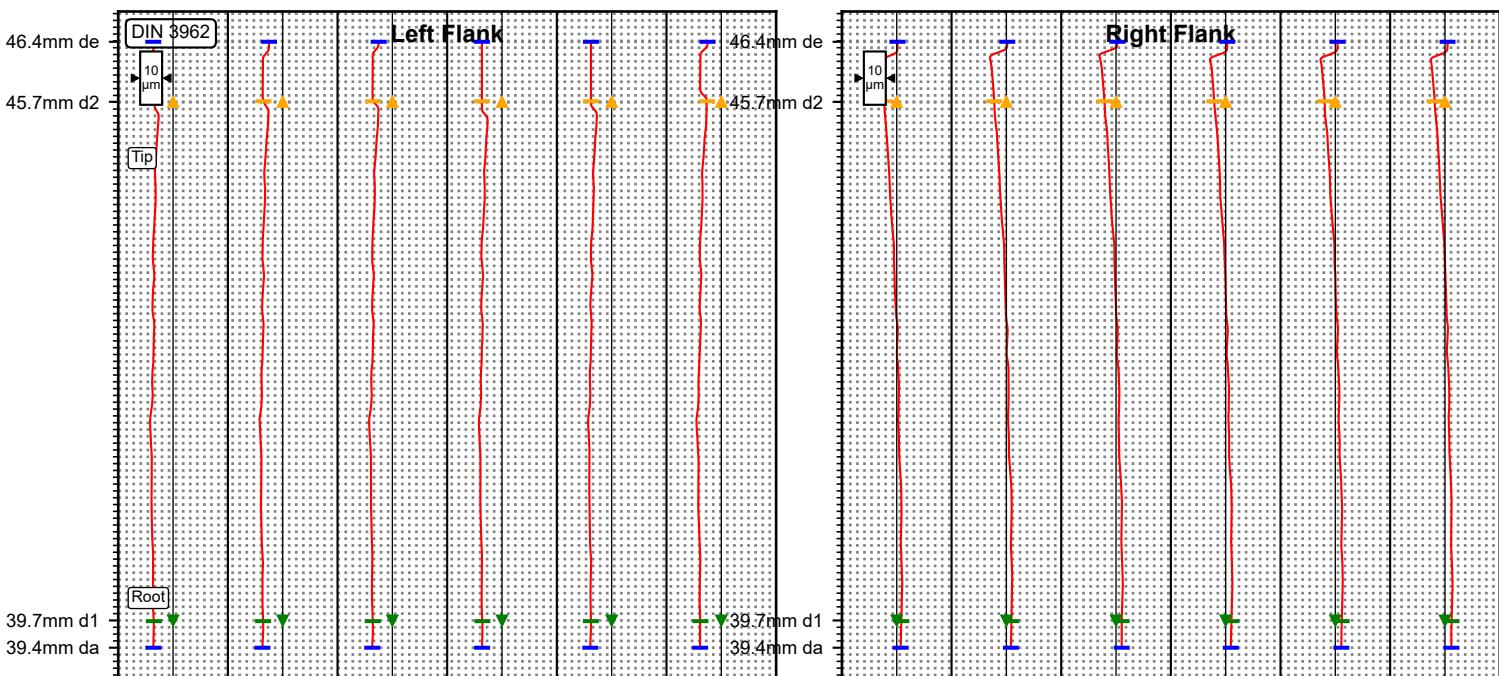
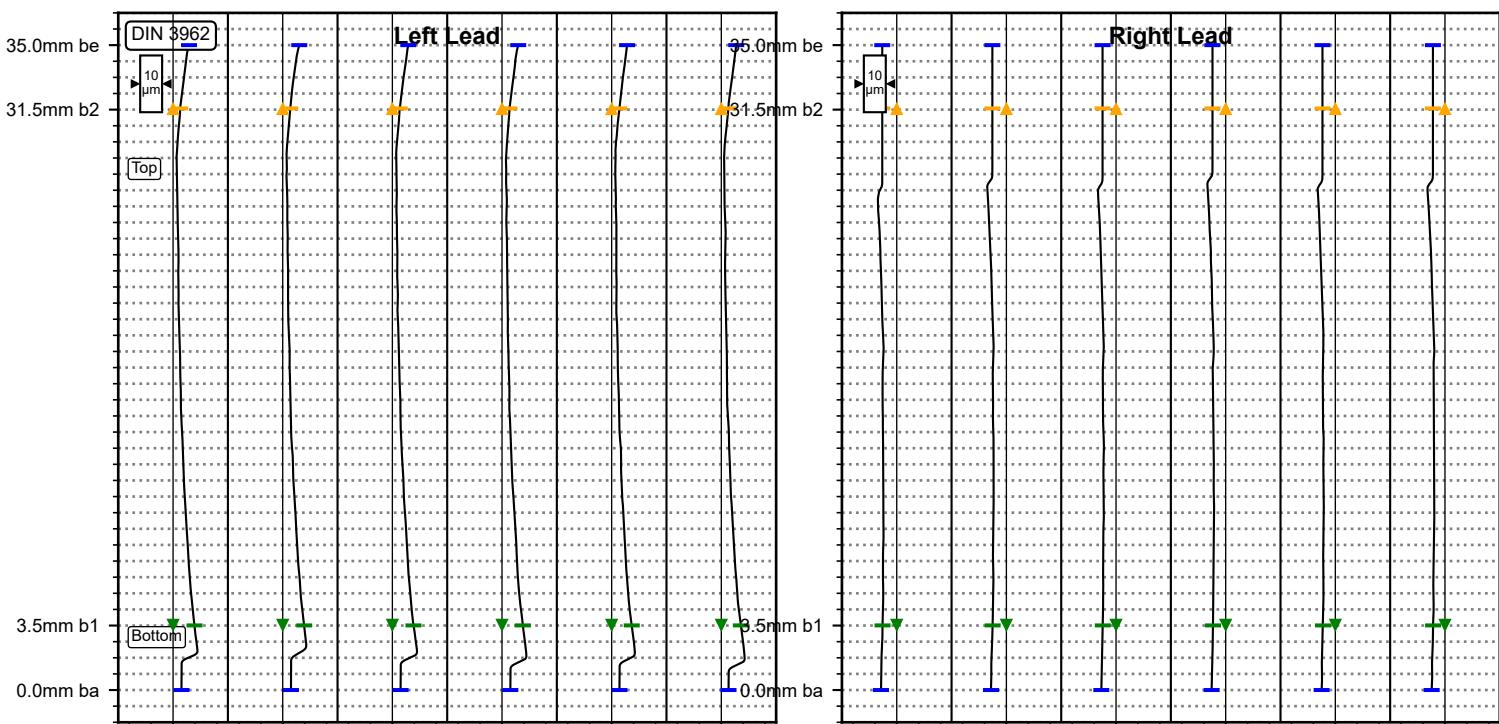


