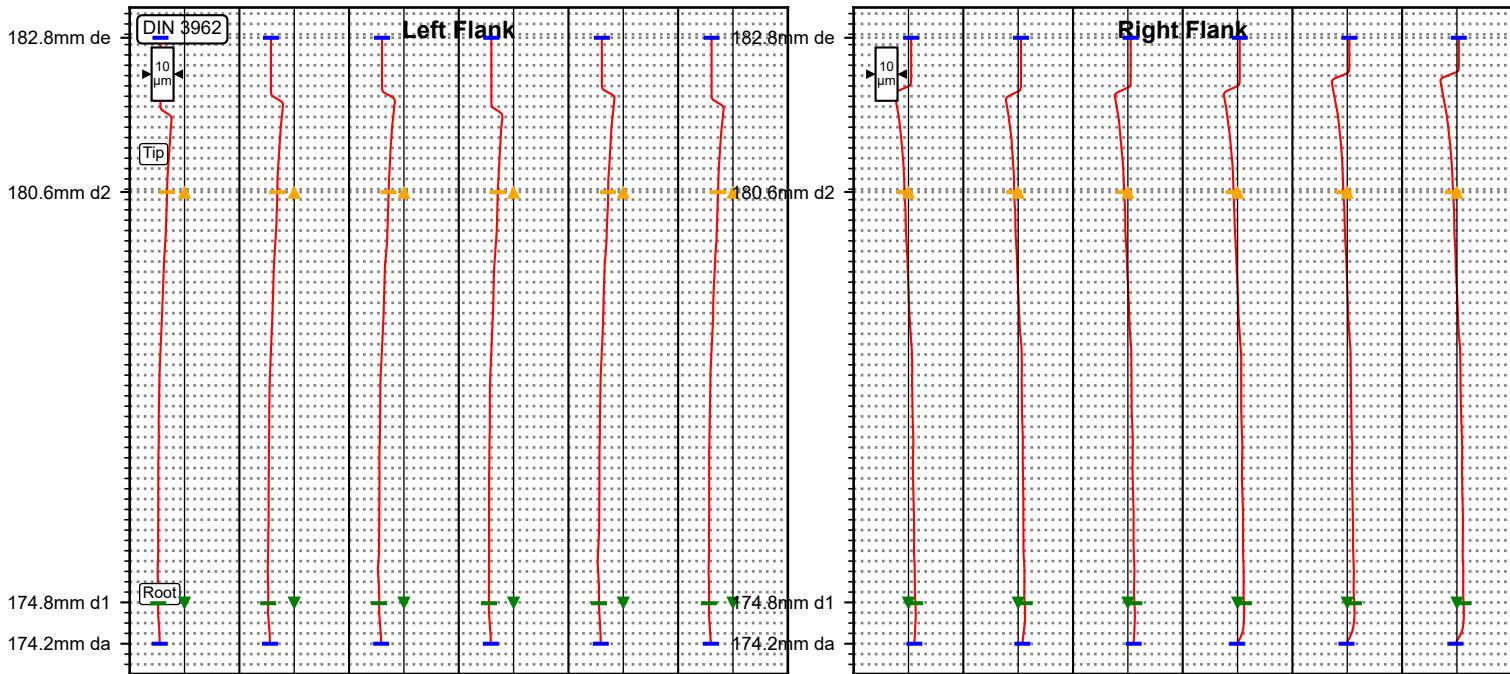
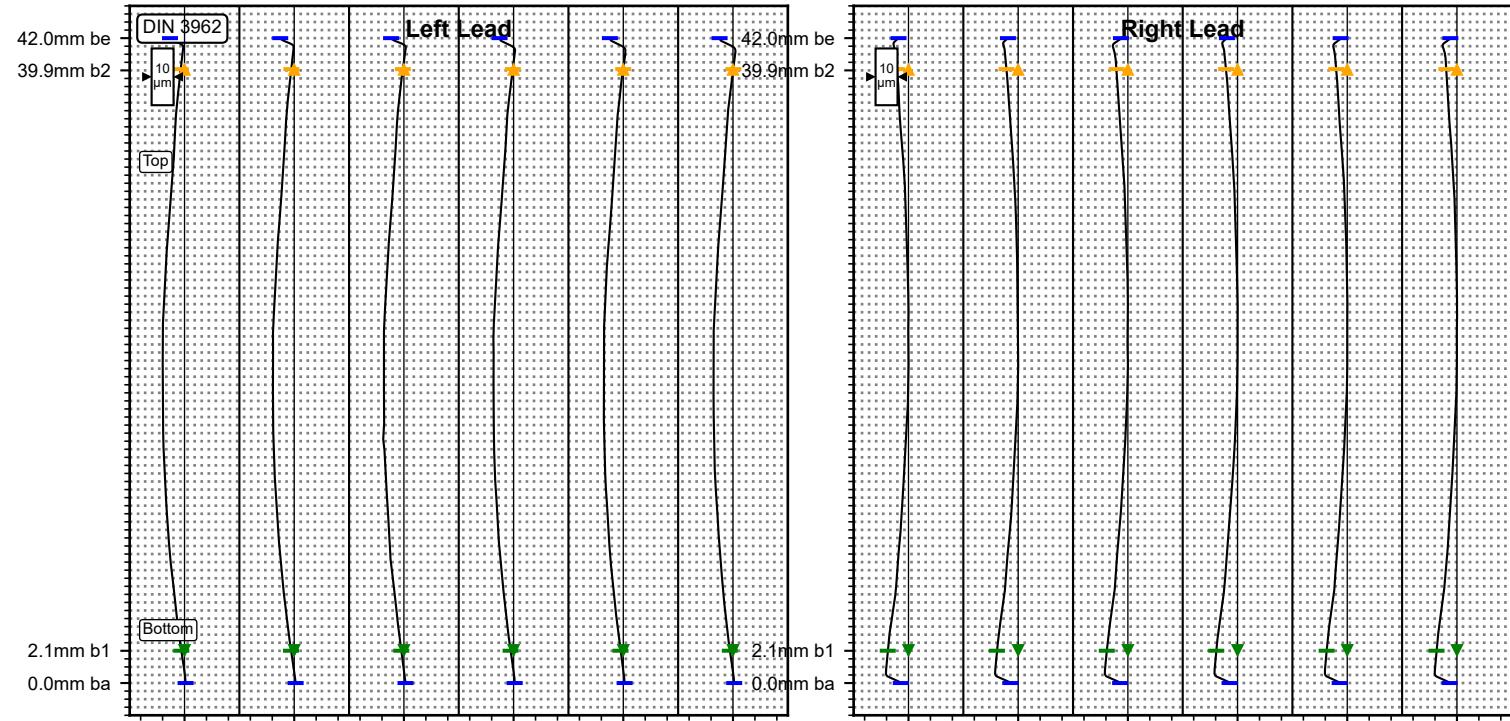


Gear Profile/Lead

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



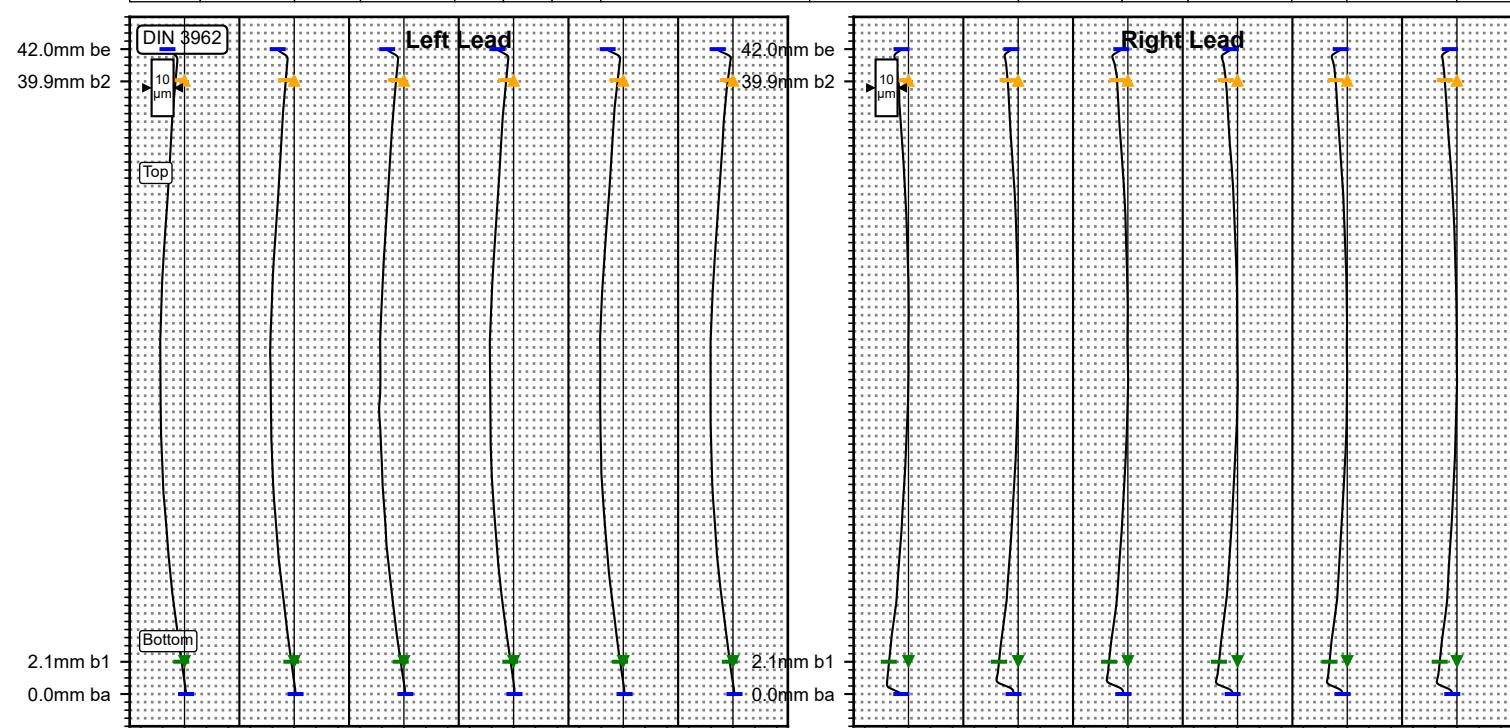
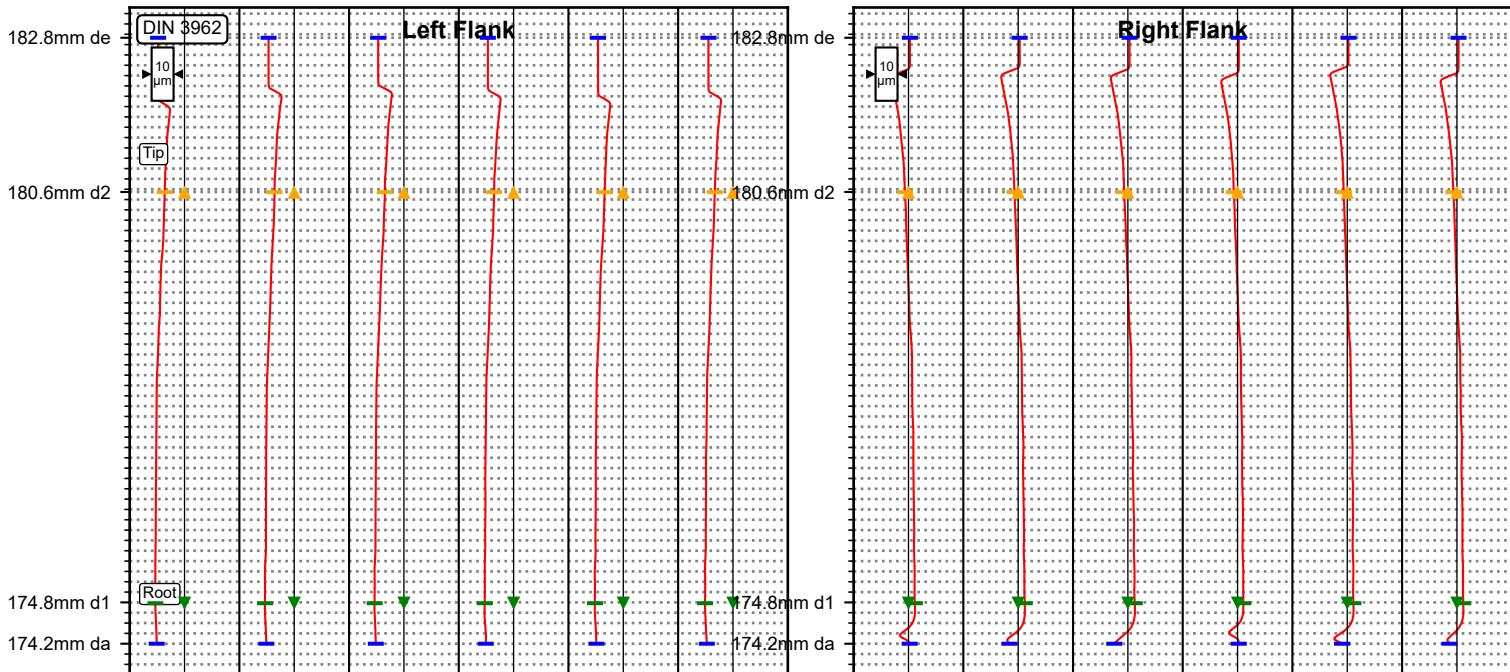
	7	6	5	4	3	2	Lim.value Qual.	Lim.value Qual.	2	3	4	5	6	7
fHam	4.7	3	V 1.1				±11 5	±11 5	-6.3	4	V 1.6			
fHa	4.1	4.8	5.2	3	4.1	5.2	3	4.6	±11 5	±11 5	-6.2	-5.6	-6.0	-6.0
fa	6.7	7.4	8.3	3	6.6	8.3	3	7.2	20 5	20 5	10.1	9.3	9.7	9.8
ffa	5.9	6.4	6.9	3	5.8	6.9	3	6.3	16 5	16 5	8.5	7.9	8.2	8.3
Ca	-1.7	-1.6	-1.6	-1.7	-1.5	-1.7					1.3	1.3	1.2	1.4
											1.1	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	4.3	
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	
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	
Cb	-8.4	-8.3	-8.2	-8.2	-8.1	-8.0					7.4	7.4	7.4	7.4	7.1

