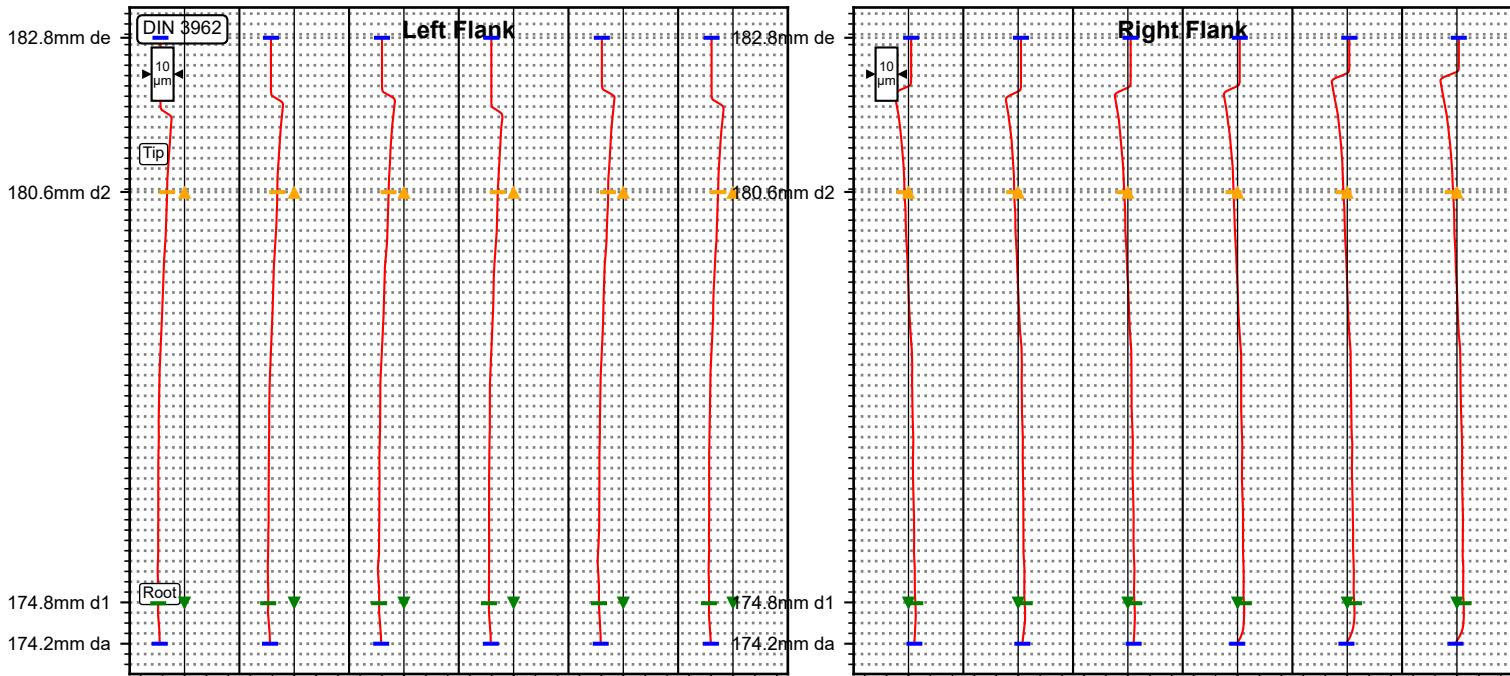
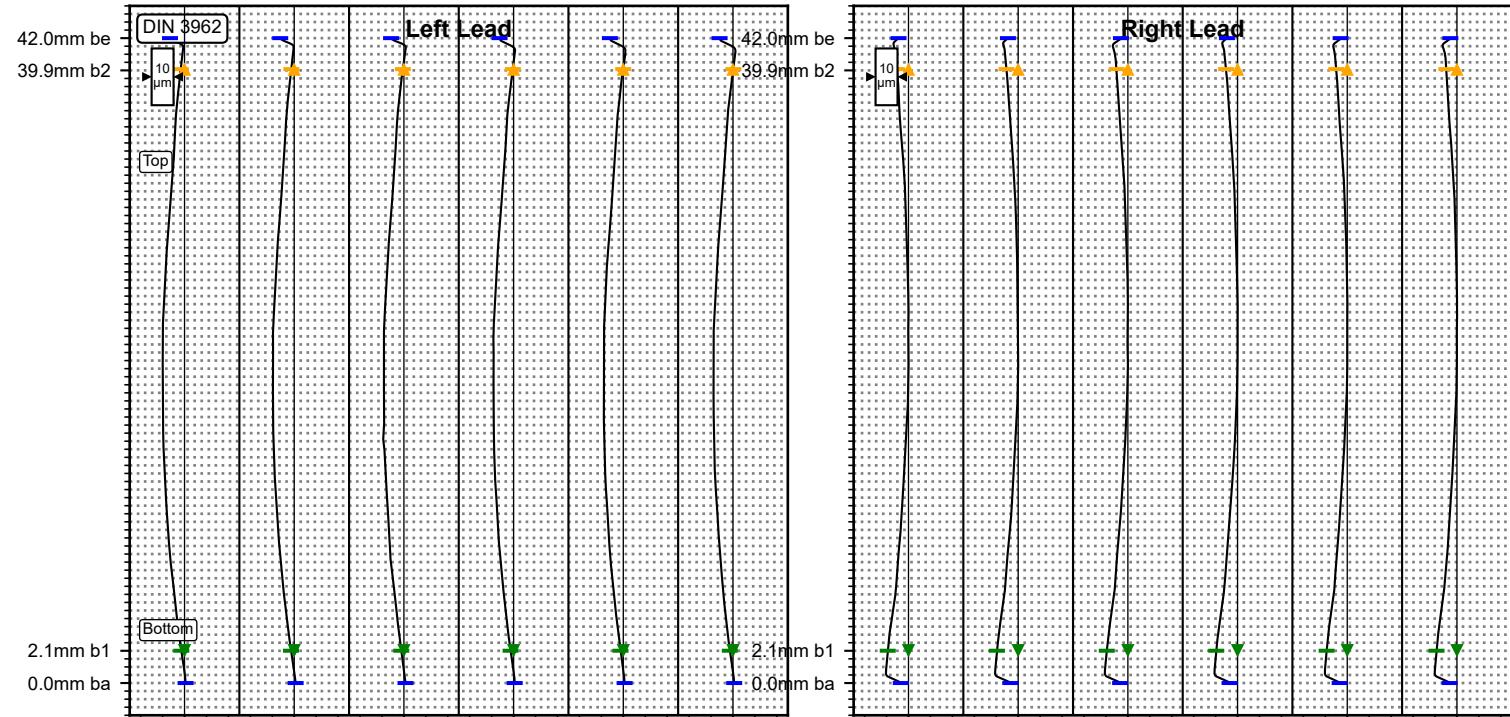


# Gear Profile/Lead

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 $\alpha$ :	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



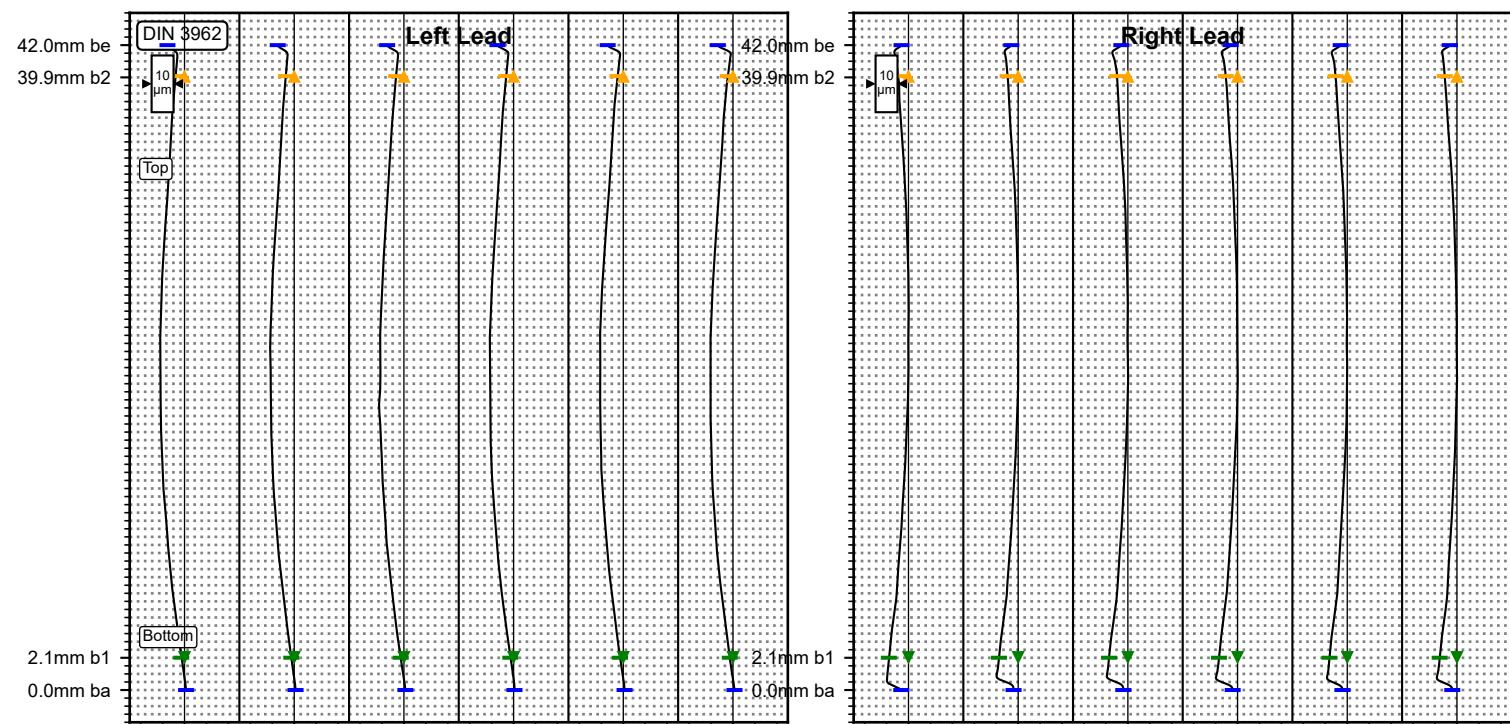
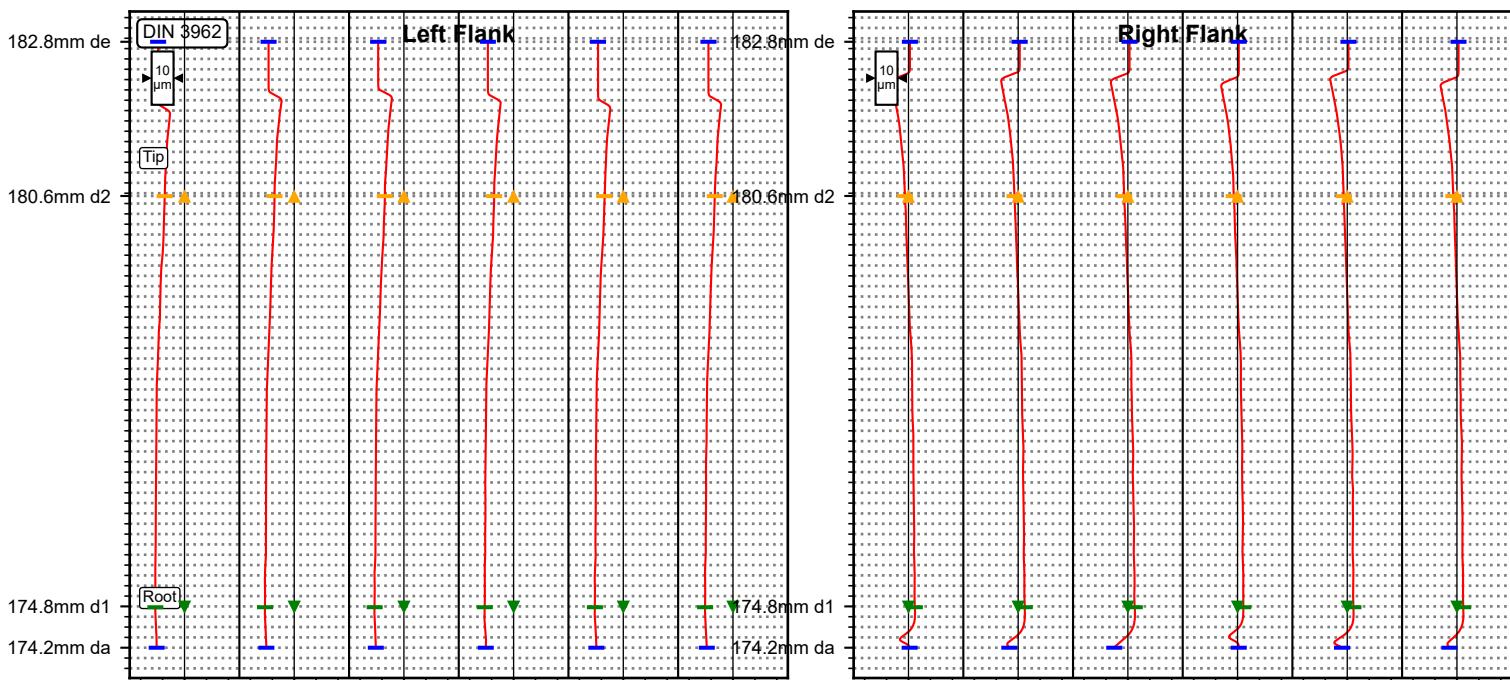
	6	5	4	3	2	1	Lim.value Qual.		1	2	3	4	5	6
fHam							±11.5							
fHa							±11.5							
fa							20.5							
ffa							16.5							
Ca	-1.6	-1.6	-1.7	-1.5	-1.7									
									1.3	1.3	1.2	1.4	1.1	



