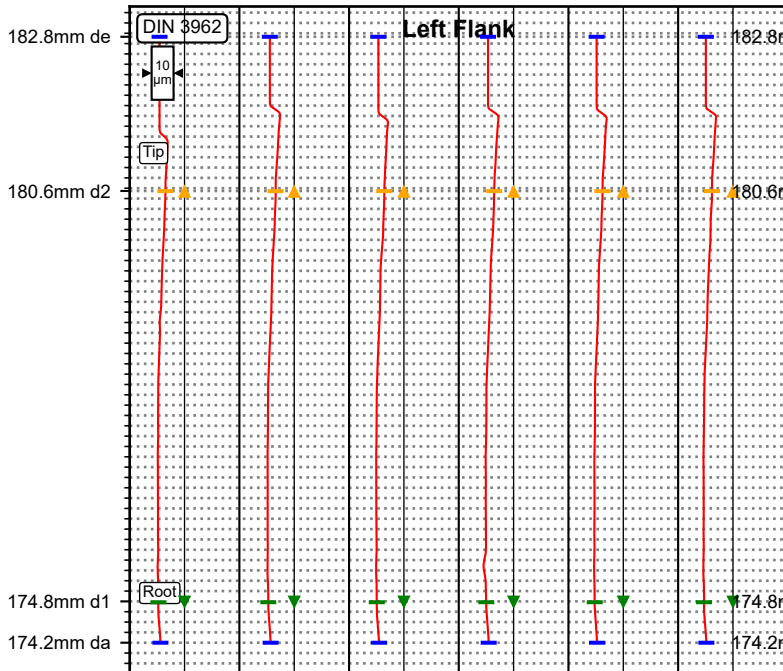


	25	24	23	22	21	20	Lim.value Qual.	Lim.value Qual.	20	21	22	23	24	25
fHbm	-4.1 3	V 0.6					±8 5	±8 5	-3.2 2	V 2.0				
fHb	-4.4 3	-4.2	-4.1	-4.3	-3.8	-3.9	±8 5	±8 5	-2.0	-2.7	-3.2	-3.4	-3.8	-4.0 3
fb	13.9	14.0	14.2	14.6 6	13.9	13.2	12 5	12 5	10.1 5	9.2	10.1 5	9.9	9.8	10.0
ffb	15.9	16.0 7	16.0 7	16.0 7	15.6	15.4	9 5	9 5	9.3 6	8.5	8.4	8.1	8.0	8.1
Cb	-8.7	-8.8	-8.6	-8.8	-8.3	-8.9			5.9	5.8	5.8	5.7	5.7	5.9

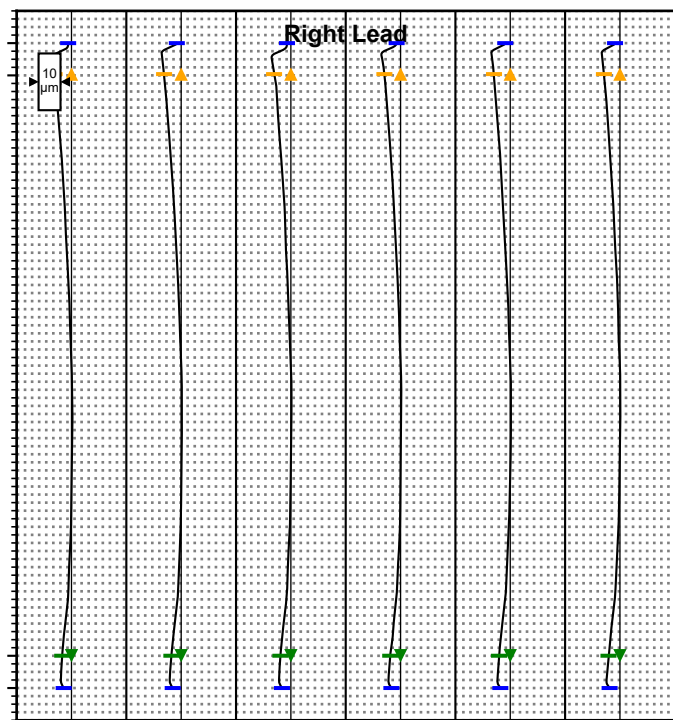
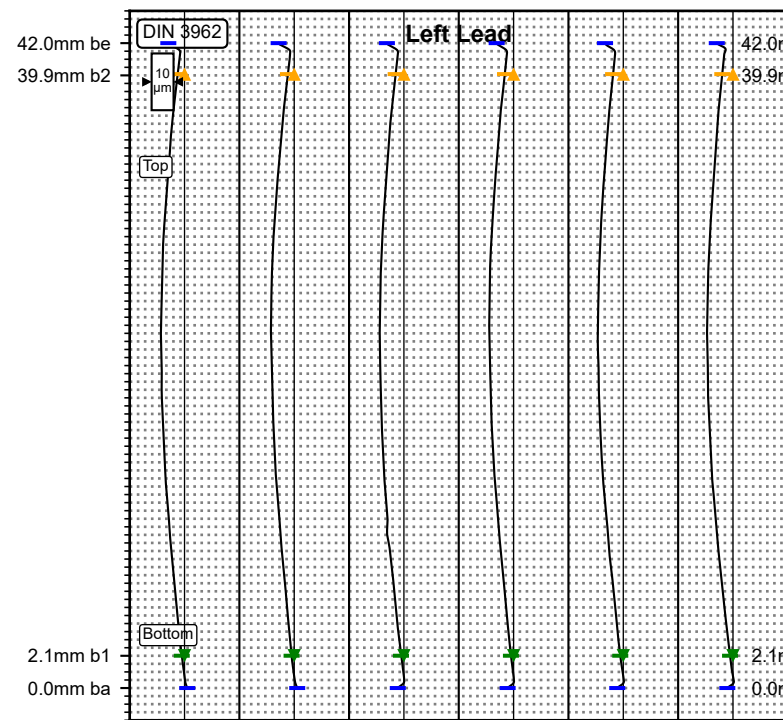


# Gear Profile/Lead

Prog.No.:	temp.mka	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



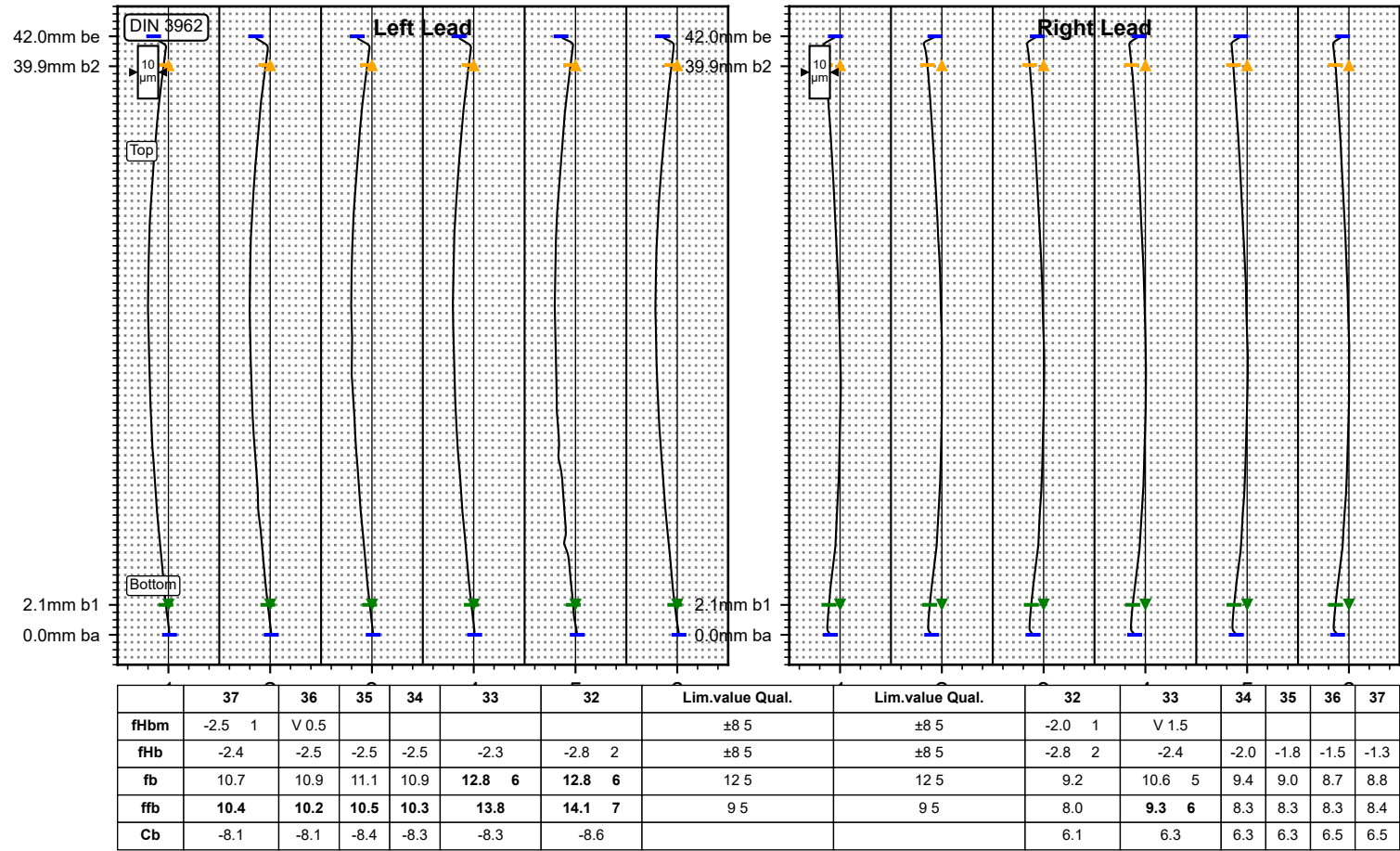
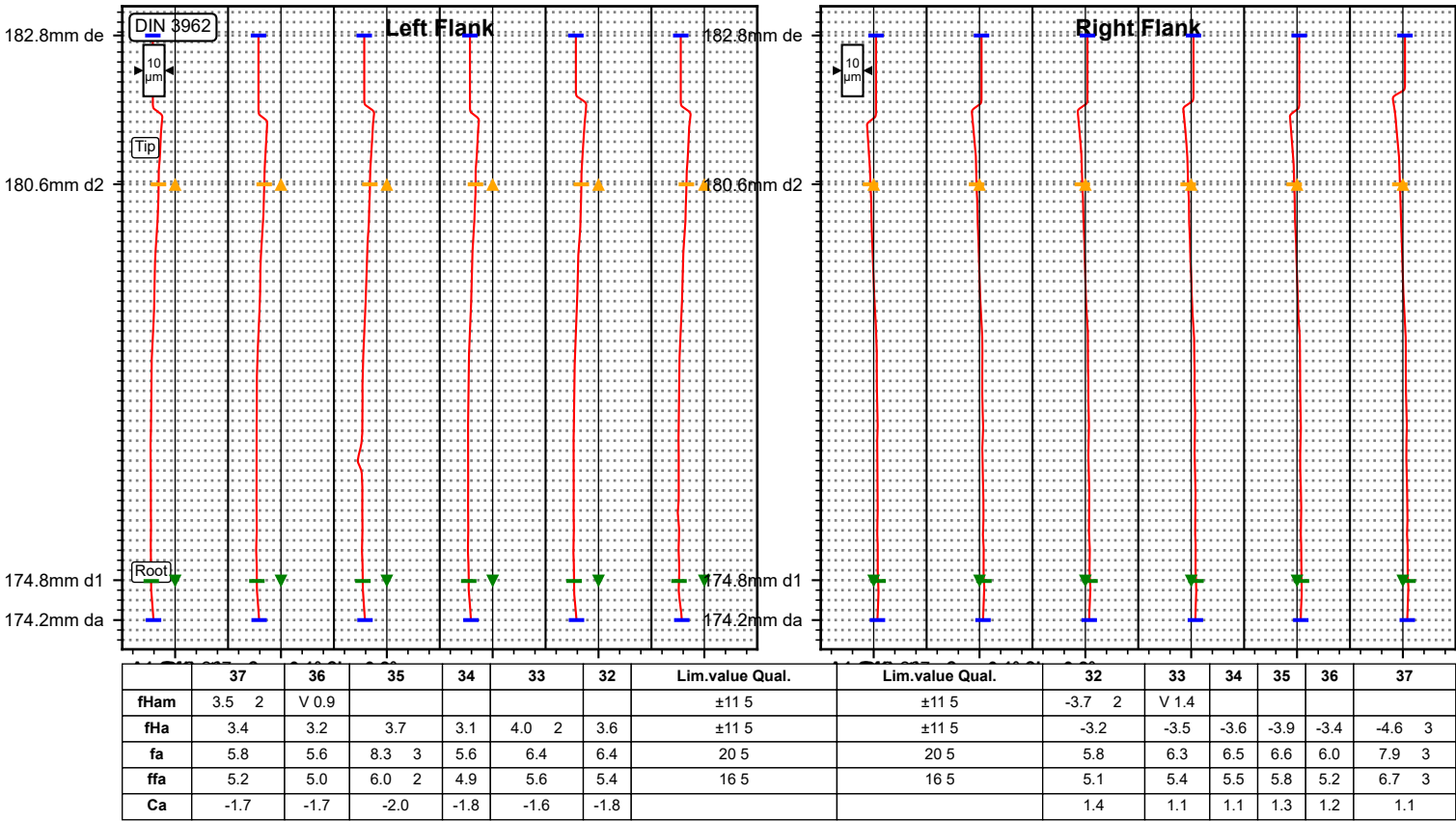
	31	30	29	28	27	26	Lim.value	Qual.	Lim.value	Qual.	26	27	28	29	30	31
fHam	3.4 2	V 1.3					±11	5	±11	5	-4.4 3	V 1.7				
fHa	2.5	3.6	3.3	3.8 2	3.6	3.7	±11	5	±11	5	-5.2 3	-4.7	-3.7	-4.5	-3.5	-4.7
fa	4.7	6.1	5.7	7.2 3	6.1	6.2	20	5	20	5	11.2 4	8.0	6.9	7.6	6.4	8.1
ffa	4.2	5.4	5.1	5.5 2	5.4	5.5 2	16	5	16	5	7.0 3	6.8	5.6	6.5	5.5	6.8
Ca	-1.7	-1.8	-1.7	-1.6	-1.6	-1.7					0.5	1.2	1.3	1.2	1.2	1.2