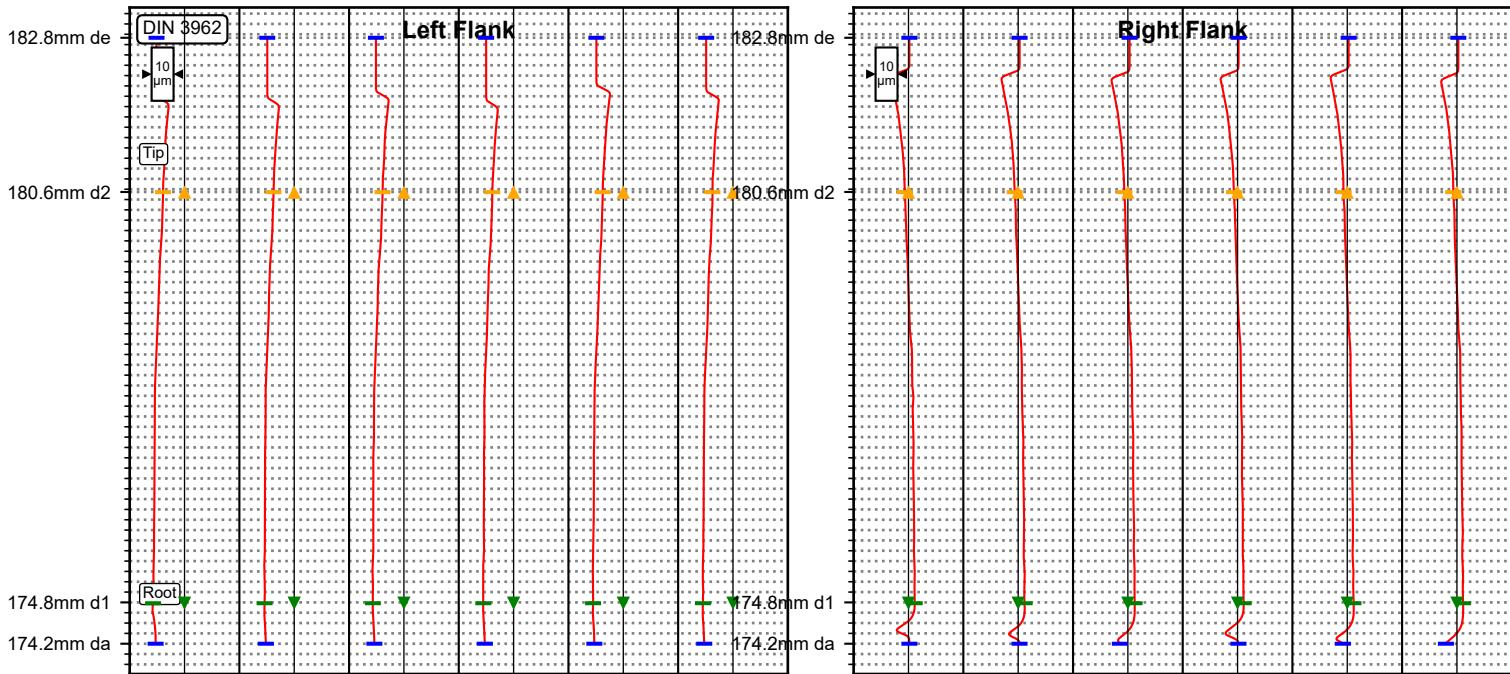
Gear Profile/Lead

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

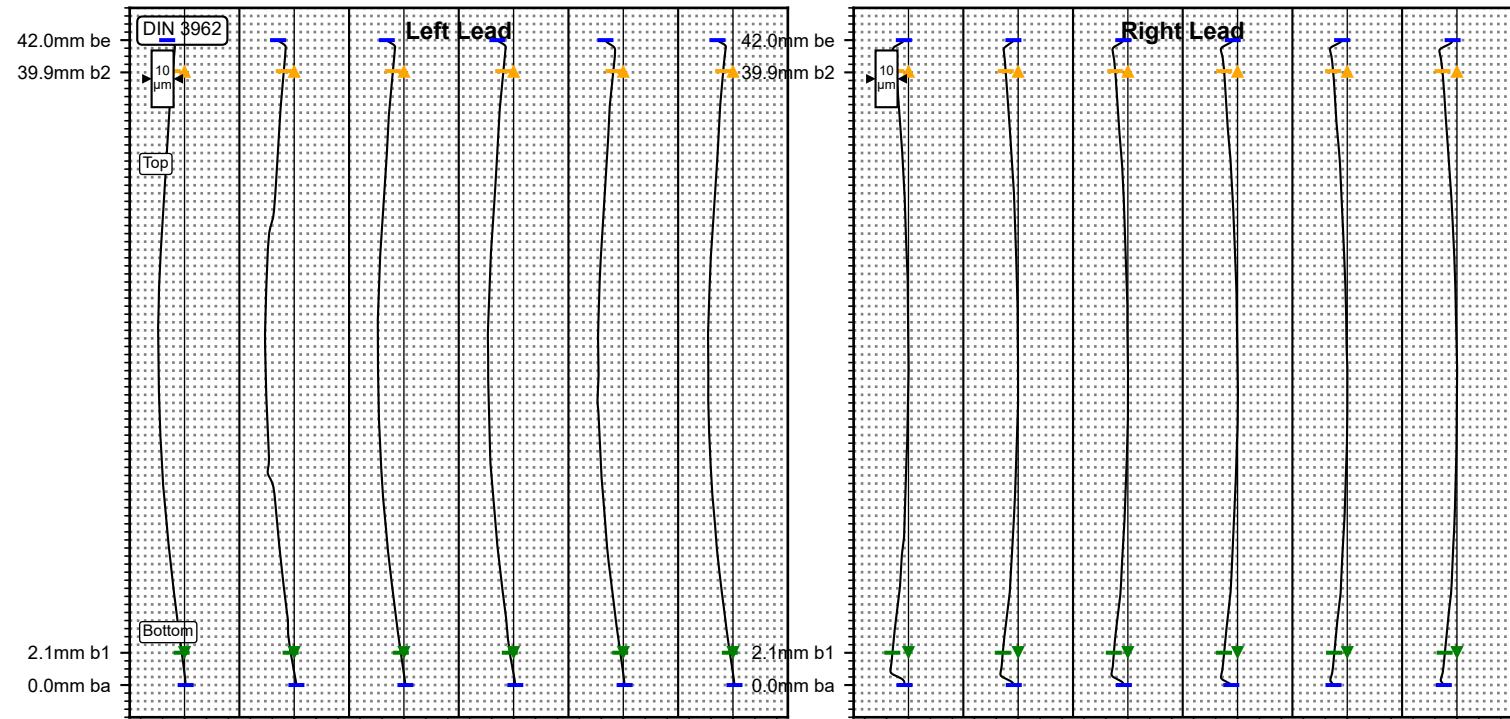


Gear Profile/Lead

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. La:	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



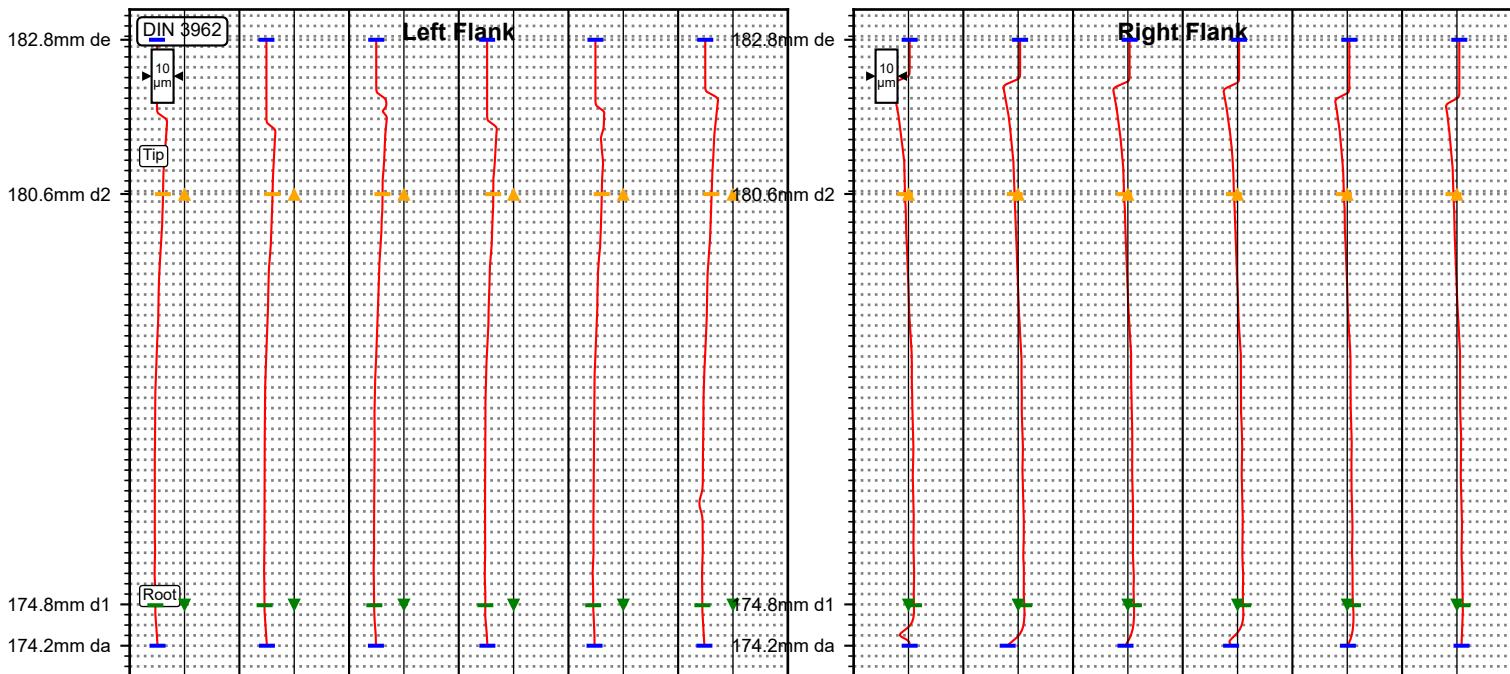
	19	18	17	16	15	14	Lim.value Qual.		Lim.value Qual.	14	15	16	17	18	19
fHam	5.0 3	V 1.1					±11 5		±11 5	-6.4 4	V 0.4				
fHa	4.8	4.6	5.2	4.5	5.6 4	5.2	±11 5		±11 5	-6.4	-6.5 4	-6.5 4	-6.1	-6.4	-6.2
fa	7.7	7.1	7.8	7.0	8.4 3	7.9	20 5		20 5	12.1 4	11.3	11.4	11.4	11.3	10.8
ffa	6.3	6.1	6.8	6.1	7.2 3	6.8	16 5		16 5	15.9 5	14.7	14.3	14.6	14.9	13.5
Ca	-1.6	-1.5	-1.7	-1.6	-1.5	-1.5				1.4	1.3	1.3	1.3	1.3	1.3



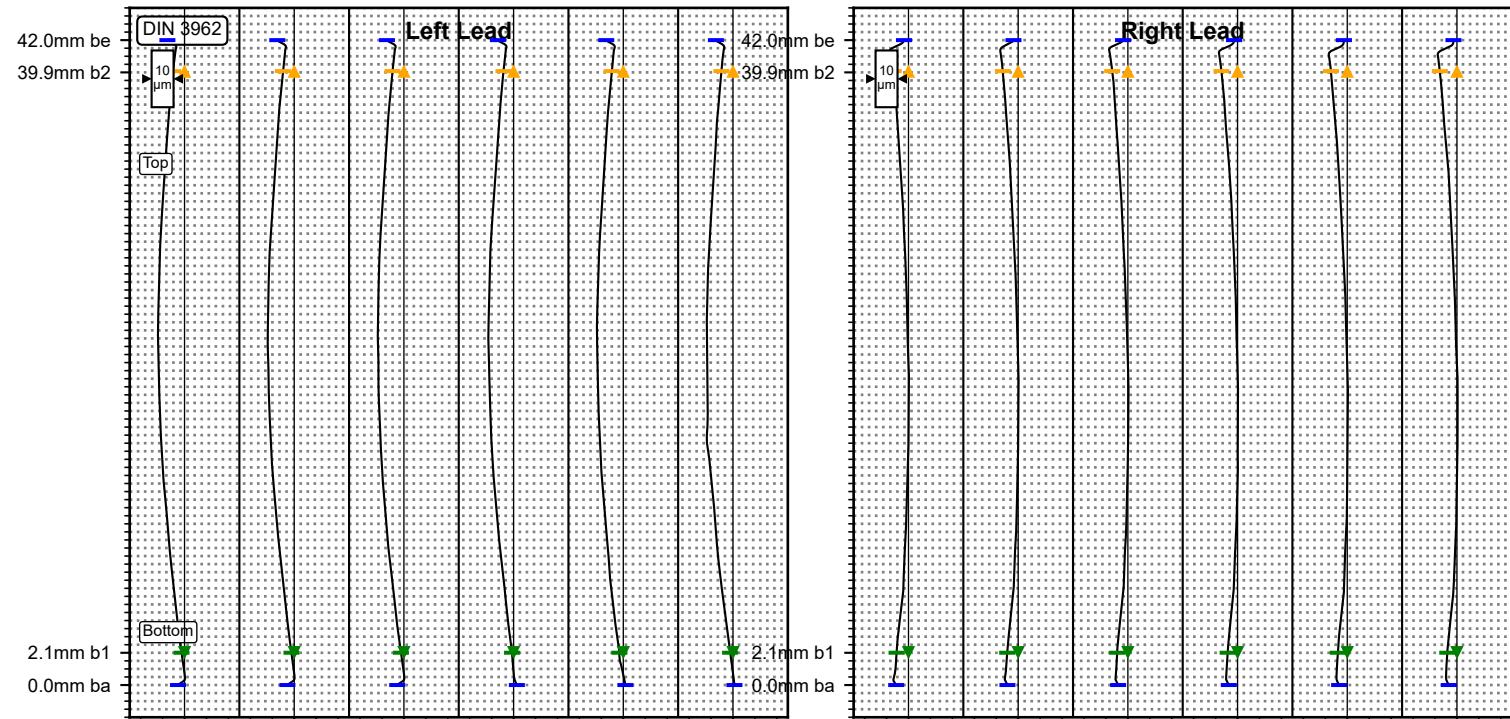
	19	18	17	16	15	14	Lim.value Qual.		Lim.value Qual.	14	15	16	17	18	19
fHbm	-3.2 2	V 1.7					±8 5		±8 5	-0.2 1	V 2.5				
fHb	-4.1 3	-3.7	-3.5	-2.9	-2.9	-2.4	±8 5		±8 5	1.0	0.8	-0.0	-0.6	-1.0	-1.5 1
fb	12.9	14.7 6	13.1	13.1	12.6	13.6	12 5		12 5	9.5	9.6 4	9.0	9.3	9.4	9.6 4
ffb	14.5	15.9 7	14.6	14.5	12.1	14.8	9 5		9 5	9.1	9.2	9.0	9.5	9.9 6	9.8
Cb	-8.7	-10.7	-8.8	-8.7	-8.6	-8.5				6.3	6.2	6.0	6.1	6.1	6.0

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. La:	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