# Gear Profile/Lead

Prog.No.:	temp.mka	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. L $\alpha$ :	6.05mm
Order No.:	1	Pressure angle:	17°	Length Ev. L $\beta$ :	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



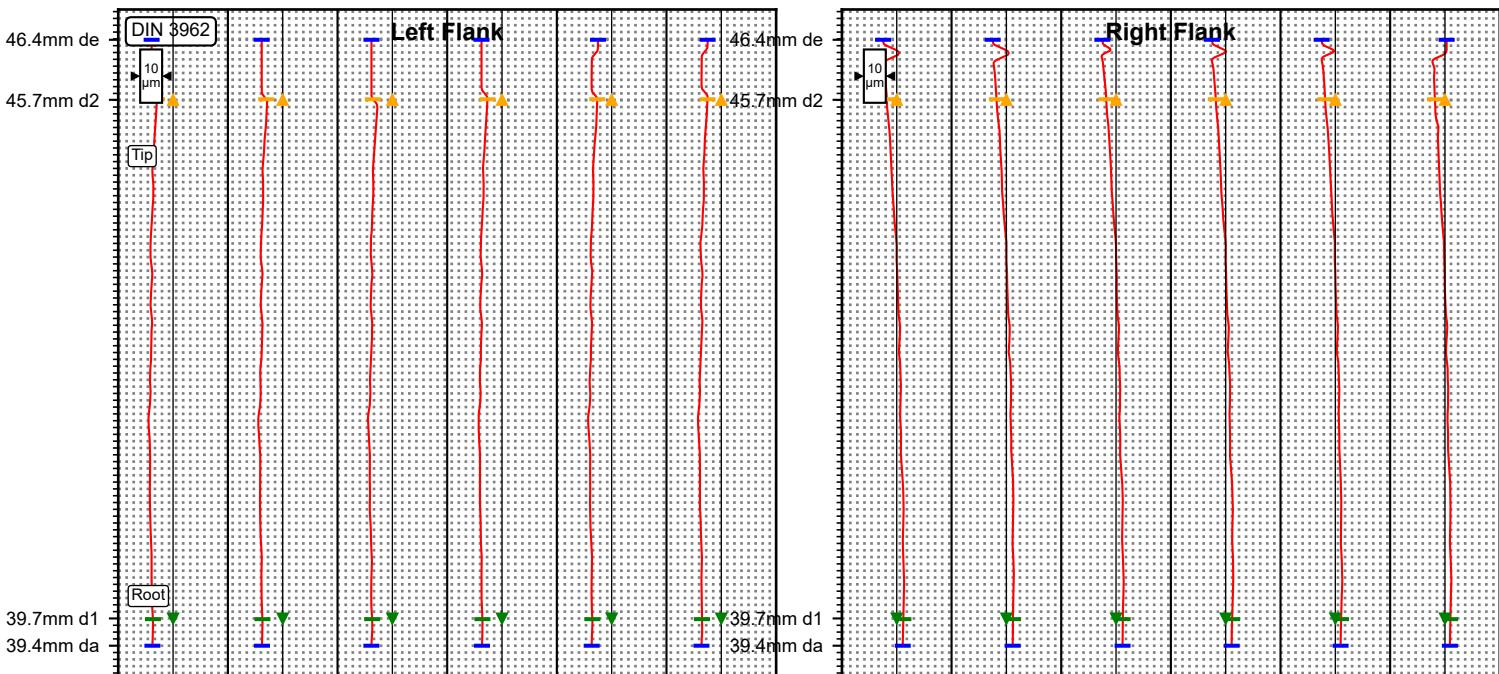
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6			
fHam	1.8	1	V 1.0				±11 5	±11 5	-8.8	5	V 0.6						
fHa	1.5		1.9	1.4	1.7	2.4	1	±11 5	±11 5	-8.6	-8.9	-9.2	5	-8.7	-8.8	-8.6	
fa	4.2		4.4	4.5	4.1	4.2	5.1	2	20 5	20 5	10.7	11.3	12.4	4	11.8	11.7	11.1
ffa	3.4		3.4	3.5	3.4	3.3	3.9	1	16 5	16 5	8.6	9.2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