	31	30	29	28	27	26	Lim.value	Qual.	Lim.value	Qual.	26	27	28	29	30	31
fHbm	-3.6 3	V 1.3					±8	5	±8	5	-3.7 3	V 1.5				
fHb	-2.9	-3.0	-3.2	-3.9	-4.2 3	-4.2 3	±8	5	±8	5	-4.1	-4.5 3	-3.5	-3.7	-3.5	-3.0
fb	14.0	14.6	13.0	12.4	12.6	14.9 6	12	5	12	5	10.0	10.2 5	10.2 5	10.2 5	9.9	9.3
ffb	15.4	15.9	14.4	14.1	13.1	16.8 8	9	5	9	5	8.0	8.3	8.4 5	8.3	8.1	8.1
Cb	-8.4	-8.5	-8.4	-8.4	-8.6	-8.6					5.8	5.8	5.8	5.8	6.0	5.9

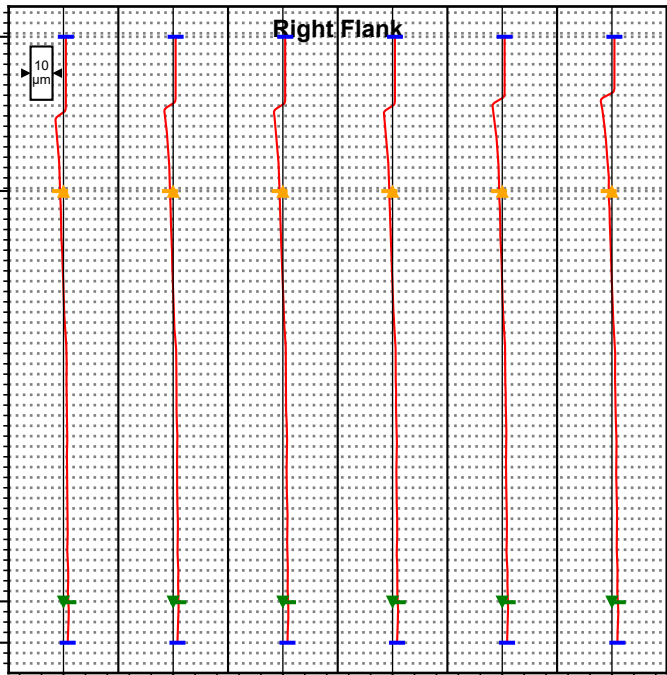
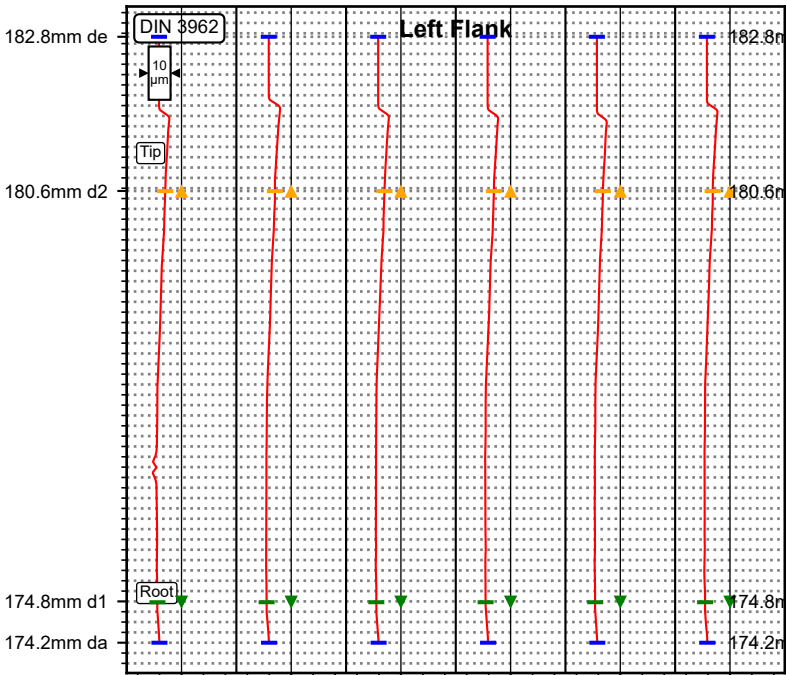
Gear Profile/Lead

Prog.No.:	temp.mka	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

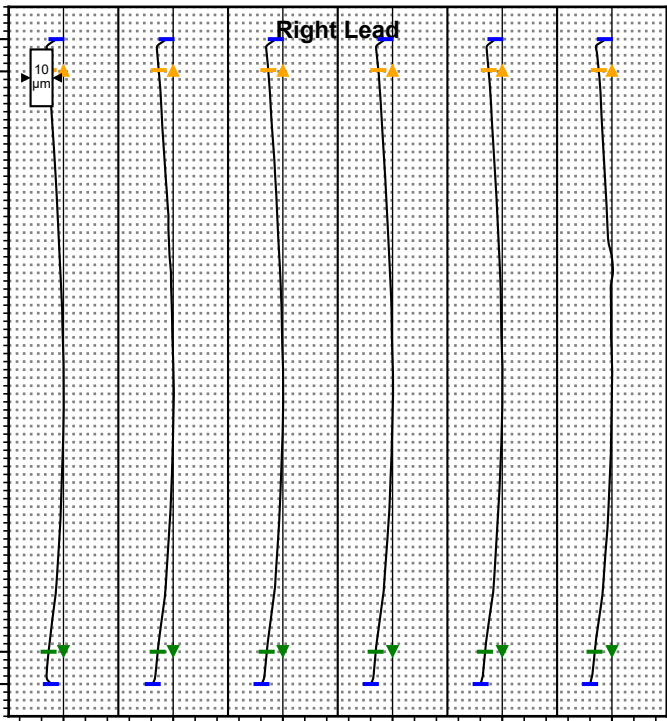
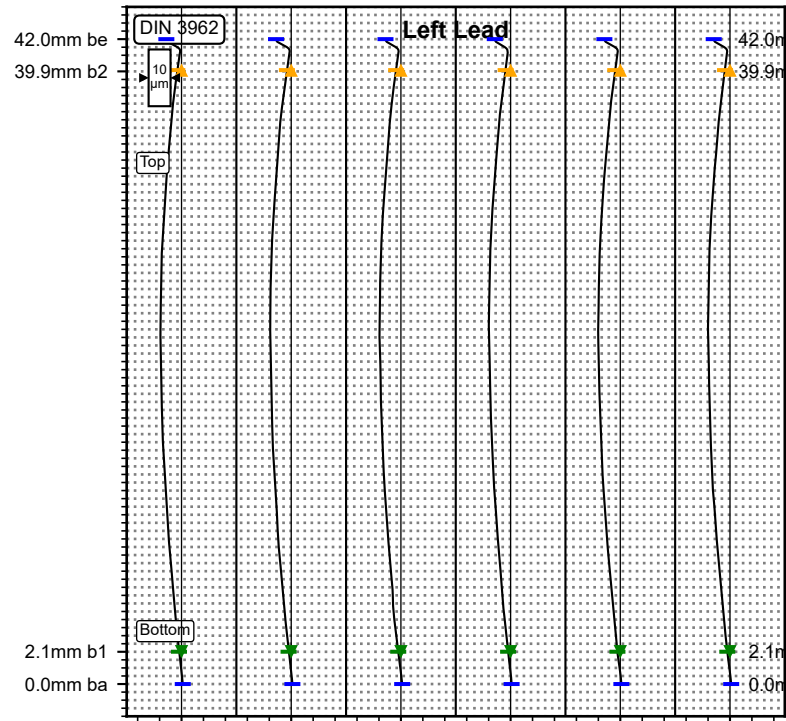