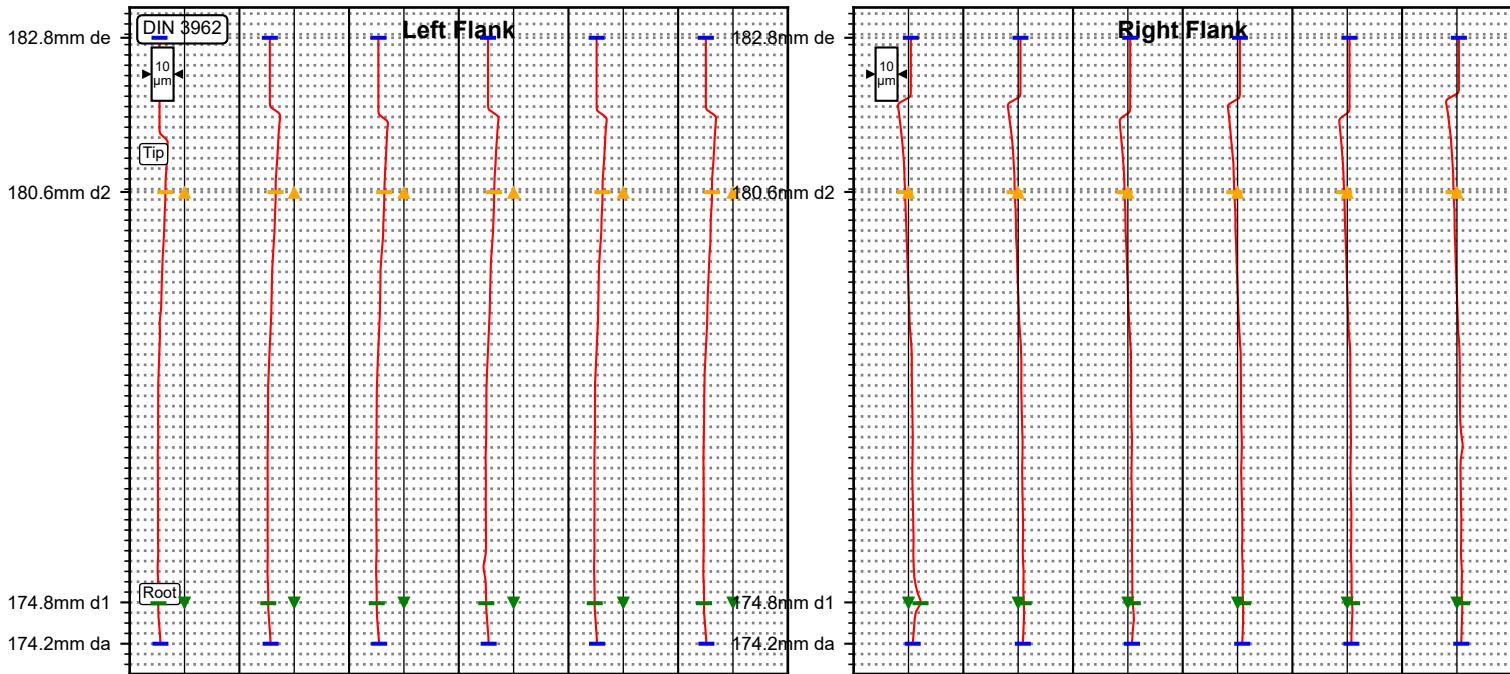
	25	24	23	22	21	20	Lim.value Qual.	Lim.value Qual.	20	21	22	23	24	25
fHam	3.9 2	V 2.0					±11 5	±11 5	-5.4 3	V 1.2				
fHa	3.5	3.2	4.4	3.4	3.8	5.2 3	±11 5	±11 5	-5.8	-5.8	-6.0 4	-5.2	-5.1	-4.8
fa	6.0	5.5	6.2	5.8	6.1	9.1 3	20 5	20 5	10.4 4	10.2	10.1	9.6	8.8	8.2
ffa	5.3	4.9	5.5	5.2	5.3	6.8 3	16 5	16 5	13.5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



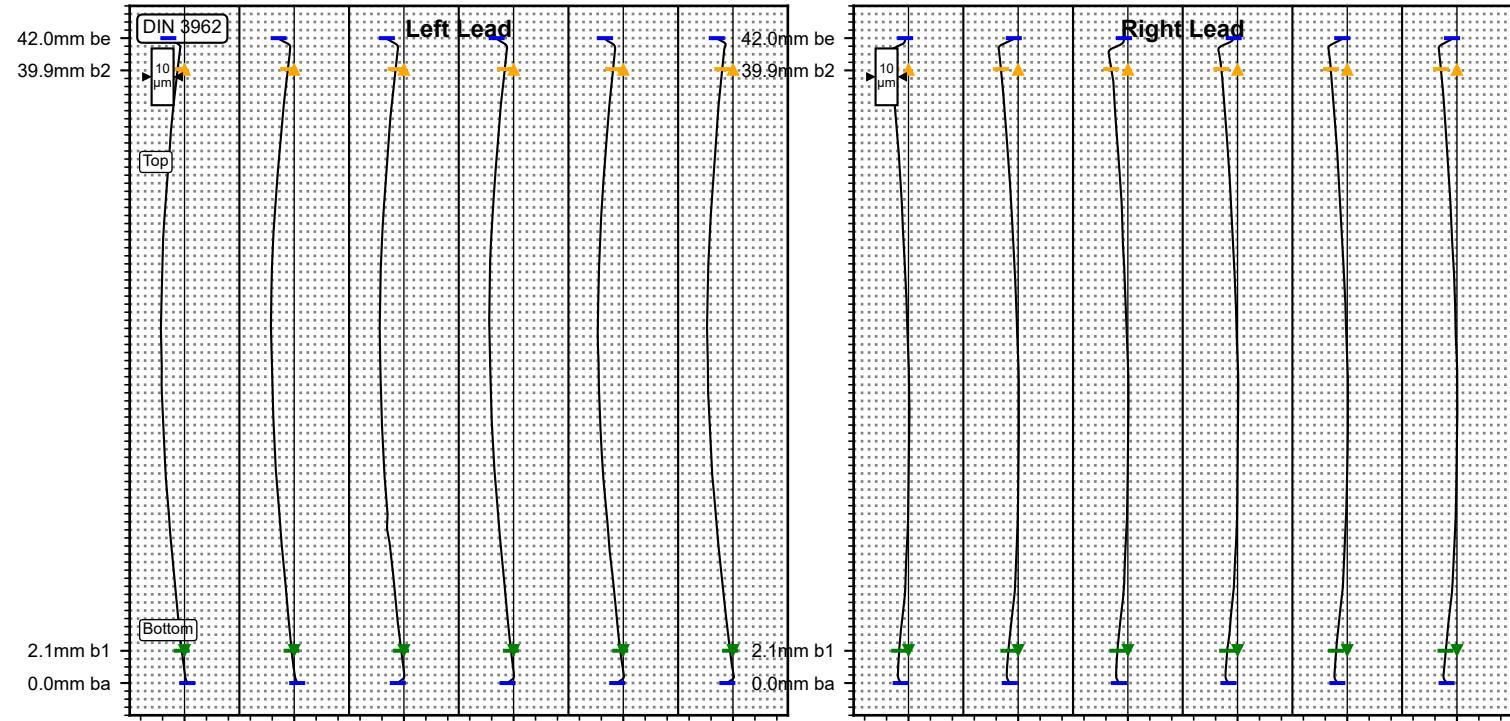
	25	24	23	22	21	20	Lim.value Qual.	Lim.value Qual.	20	21	22	23	24	25
fHbm	-4.1 3	V 0.6					±8 5	±8 5	-3.2 2	V 2.0				
fHb	-4.4 3	-4.2	-4.1	-4.3	-3.8	-3.9	±8 5	±8 5	-2.0	-2.7	-3.2	-3.4	-3.8	-4.0 3
fb	13.9	14.0	14.2	14.6 6	13.9	13.2	12 5	12 5	10.1 5	9.2	10.1 5	9.9	9.8	10.0
ffb	15.9	16.0 7	16.0 7	16.0 7	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.:		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



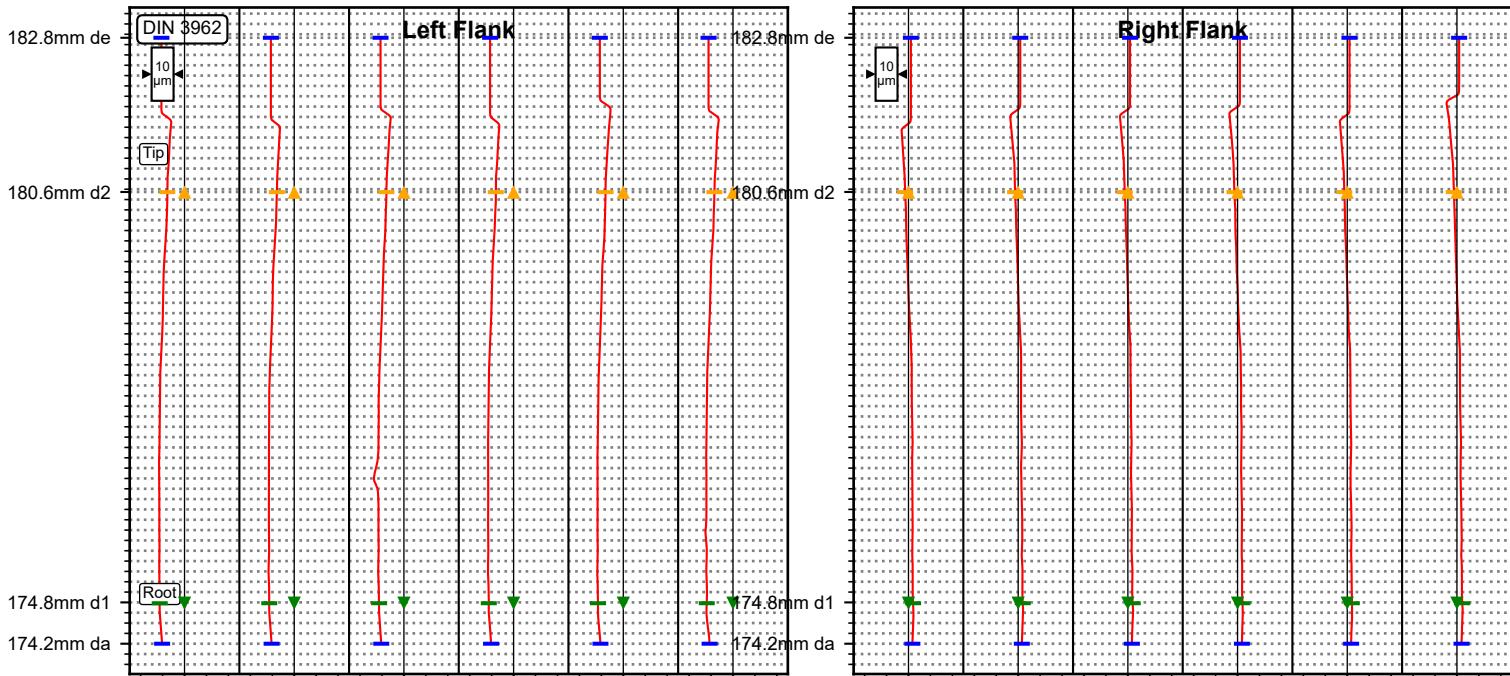
	31	30	29	28	27	26	Lim.value Qual.	Lim.value Qual.	26	27	28	29	30	31			
fHam	3.4	2	V 1.3				±11 5	±11 5	-4.4	3	V 1.7						
fHa	2.5	3.6	3.3	3.8	2	3.6	3.7	±11 5	±11 5	-5.2	3	-4.7	-3.7	-4.5	-3.5	-4.7	
fa	4.7	6.1	5.7	7.2	3	6.1	6.2	20 5	20 5	11.2	4	8.0	6.9	7.6	6.4	8.1	
ffa	4.2	5.4	5.1	5.5	2	5.4	5.5	2	16 5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



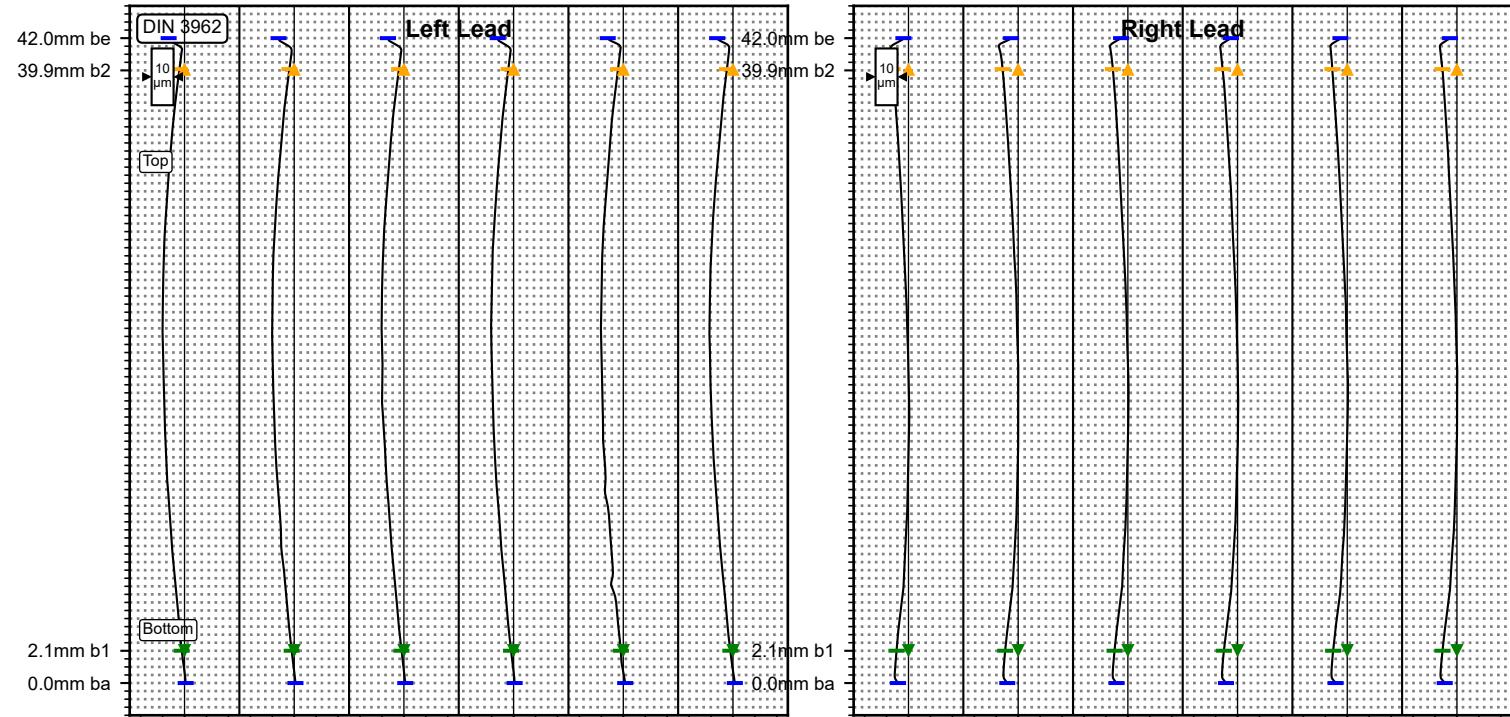
	31	30	29	28	27	26	Lim.value Qual.	Lim.value Qual.	26	27	28	29	30	31		
fHbm	-3.6	3	V 1.3				±8 5	±8 5	-3.7	3	V 1.5					
fHb	-2.9	-3.0	-3.2	-3.9	-4.2	3	-4.2	3	±8 5	±8 5	-4.1	-4.5	3	-3.5	-3.5	-3.0
fb	14.0	14.6	13.0	12.4	12.6	14.9	6	12 5	12 5	10.0	10.2	5	10.2	5	9.9	9.3
ffb	15.4	15.9	14.4	14.1	13.1	16.8	8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

