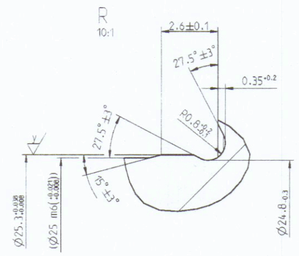
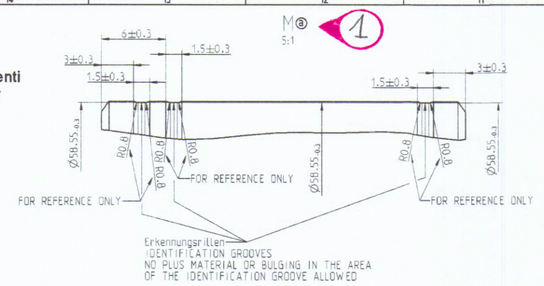
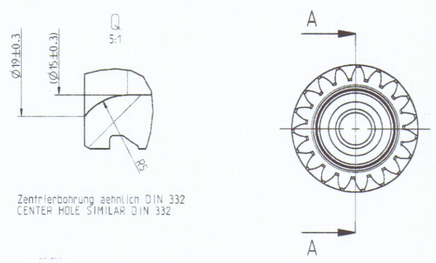
Design-Release:	2014-08-11	Agapi.Raidt
Function-Release:	2014-09-05	Alejandro.Mejia
Geardata-Release:	2014-02-25	I.A. Fabrizio Cricenti
SAP-Release:	2014-09-12	Ruth.Ernstberger

Document Status: approved







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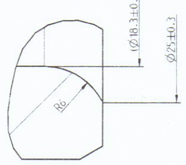
CENTER HOLE SIMILAR DIN 332



Zentrierbohrung aehnlich DIN 332
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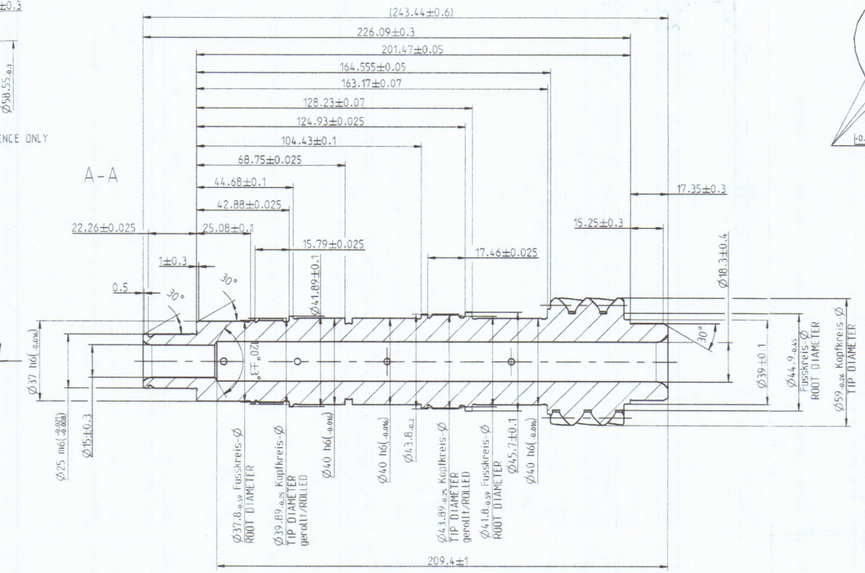
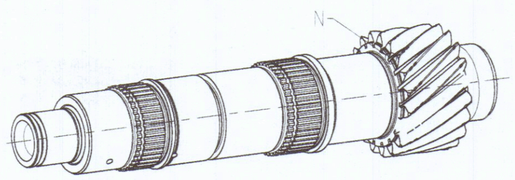
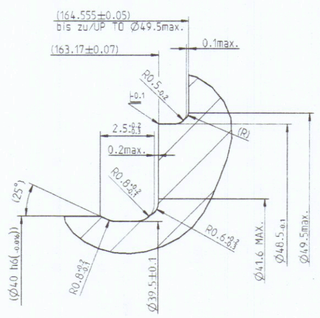
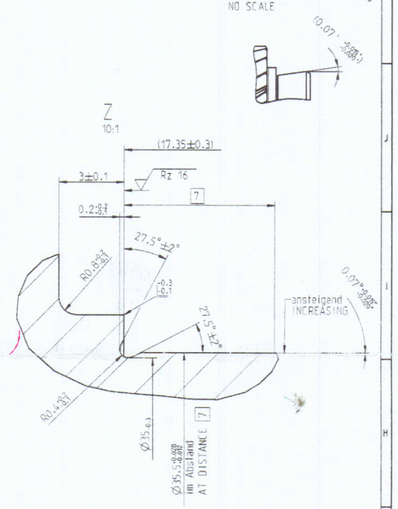
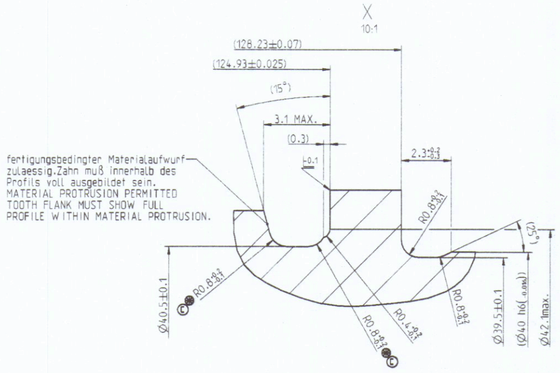