Gear Profile/Lead

Prog.No.:	temp.mka	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



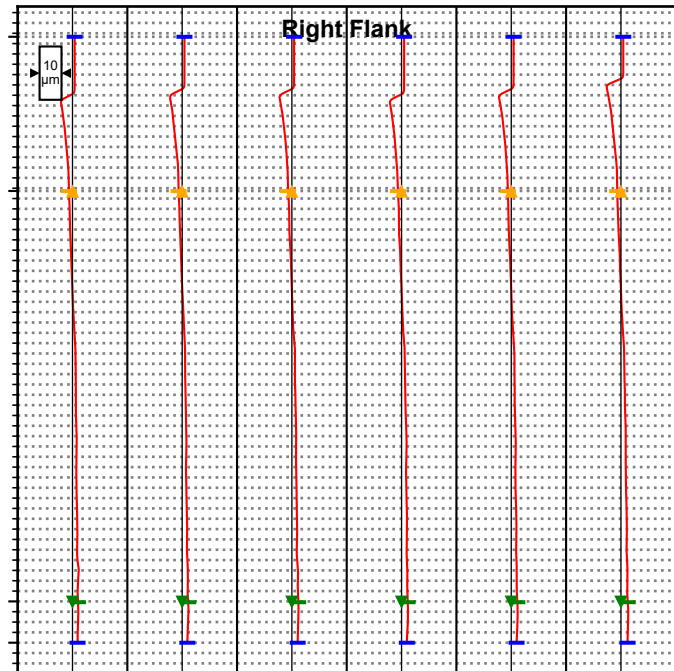
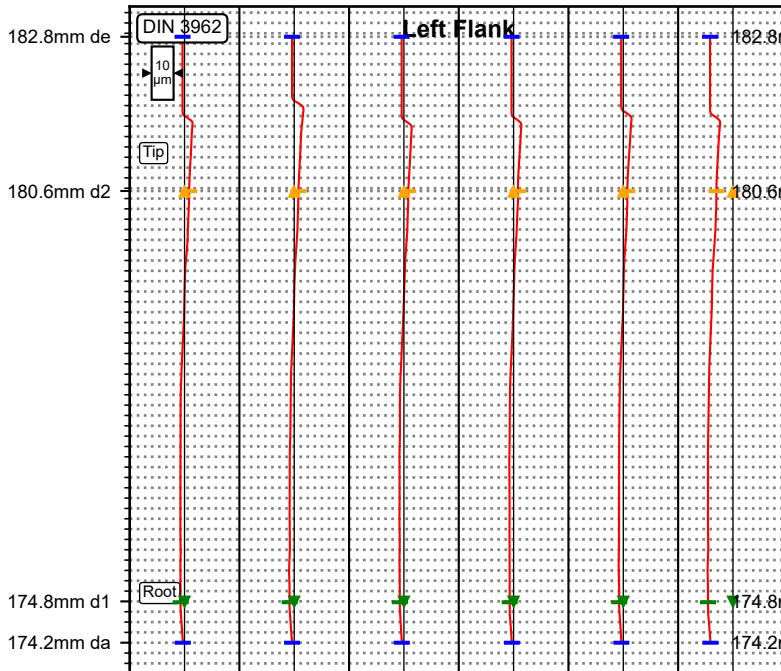
	43	42	41	40	39	38	Lim.value Qual.	Lim.value Qual.	38	39	40	41	42	43
fHam	3.8 2	V 0.7					±11 5	±11 5	-4.2 3	V 1.4				
fHa	3.8	4.2 3	3.8	3.8	3.5	3.9	±11 5	±11 5	-3.6	-4.1	-4.1	-4.1	-4.4	-5.0 3
fa	9.6 3	6.7	6.3	6.3	5.9	6.4	20 5	20 5	6.4	7.0	7.1	7.0	7.7	8.5 3
ffa	7.5 3	6.0	5.6	5.6	5.3	5.7	16 5	16 5	5.5	6.1	6.1	6.0	6.5	7.2 3
Ca	-2.0	-1.7	-1.8	-1.8	-1.7	-1.8			1.3	1.2	1.3	1.3	1.2	1.2



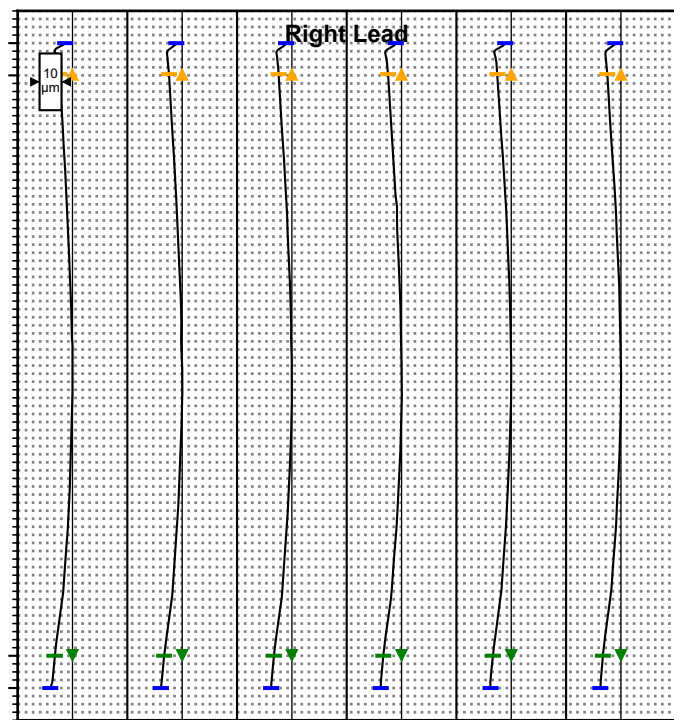
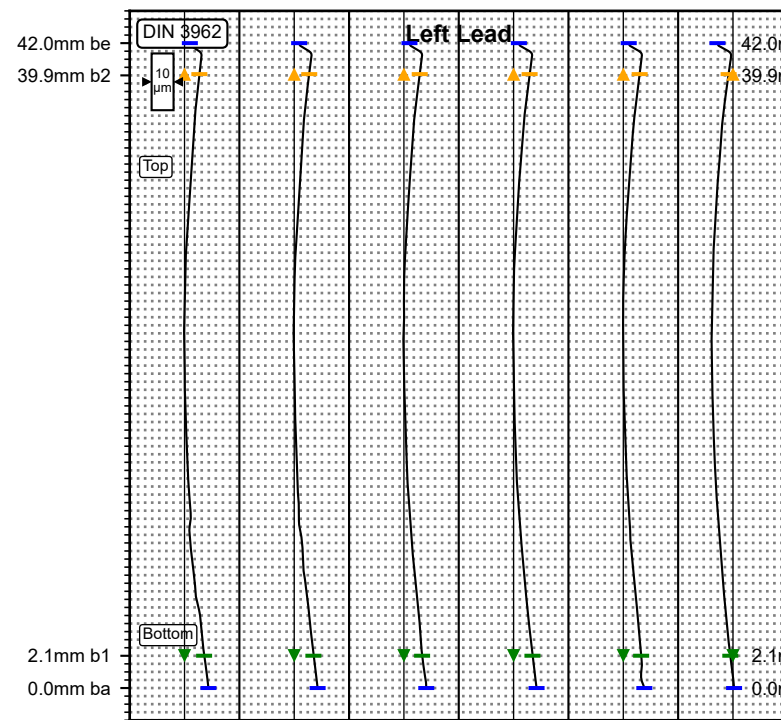
	43	42	41	40	39	38	Lim.value Qual.	Lim.value Qual.	38	39	40	41	42	43
fHbm	-2.3 1	V 0.6					±8 5	±8 5	-0.0 1	V 2.1				
fHb	-2.0	-2.1	-2.3	-2.6 2	-2.5	-2.4	±8 5	±8 5	-1.1 1	-0.6	-0.4	0.2	0.7	1.0
fb	10.4	10.3	10.7	10.5	10.8 5	10.8 5	12 5	12 5	8.6	11.3	11.9	12.1 6	11.5	11.7
ffb	10.4 6	10.3	10.0	9.9	10.4 6	10.1	9 5	9 5	8.5	11.5	12.1 7	12.0	11.1	11.1
Cb	-7.9	-7.7	-7.7	-7.9	-8.1	-8.0			6.6	6.7	6.9	7.0	6.9	7.0

# Gear Profile/Lead

Prog.No.:	temp.mka	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



	49	48	47	46	45	44	Lim.value	Qual.	Lim.value	Qual.	44	45	46	47	48	49
fHm	3.8 2	V 0.9					±11	5	±11	5	-5.5	3	V 1.6			
fHa	3.7	4.4 3	3.6	3.5	3.8	3.6	±11	5	±11	5	-5.0	-5.3	-5.6	-5.3	-5.4	-6.6 4
fa	6.1	6.9 2	6.0	5.9	6.2	6.1	20	5	20	5	8.8	8.9	9.2	8.8	9.1	10.5 4
ffa	5.5	6.0 2	5.4	5.3	5.5	5.4	16	5	16	5	7.3	7.5	7.7	7.5	7.7	8.7 4
Ca	-1.9	-1.6	-1.8	-1.8	-1.7	-1.7					1.2	1.1	1.2	1.4	1.2	1.3

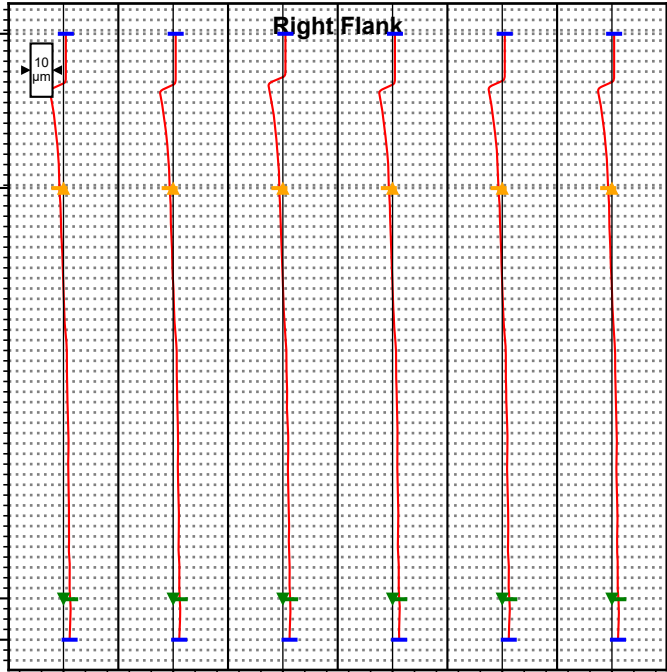
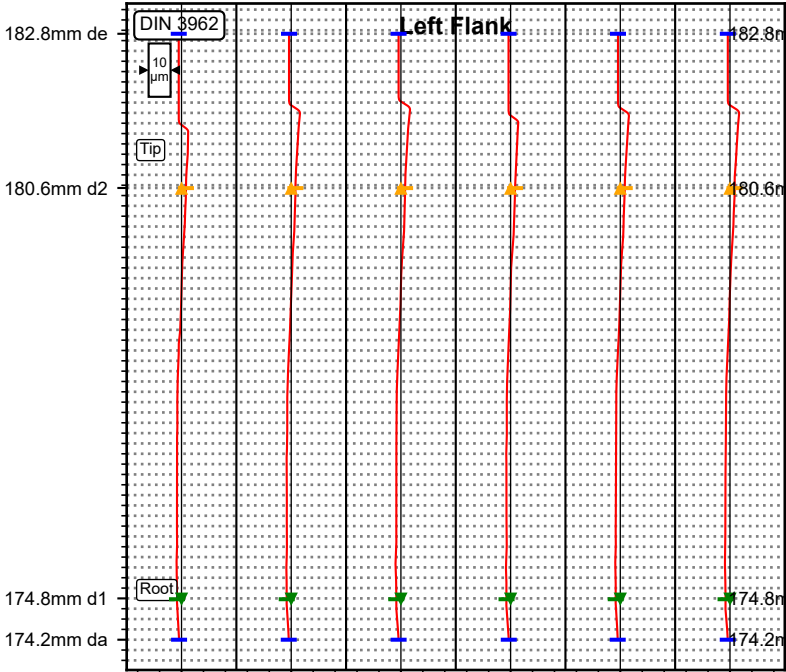


	49	48	47	46	45	44	Lim.value	Qual.	Lim.value	Qual.	44	45	46	47	48	49
fHbm	-2.3 1	V 0.9					±8	5	±8	5	1.3	1	V 0.4			
fHb	-2.6	-2.7 2	-2.4	-2.3	-1.8	-2.0	±8	5	±8	5	1.0	1.3	1.4 1	1.4 1	1.4 1	1.3
fb	11.5 5	11.4	10.5	11.1	10.6	10.5	12	5	12	5	11.8 5	10.1	9.6	9.8	9.8	9.5
ffb	10.1	9.9	10.0	10.1	9.9	10.2 6	9	5	9	5	11.3 6	9.4	9.0	9.6	9.9	8.9
Cb	-7.8	-7.9	-8.0	-8.0	-7.9	-7.8					6.9	6.9	7.0	7.2	7.2	7.2