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



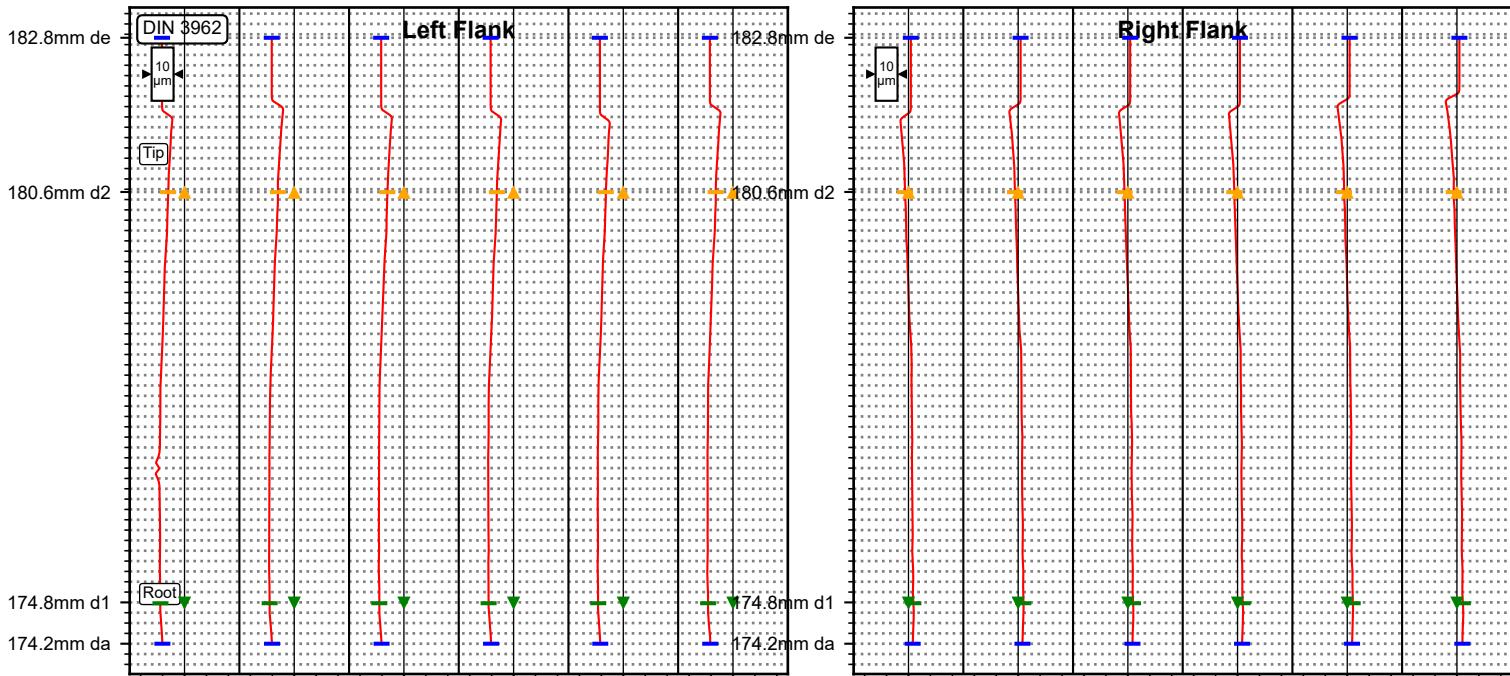
	37	36	35	34	33	32	Lim.value Qual.	Lim.value Qual.	32	33	34	35	36	37		
fHam	3.5	2	V 0.9				±11.5	±11.5	-3.7	2	V 1.4					
fHa	3.4	3.2	3.7	3.1	4.0	2	3.6	±11.5	±11.5	-3.2	-3.5	-3.6	-3.9	-3.4	-4.6	3
fa	5.8	5.6	8.3	3	5.6	6.4	6.4	20.5	20.5	5.8	6.3	6.5	6.6	6.0	7.9	3
ffa	5.2	5.0	6.0	2	4.9	5.6	5.4	16.5	16.5	5.1	5.4	5.5	5.8	5.2	6.7	3
Ca	-1.7	-1.7	-2.0	-1.8	-1.6	-1.8			1.4	1.1	1.1	1.3	1.2	1.1		



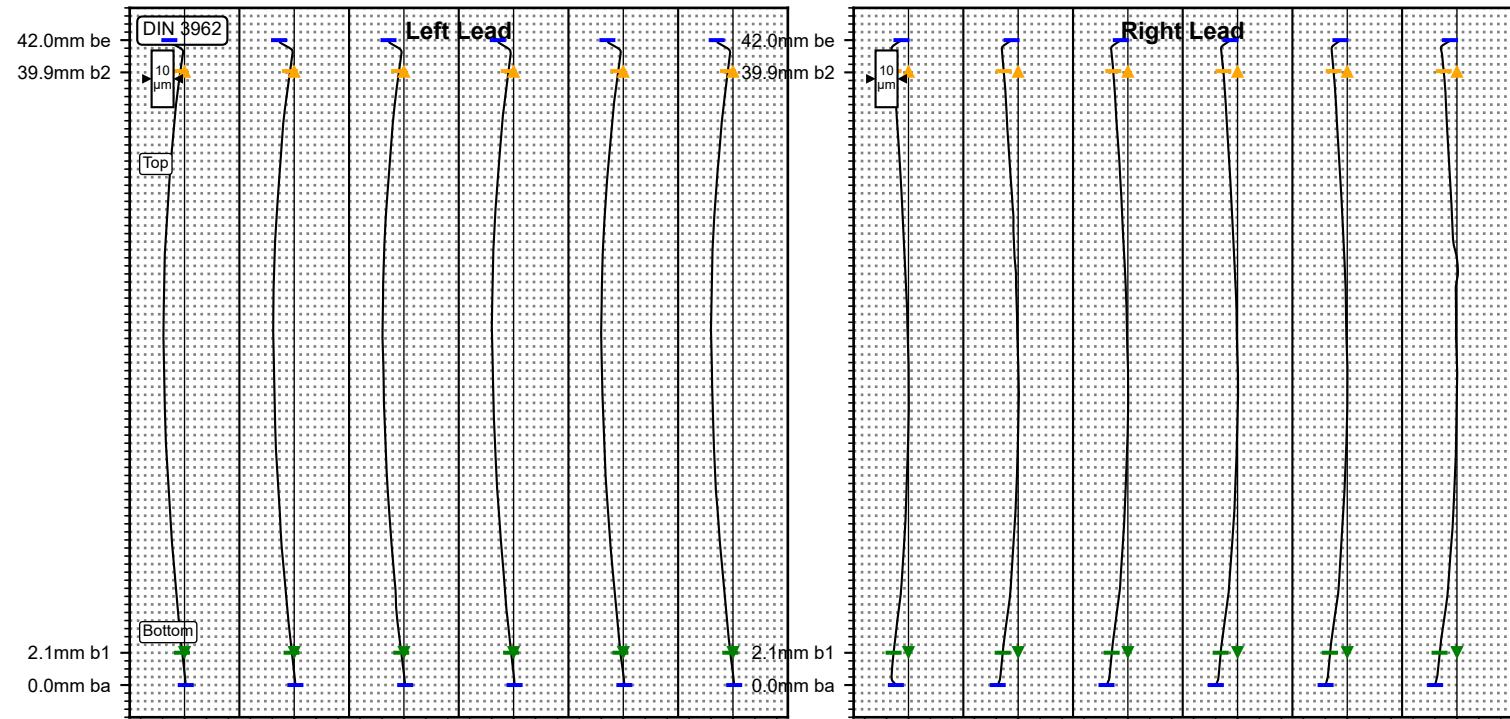
	37	36	35	34	33	32	Lim.value Qual.	Lim.value Qual.	32	33	34	35	36	37			
fHbm	-2.5	1	V 0.5				±8.5	±8.5	-2.0	1	V 1.5						
fHb	-2.4	-2.5	-2.5	-2.5	-2.3	-2.8	2	±8.5	±8.5	-2.8	2	-2.4	-2.0	-1.8	-1.5	-1.3	
fb	10.7	10.9	11.1	10.9	12.8	6	12.8	6	12.5	12.5	9.2	10.6	5	9.4	9.0	8.7	8.8
ffb	10.4	10.2	10.5	10.3	13.8	14.1	7	9.5	9.5	8.0	9.3	6	8.3	8.3	8.3	8.4	
Cb	-8.1	-8.1	-8.4	-8.3	-8.3	-8.6			6.1	6.3	6.3	6.3	6.5	6.5	6.5		

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. 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



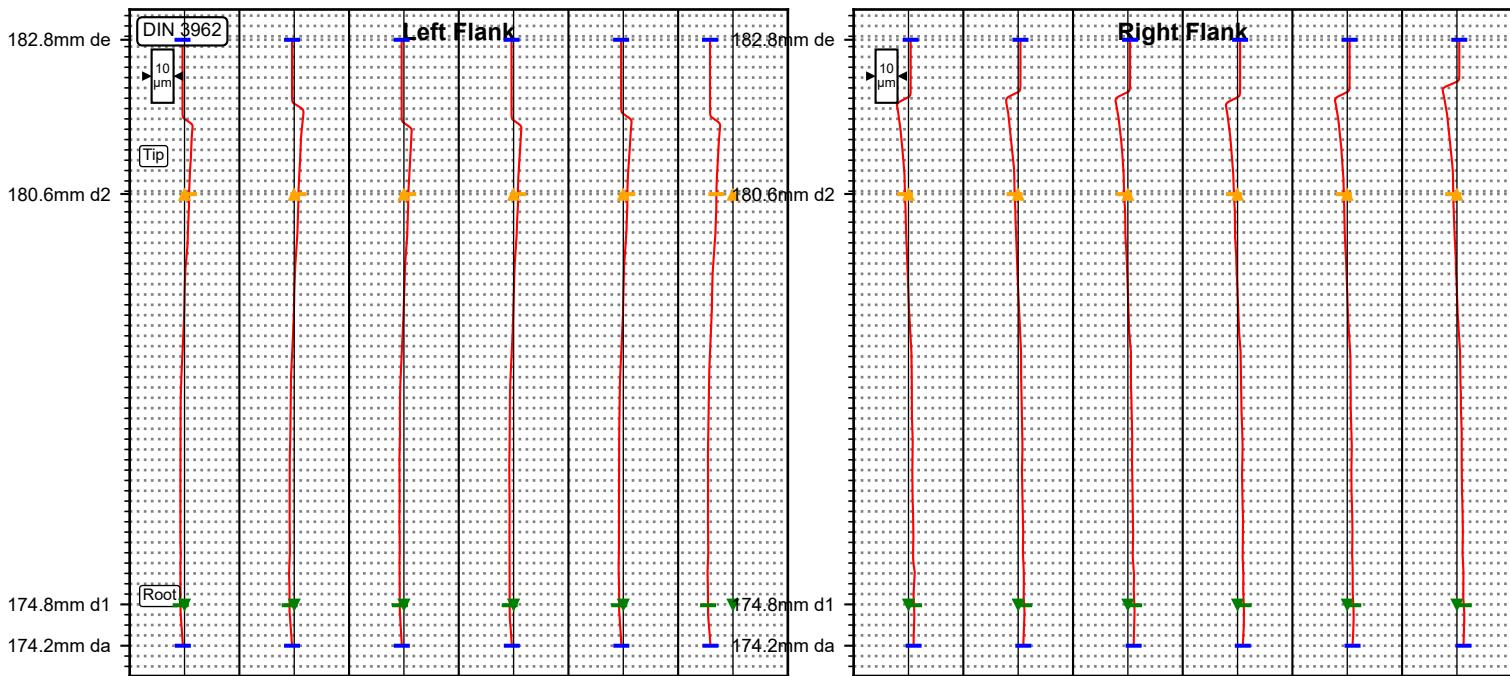
	43	42	41	40	39	38	Lim.value Qual.	Lim.value Qual.	38	39	40	41	42	43
fHam	3.8 2	V 0.7					±11 5	±11 5	-4.2 3	V 1.4				
fHa	3.8	4.2 3	3.8	3.8	3.5	3.9	±11 5	±11 5	-3.6	-4.1	-4.1	-4.1	-4.4	-5.0 3
fa	9.6 3	6.7	6.3	6.3	5.9	6.4	20 5	20 5	6.4	7.0	7.1	7.0	7.7	8.5 3
ffa	7.5 3	6.0	5.6	5.6	5.3	5.7	16 5	16 5	5.5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



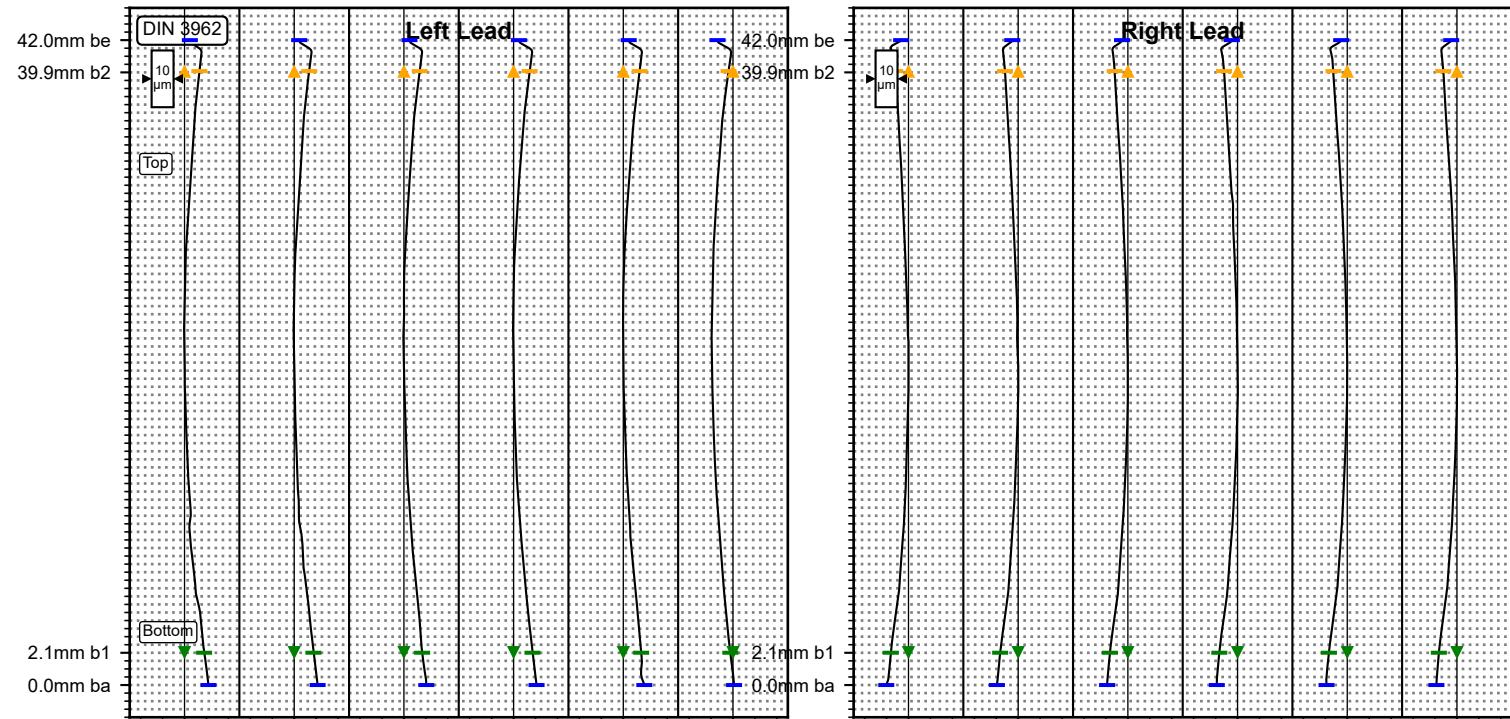
	43	42	41	40	39	38	Lim.value Qual.	Lim.value Qual.	38	39	40	41	42	43
fHbm	-2.3 1	V 0.6					±8 5	±8 5	-0.0 1	V 2.1				
fHb	-2.0	-2.1	-2.3	-2.6 2	-2.5	-2.4	±8 5	±8 5	-1.1 1	-0.6	-0.4	0.2	0.7	1.0
fb	10.4	10.3	10.7	10.5	10.8 5	10.8 5	12 5	12 5	8.6	11.3	11.9	12.1 6	11.5	11.7
ffb	10.4 6	10.3	10.0	9.9	10.4 6	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.:		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. La:	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