	6	5	4	3	2	1	Lim.value Qual.		1	2	3	4	5	6
fHbm							±8.5							
fHb							±8.5							
fb							12.5							
ffb							9.5							
Cb	-8.3	-8.2	-8.2	-8.1	-8.0				7.4	7.4	7.4	7.4	7.2	

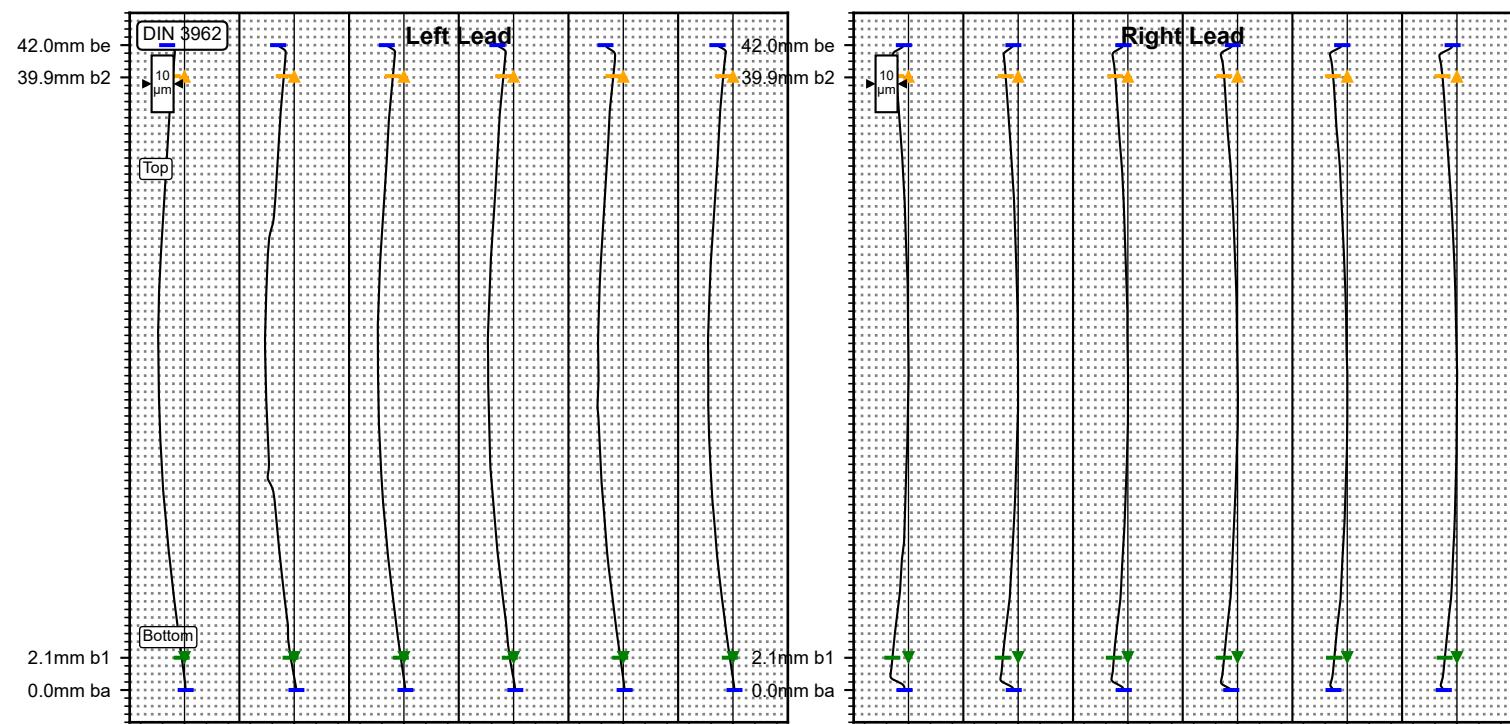
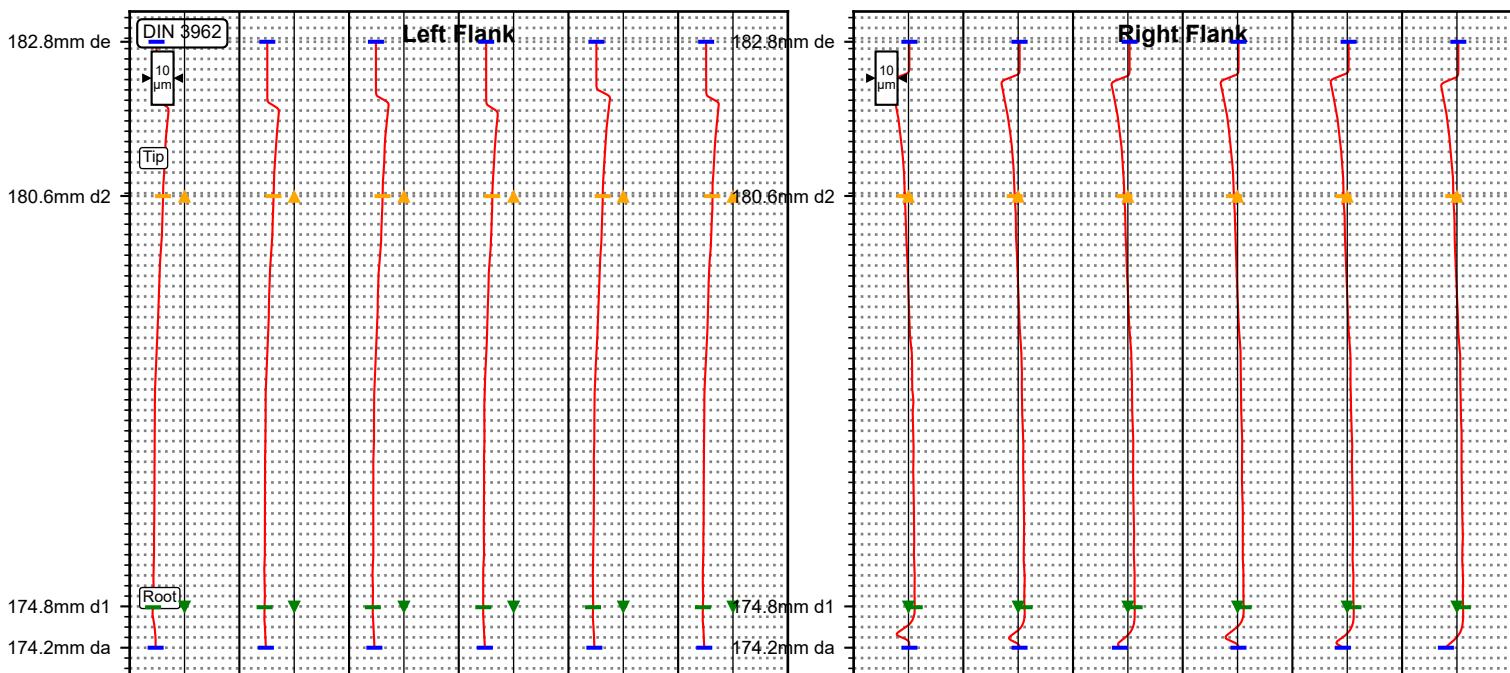
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



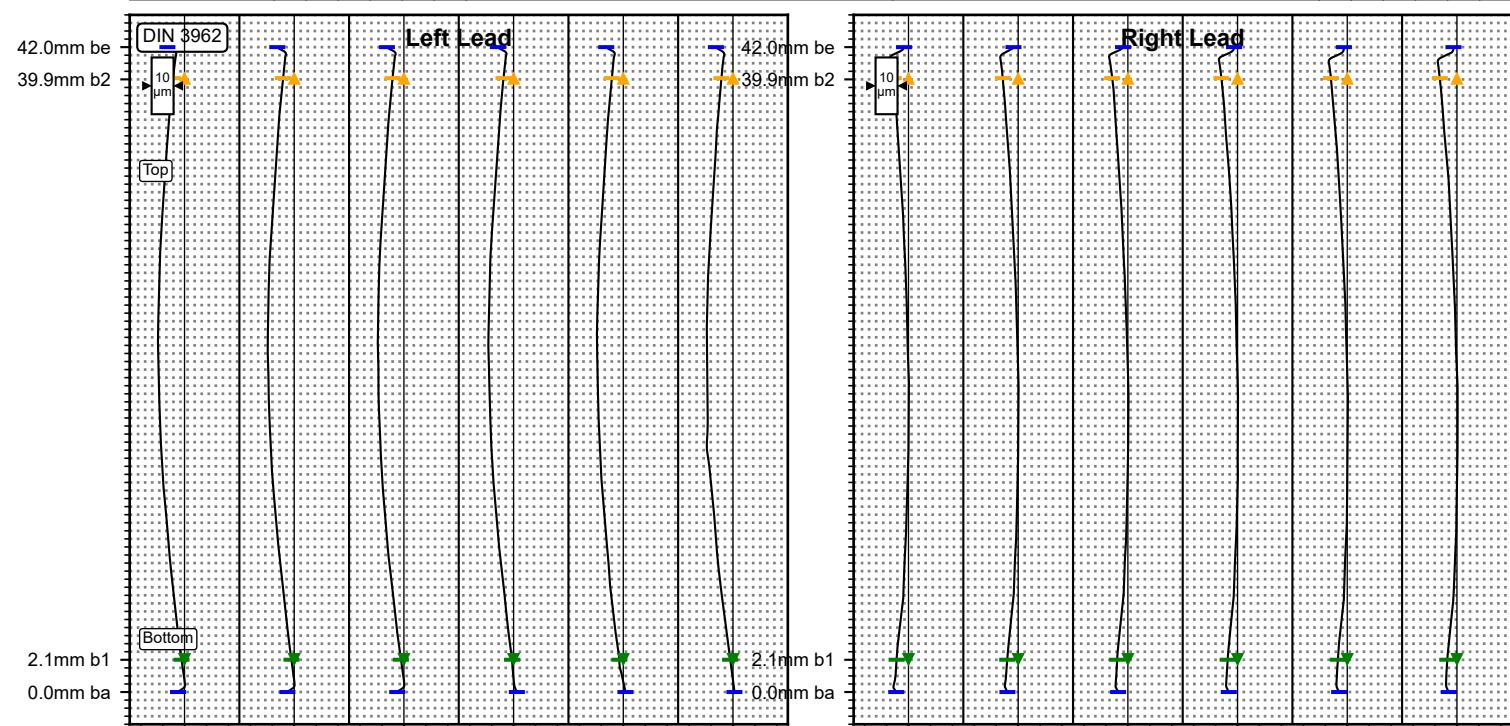
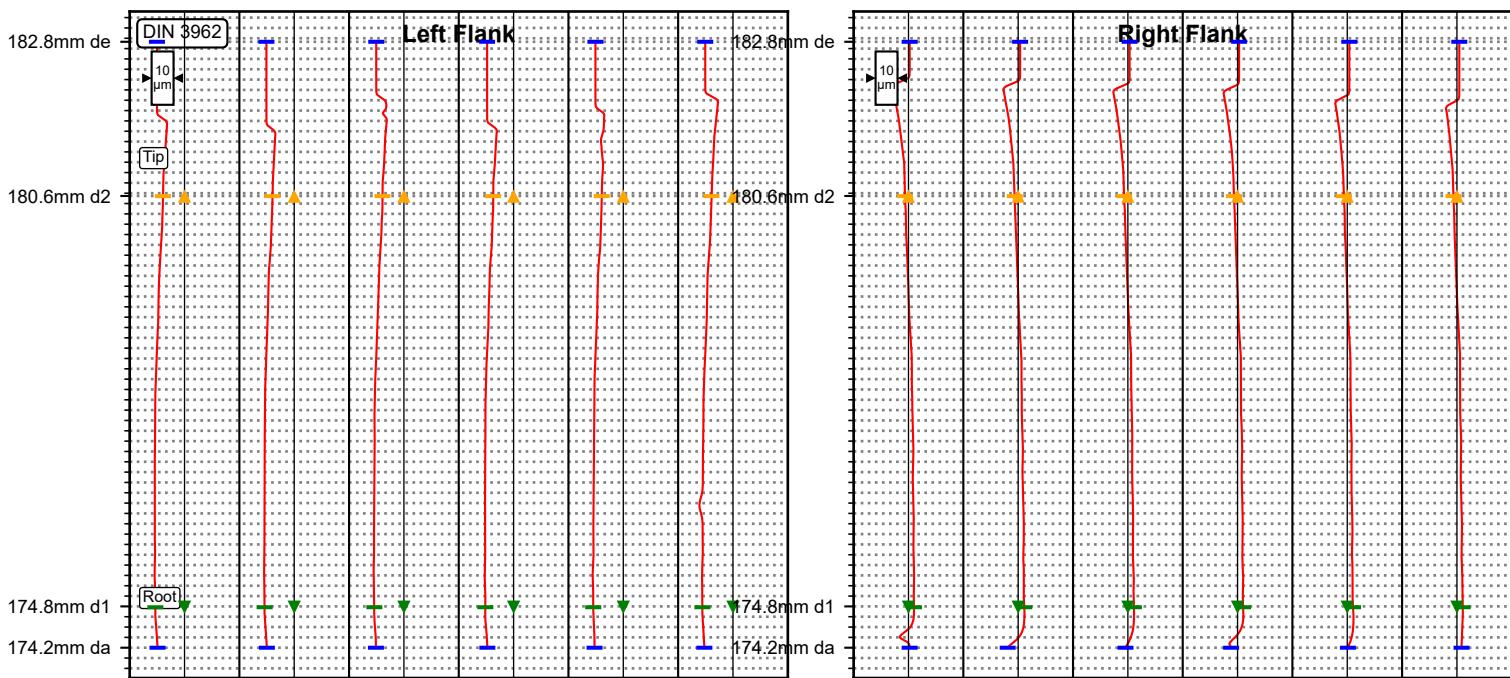
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