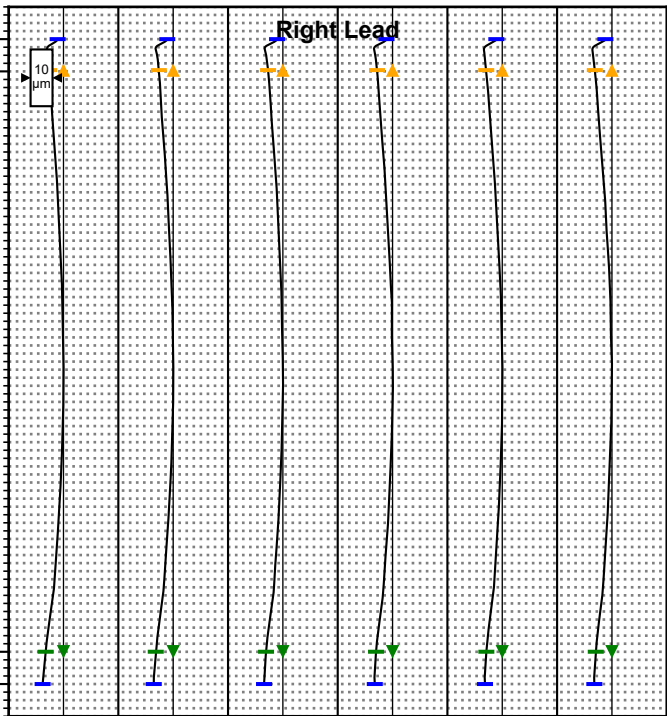
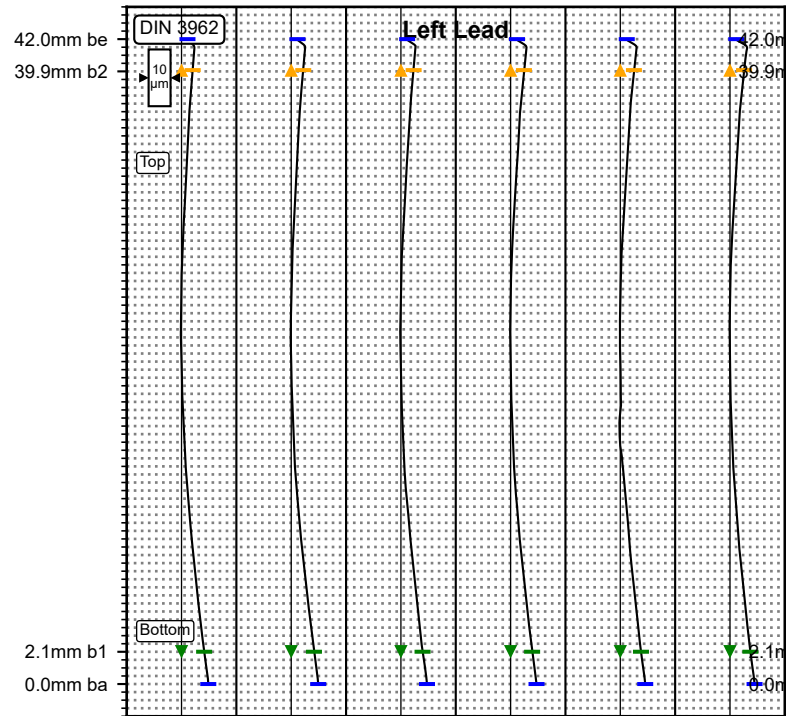


Gear Profile/Lead

Prog.No.:	temp.mka	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



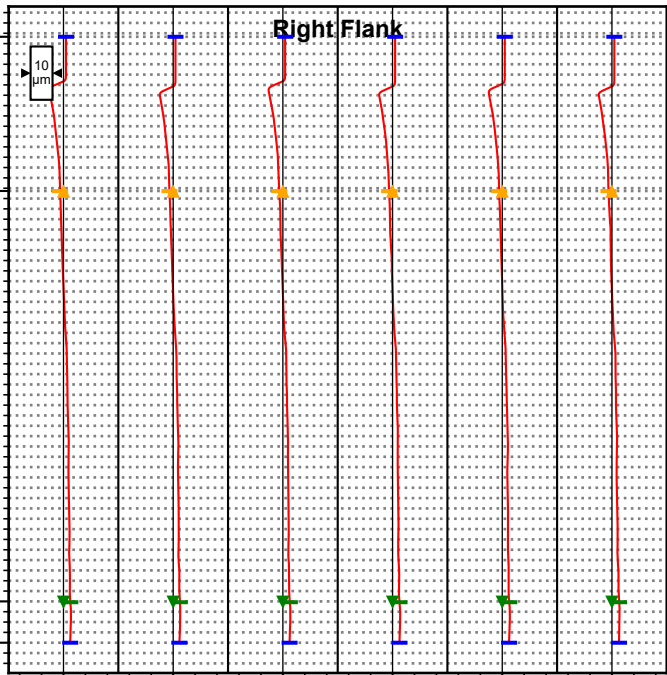
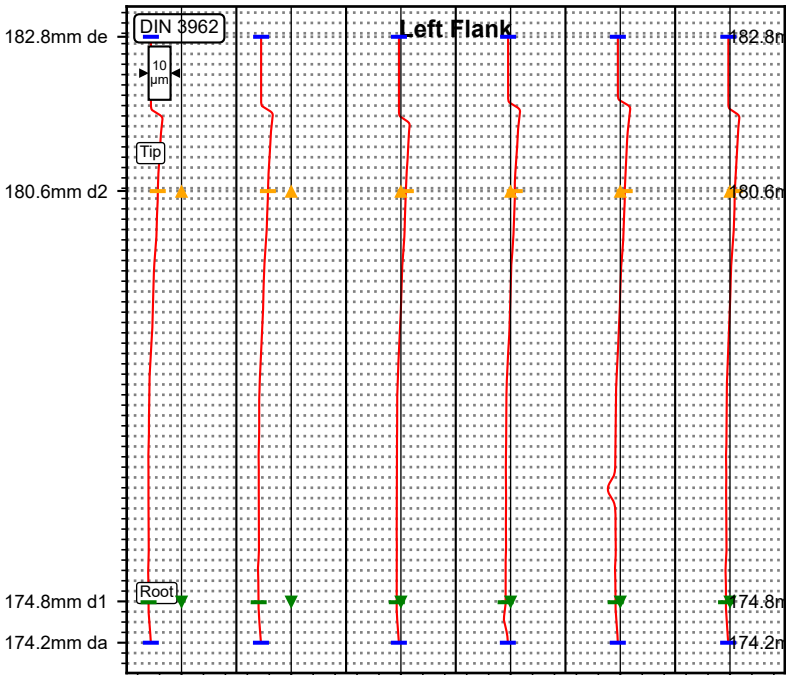
	55	54	53	52	51	50	Lim.value Qual.	Lim.value Qual.	50	51	52	53	54	55
fHam	3.9 2	V 1.0					±11 5	±11 5	-6.2 4	V 0.8				
fHa	3.3	4.1	4.3 3	3.6	4.1	4.2	±11 5	±11 5	-6.2	-5.9	-6.7 4	-6.1	-6.4	-6.2
fa	5.8	6.5	6.9 2	6.0	6.6	6.8	20 5	20 5	9.9	9.8	10.6 4	9.9	10.3	10.0
ffa	5.2	5.8	6.0 2	5.3	5.8	6.0 2	16 5	16 5	8.3	8.2	8.8 4	8.2	8.5	8.3
Ca	-1.8	-1.7	-1.8	-1.8	-1.7	-1.8			1.3	1.2	1.2	1.3	1.2	1.2



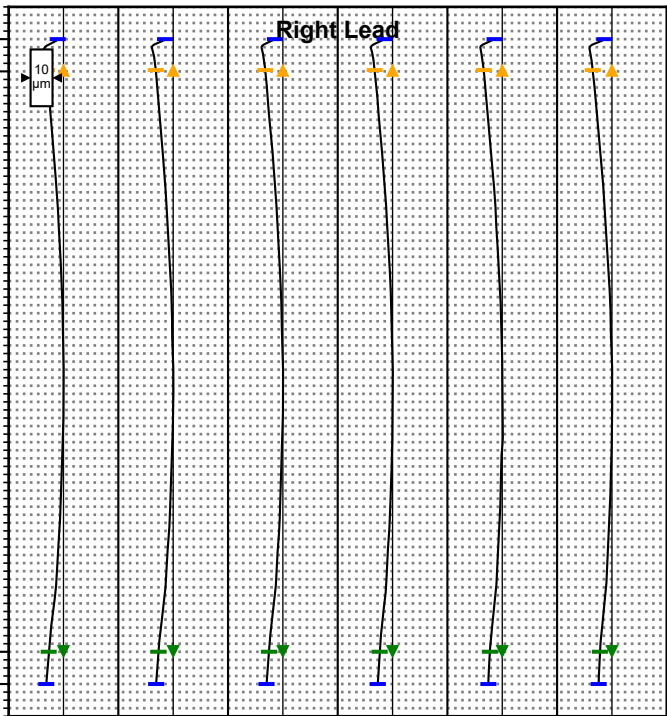
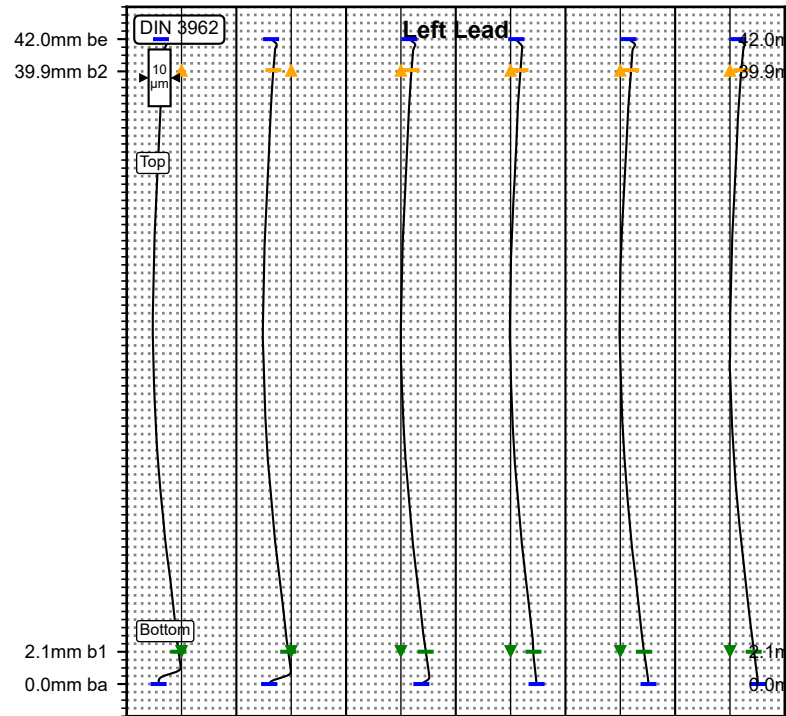
	55	54	53	52	51	50	Lim.value Qual.	Lim.value Qual.	50	51	52	53	54	55
fHbm	-4.5 3	V 2.3					±8 5	±8 5	0.0 1	V 1.9				
fHb	-5.7 4	-5.3	-4.6	-4.1	-3.6	-3.4	±8 5	±8 5	1.0 1	0.7	0.3	-0.2	-0.7	-0.9
fb	12.6	12.7	12.7	12.4	12.9	13.0 6	12 5	12 5	9.9 4	9.5	9.8	9.8	9.2	9.7
ffb	12.7	13.7	14.8	14.3	15.0 7	14.6	9 5	9 5	9.4	9.9	10.0 6	9.7	8.9	9.2
Cb	-7.9	-8.1	-8.1	-8.1	-8.2	-8.0			7.2	7.2	7.1	7.3	7.3	7.5