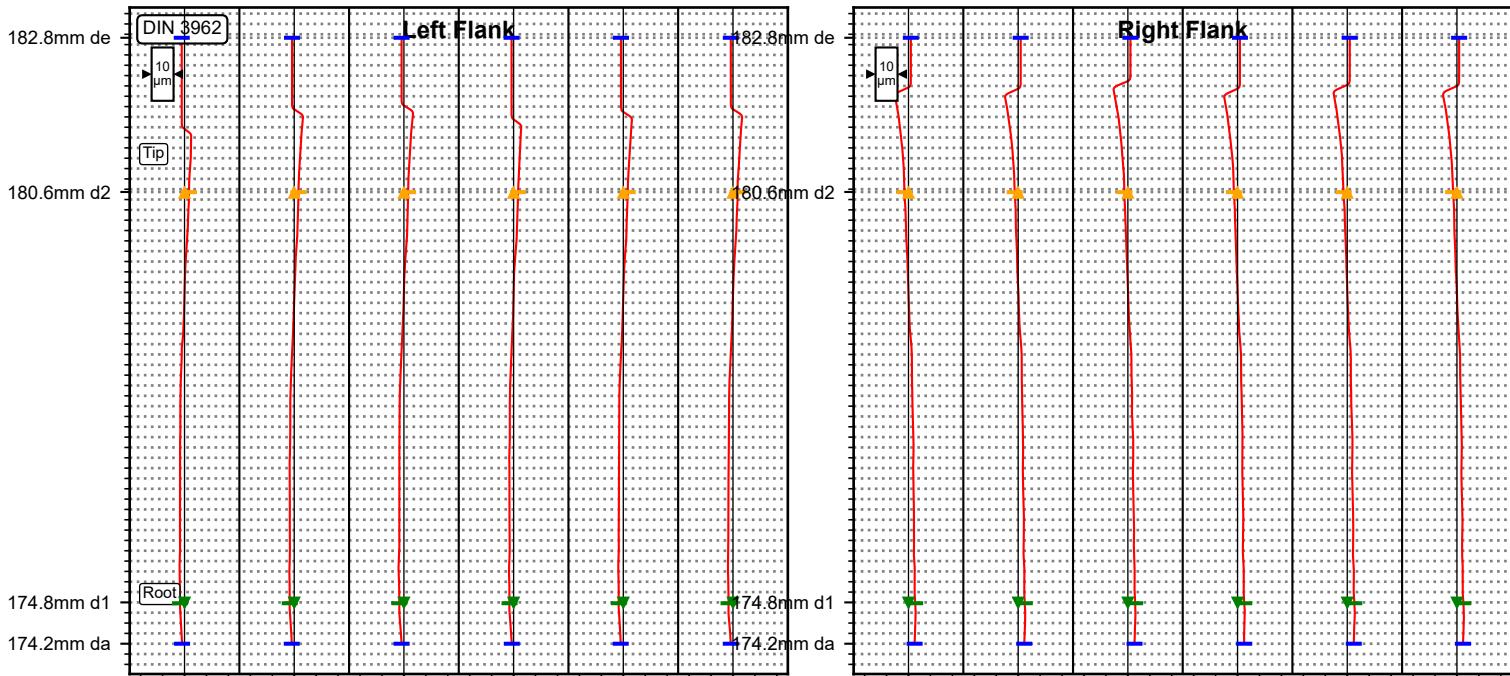
	49	48	47	46	45	44	Lim.value Qual.	Lim.value Qual.	44	45	46	47	48	49
fHam	3.8 2	V 0.9					±11 5	±11 5	-5.5 3	V 1.6				
fHa	3.7	4.4 3	3.6	3.5	3.8	3.6	±11 5	±11 5	-5.0	-5.3	-5.6	-5.3	-5.4	-6.6 4
fa	6.1	6.9 2	6.0	5.9	6.2	6.1	20 5	20 5	8.8	8.9	9.2	8.8	9.1	10.5 4
ffa	5.5	6.0 2	5.4	5.3	5.5	5.4	16 5	16 5	7.3	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



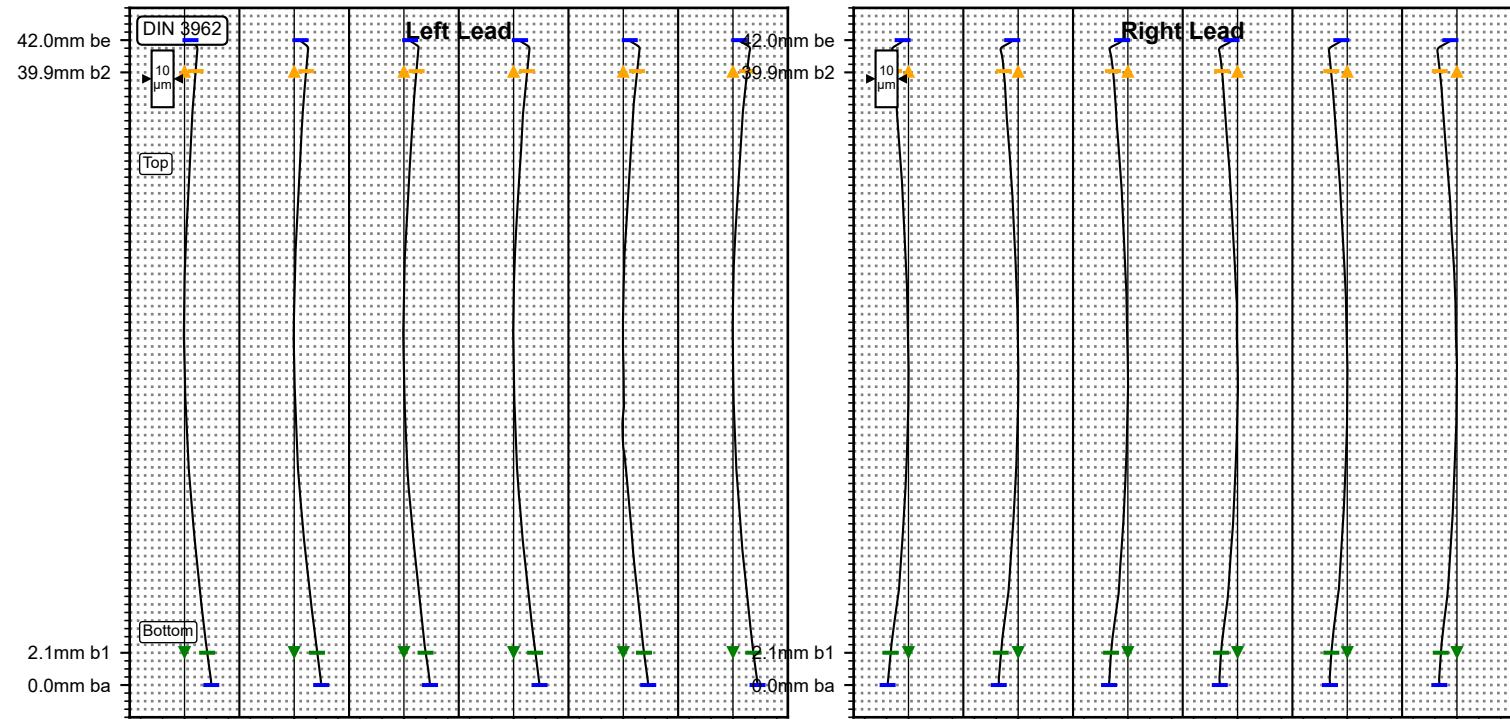
	49	48	47	46	45	44	Lim.value Qual.	Lim.value Qual.	44	45	46	47	48	49
fHbm	-2.3 1	V 0.9					±8 5	±8 5	1.3 1	V 0.4				
fHb	-2.6	-2.7 2	-2.4	-2.3	-1.8	-2.0	±8 5	±8 5	1.0	1.3	1.4 1	1.4 1	1.4 1	1.3
fb	11.5 5	11.4	10.5	11.1	10.6	10.5	12 5	12 5	11.8 5	10.1	9.6	9.8	9.8	9.5
ffb	10.1	9.9	10.0	10.1	9.9	10.2 6	9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



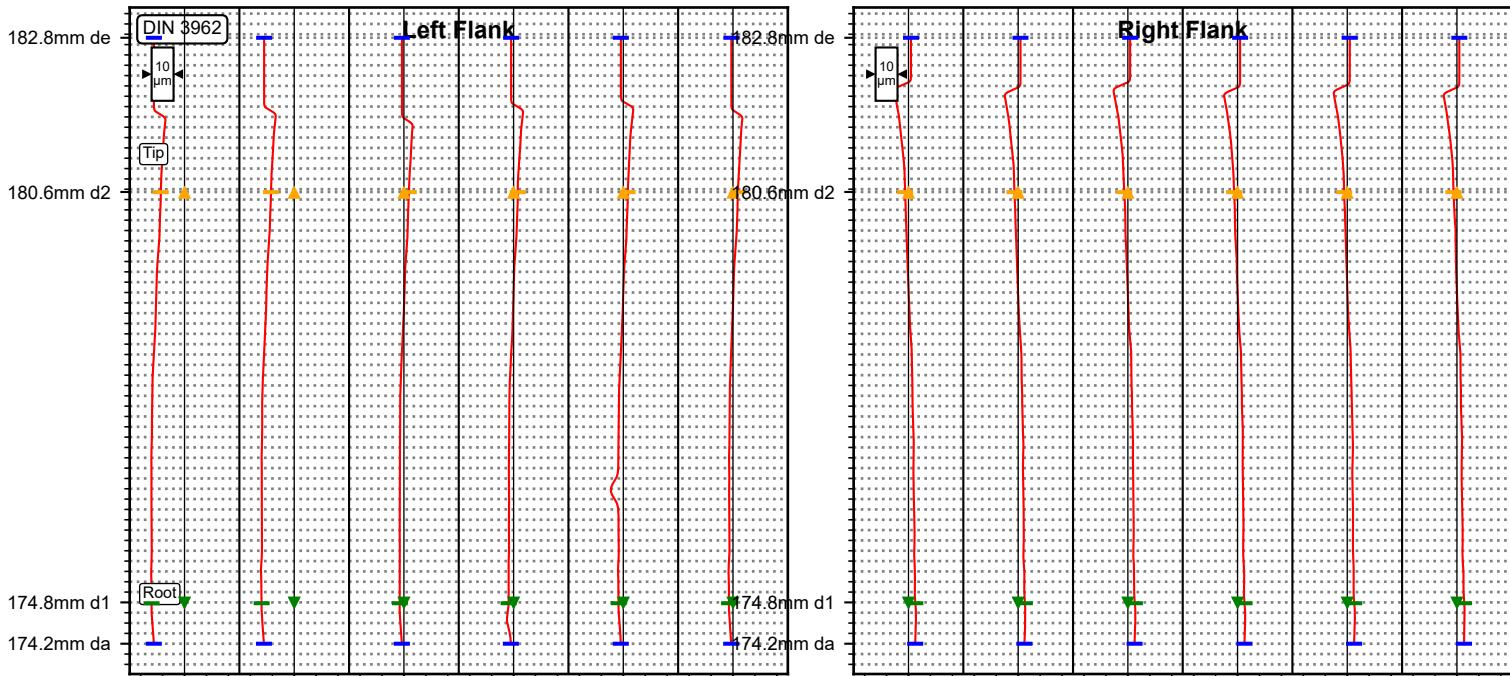
	55	54	53	52	51	50	Lim.value Qual.	Lim.value Qual.	50	51	52	53	54	55
fHam	3.9 2	V 1.0					±11 5	±11 5	-6.2 4	V 0.8				
fHa	3.3	4.1	4.3 3	3.6	4.1	4.2	±11 5	±11 5	-6.2	-5.9	-6.7 4	-6.1	-6.4	-6.2
fa	5.8	6.5	6.9 2	6.0	6.6	6.8	20 5	20 5	9.9	9.8	10.6 4	9.9	10.3	10.0
ffa	5.2	5.8	6.0 2	5.3	5.8	6.0 2	16 5	16 5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



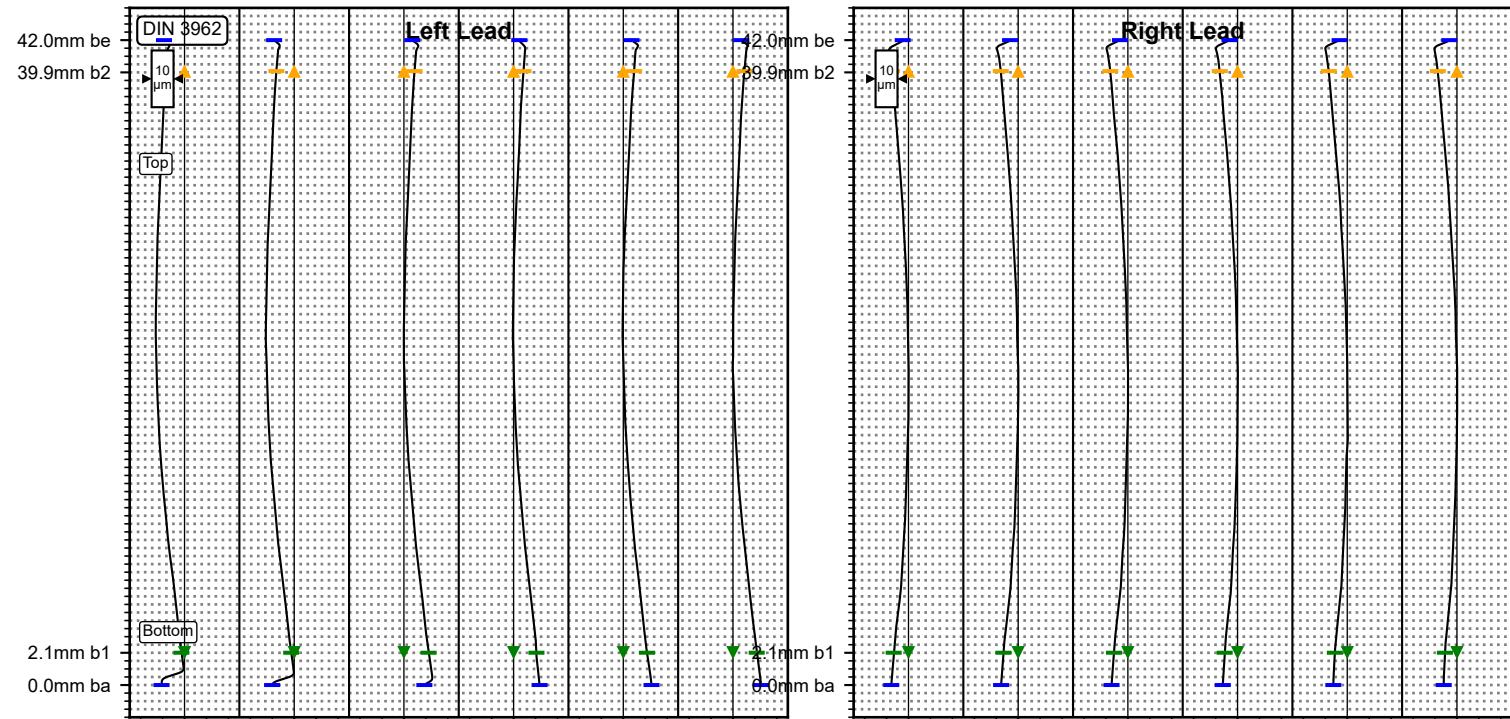
	55	54	53	52	51	50	Lim.value Qual.	Lim.value Qual.	50	51	52	53	54	55
fHbm	-4.5 3	V 2.3					±8 5	±8 5	0.0 1	V 1.9				
fHb	-5.7 4	-5.3	-4.6	-4.1	-3.6	-3.4	±8 5	±8 5	1.0 1	0.7	0.3	-0.2	-0.7	-0.9
fb	12.6	12.7	12.7	12.4	12.9	13.0 6	12 5	12 5	9.9 4	9.5	9.8	9.8	9.2	9.7
ffb	12.7	13.7	14.8	14.3	15.0 7	14.6	9 5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