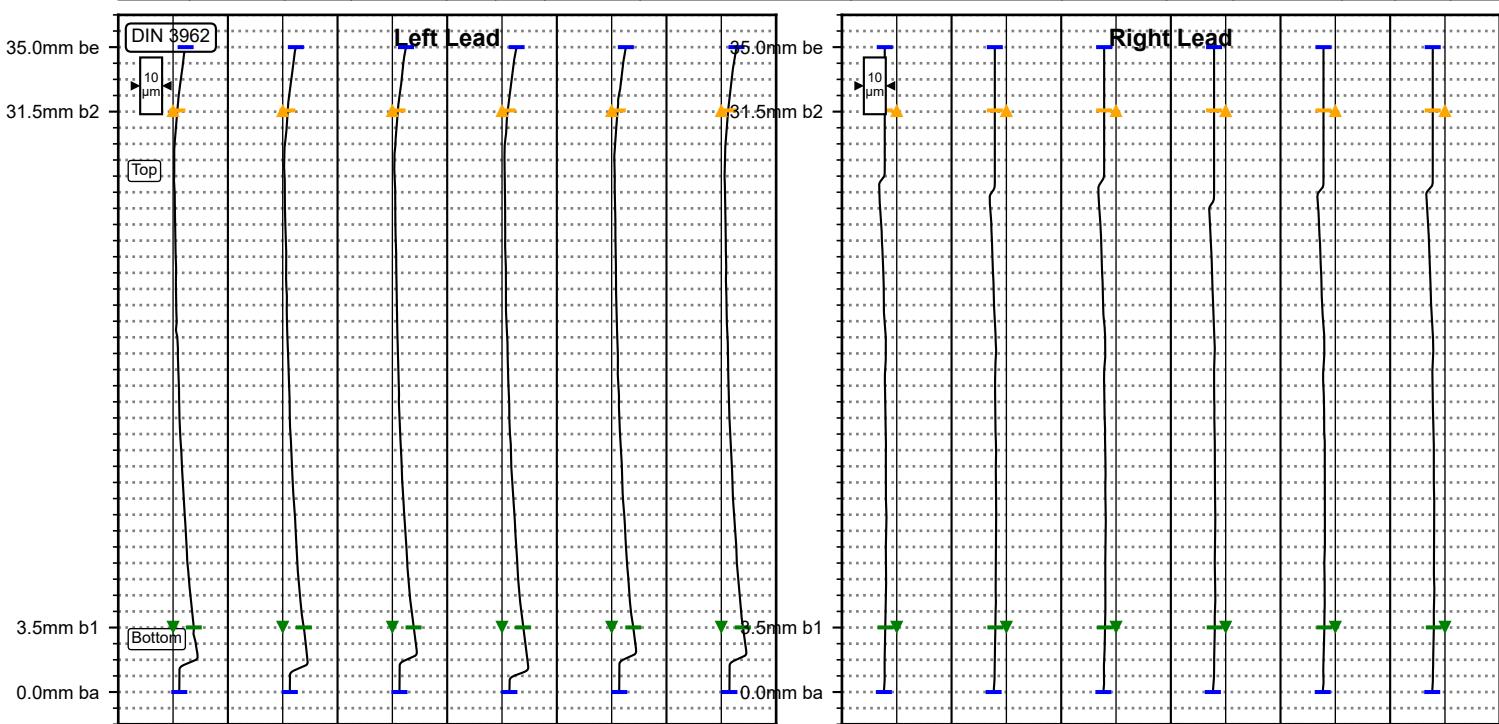
	6	5	4	3	2	1	Lim.value Qual.	Lim.value Qual.	1	2	3	4	5	6		
fHbm	-5.1	4	V 0.6				±8 5	±8 5	-0.8	1	V 0.3					
fHb	-5.3	4	-4.9	-5.2	-5.2	-4.7	-5.1	±8 5	±8 5	-0.7	-0.8	-0.7	-1.0	1	-0.8	-0.8
fb	10.1	5	9.6	10.0	9.7	9.4	9.8	12 5	12 5	3.0	3.4	3.1	3.5	2	3.1	3.4
ffb	9.7	6	9.5	9.4	9.4	8.4	8.8	9 5	9 5	2.8	3.1	2.8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



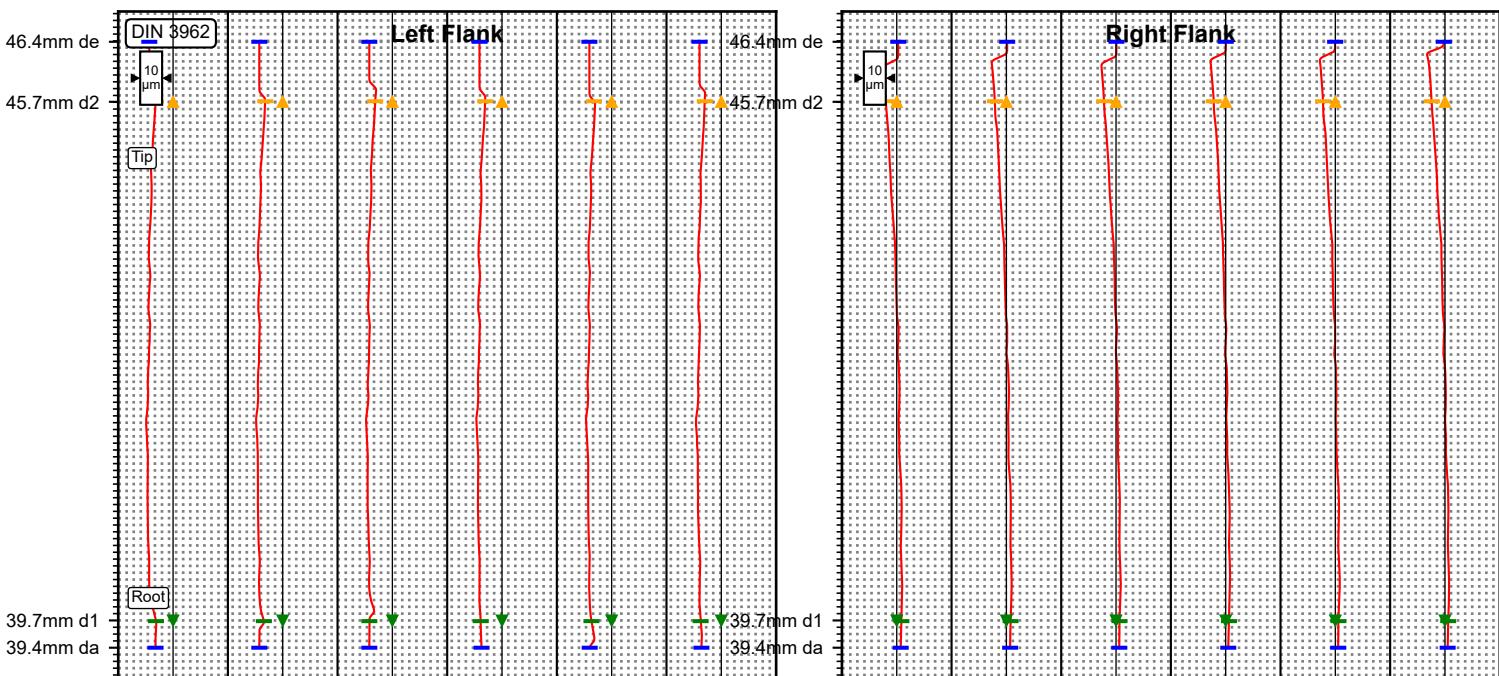
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12			
fHam	1.6	1	V 0.7				±11.5	±11.5	-8.5	5	V 1.7						
fHa	1.3		1.4	1.4	1.9	2.0	1	±11.5	±11.5	-8.6	-8.6	-9.1	5	-8.9	-8.6	-7.4	
fa	4.3		4.3	4.5	4.3	4.6	4.8	1	20.5	20.5	10.0	10.0	11.5	4	11.1	10.5	9.8
ffa	3.6		3.6	3.8	1	3.5	3.5	3.7	16.5	16.5	8.0	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	