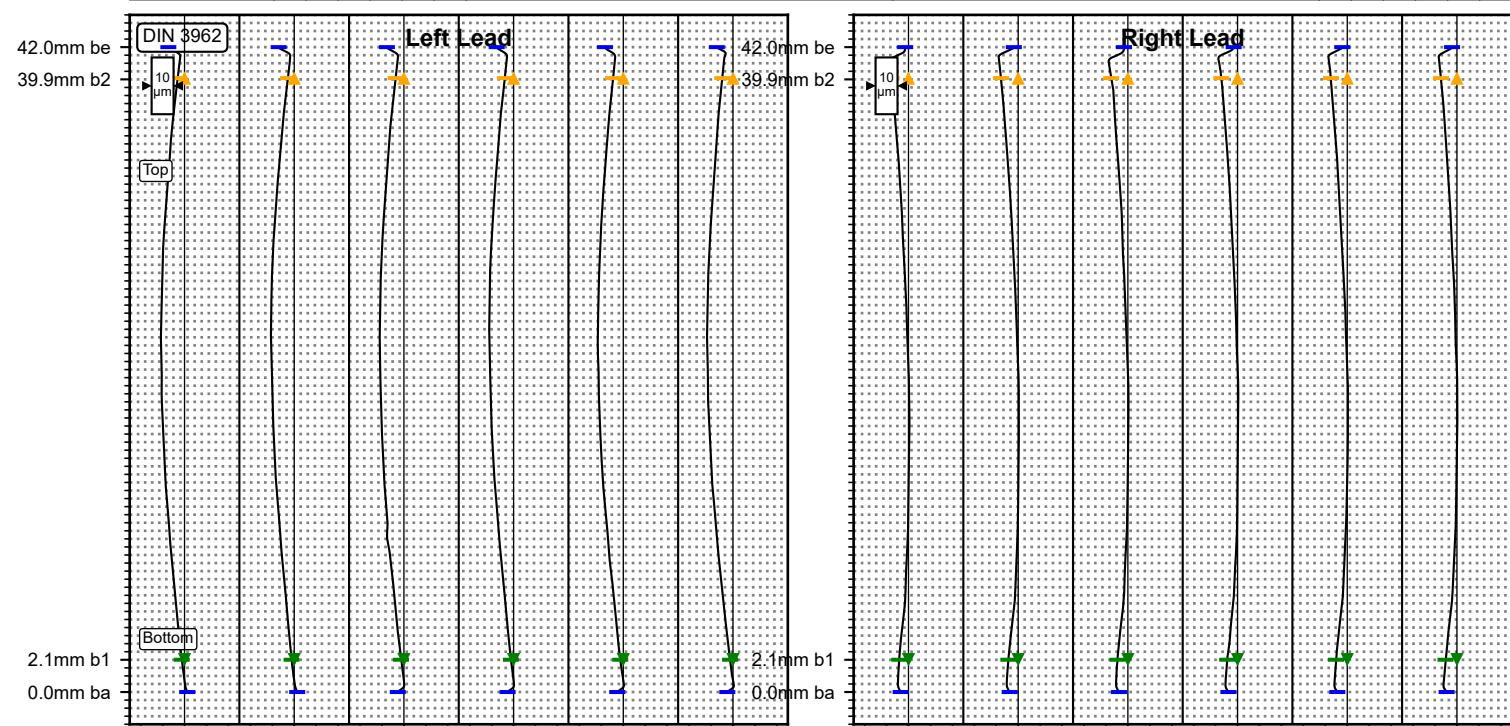
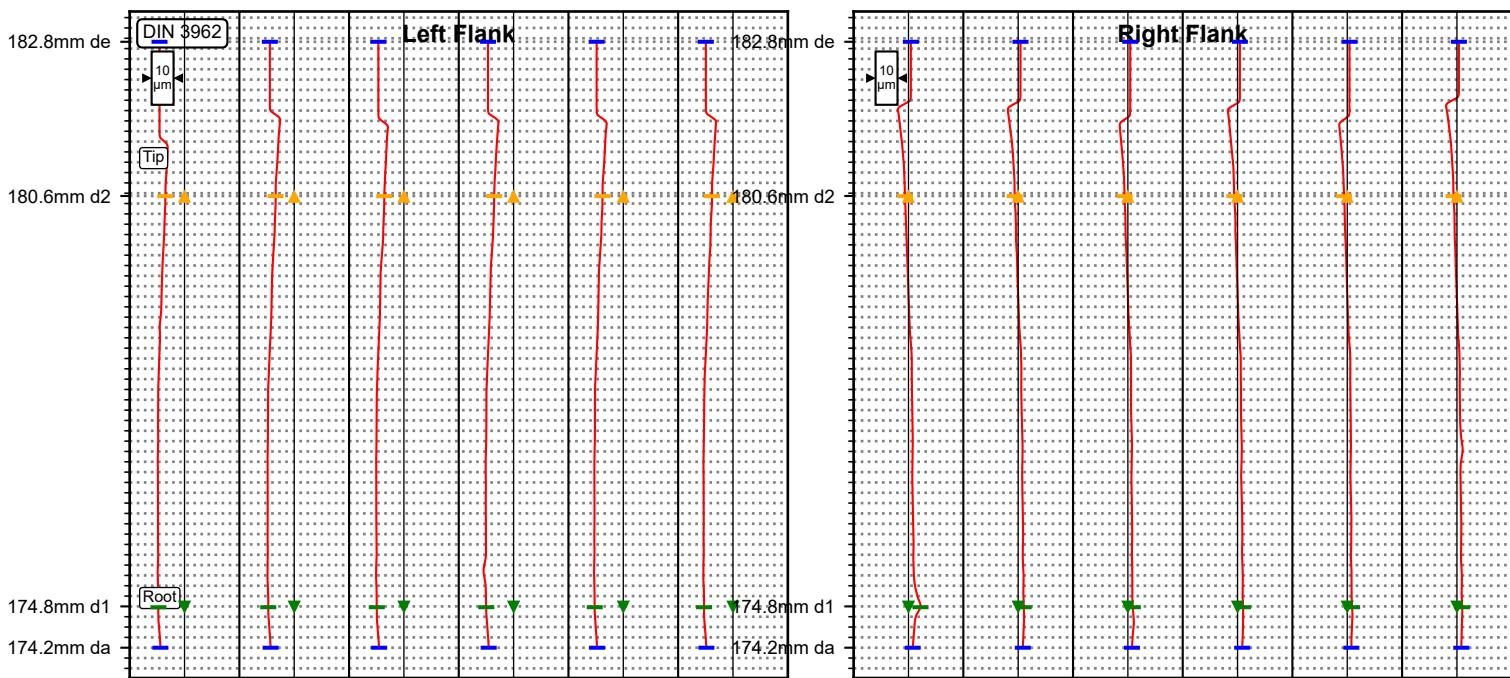
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



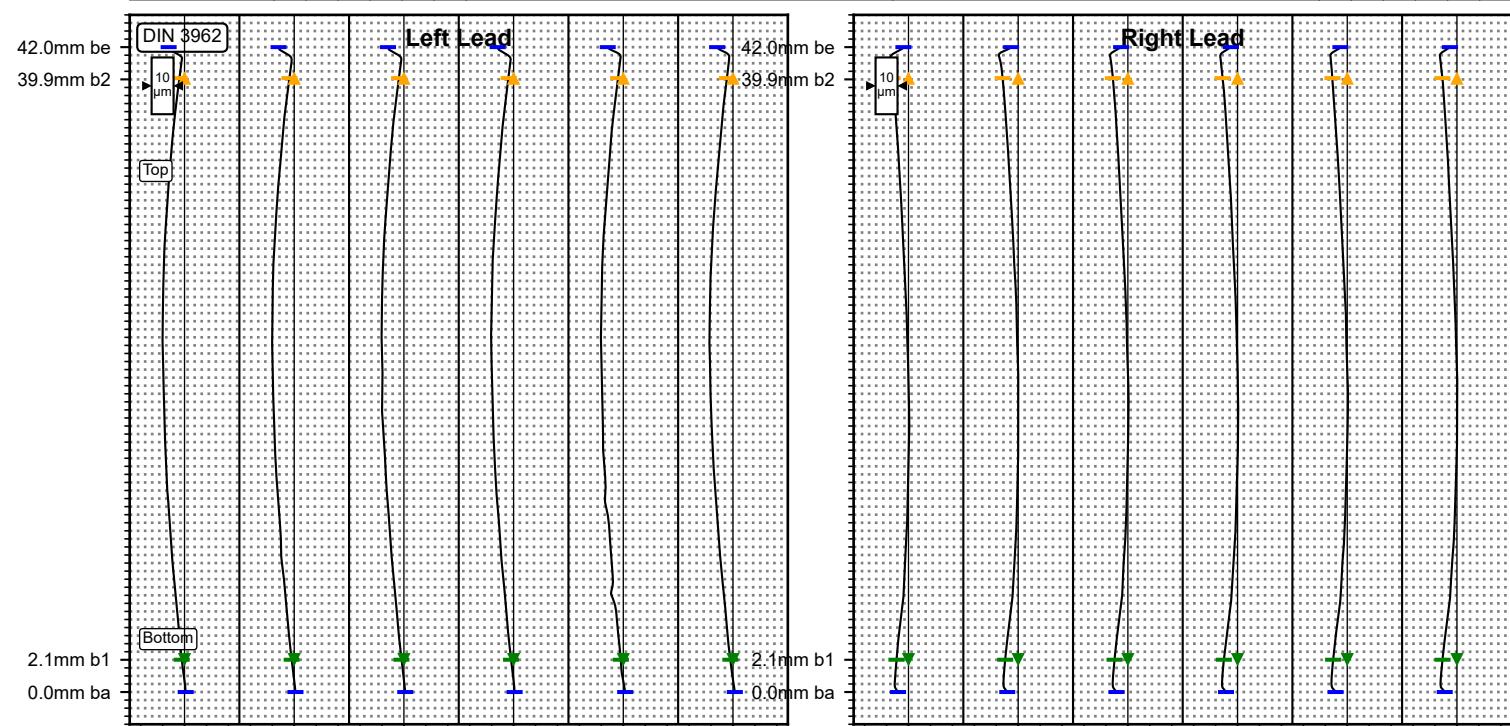
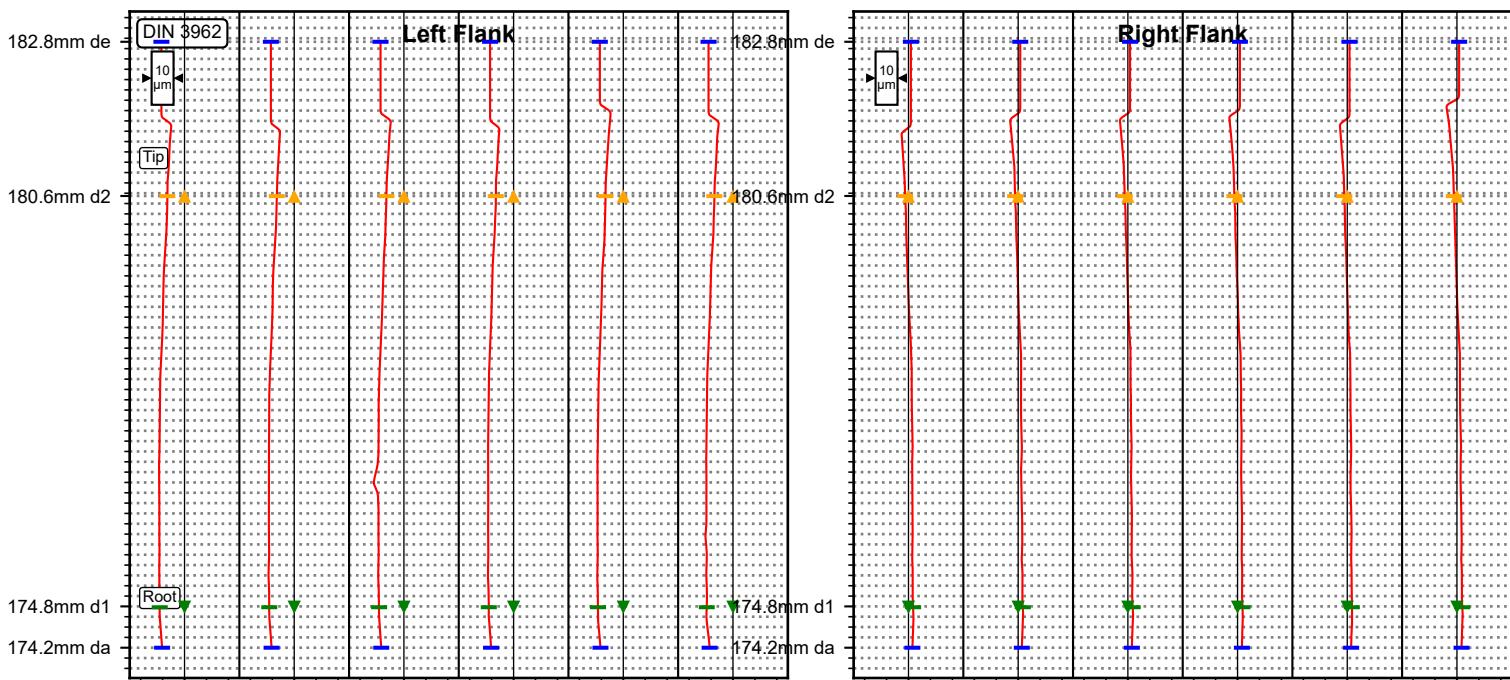
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