Gear Profile/Lead

Prog.No.:	temp.mka	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



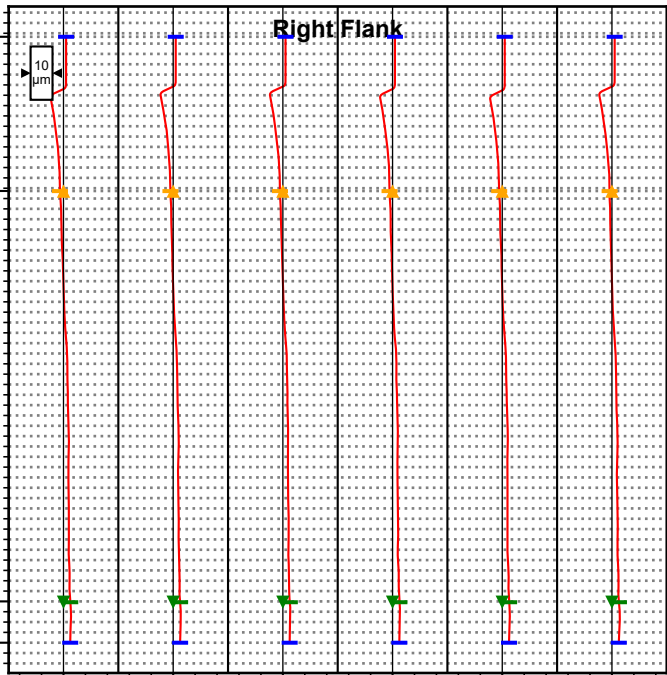
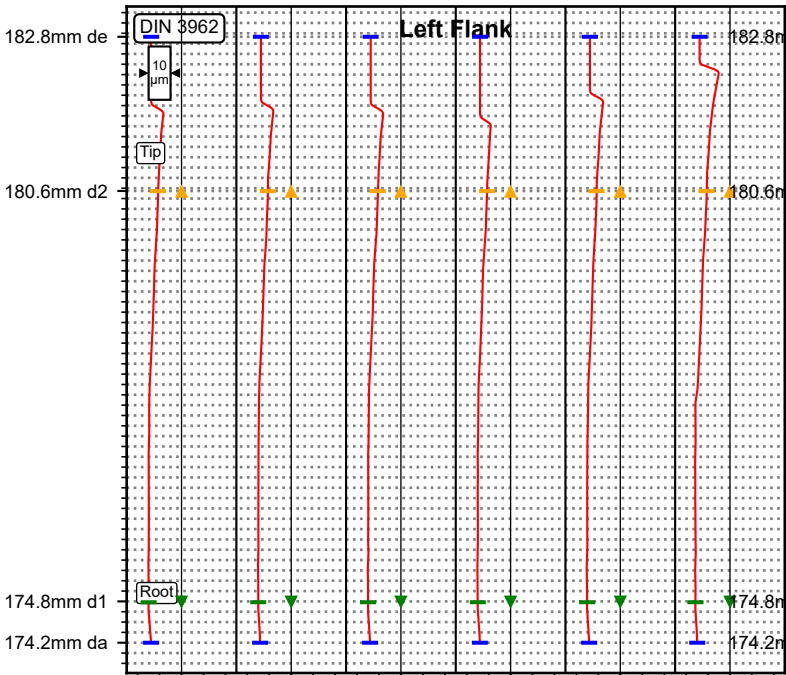
	61	60	59	58	57	56	Lim.value	Qual.	Lim.value	Qual.	56	57	58	59	60	61
fHam	4.3	3	V 1.0				±11	5	±11	5	-6.3	4	V 0.5			
fHa	4.2	4.4	3.9	4.6	4.9	3	4.0		±11	5	-6.5	-6.1	-6.6	4	-6.3	-6.2
fa	6.8	7.1	6.4	7.7	10.7	4	6.6		20	5	10.4	9.9	10.5	4	10.2	10.1
ffa	6.1	6.2	5.8	6.3	7.6	3	5.8		16	5	8.6	8.2	8.6	4	8.4	8.2
Ca	-1.9	-1.8	-1.9	-1.7	-2.2	-1.7					1.3	1.3	1.2	1.3	1.2	1.1



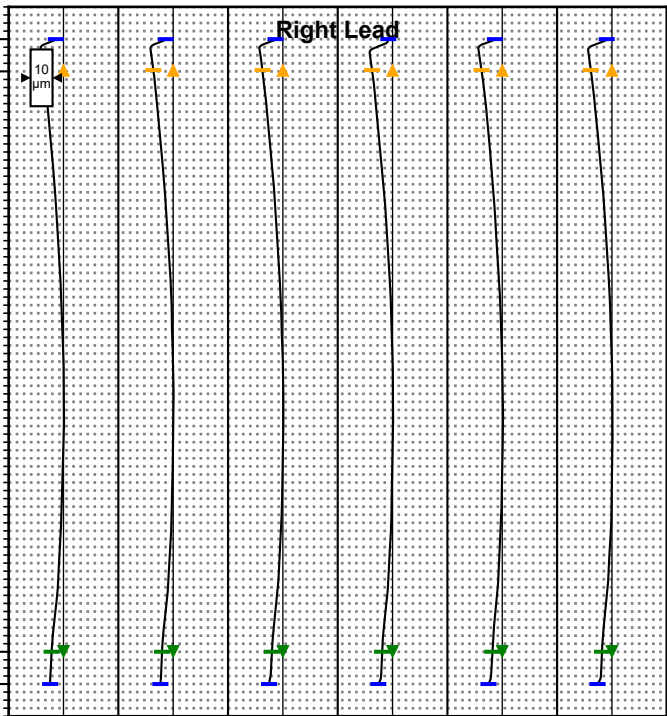
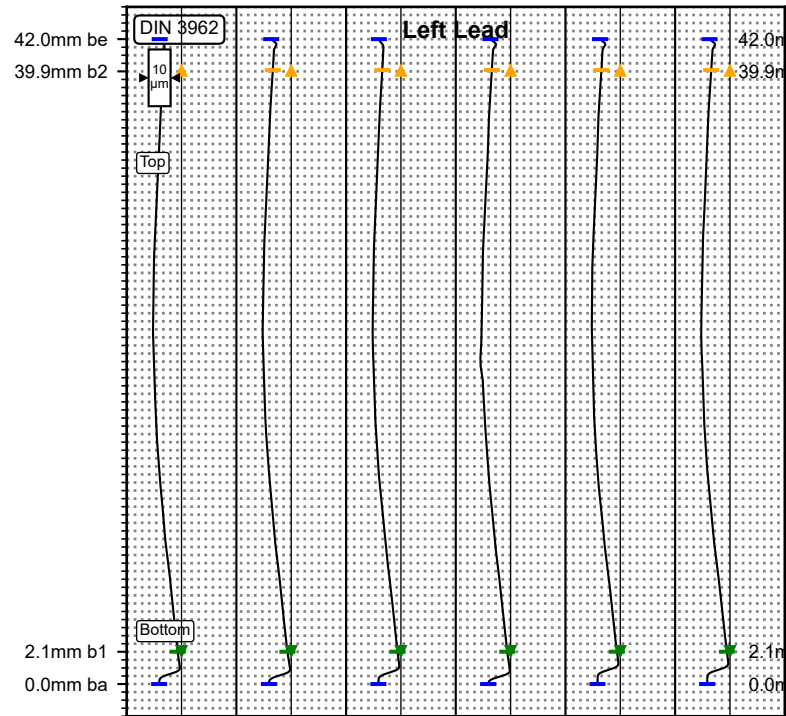
	61	60	59	58	57	56	Lim.value	Qual.	Lim.value	Qual.	56	57	58	59	60	61
fHbm	-6.4	5	V 0.8				±8	5	±8	5	-2.6	2	V 2.7			
fHb	-6.6	5	-6.5	-6.6	5	-6.6	5	-6.4	-5.8		-1.3	-2.0	-2.3	-2.8	-3.5	-4.0
fb	13.2	13.3	13.4	12.4	13.6	6	13.2		12	5	9.9	11.3	11.3	11.5	5	11.4
ffb	16.4	16.0	16.5	8	11.9	16.5	8	15.7		9	5	9.3	10.2	6	10.1	9.3
Cb	-8.2	-8.2	-8.1	-7.9	-8.1	-8.1					7.1	7.3	7.1	7.0	7.0	7.0

Gear Profile/Lead

Prog.No.:	temp.mka	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.- $\varnothing$ db:	167.6532mm	Stylus- $\varnothing$ :	1.000mm
Condition:	Grinding-0403	Base Helix ang:	23.893°	Add.Mod.Coe:	-0.378



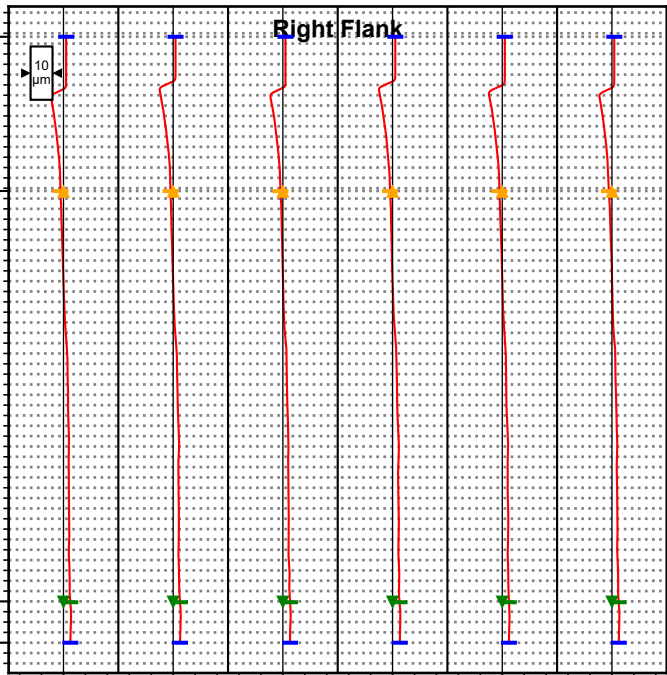
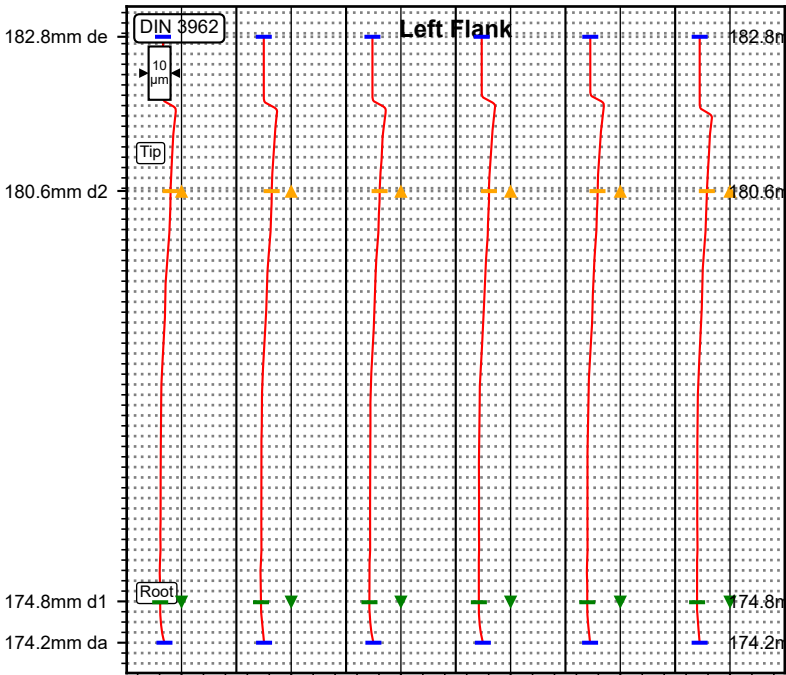
	67	66	65	64	63	62	Lim.value Qual.	Lim.value Qual.	62	63	64	65	66	67
fHam	5.2 3	V 4.3					±11 5	±11 5	-5.9 4	V 0.3				
fHa	4.6	4.7	4.6	3.9	5.2	8.2 5	±11 5	±11 5	-5.9	-5.8	-6.0 4	-5.8	-5.7	-5.9
fa	7.2	7.4	7.3	6.6	8.0	11.5 4	20 5	20 5	9.9	9.8	10.0 3	9.7	9.5	9.9
ffa	6.4	6.6	6.5	5.9	7.0	9.9 4	16 5	16 5	8.2 4	8.0	8.2 4	7.8	7.7	8.1
Ca	-1.8	-1.8	-1.8	-1.8	-1.7	-2.0			1.4	1.3	1.3	1.3	1.3	1.2