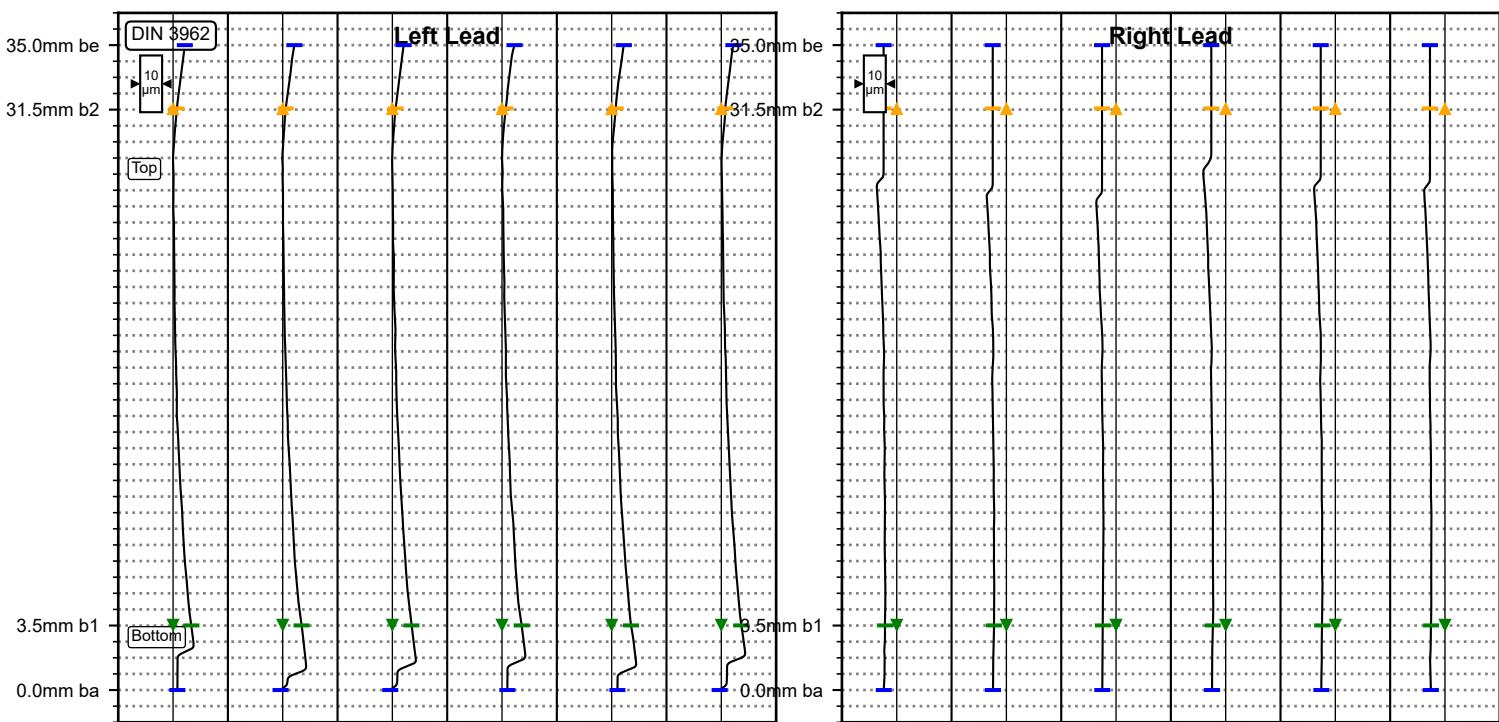
	12	11	10	9	8	7	Lim.value Qual.	Lim.value Qual.	7	8	9	10	11	12			
fHbm	-6.3	5	V 1.3				±8.5	±8.5	-1.2	1	V 0.5						
fHb	-6.7		-6.8	-6.0	-7.0	5	-5.8	-5.7	±8.5	±8.5	-1.2	-0.9	-1.3	-0.9	-1.3	-1.4	1
fb	11.7	5	11.3	10.7	11.4	10.4	10.4	12.5	12.5	3.6	3.4	3.8	3.1	3.8	4.1	2	
ffb	10.3		10.4	9.4	11.0	6	9.8	9.8	9.5	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.:	temp.mka	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. La:	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