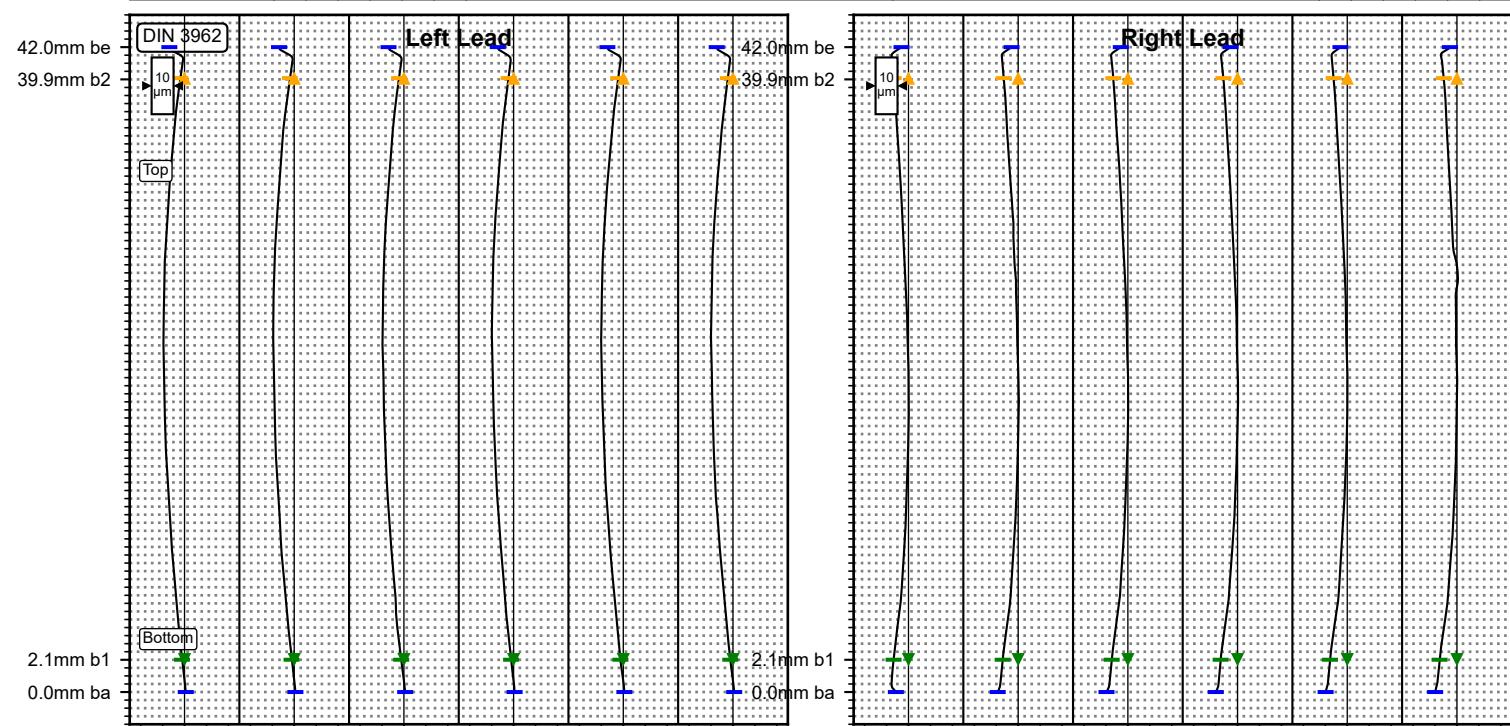
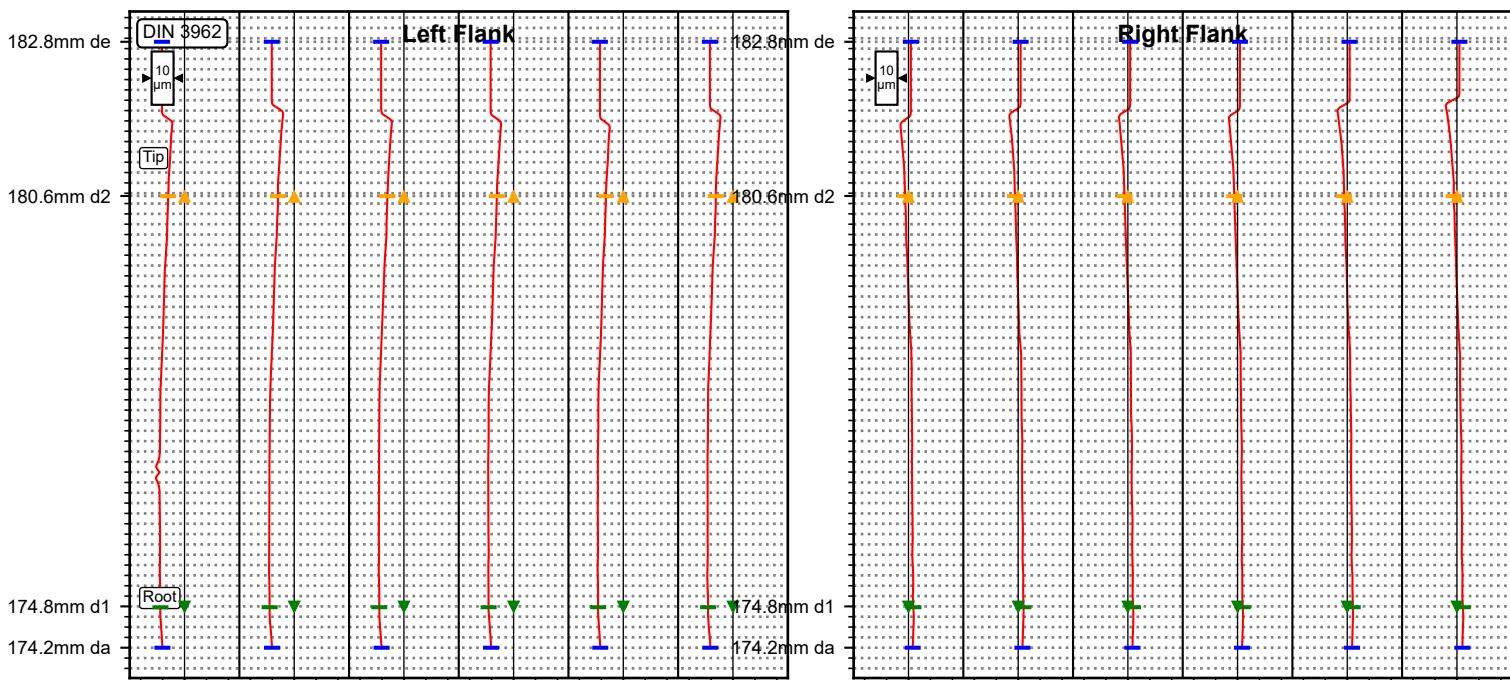
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



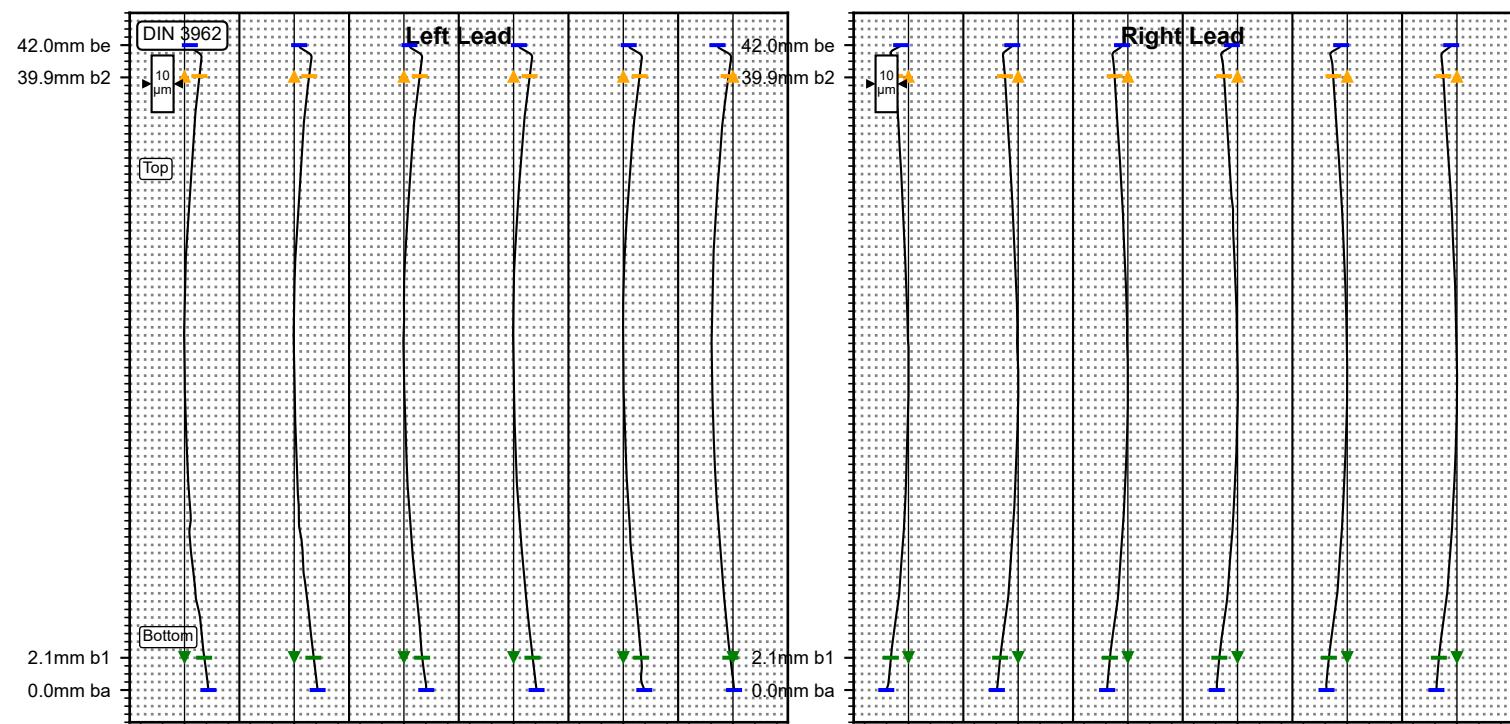
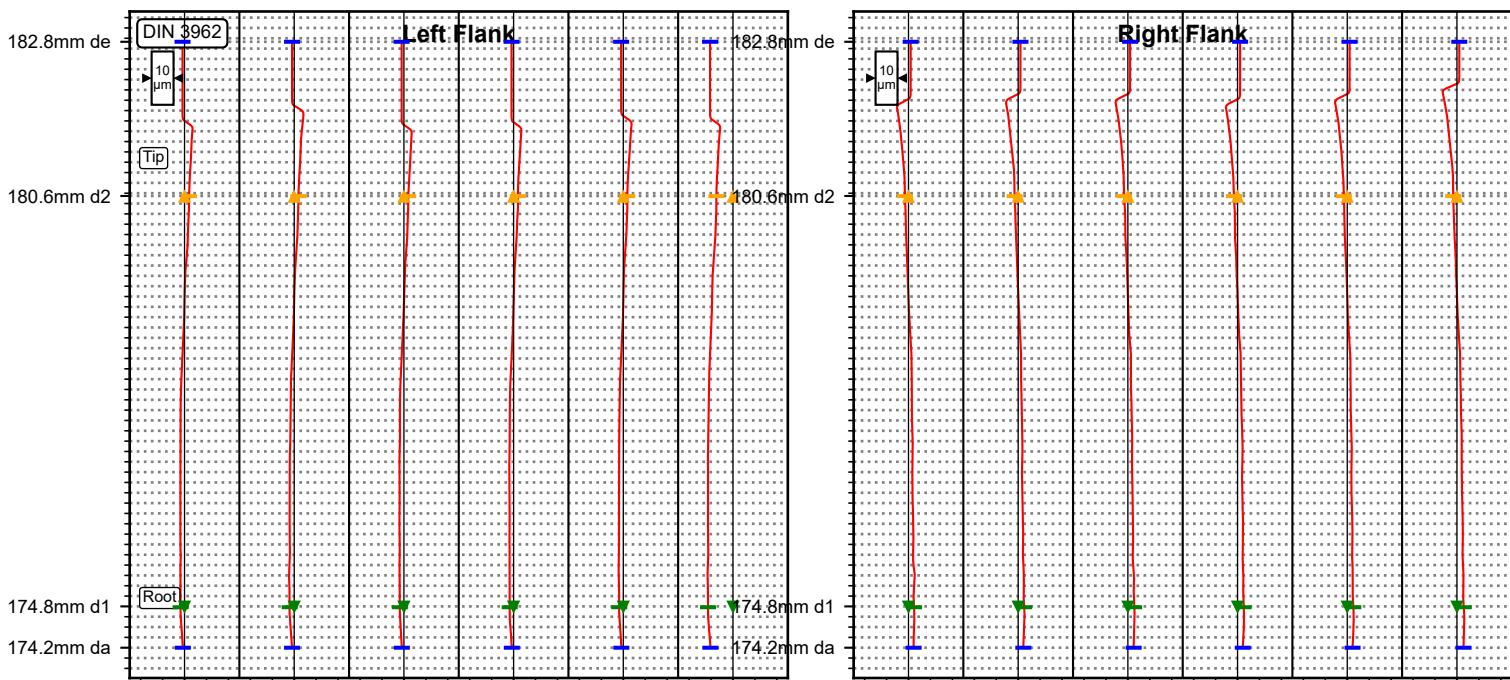
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