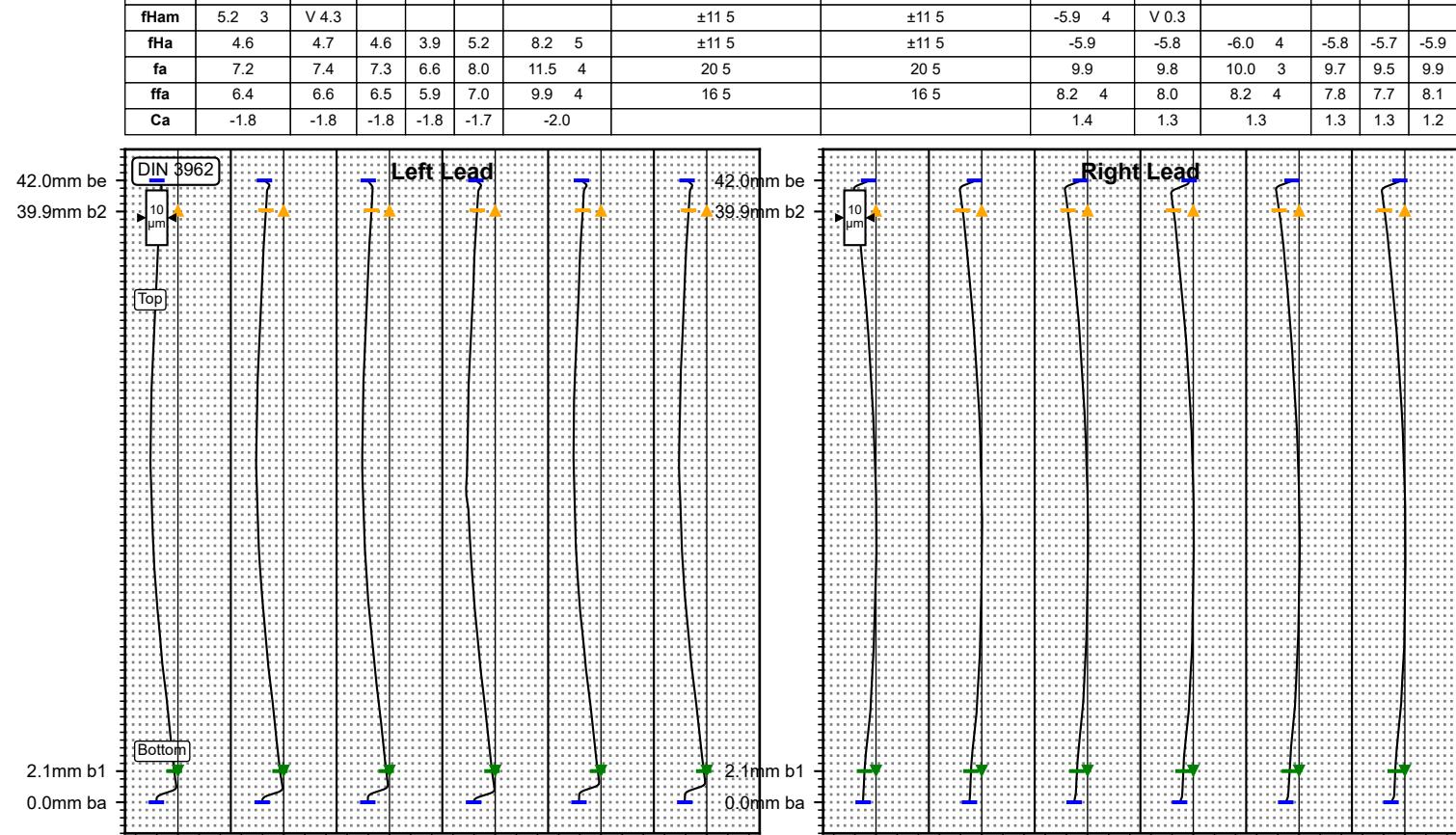
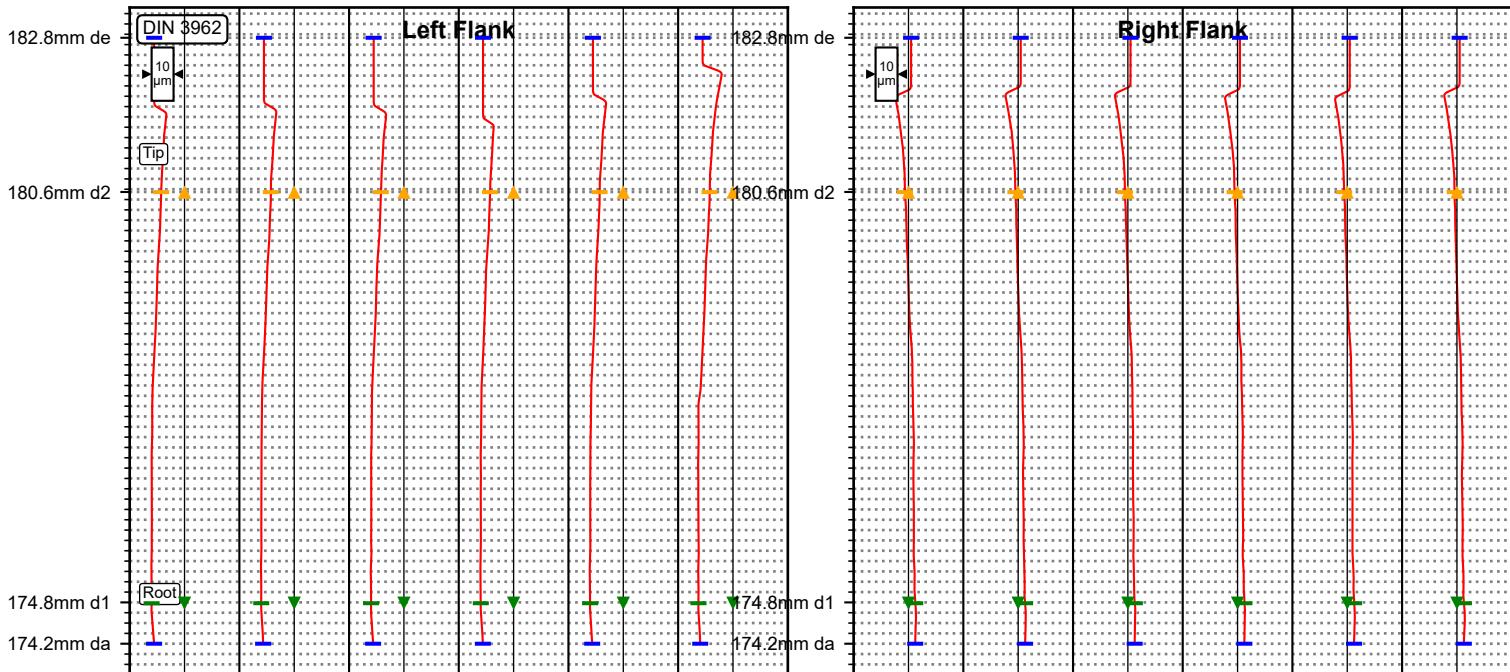
	61	60	59	58	57	56	Lim.value Qual.	Lim.value Qual.	56	57	58	59	60	61				
fHam	4.3	3	V 1.0				±11 5	±11 5	-6.3	4	V 0.5							
fHa	4.2		4.4	3.9	4.6	4.9	3	4.0	±11 5		±11 5	-6.5	-6.1	-6.6	4	-6.3	-6.3	-6.2
fa	6.8		7.1	6.4	7.7	10.7	4	6.6	20 5		20 5	10.4	9.9	10.5	4	10.2	10.2	10.1
ffa	6.1		6.2	5.8	6.3	7.6	3	5.8	16 5		16 5	8.6	8.2	8.6	4	8.4	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	±8 5	±8 5	-1.3	-2.0	-2.3	-2.8	-3.5	-4.0	3	
fb	13.2		13.3	13.4	12.4	13.6	6	13.2	12 5		12 5	9.9	11.3	11.3	11.5	5	11.5	5	11.4
ffb	16.4		16.0	16.5	8	11.9	16.5	8	15.7	9 5		9.5	9.3	10.2	6	10.1	10.0	9.6	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	7.0	

Gear Profile/Lead

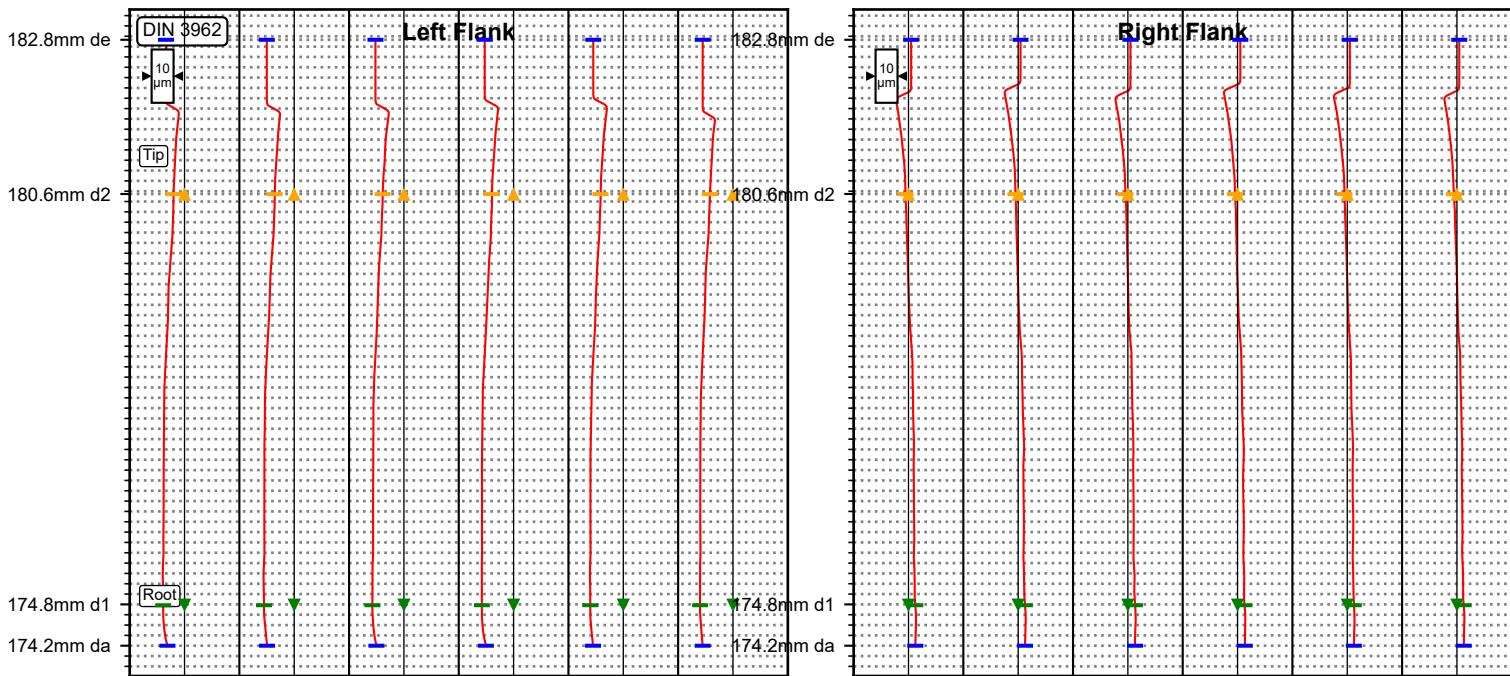
Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. L α :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L β :	37.80mm
Cust./Mach. N:	P26-601418	Helix angle:	25.30°	Appr. Length:	0.58mm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



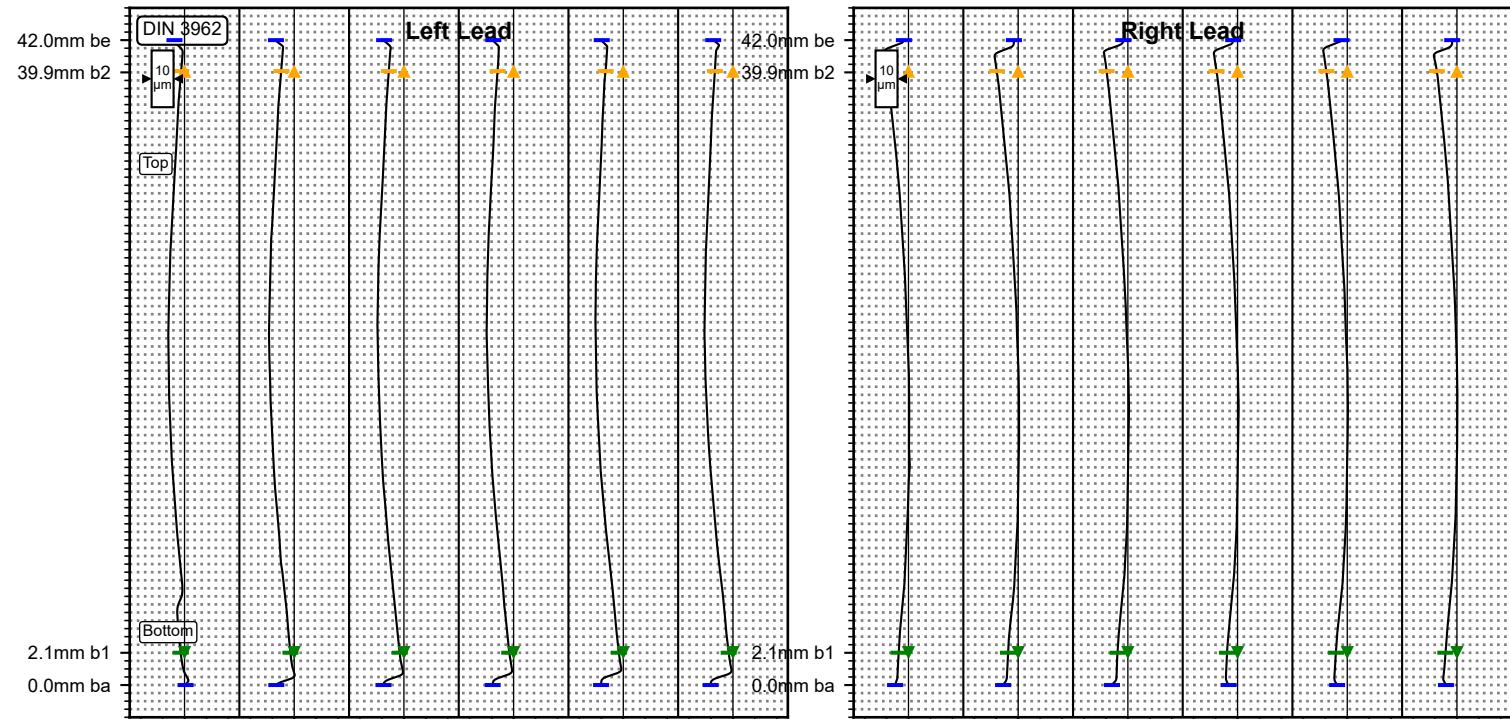
	67	66	65	64	63	62	Lim.value Qual.	Lim.value Qual.	62	63	64	65	66	67
fHbm	-6.5 5	V 0.7					±8 5	±8 5	-4.9 4	V 1.4				
fHb	-6.4	-6.4	-6.6	-6.9 5	-6.2	-6.3	±8 5	±8 5	-4.2	-4.5	-4.9	-4.8	-5.4	-5.6 4
fb	13.2	13.4	12.8	14.3 6	12.7	12.8	12 5	12 5	11.6	11.4	11.8	11.4	12.1 6	12.1 6
ffb	12.6	16.1	11.9	17.0 8	16.3	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.:		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