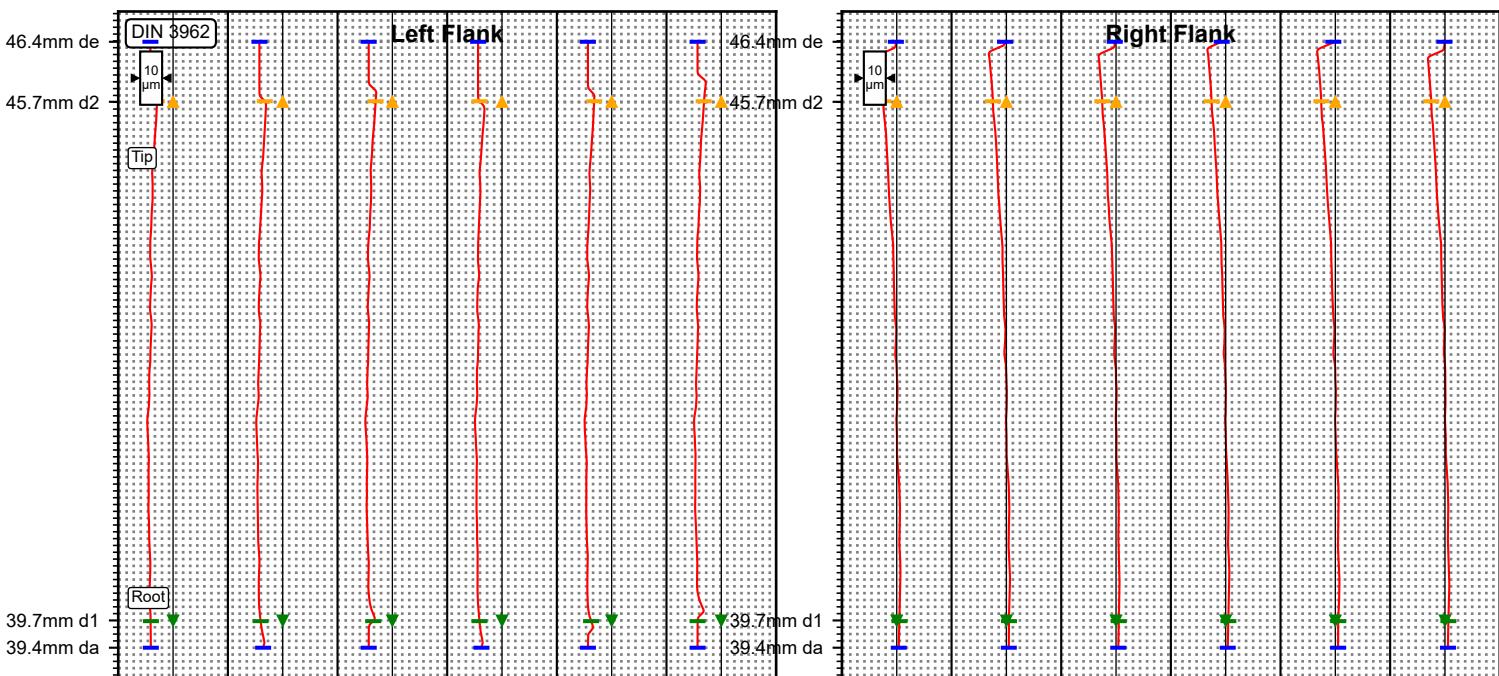
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHam	1.2 1	V 0.7					±11.5	±11.5	-7.8 4	V 1.4				
fHa	0.9	1.2	1.6 1	1.3	1.0	1.2	±11.5	±11.5	-7.3	-7.9	-7.5	-7.7	-7.9	-8.7 5
fa	5.1 2	4.5	5.0	4.5	4.5	4.7	20.5	20.5	9.0	9.9	9.4	9.9	9.8	11.8 4
ffa	5.1	4.9	5.2 2	3.7	4.7	4.0	16.5	16.5	7.4	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