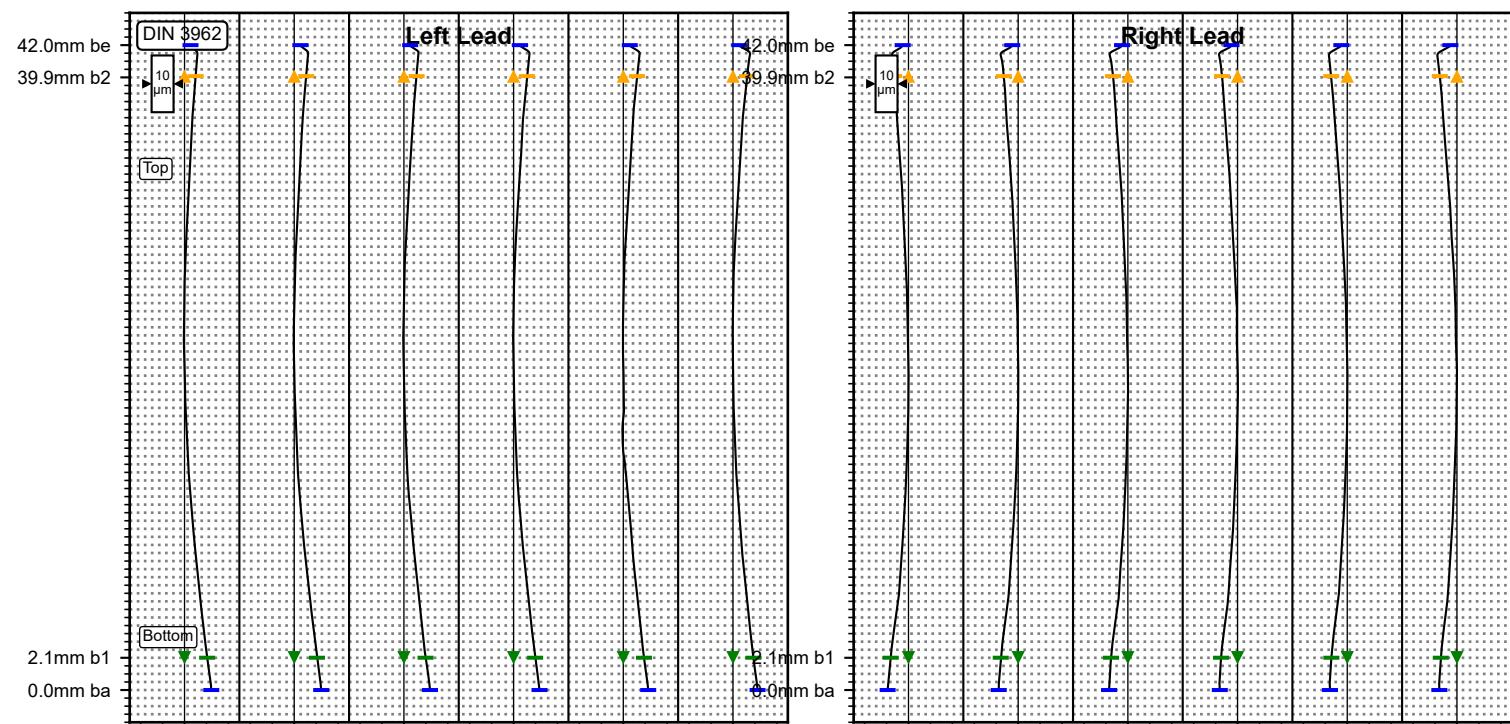
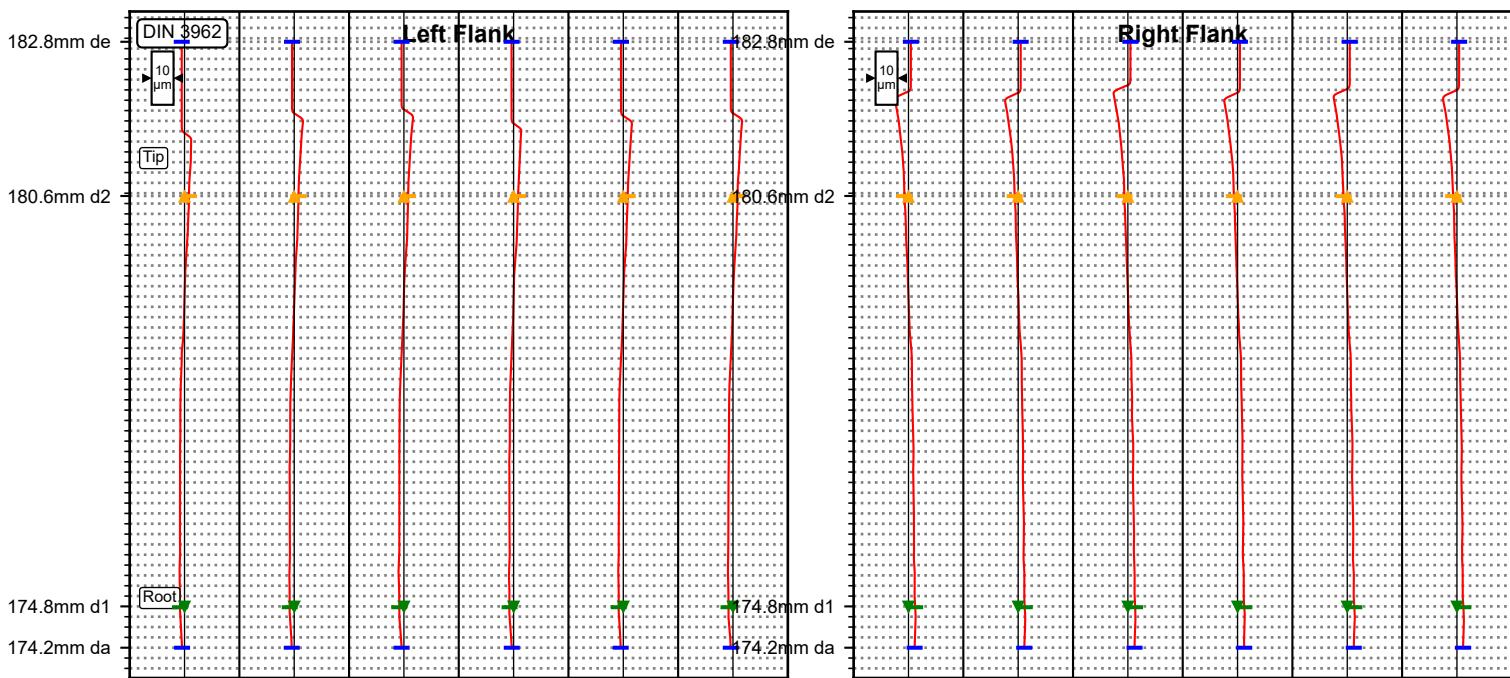
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



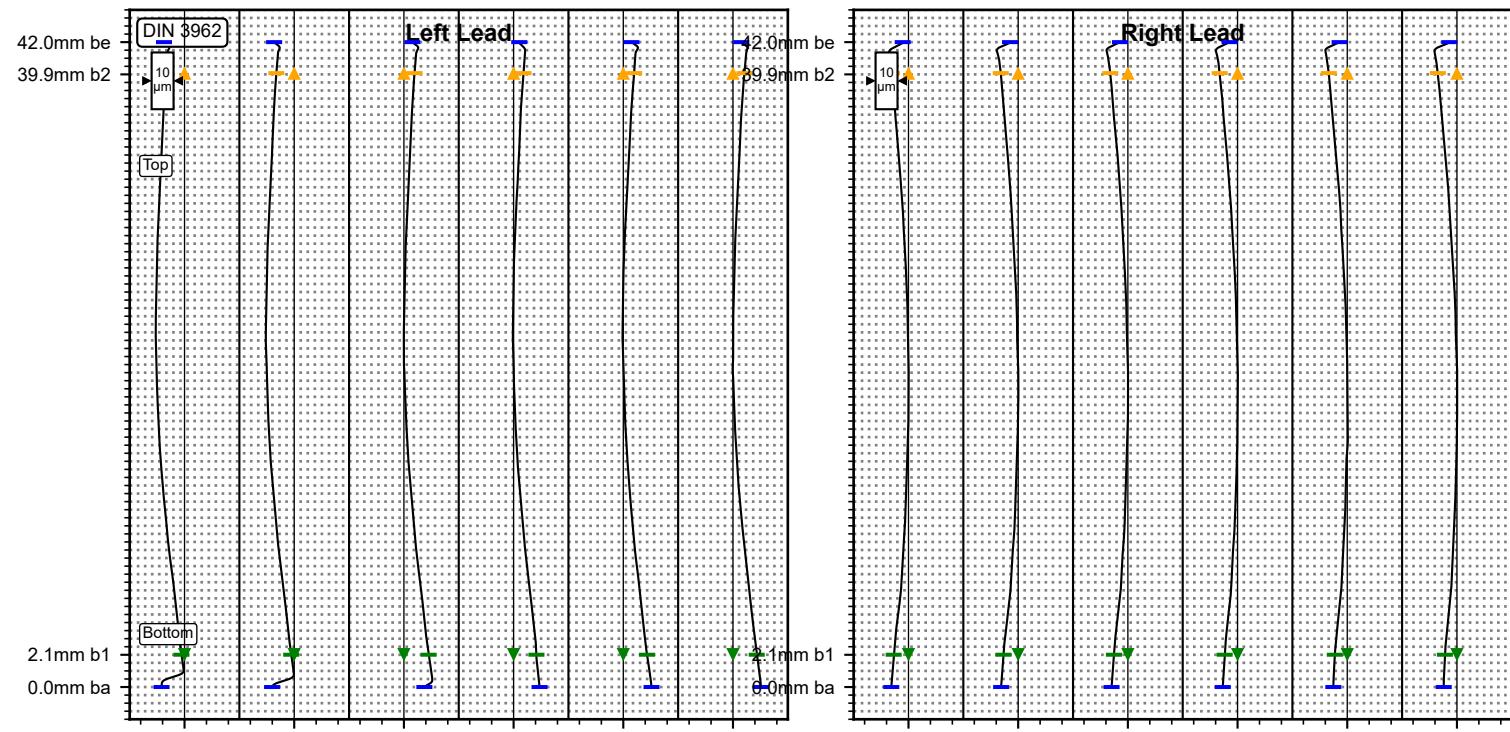
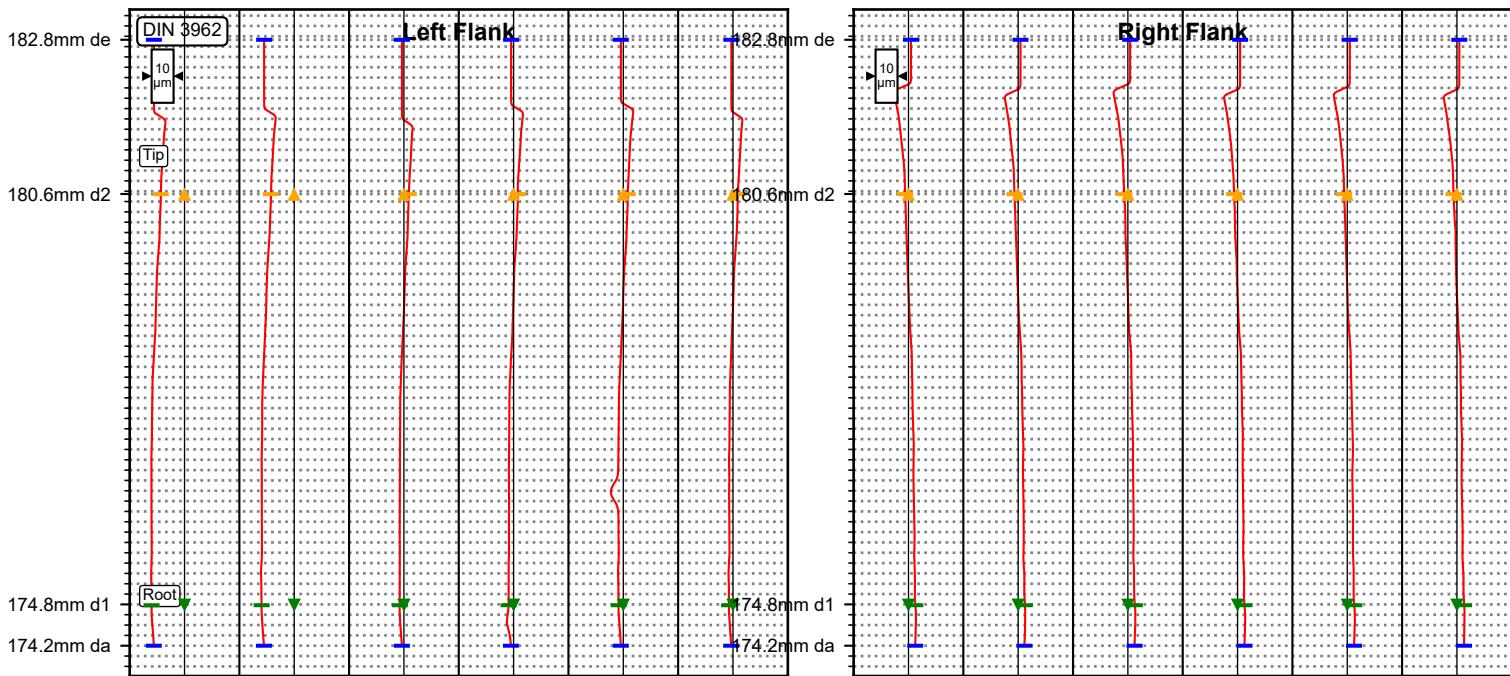
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