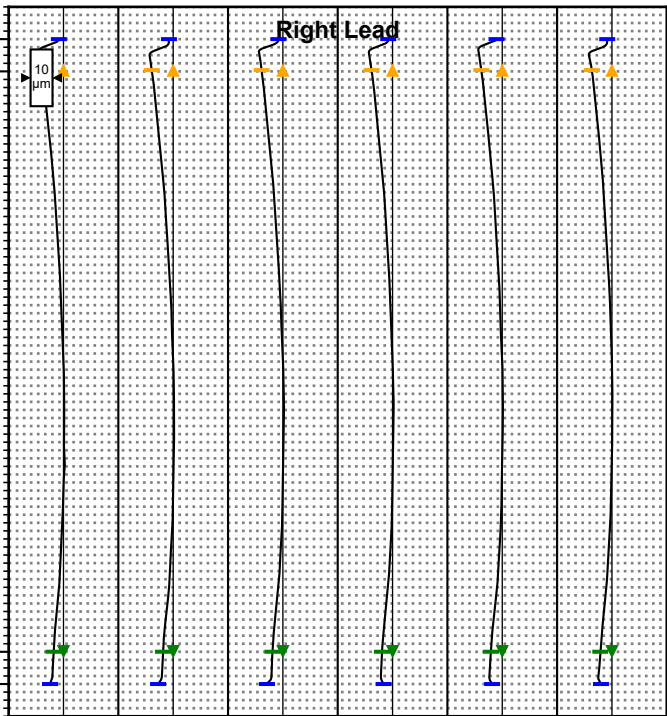
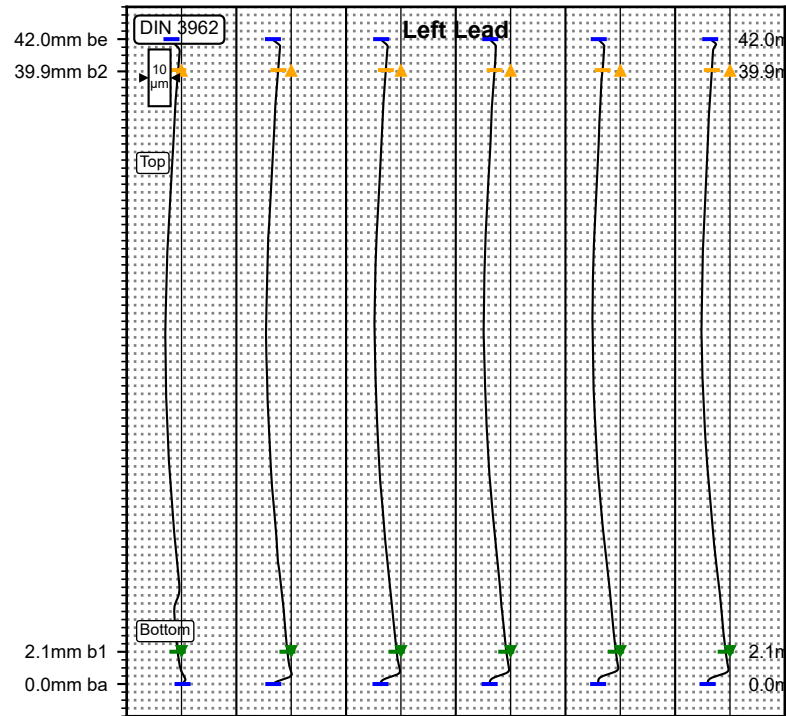
	67	66	65	64	63	62	Lim.value Qual.	Lim.value Qual.	62	63	64	65	66	67
fHbm	-6.5 5	V 0.7					±8 5	±8 5	-4.9 4	V 1.4				
fHb	-6.4	-6.4	-6.6	-6.9 5	-6.2	-6.3	±8 5	±8 5	-4.2	-4.5	-4.9	-4.8	-5.4	-5.6 4
fb	13.2	13.4	12.8	14.3 6	12.7	12.8	12 5	12 5	11.6	11.4	11.8	11.4	12.1 6	12.1 6
ffb	12.6	16.1	11.9	17.0 8	16.3	16.2	9 5	9 5	9.4	9.1	10.2	11.3	11.5	12.6 7
Cb	-7.9	-7.9	-7.9	-8.3	-8.0	-8.1			7.1	7.0	7.0	7.0	6.9	7.0

Gear Profile/Lead

Prog.No.:	temp.mka	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



	73	72	71	70	69	68	Lim.value Qual.	Lim.value Qual.	68	69	70	71	72	73
fHam	5.0 3	V 0.9					±11 5	±11 5	-6.0 4	V 0.6				
fHa	4.9	5.1	4.9	5.2	5.4 3	4.5	±11 5	±11 5	-5.8	-6.2	-5.8	-6.4 4	-6.0	-5.8
fa	7.7	7.9	7.9	8.0	8.2 3	7.2	20 5	20 5	9.7	10.2	9.8	10.4 4	9.9	9.7
ffa	6.7	7.0	6.9	7.1	7.2 3	6.4	16 5	16 5	7.9	8.3	7.9	8.5 4	8.3	7.8
Ca	-1.9	-2.0	-1.8	-2.0	-1.9	-1.9			1.4	1.3	1.0	1.3	1.3	1.1

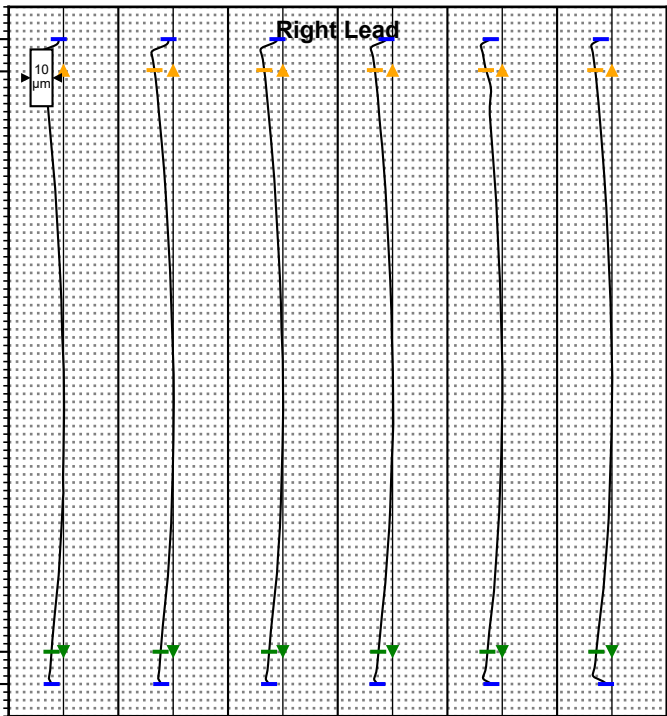
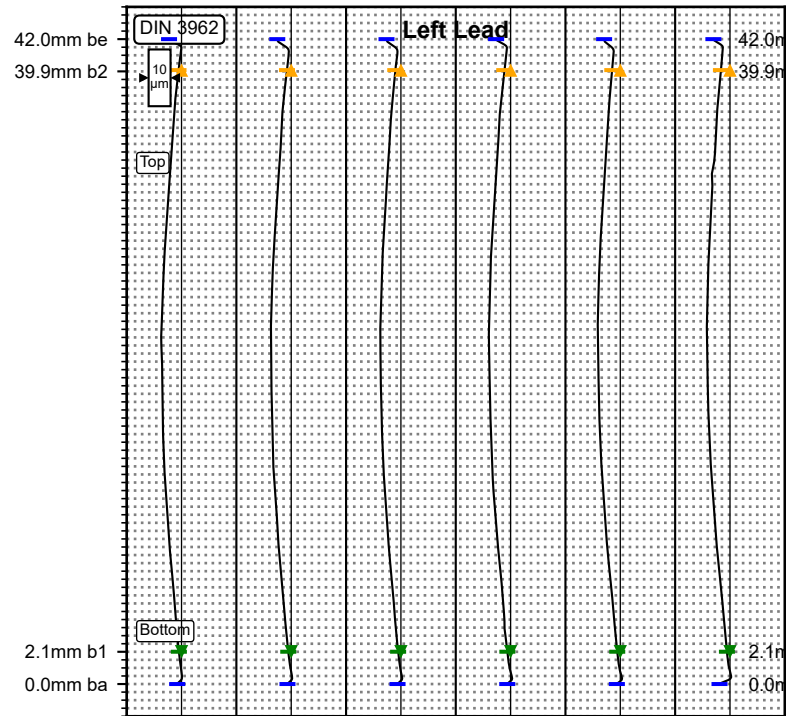
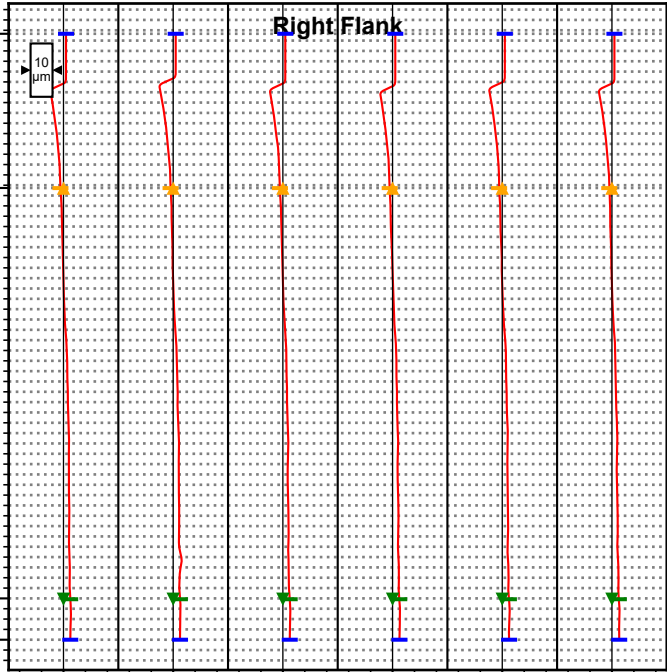
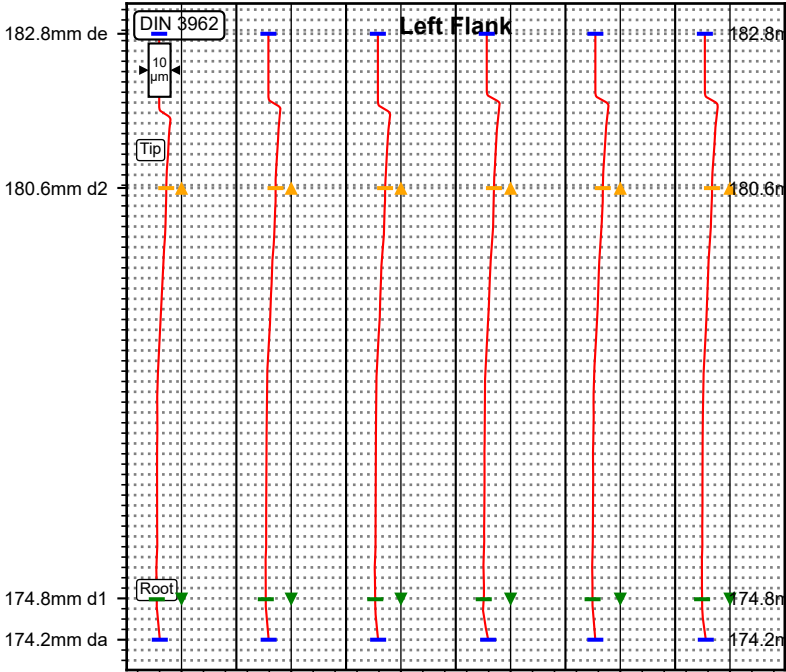