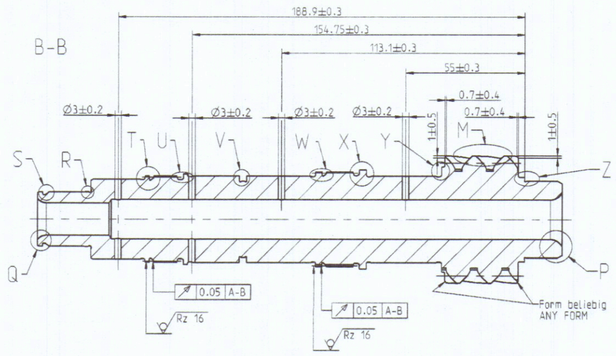


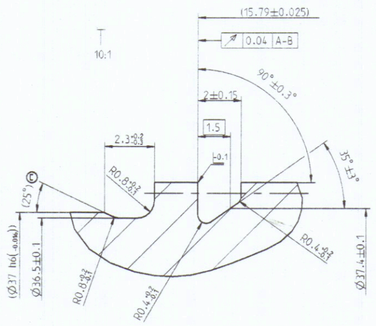
unmassstaebliche Darstellung
NO SCALE

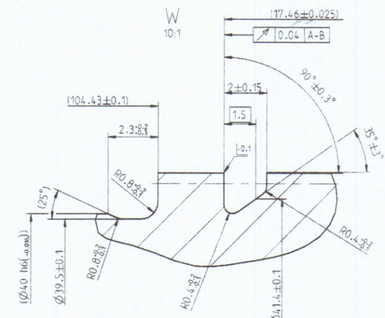


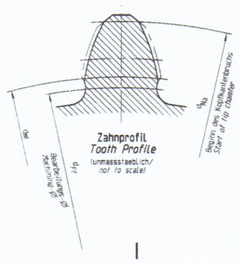


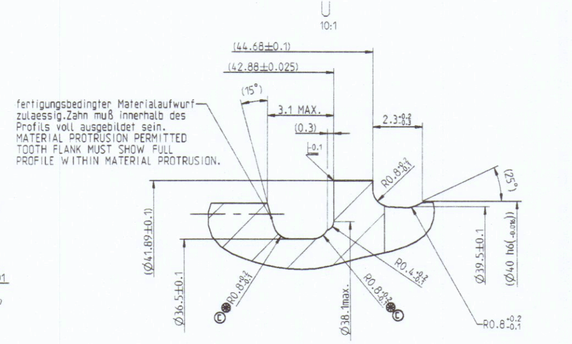


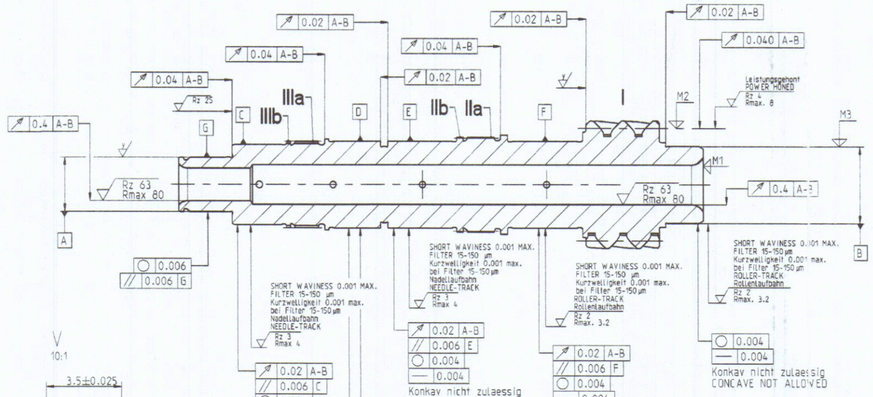


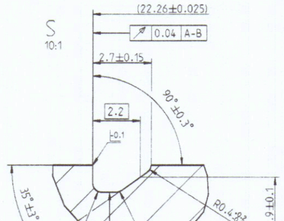


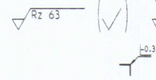


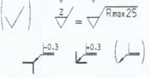


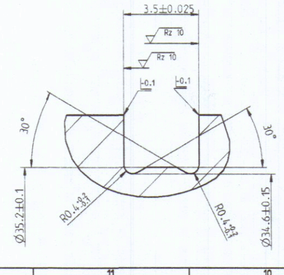




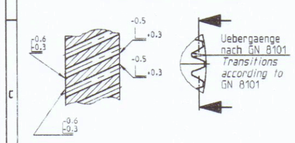








Kanten an Laufverzahnungen \ *Tooth chamfers*
unmassstaeblich \ *not to scale*



	I	IIa	IIb	IIIa	IIIb
Aussenverzahnung / EXTERNAL GEAR		da normabweichend NON STANDARD	da normabweichend NON STANDARD	da normabweichend NON STANDARD	da normabweichend NON STANDARD
Zahnwelle/ SPLINE DATA EXTERNAL		DIN 5480-W44x1.00x43x9	DIN 5480-W44x1.00x43x9.3h	DIN 5480-W40x1.00x38x9	DIN 5480-W40x1.00x38x9.3h
Bezugsdurchmesser / REFERENCE DIAMETER d_B		44.000	44.000	40.000	40.000
Modul / NORMAL MODULE m_n	2.300	1.000	1.000	1.000	1.000
Zaehnezahl / NUMBER OF TEETH z	19	43	43	38	38
Eingriffswinkel / NORMAL PRESSURE ANGLE α_n	20.0°	30.0°	30.0°	30.0°	30.0°
Schraegungswinkel / HELIX ANGLE β	30.0°	0°	0°	0°	0°
Richtung / HANG OF HELIX	LEFT, links	STRAIGHT, gerade	STRAIGHT, gerade	STRAIGHT, gerade	STRAIGHT, gerade
Bezugsprofil / BASIC RACK		DIN 5480	DIN 5480	DIN 5480	DIN 5480