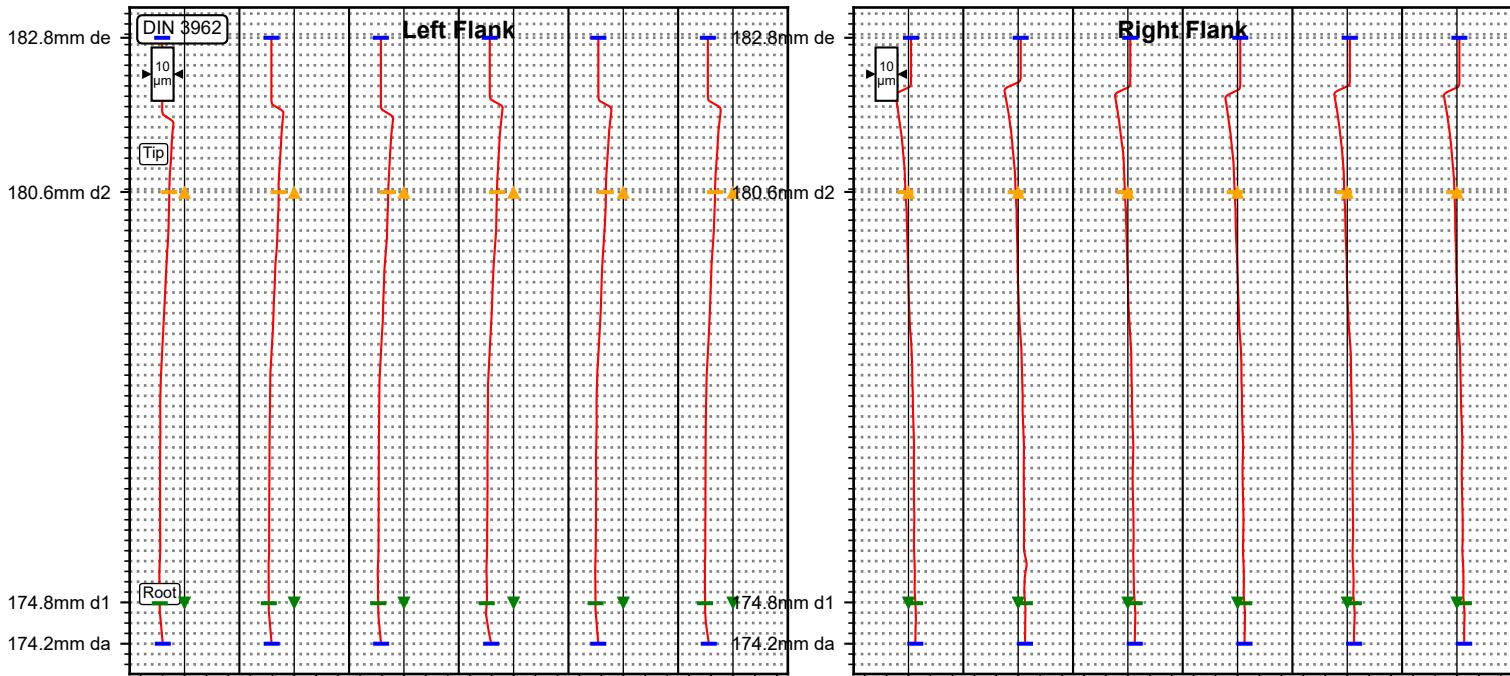
	73	72	71	70	69	68	Lim.value Qual.	Lim.value Qual.	68	69	70	71	72	73
fHam	5.0 3	V 0.9					±11 5	±11 5	-6.0 4	V 0.6				
fHa	4.9	5.1	4.9	5.2	5.4 3	4.5	±11 5	±11 5	-5.8	-6.2	-5.8	-6.4 4	-6.0	-5.8
fa	7.7	7.9	7.9	8.0	8.2 3	7.2	20 5	20 5	9.7	10.2	9.8	10.4 4	9.9	9.7
ffa	6.7	7.0	6.9	7.1	7.2 3	6.4	16 5	16 5	7.9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



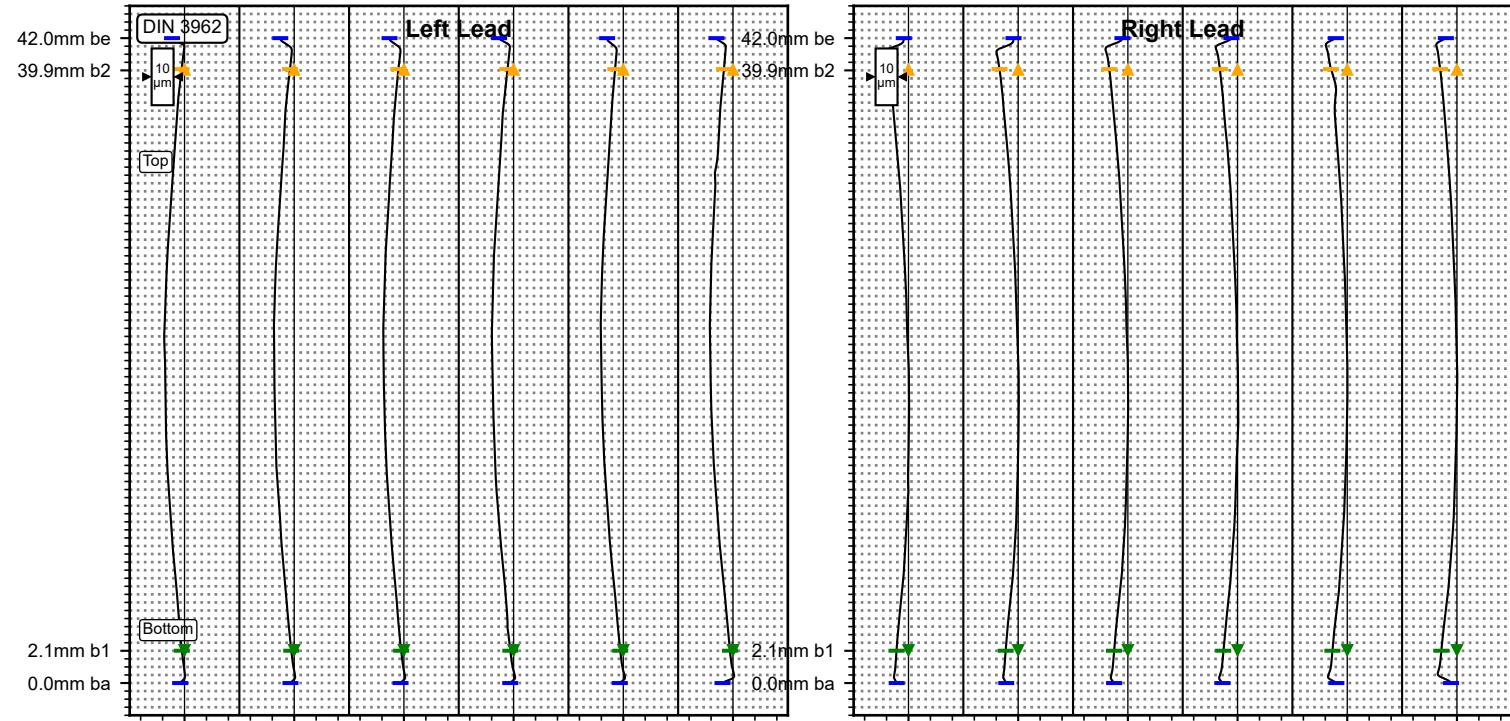
	73	72	71	70	69	68	Lim.value Qual.	Lim.value Qual.	68	69	70	71	72	73
fHbm	-4.7 4	V 4.5					±8 5	±8 5	-5.1 4	V 1.6				
fHb	-1.6	-4.5	-5.0	-5.3	-5.8	-6.1 5	±8 5	±8 5	-5.6 4	-5.2	-5.4	-5.2	-4.9	-4.0
fb	11.7	13.7 6	13.2	13.0	13.0	13.6	12 5	12 5	12.7 6	12.0	12.7 6	12.3	12.2	12.3
ffb	10.8	13.7	13.2	12.2	13.2	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.:		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



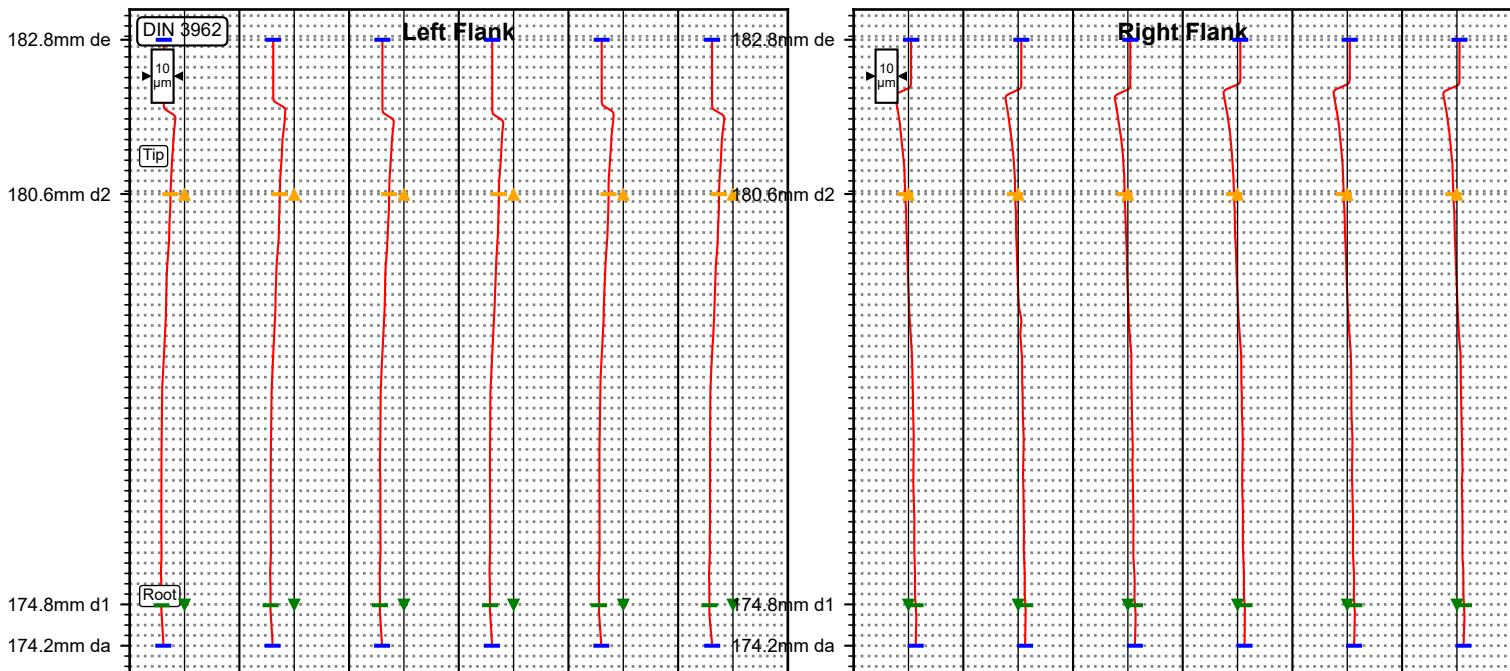
	79	78	77	76	75	74	Lim.value Qual.	Lim.value Qual.	74	75	76	77	78	79
fHam	4.7 3	V 0.9					±11.5	±11.5	-6.0 4	V 0.7				
fHa	4.1	4.6	4.5	5.0 3	5.0 3	4.9	±11.5	±11.5	-6.0	-6.4 4	-5.9	-5.7	-6.0	-6.0
fa	6.8	7.4	7.4	8.1 3	7.9	7.7	20.5	20.5	9.8	10.8 4	9.8	9.5	9.8	10.0
ffa	6.0	6.5	6.5	6.9 3	6.9 3	6.8	16.5	16.5	8.1	8.5 4	8.0	7.8	8.1	8.1
Ca	-2.0	-1.8	-1.8	-1.9	-1.8	-1.9			1.2	1.1	1.1	1.2	1.3	1.1



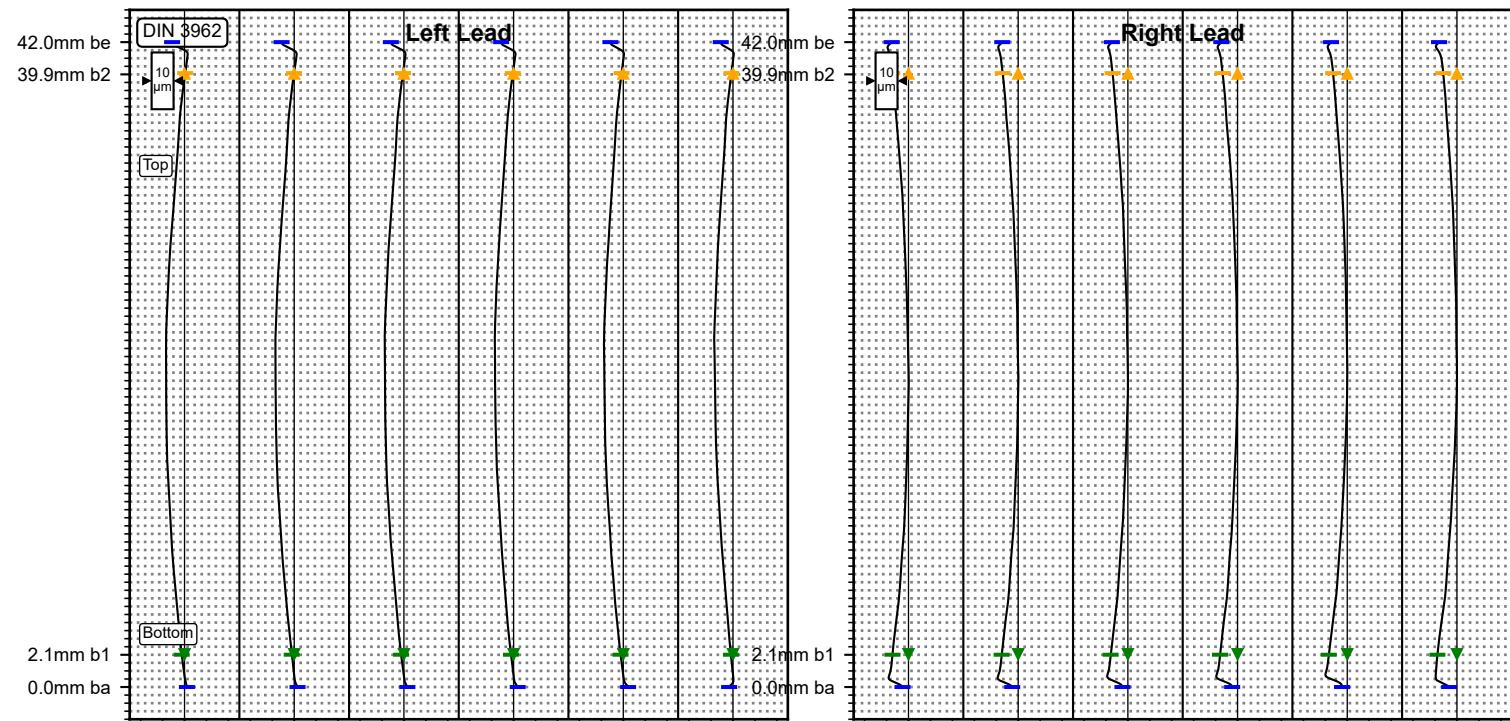
	79	78	77	76	75	74	Lim.value Qual.	Lim.value Qual.	74	75	76	77	78	79
fHbm	-1.9 1	V 2.9					±8.5	±8.5	-2.3 1	V 2.5				
fHb	-0.4	-1.0	-1.8	-2.0	-2.9	-3.3 2	±8.5	±8.5	-3.7 3	-3.0	-2.6	-1.9	-1.2	-1.3
fb	14.3 6	10.7	11.3	13.2	12.7	12.7	12.5	12.5	12.4 6	11.8	12.2	12.2	11.7	11.2
ffb	14.5 7	10.2	10.3	14.1	11.2	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.:		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