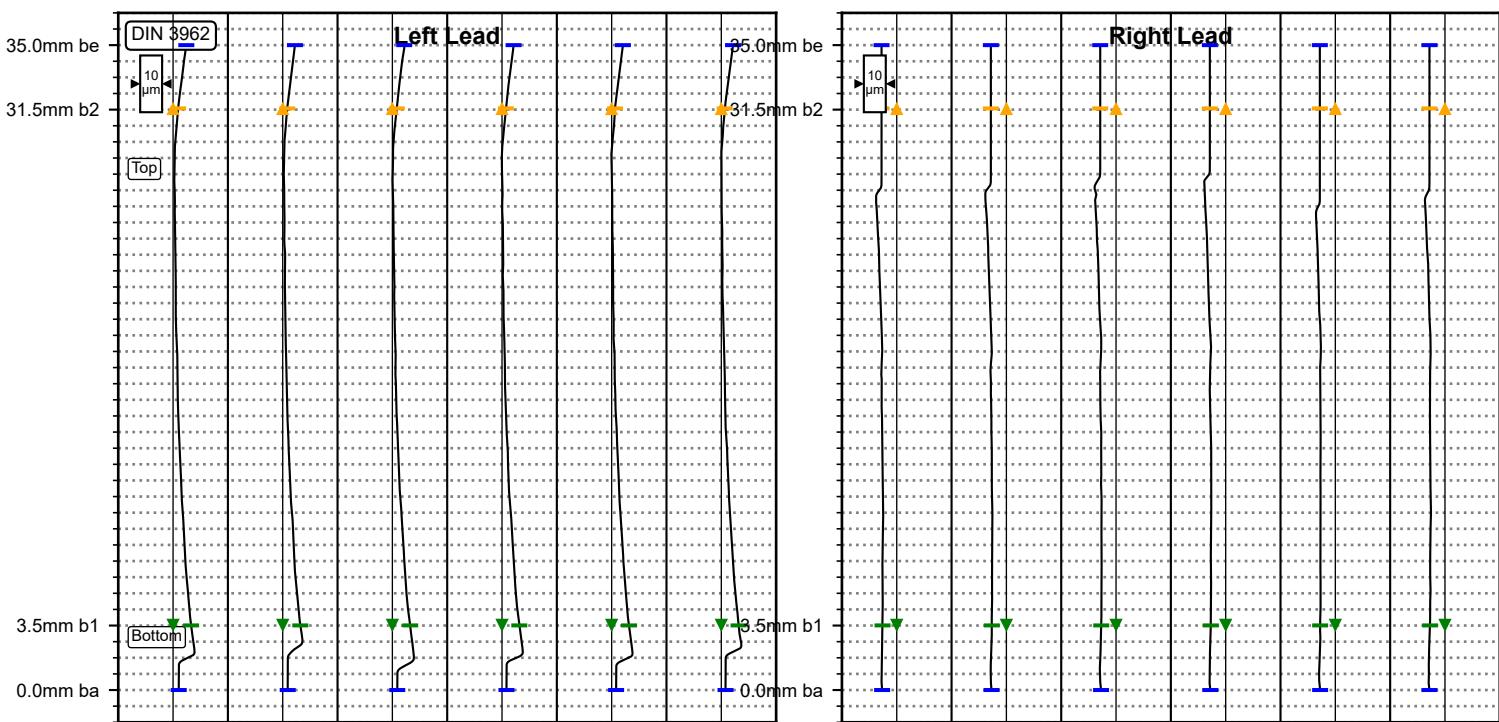
	18	17	16	15	14	13	Lim.value Qual.	Lim.value Qual.	13	14	15	16	17	18
fHbm	-6.4 5	V 2.1					±8.5	±8.5	-1.6 1	V 0.9				
fHb	-5.0	-7.0	-6.7	-6.5	-7.1 5	-6.3	±8.5	±8.5	-1.7	-1.4	-1.2	-2.1 1	-1.7	-1.3
fb	9.8	17.5	17.3	11.0	11.3	17.6 7	12.5	12.5	4.3	3.8	3.6	4.8 2	4.3	3.8
ffb	8.5	19.2 8	18.4	10.5	10.7	18.7	9.5	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.:	temp.mka	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. La:	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



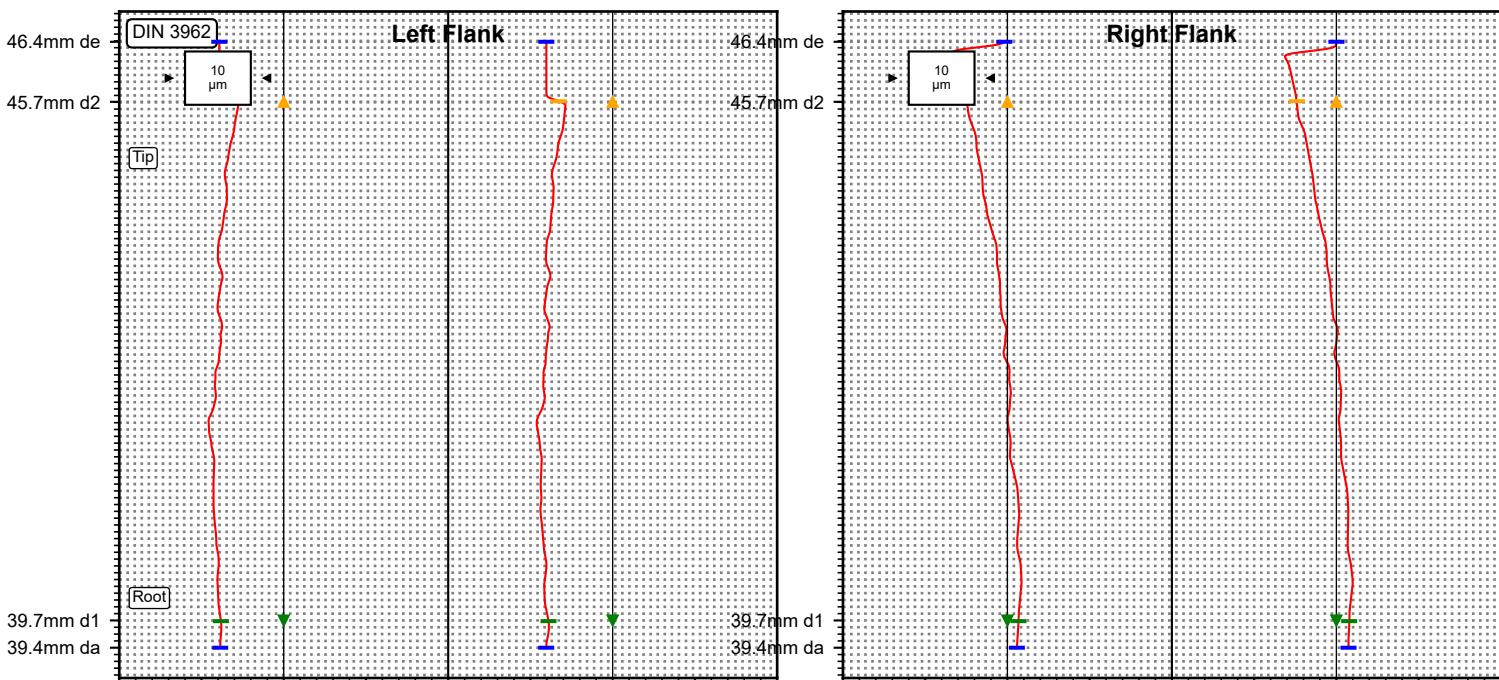
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHam	1.8 1	V 0.9					±11 5	±11 5	-8.8 5	V 0.8				
fHa	1.9	1.6	1.8	1.3	1.7	2.2 1	±11 5	±11 5	-8.5	-8.7	-8.6	-9.2	-9.3 5	-8.8
fa	4.6	4.8	5.5	4.5	4.8	5.9 2	20 5	20 5	10.2	10.7	10.6	11.2 4	11.1	10.7
ffa	3.6	4.9	6.1	4.5	5.3	6.3 3	16 5	16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