	73	72	71	70	69	68	Lim.value Qual.	Lim.value Qual.	68	69	70	71	72	73
fHbm	-4.7 4	V 4.5					±8 5	±8 5	-5.1 4	V 1.6				
fHb	-1.6	-4.5	-5.0	-5.3	-5.8	-6.1 5	±8 5	±8 5	-5.6 4	-5.2	-5.4	-5.2	-4.9	-4.0
fb	11.7	13.7 6	13.2	13.0	13.0	13.6	12 5	12 5	12.7 6	12.0	12.7 6	12.3	12.2	12.3
ffb	10.8	13.7	13.2	12.2	13.2	16.5 8	9 5	9 5	11.5	13.0	14.3 7	9.9	9.7	10.2
Cb	-5.8	-7.7	-7.7	-7.6	-7.7	-7.9			7.1	7.1	7.2	7.1	7.2	7.0



Gear Profile/Lead

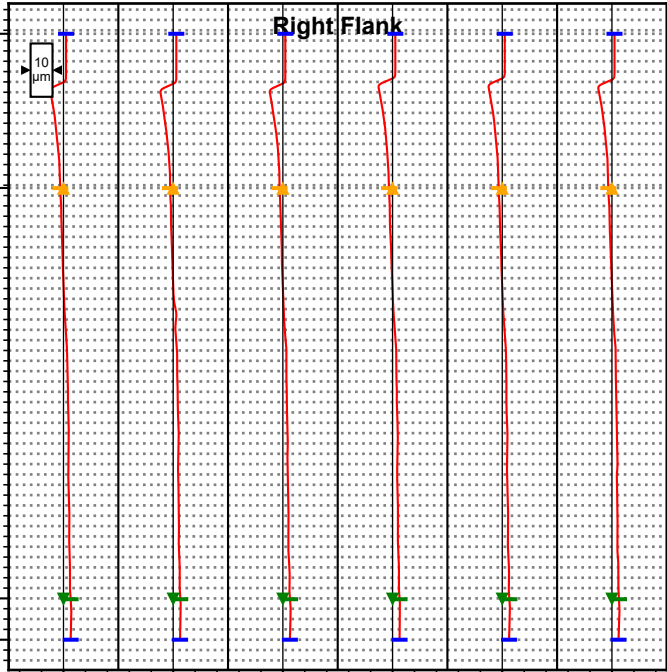
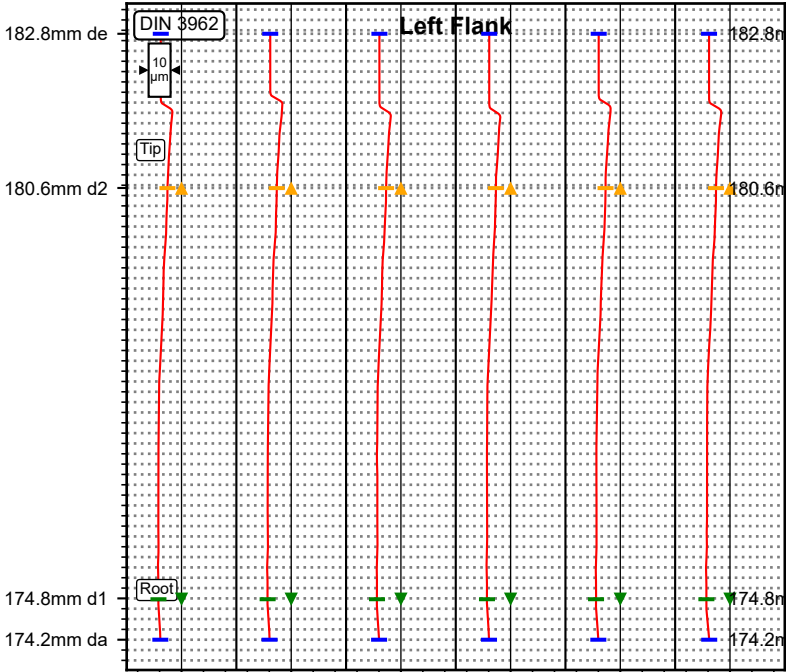
Prog.No.:	temp.mka	Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. L $\alpha$ :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L $\beta$ :	37.80mm
Cust./Mach. N:	P26 -601418	Helix angle:	25.30°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



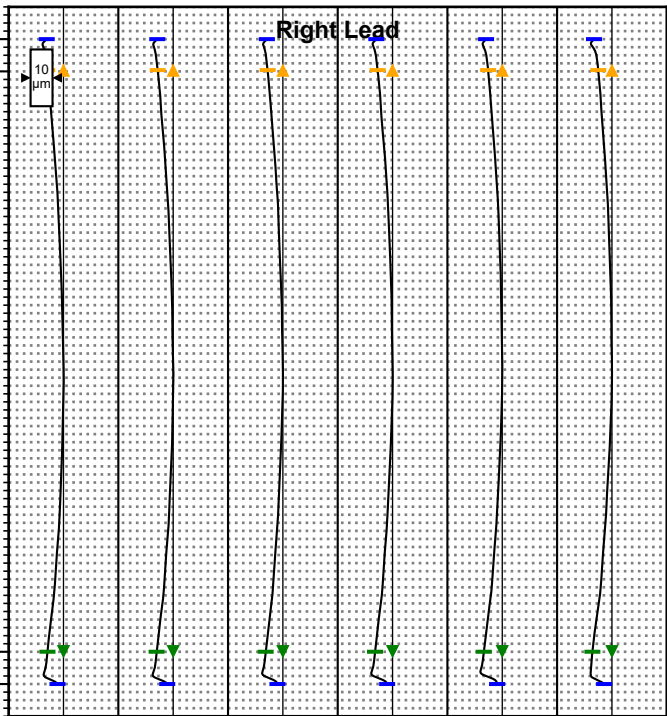
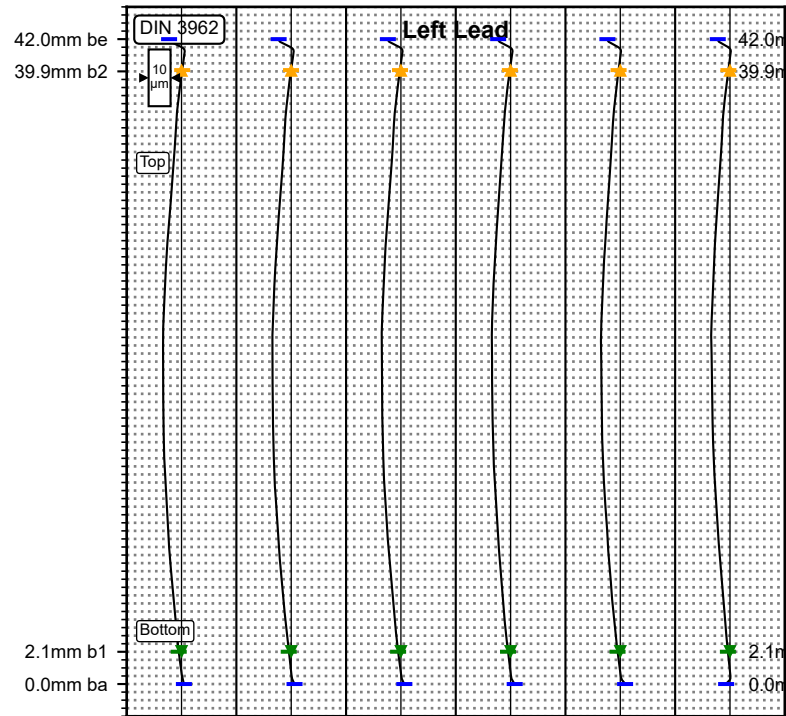
	79	78	77	76	75	74	Lim.value Qual.	Lim.value Qual.	74	75	76	77	78	79
fHbm	-1.9 1	V 2.9					±8 5	±8 5	-2.3 1	V 2.5				
fHb	-0.4	-1.0	-1.8	-2.0	-2.9	-3.3 2	±8 5	±8 5	-3.7 3	-3.0	-2.6	-1.9	-1.2	-1.3
fb	14.3 6	10.7	11.3	13.2	12.7	12.7	12 5	12 5	12.4 6	11.8	12.2	12.2	11.7	11.2
ffb	14.5 7	10.2	10.3	14.1	11.2	13.9	9 5	9 5	10.4	10.2	10.8	11.3	11.6 6	11.5
Cb	-7.8	-7.6	-7.5	-7.7	-7.8	-7.8			7.0	7.0	7.2	7.3	6.7	7.2

Gear Profile/Lead

Prog.No.:	temp.mka	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



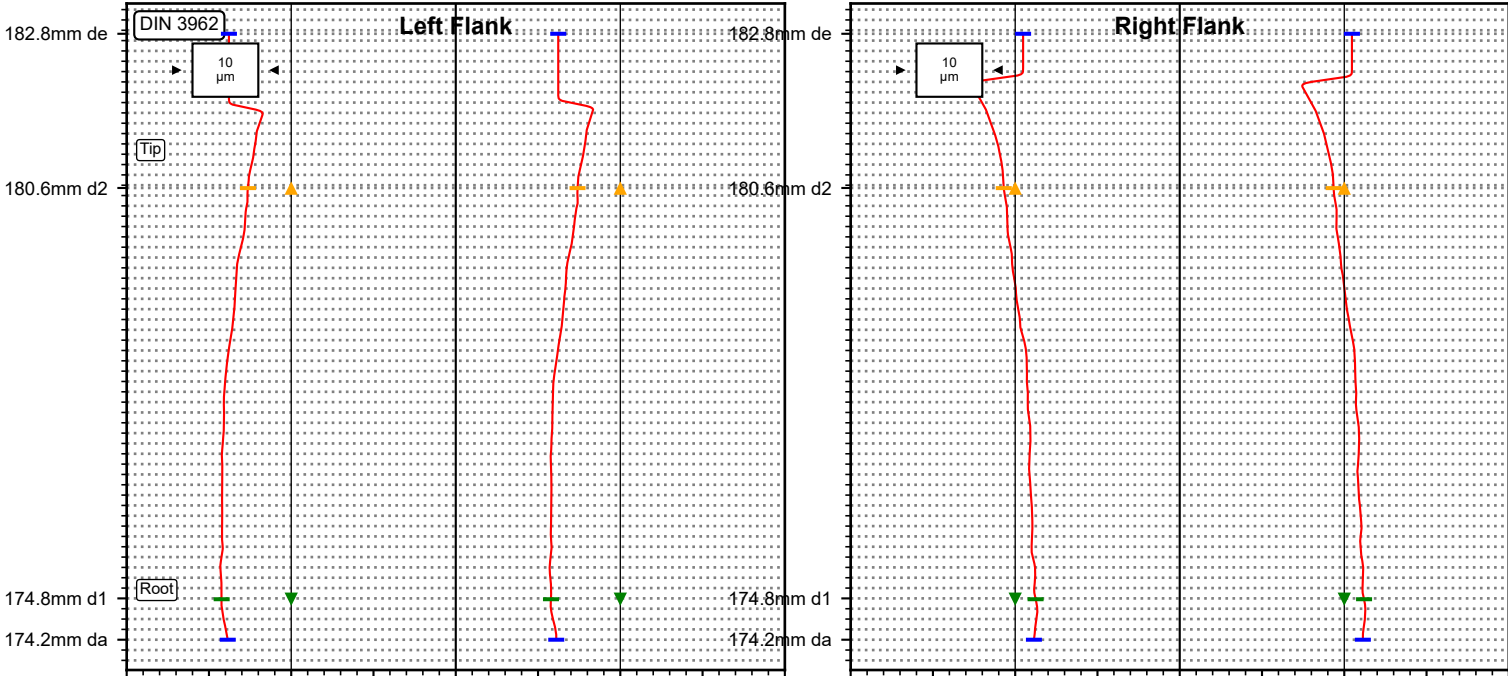
	85	84	83	82	81	80	Lim.value Qual.	Lim.value Qual.	80	81	82	83	84	85
fHm	4.4 3	V 0.8					±11 5	±11 5	-6.2 4	V 0.6				
fHa	4.3	4.8 3	4.1	4.0	4.6	4.5	±11 5	±11 5	-6.2	-5.9	-6.0	-6.4	-6.5 4	-6.3
fa	6.9	7.5 3	6.7	6.6	7.1	7.3	20 5	20 5	10.1	9.9	10.1	10.4 4	10.3	10.3
ffa	6.2	6.5 3	6.0	5.9	6.3	6.5 3	16 5	16 5	8.2	8.3	8.2	8.7 4	8.5	8.5
Ca	-1.8	-1.7	-1.8	-1.8	-1.8	-1.8			1.3	1.4	1.0	1.4	1.2	1.3