# Gear Profile/Lead

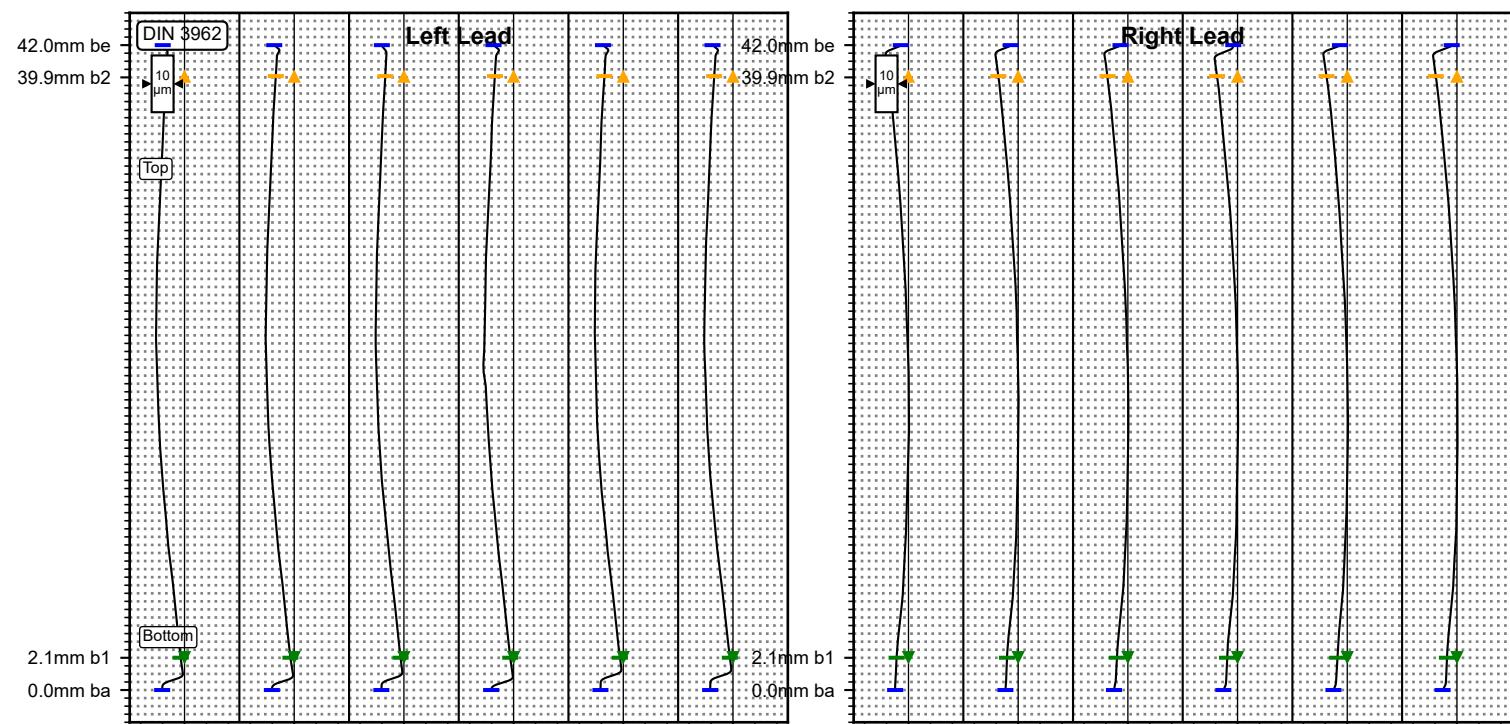
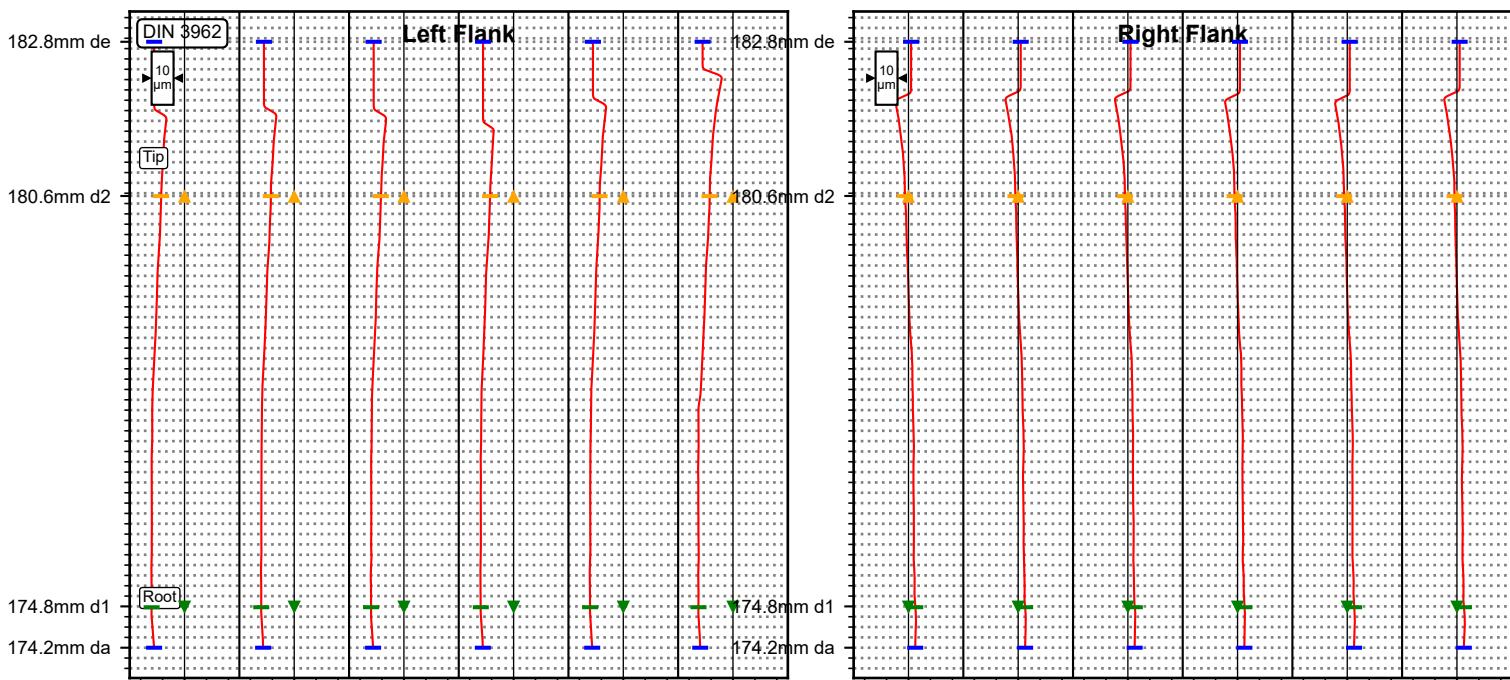
Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. L $\alpha$ :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L $\beta$ :	37.80mm
Cust./Mach. N:	P26-601418	Helix angle:	25.30°	Appr.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



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 $\alpha$ :	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

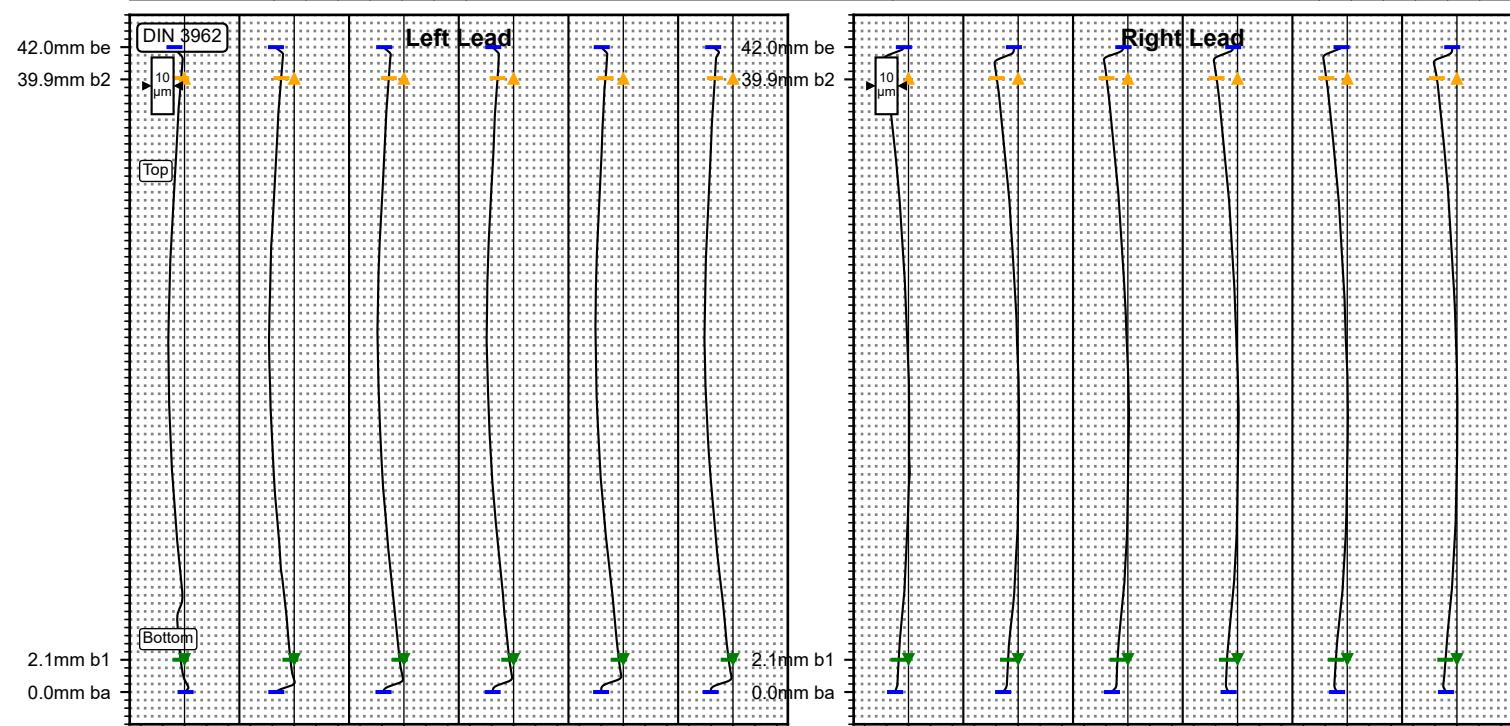
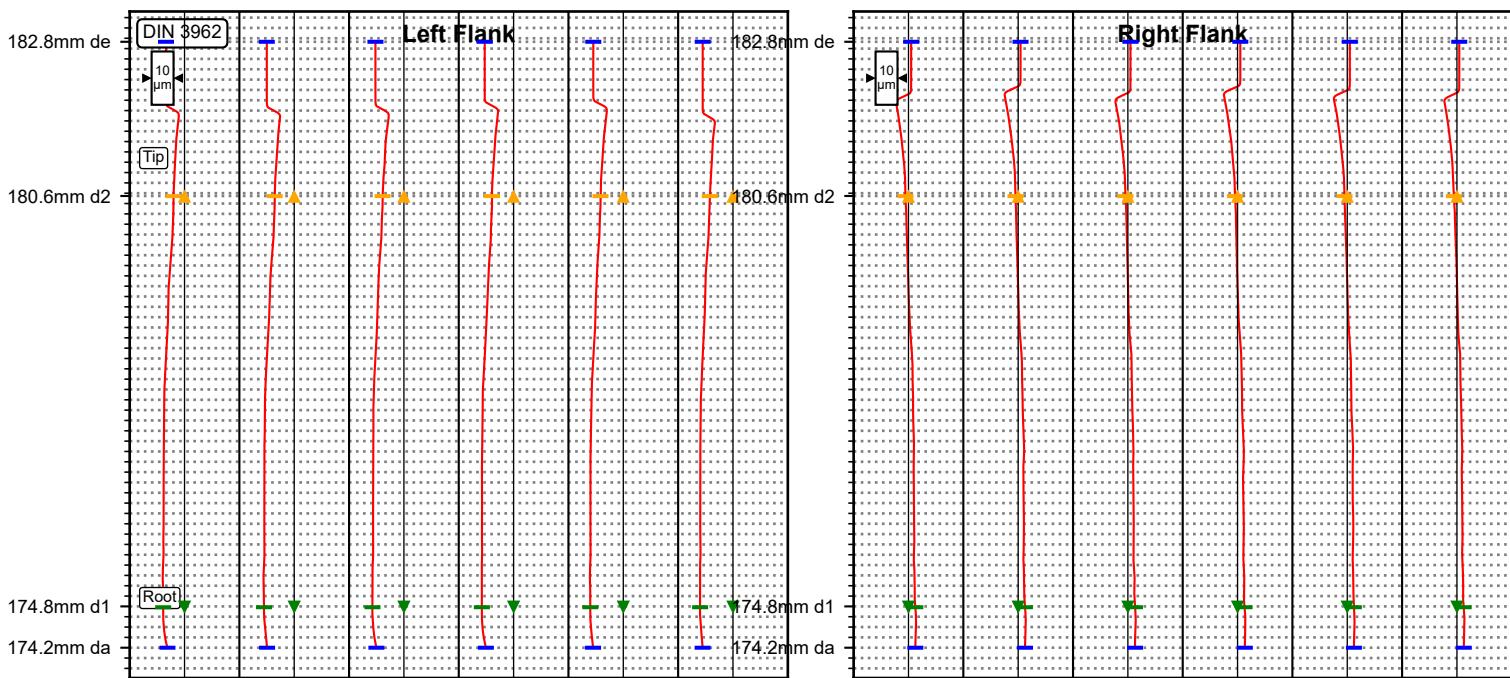
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