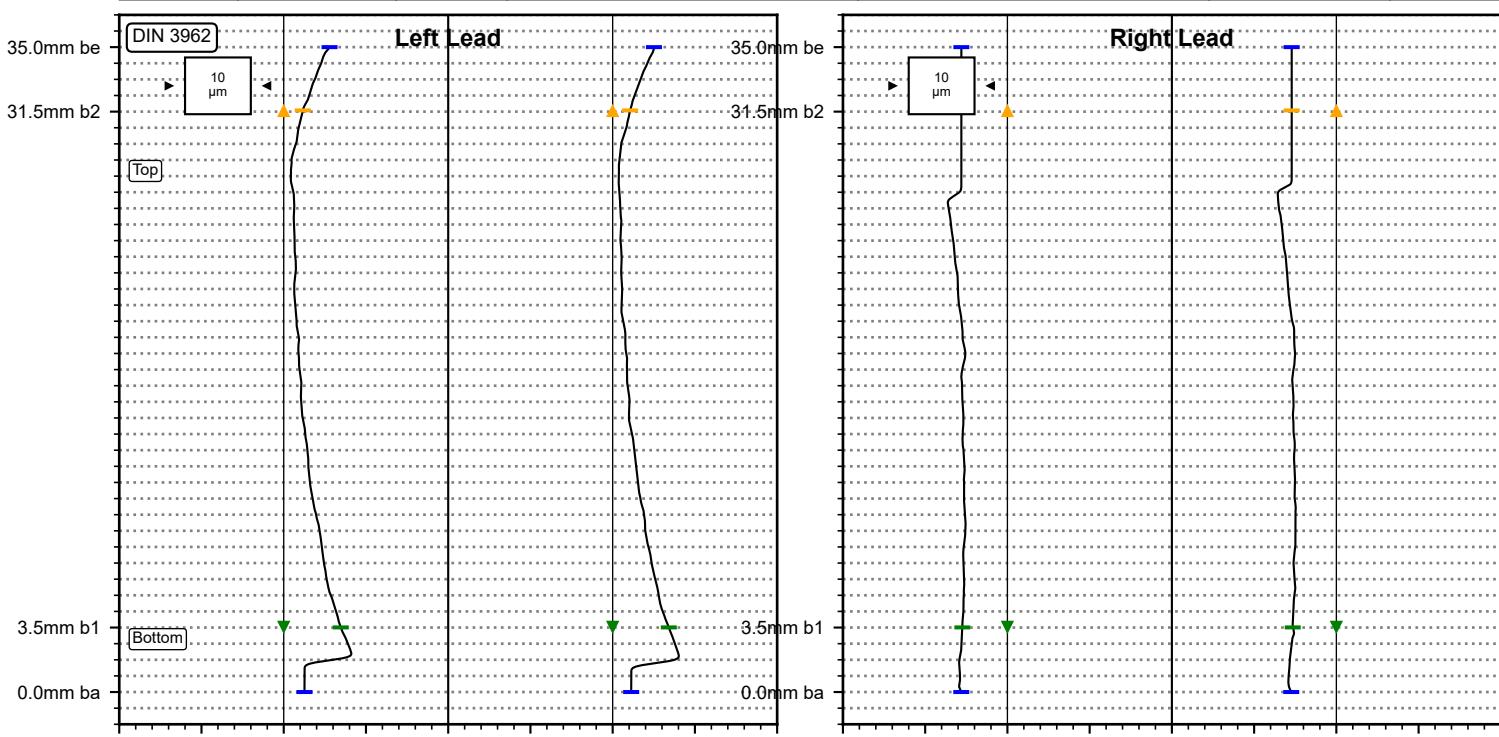
	24	23	22	21	20	19	Lim.value Qual.	Lim.value Qual.	19	20	21	22	23	24
fHbm	-5.0 4	V 1.4					±8 5	±8 5	-1.1 1	V 0.7				
fHb	-4.9	-4.2	-5.6 4	-5.2	-5.4	-4.8	±8 5	±8 5	-1.2	-1.2	-1.3 1	-1.3 1	-0.6	-0.7
fb	9.7	9.1	10.4 5	10.2	10.2	9.7	12 5	12 5	4.3 2	3.6	4.2	4.0	2.7	3.2
ffb	8.4	7.8	8.9 5	8.5	8.6	8.6	9 5	9 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.:	temp.mka	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. La:	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



	26	25	Lim.value Qual.	25	26
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