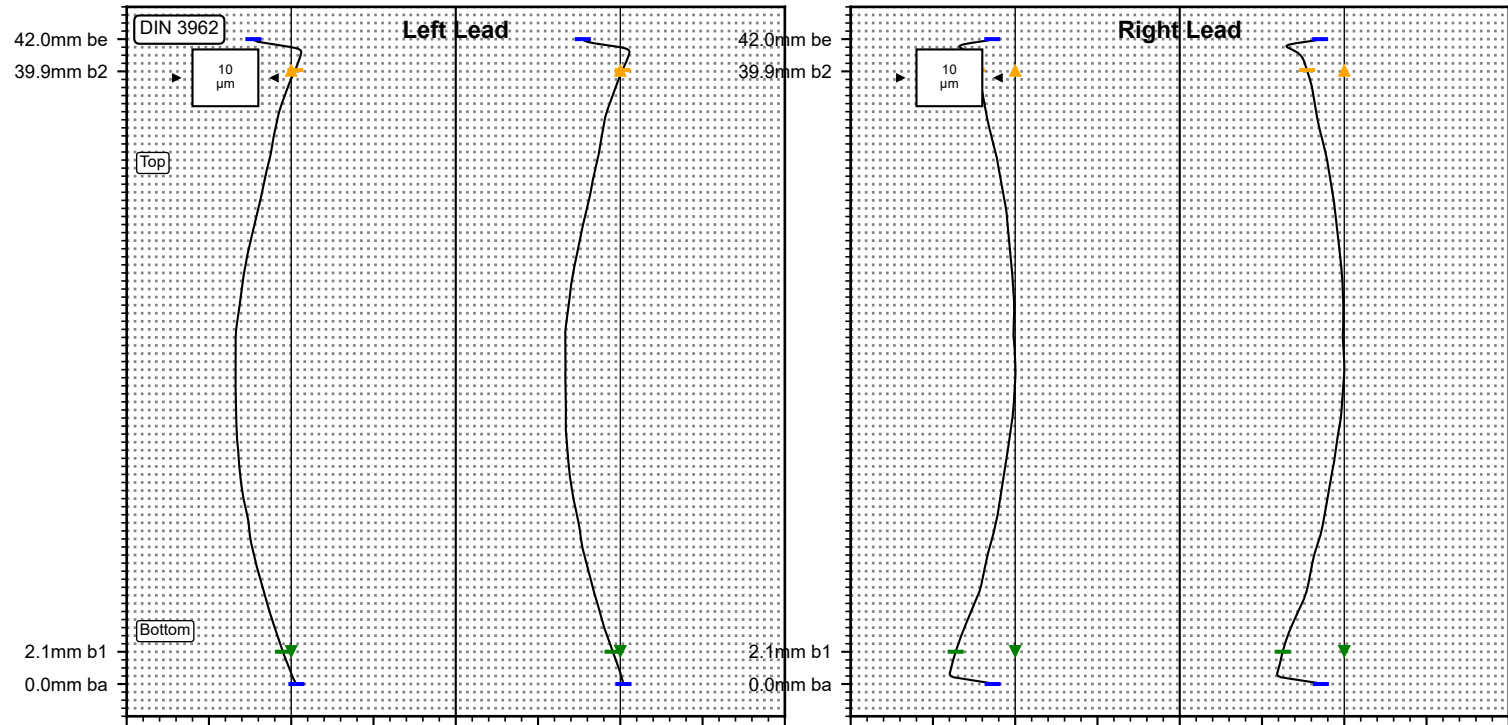
	85	84	83	82	81	80	Lim.value Qual.	Lim.value Qual.	80	81	82	83	84	85
fHbm	0.6 1	V 1.7					±8 5	±8 5	0.4 1	V 2.8				
fHb	1.4 1	0.9	0.6	0.5	0.2	-0.3	±8 5	±8 5	-0.9	-0.2	0.2	0.6	1.1	1.9 1
fb	10.7	11.9	12.3	13.0	13.9 6	9.4	12 5	12 5	11.4	11.7	11.4	12.0	11.9	12.5 6
ffb	11.4	12.5	12.7	13.2	14.0 7	9.5	9 5	9 5	11.6	11.8	11.3	11.7	11.6	13.5 7
Cb	-7.9	-7.9	-7.8	-7.7	-7.6	-7.5			7.2	7.2	7.2	7.3	7.3	7.4

Gear Profile/Lead

Prog.No.:	temp.mka	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



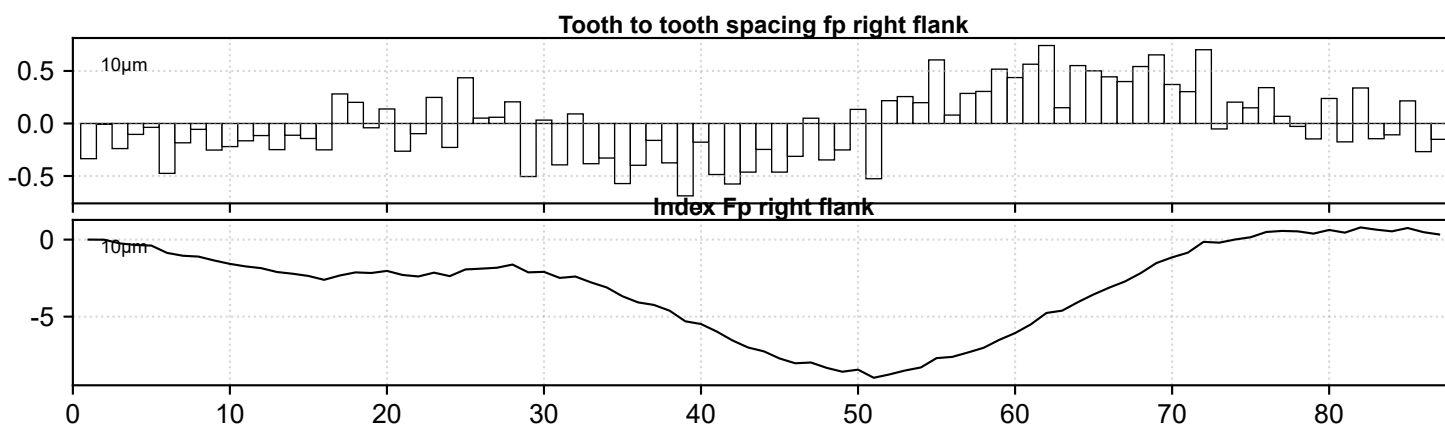
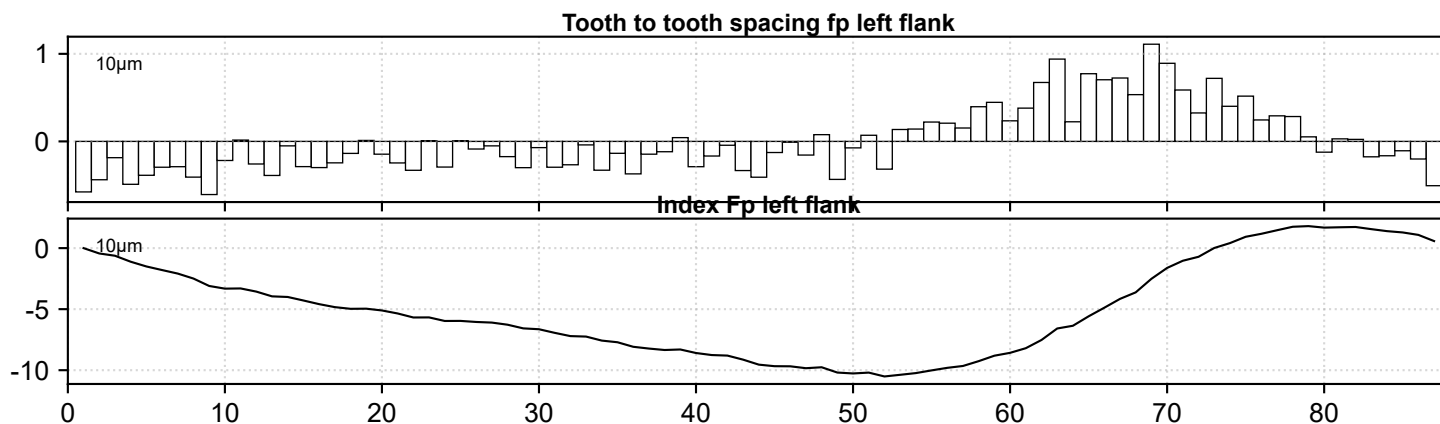
0.	87	86	Lim.value Qual.	Lim.value Qual.	86	87
fHam	4.2 3	V 0.3	±11 5	±11 5	-6.4 4	V 0.3
fHa	4.1	4.4 3	±11 5	±11 5	-6.6 4	-6.3
fa	6.7	6.9 2	20 5	20 5	10.5 4	10.2
ffa	5.9	6.1 3	16 5	16 5	8.8 4	8.6
Ca	-1.6	-1.7			1.4	1.3



0.	87	86	Lim.value Qual.	Lim.value Qual.	86	87
fHbm	1.7 1	V 0.4	±8 5	±8 5	3.0 2	V 0.6
fHb	1.9 1	1.5	±8 5	±8 5	2.7	3.3 2
fb	10.8 5	10.8 5	12 5	12 5	11.2	12.1 6
ffb	11.0 6	10.1	9 5	9 5	12.6	13.8 7
Cb	-8.0	-7.9			7.4	7.4

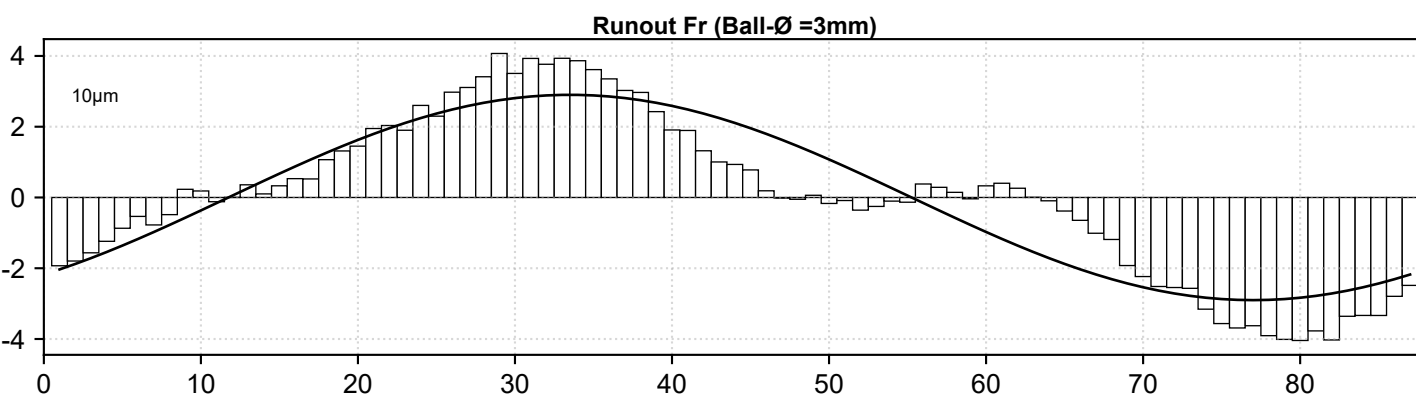
## Gear Spacing

<b>Prog.No.:</b>	temp.mka	<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