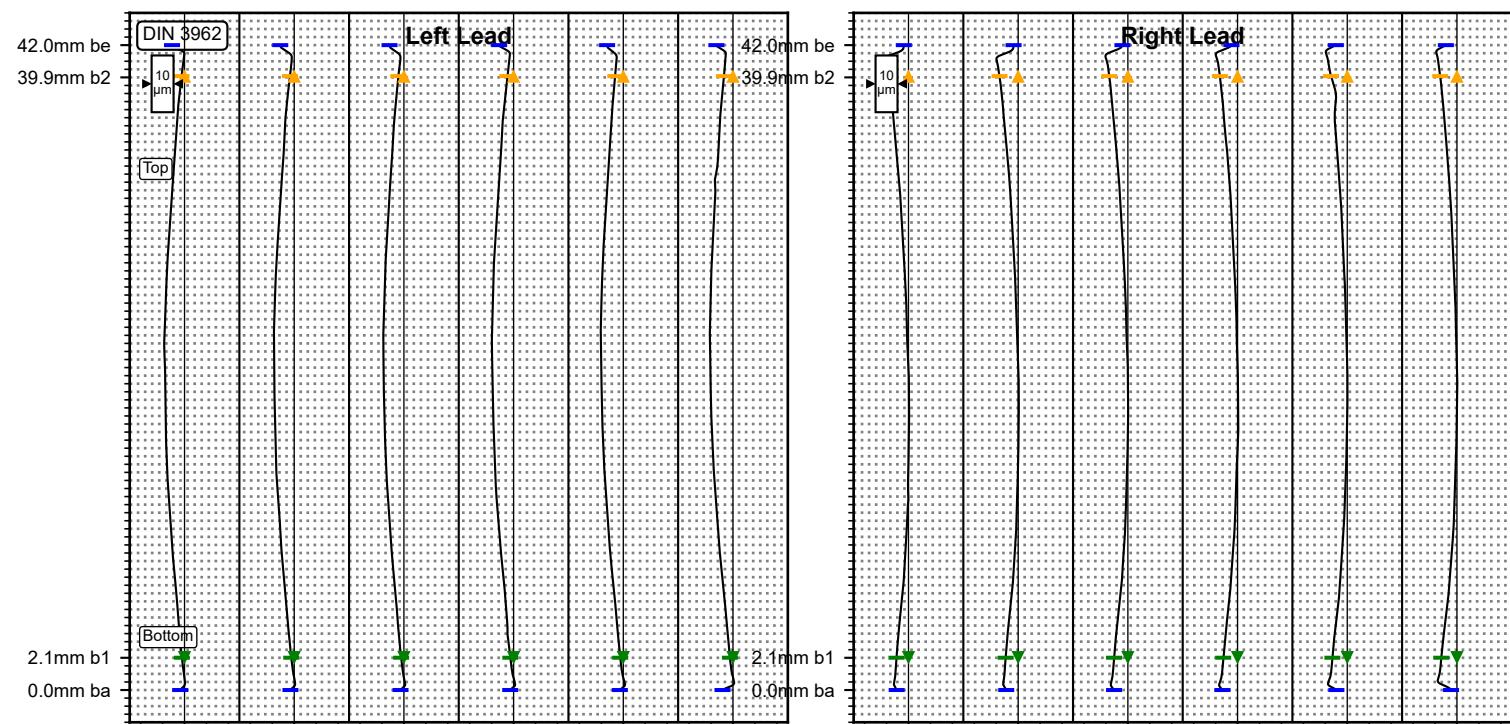
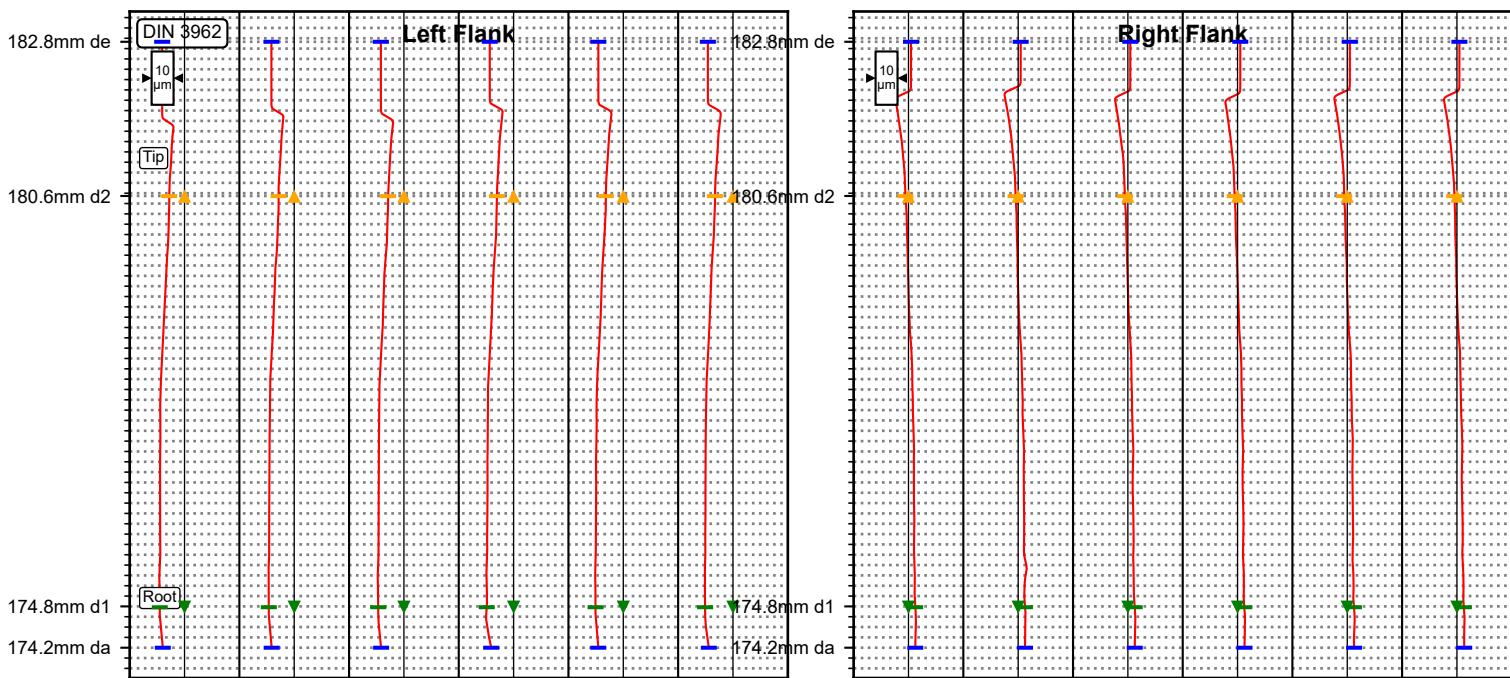
## **Gear Profile/Lead**

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. 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



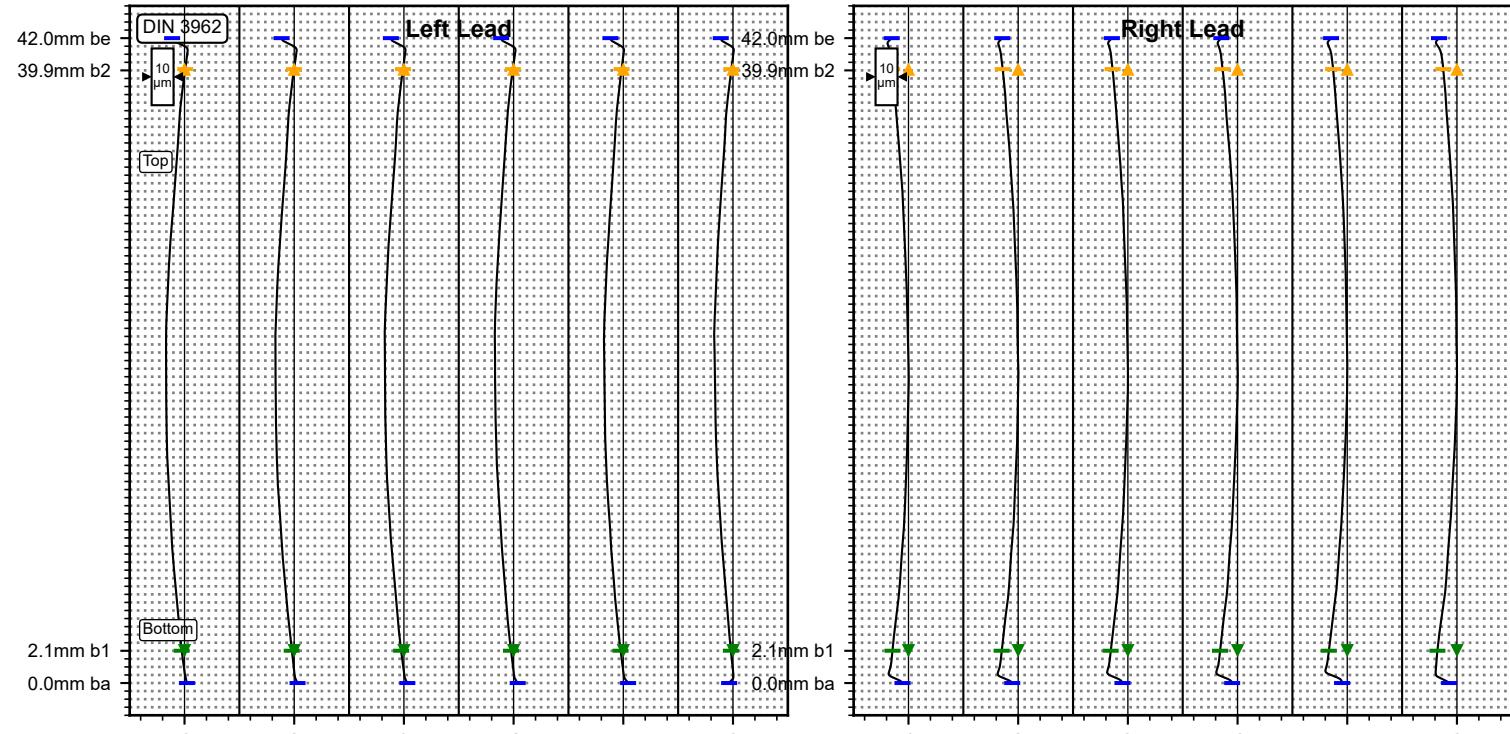
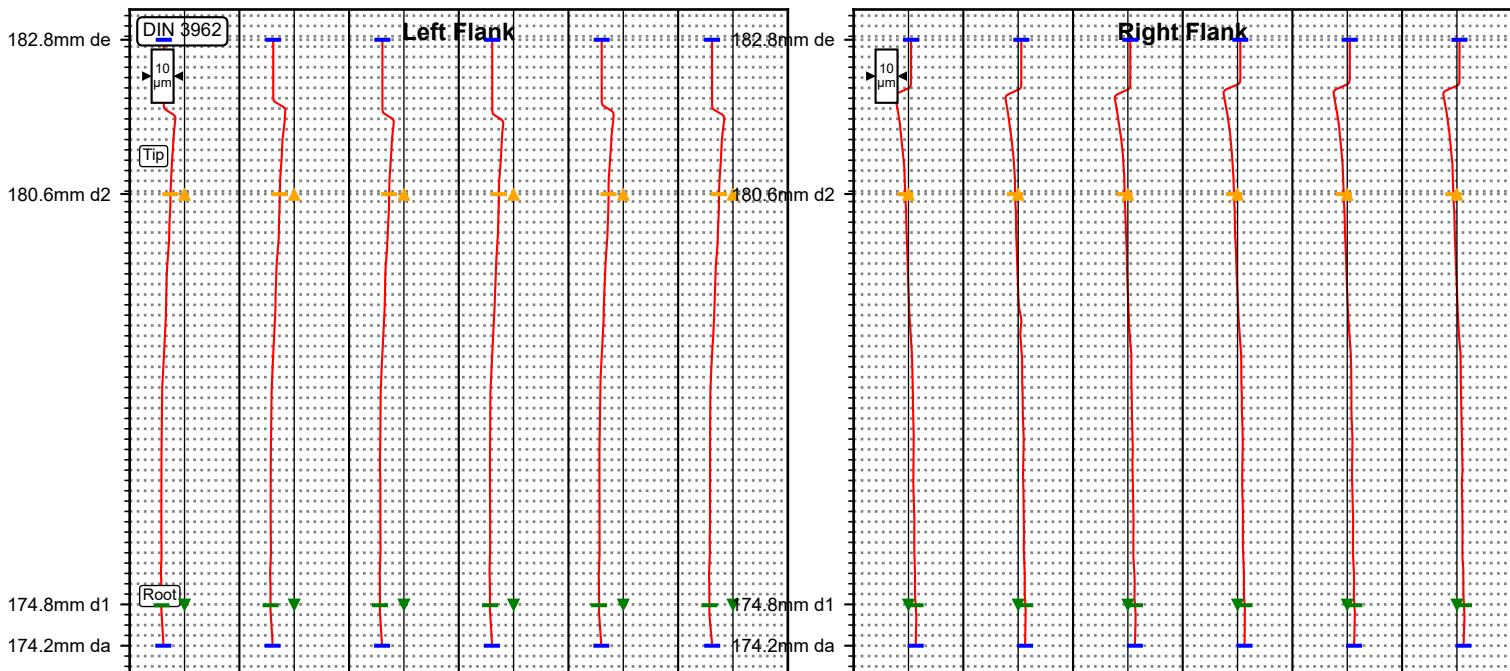
## **Gear Profile/Lead**

<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. Lα:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



