

212

Wkz-Profil siehe Werkzeugdatenblatt Nr.
For Tooth profile, see tool data sheet number

Measuring plane for MOB

2.65
0.82
22.78
20.45
7

da = 41.00
dw = 34.729
dt = 28.00

Inside this area partially honing (minus material) is allowed. No plus material allowed.

	linke Flanke left flank	Profil Profile	rechte Flanke right flank
Kopf Tip	13.58 13.23	0.012±0.008	13.58 13.23
	10.60		10.60
	9.67		9.67
	2.42		2.42
Fuß Root	$f_{ht} = 0.000 \pm 0.006$	Average values	$f_{ht} = 0.000 \pm 0.006$

linke Flanke / left flank: (a)

rechte Flanke / right flank: (b)

Lineare Auswertung/
Linear regression

Profil nicht hohlballig/
Profile not concave

3d

b • *ftod* (zwischen *dNI* und dem Schreibbeginn *ds*) max *ftod*/2, jedoch 0.003 zulässig;
• *ftod* (between *dNI* and start of checking *ds*) max *ftod*/2, 0.003 allowable.

Profile and helix checking according to VDI/VDE 2612
Listed tolerance data for F_{β} and f_{β} refers to the total face width in the meas. dia. d_M
Tooth trace testing area $L_{\beta} = 0.8 \cdot b$ calculated to $1.0 \cdot b$
Terms of the tooth system according to DIN (German Industrial Standards) No. 888, 3960, 3968

				Verteiler
--	--	--	--	-----------

change report	15/11/2011	Cricen
---------------	------------	--------

2011/02/07	Cricen
------------	--------

change report	20100023	Paula
---------------	----------	-------

W. 0.000 +0.003	20090513	P2A150
-----------------	----------	--------

[illegible]

Ersatz für	Stichlich
------------	-----------

Erstverwendung	250.0.000X.XX
----------------	---------------

me	Verzahnungsblatt Endkontrolle
----	-------------------------------

Fabrizio Final Check Gear Data

Commentary:

Warning:

Innit Shaft Inner Jet

--

1116095919, printed at 2012-08-0

Revision: 20111116095919, printed at 2012-08-06, 13:02:14 by Auditors, Generic User

GETRAG		Geardata-Sheet		D-No.: 250.6.3653.36	z = 17
External gearing				Remark:	
Main gear:		i 17 / 17	a	Type: 250	Speed: Antr. Innen
(234)		i /	a	Customer: Ford	
z 17	m _n 1.058333	α 30 ° 0 ' 0 "	β 0 ° 0 ' 0 "	STRAIGHT	
x -0.014	d 17.992	d _b 15.581	d _a 19.05 -0.30	d _f 16.29 -0.30	
Tolerance Class			Tooth thickness	1.622 ÷ 1.583	
GO-GAGE takes priority over inspection of individual deviations			Base tangent length over 3 teeth		
Radial composite err. F _i "	Tangent. comp. err. F _i '	finished: 8.001 ÷ 7.967			
Rad. tooth to tooth comp. err. f _i "	Tang. tooth to tooth comp. err. f _i '	shaped: ÷			
Profile form error ff _α	Profile angle error fh _α	hobbed: ÷			
Total profile error F _α	Adjacent pitch err. fp	shaved: ÷			
Normal pitch error fpe	Diff. bet. adj. pitch. fu	Measurement over 2 balls DM= 2.00			
Cumulative pitch error Fp	Cum. circ. pitch err. Fpk	finished: 20.889 ÷ 20.830			
Cumu. circ. pitch err. 1/8 extent Fpz/8	Radial run-out Fr 0.050	shaped: ÷			
Range of tooth thicken. error Rs	Longit. alignm. err. ff _β	usable diameter dNa 18.75 dNf 16.83			
Tooth alignment err. fh _β	Total alignment err. F _β	rad. of curvature pdNa 5.22 pdNf 3.18			
Tool	Bezugsprofil	DIN 5480	haP0 =		
grinding wheel	h _{aP0}	p _{aP0}	b		
Standard ANSI B92.1-1996; P/Ps = 24/48					
GAGE DIMENSION sn max. eff. = 1.645					
Ch.ind.	Ch. No.	Changes		Date	Name
VBL drawn: CRICENTI Date: 24.03.09 Subst. For:					

	linke Flanke + left flank	- Profile	rechte Flanke - right flank	
	19.77 19.44	(b) 0.012±0.008	19.77 19.44	
	rechte Flanke / right flank: Lineare Auswertung/ Linear regression Profil nicht horizontal/ Profile not concave			
	7.90	C _a I.R. = 0.000 +0.004	7.90	
f _{ha} = 0.000 ± 0.006	22c	Average values (22b)	f _{ha} = 0.000 ± 0.006	
* Schriebelbeginn	Ø = 75.36 -0.30 = 6.98			
* Start of checking				
- linke Flanke left flank	+ Flankenlinie Tooth trace	- rechte Flanke right flank	+	
crowding: 0.000 +0.005 (0.8°b) Lead Twistst +0.000 ± 0.005 Lead Root on p.d.n = 7.90 minus tH8_Tip on p.d.h = 19.68 Average values (b) f_{hp} = - 0.015 ± 0.006				
f _{hp} = 0.010 ± 0.006	Average values (b) f _{hp} = - 0.015 ± 0.006			

	Final Check Gear Data
Banennur:	

Input Shaft Inner 3rd

Revision: 20111025142822, printed at 2012-08-06, 13:02:14 by Auditors, Generic User