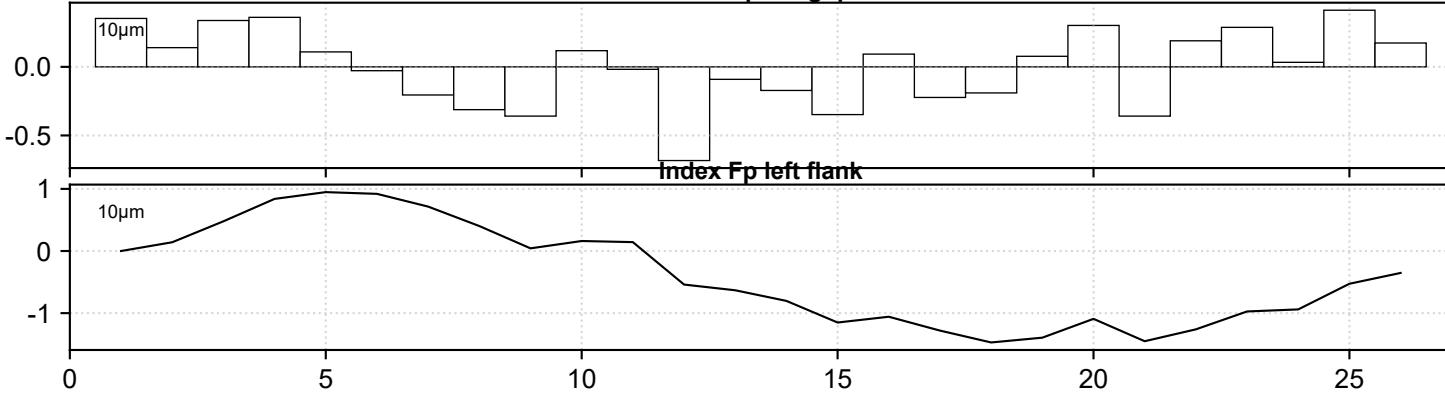


	26	25	Lim.value Qual.	25	26
fHbm	-4.8 4	V 0.3	±8.5	±8.5	-0.8 1 V 0.0
fHb	-4.7	-5.0 4	±8.5	±8.5	-0.8 1 -0.8 1
fb	9.7 4	9.6	12.5	12.5	3.0 3.1 2
ffb	9.2 6	8.5	9.5	9.5	2.8 2 2.7
Cb	-2.9	-2.9			-0.1 0.0

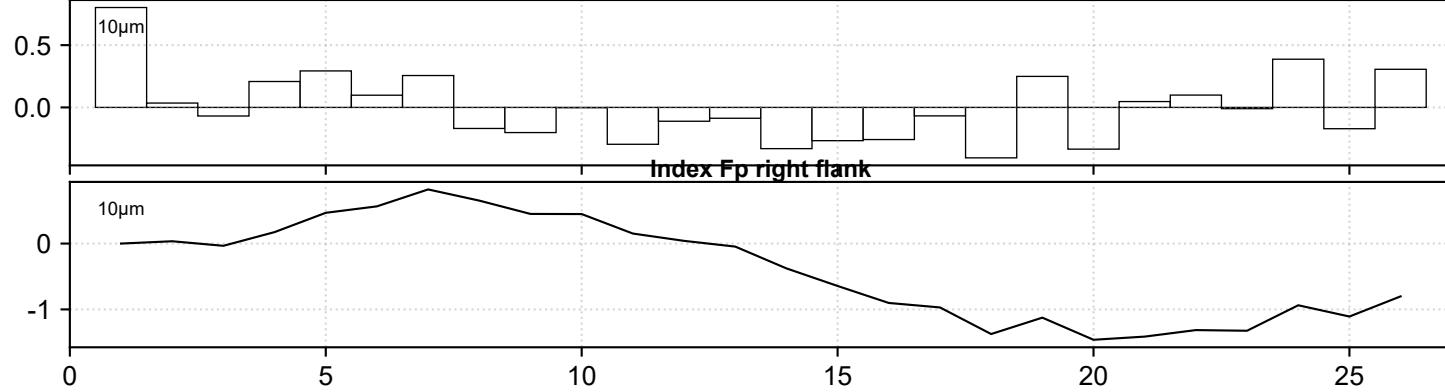
# Gear Spacing

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

Tooth to tooth spacing fp left flank



Tooth to tooth spacing fp right flank



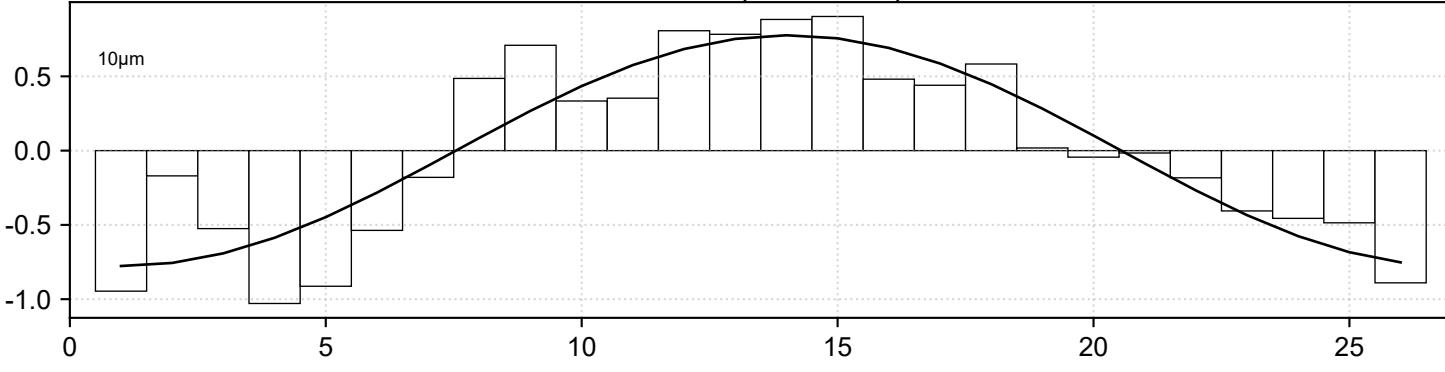
Pitch measuring circle:

left flank

right flank

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

Runout Fr (Ball-Ø =3mm)



MdK 47.347[mm]/Ball-Ø 1

Pitch Line Runout	Fr	1.9			Lim.value	47.393	47.301	
Variation of tooth thickn	Rs				Act.	46.207	47.348	45.110