# Gear Profile/Lead

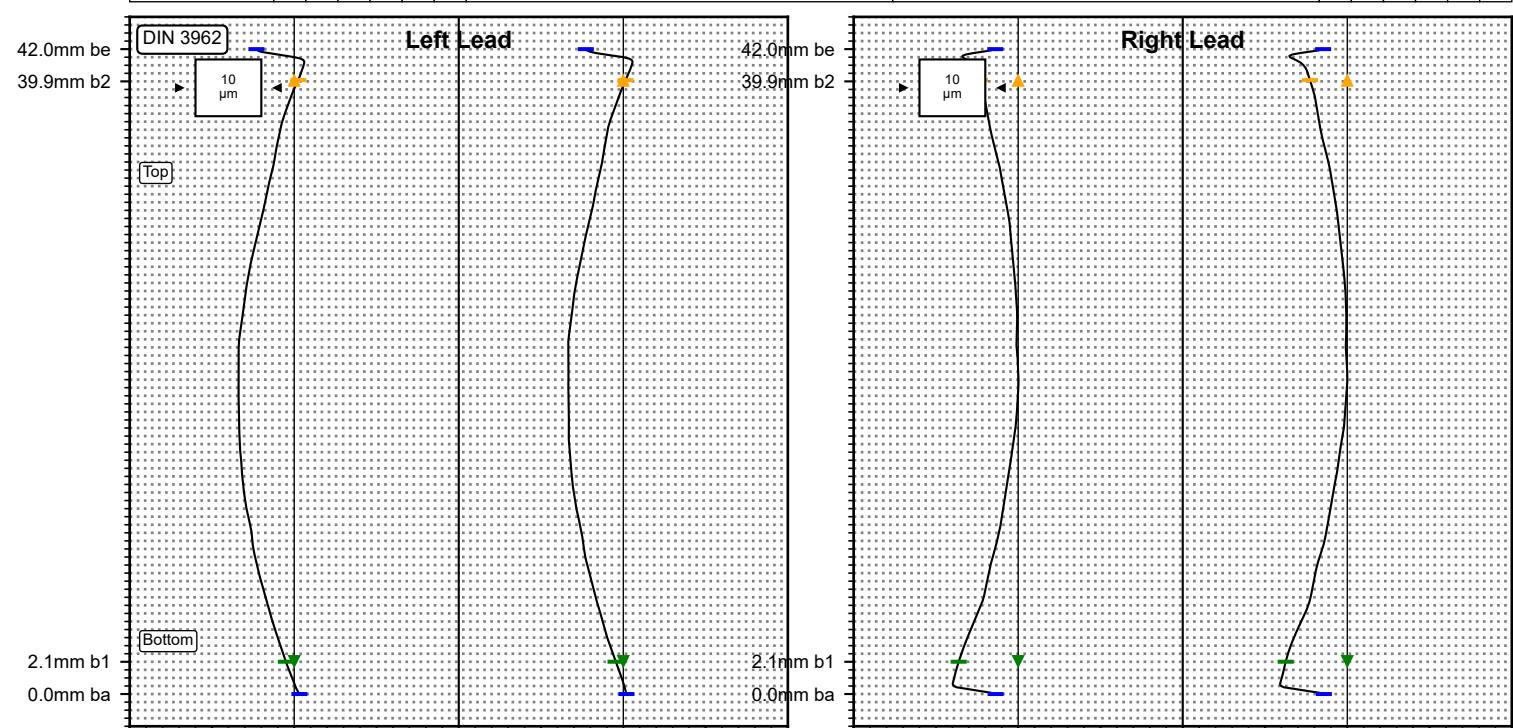
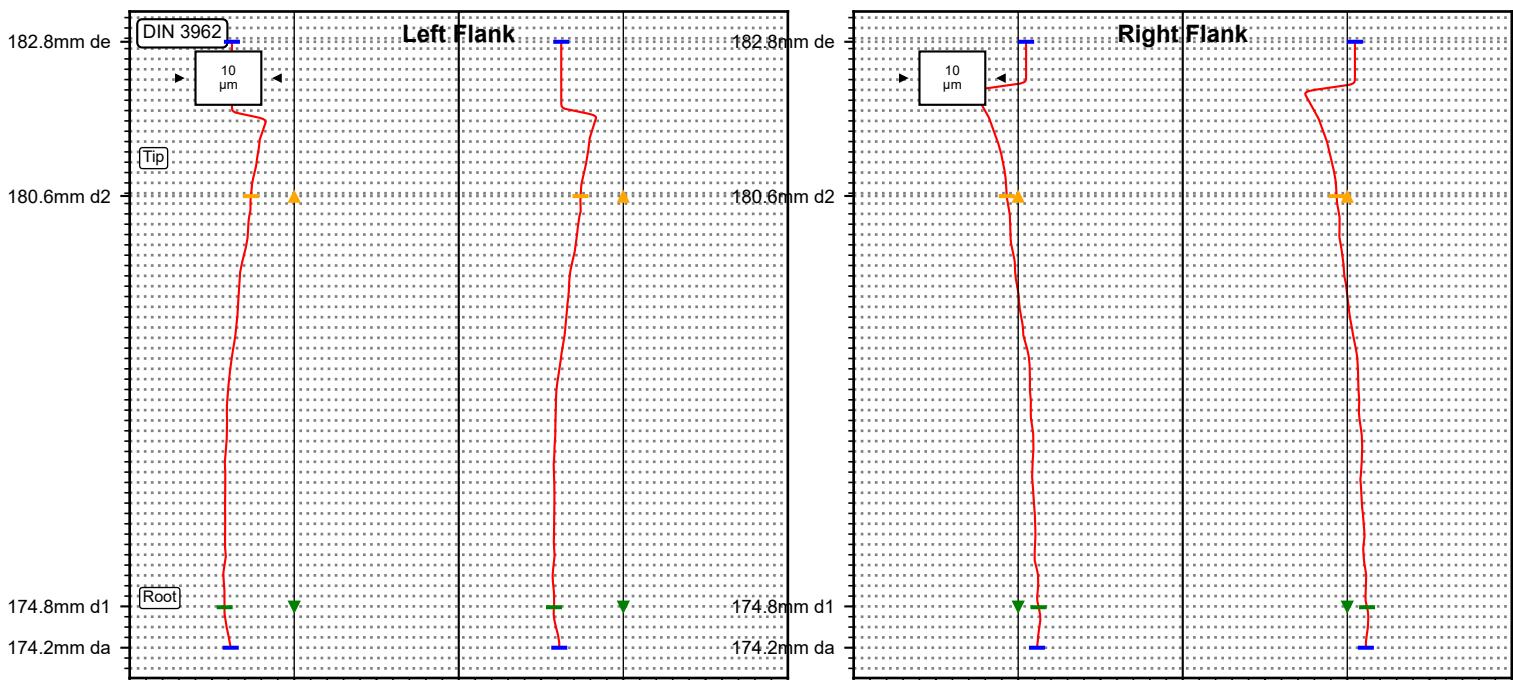
Prog.No.:		Operator:	xue	Date:	14.02.25
Type:	gear	No. of teeth:	87	Face Width:	42.00mm
Drawing No.:	84-T3.2.47.02.76-G-WAV	Module m:	1.859mm	Length Ev. L $\alpha$ :	5.78mm
Order No.:	263751-018-WAV	Pressure angle:	19°	Length Ev. L $\beta$ :	37.80mm
Cust./Mach. N:	P26-601418	Helix angle:	25.30°	Appr.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



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 $\alpha$ :	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**

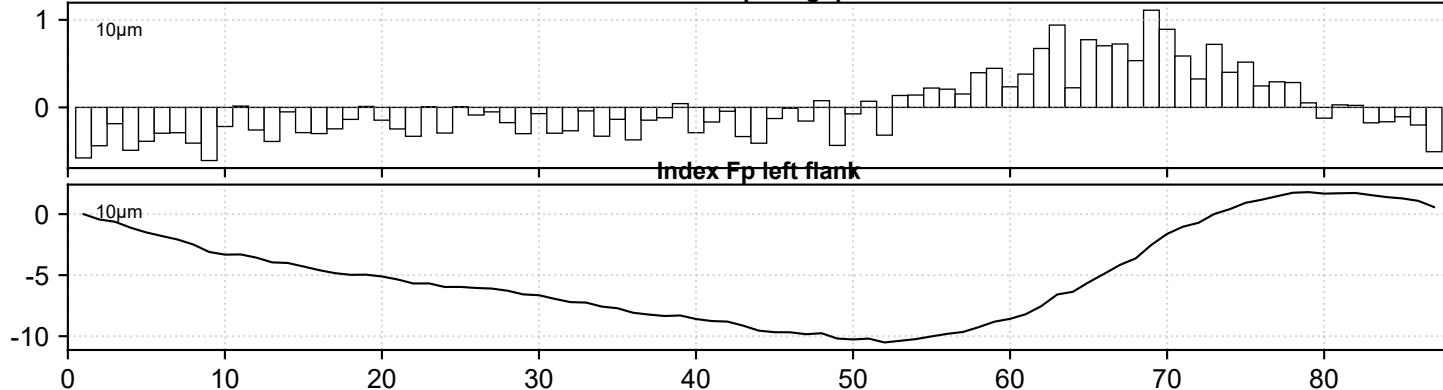
<b>Prog.No.:</b>		<b>Operator:</b>	xue	<b>Date:</b>	14.02.25
<b>Type:</b>	gear	<b>No. of teeth:</b>	87	<b>Face Width:</b>	42.00mm
<b>Drawing No.:</b>	84-T3.2.47.02.76-G-WAV	<b>Module m:</b>	1.859mm	<b>Length Ev. La:</b>	5.78mm
<b>Order No.:</b>	263751-018-WAV	<b>Pressure angle:</b>	19°	<b>Length Ev. Lβ:</b>	37.80mm
<b>Cust./Mach. N:</b>	P26 -601418	<b>Helix angle:</b>	25.30°	<b>Appr. Length:</b>	0.58mm
<b>Loc. of check:</b>	Jintan	<b>Base Cir.-Ø db:</b>	167.6532mm	<b>Stylus-Ø:</b>	1.000mm
<b>Condition:</b>	Grinding-0403	<b>Base Helix ang:</b>	23.893°	<b>Add.Mod.Coe:</b>	-0.378



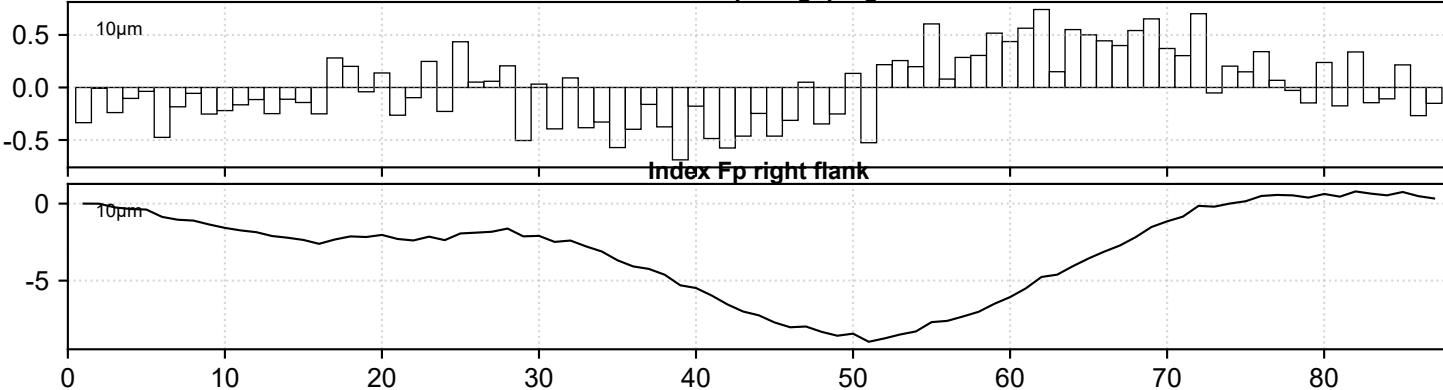
# Gear Spacing

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		

Tooth to tooth spacing fp left flank



Tooth to tooth spacing fp right flank



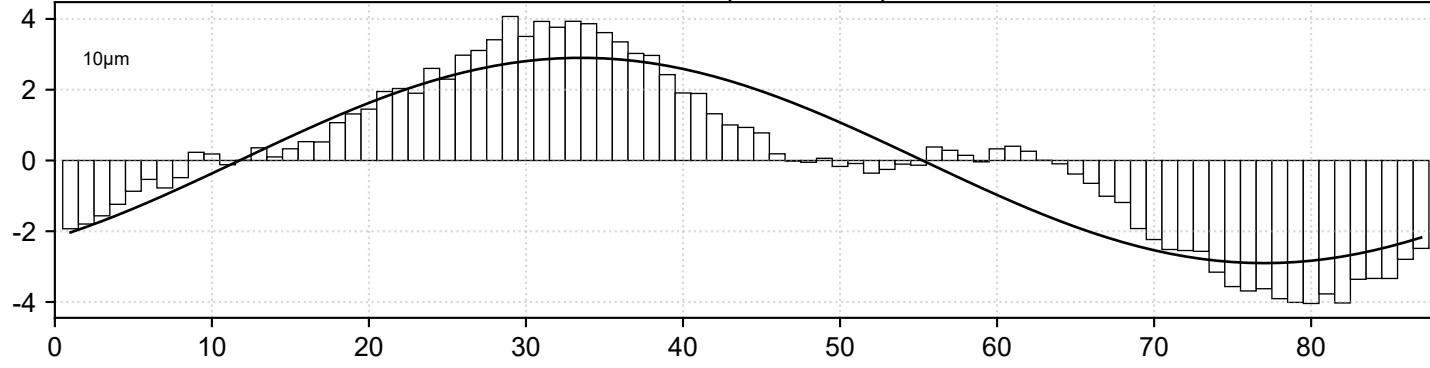
Pitch measuring circle:

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