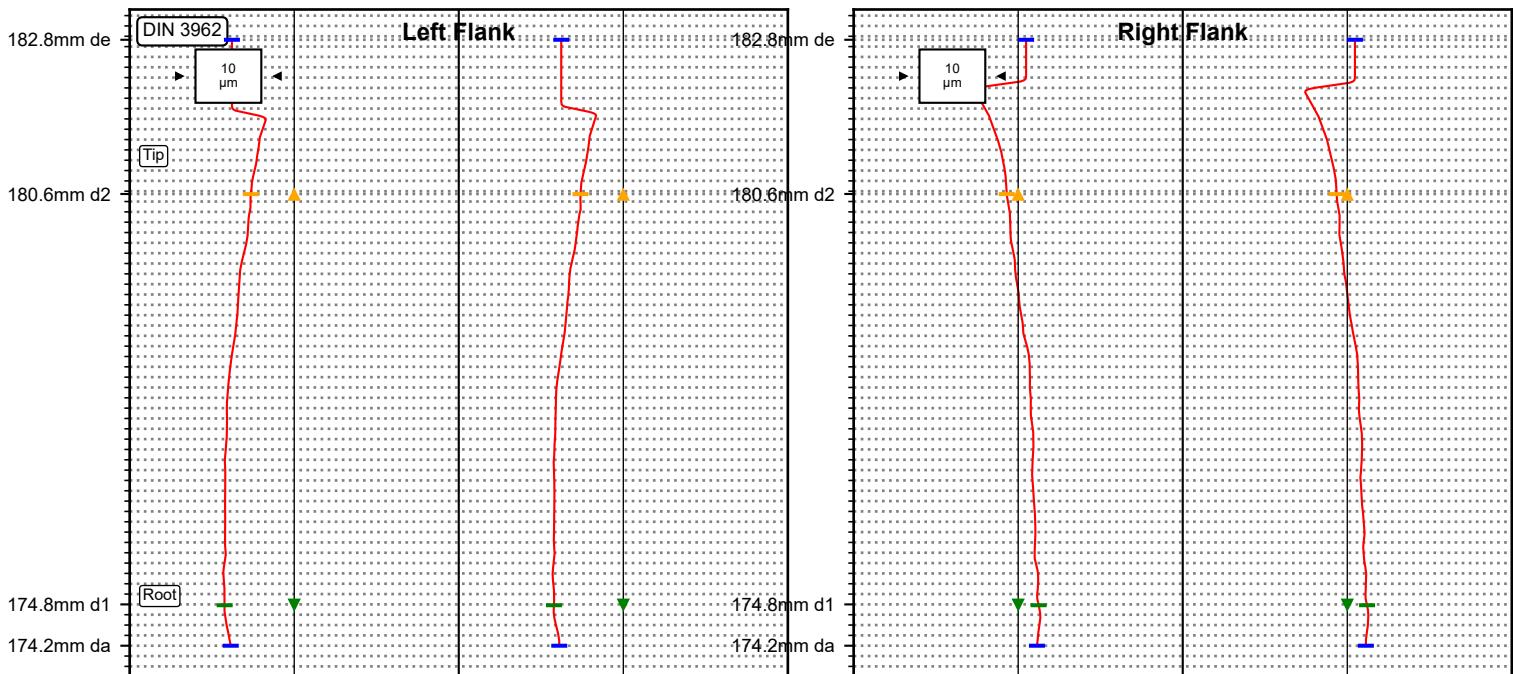
	85	84	83	82	81	80	Lim.value Qual.	Lim.value Qual.	80	81	82	83	84	85
fHam	4.4 3	V 0.8					±11 5	±11 5	-6.2 4	V 0.6				
fHa	4.3	4.8 3	4.1	4.0	4.6	4.5	±11 5	±11 5	-6.2	-5.9	-6.0	-6.4	-6.5 4	-6.3
fa	6.9	7.5 3	6.7	6.6	7.1	7.3	20 5	20 5	10.1	9.9	10.1	10.4 4	10.3	10.3
ffa	6.2	6.5 3	6.0	5.9	6.3	6.5 3	16 5	16 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



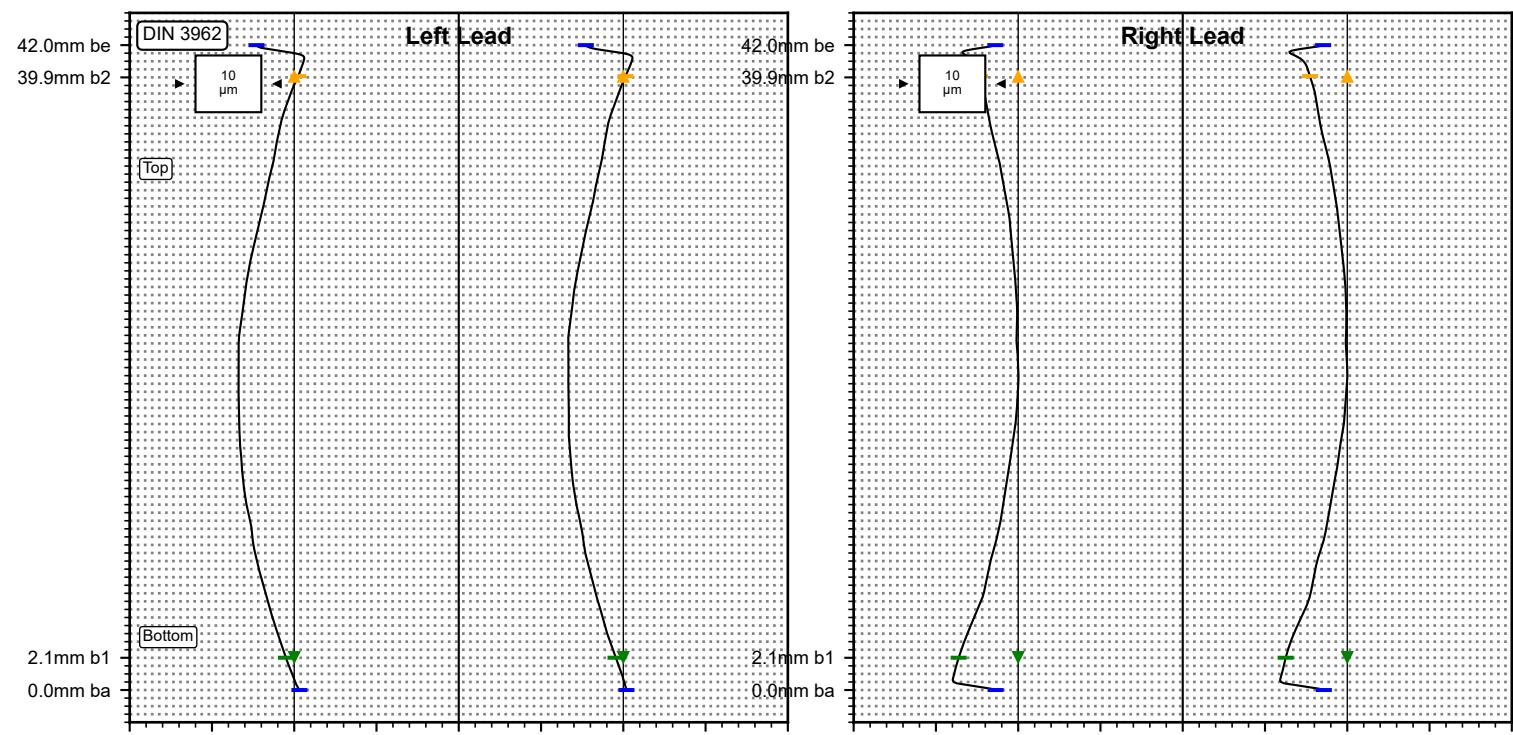
	85	84	83	82	81	80	Lim.value Qual.	Lim.value Qual.	80	81	82	83	84	85
fHbm	0.6 1	V 1.7					±8 5	±8 5	0.4 1	V 2.8				
fHb	1.4 1	0.9	0.6	0.5	0.2	-0.3	±8 5	±8 5	-0.9	-0.2	0.2	0.6	1.1	1.9 1
fb	10.7	11.9	12.3	13.0	13.9 6	9.4	12 5	12 5	11.4	11.7	11.4	12.0	11.9	12.5 6
ffb	11.4	12.5	12.7	13.2	14.0 7	9.5	9 5	9 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.:		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



	87	86	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

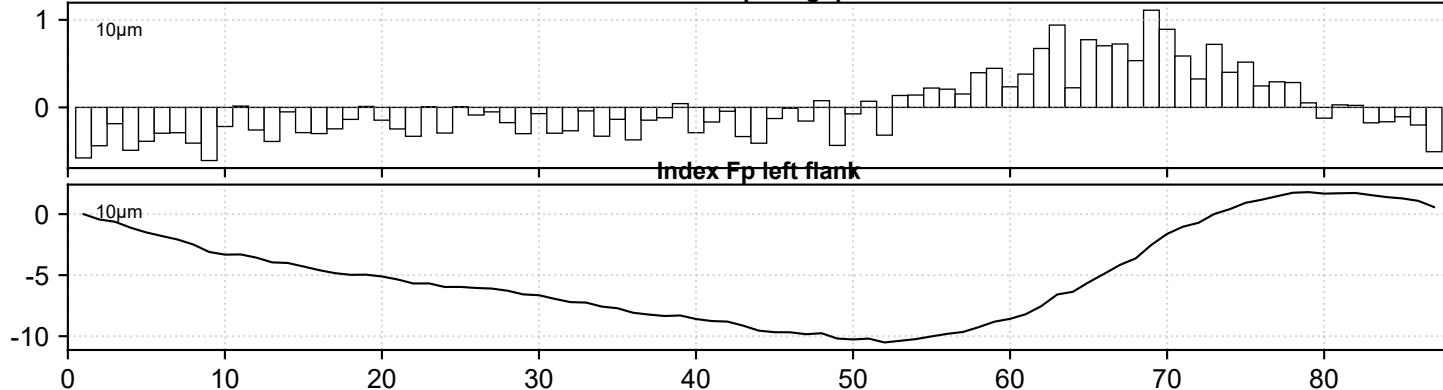


	87	86	Lim.value Qual.	86	87
fHbm	1.7 1	V 0.4	±8.5	±8.5	3.0 2 V 0.6
fHb	1.9 1	1.5	±8.5	±8.5	2.7 3.3 2
fb	10.8 5	10.8 5	12.5	12.5	11.2 12.1 6
ffb	11.0 6	10.1	9.5	9.5	12.6 13.8 7
Cb	-8.0	-7.9			7.4 7.4

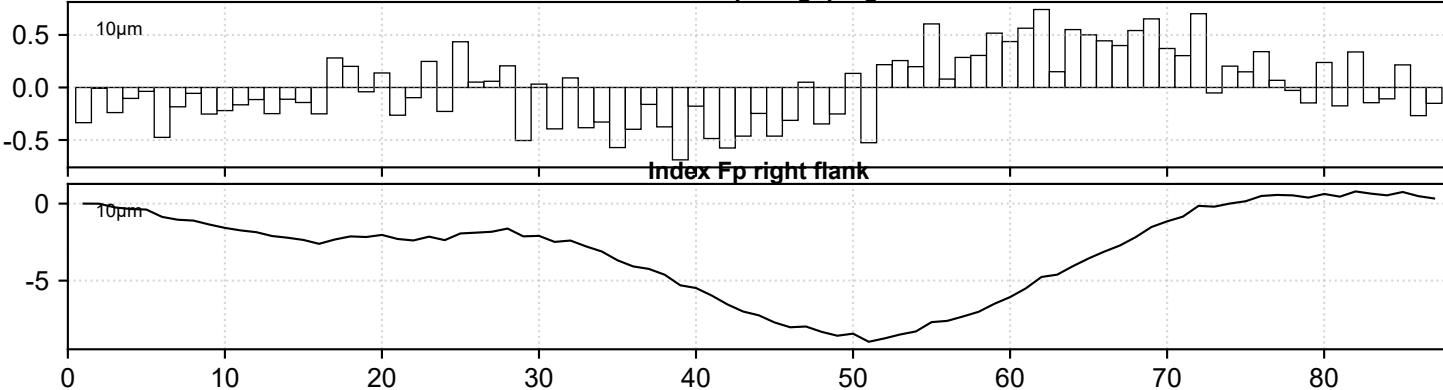
Gear Spacing

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		

Tooth to tooth spacing fp left flank



Tooth to tooth spacing fp right flank



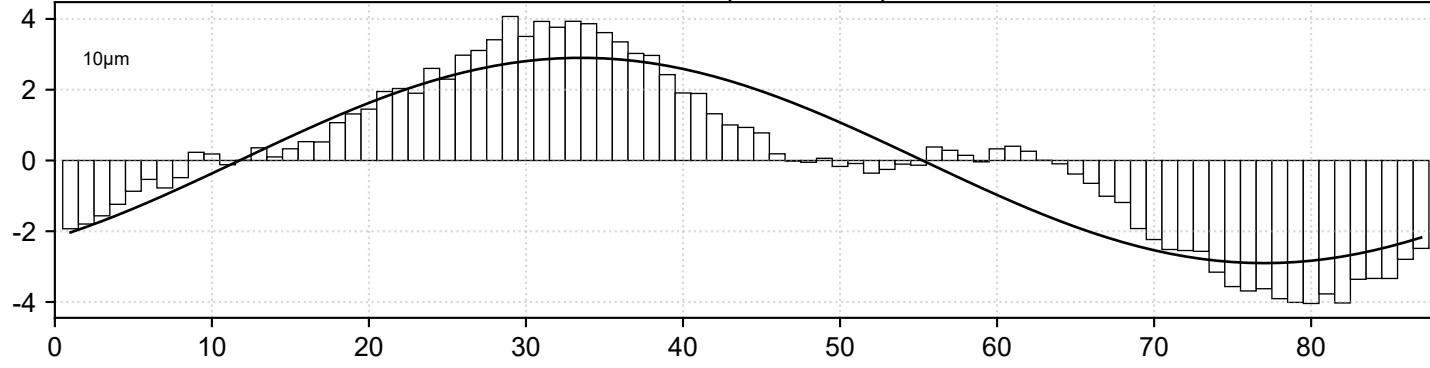
Pitch measuring circle:

left flank

right flank

	Act.value	Qual.	Lim.value Qual.	Act.value	Qual.	Lim.value Qual.
Worst single pitch deviation fp max	1.1		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		

Runout Fr (Ball-Ø =3mm)



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