Profilverschiebung/ADDENDUM MODIFICATION x×m, Nennmass / NOMINAL	1.380	-0.050	-0.050	0.450	0.450
Qualitaet / GEAR TOOLTH QUALITY (DIN3961)	8				
Toleranzklasse / TOLERANCE CLASS		9	9.3	9	9.3
Zahndicke / TOOTH THICKNESS s_n (Lehrenmass / GAGE DIMENSION) effective max.		1.613	1.513	2.190	2.090
Zahndicke / TOOTH THICKNESS s_n (Einzelmessung / ACTUAL) max.	4.617	1.590	1.487	2.167	2.064
	4.587	1.550	1.442	2.127	2.019
Messkugel-Ø / BALL DIA D_M	3.50	2.00	2.00	2.00	2.00
Pruefmass / MEASUREMENT OVER BALLS M_{DK} max.	56.486	46.231	46.065	42.148	41.992
(Einzelmessung / ACTUAL) min.	56.421	46.167	45.992	42.088	41.923

Technische Sauberkeit / TECHNICAL CLEANLINESS:

Es gelten die Sauberkeitsanforderungen nach GN 4340-1
CLEANLINESS REQUIREMENTS OF THE GN 4340-1 HAVE TO BE ABIDED

Gekennzeichnete Masse muessen
vor Fertigstellung der Verzahnung gemessen werden
MEASUREMENTS OF MARKED DIMENSIONS
SHOULD BE MADE BEFORE SPLINES GET FINISHED

Im gesamten Bereich
aller Einstiche und Freistiche
maximale Kerben bis zu 0.025mm zulaessig
IN THE TOTAL AREA OF ALL CUT-IN
AND UNDERCUT MAXIMUM GROOVES
UP TO 0.025mm ALLOWED

einsatzgehaertet und angelassen
M1 (Oberflaechenhaerte) : 80.5+2.5 HRA
M2 (Zahnflanke) : CHD (Eht) = 0.7+0.5
M3 (nach dem Schleifen) : CHD (Eht) = 0.5 min
M4 (Kernhaerte) : min 300 HV10

CASE HARDENED AND TEMPERED
M1 (CASE HARDNESS) : 80.5+2.5 HRA
M2 (TOOTH FLANK) : CHD (Eht) = 0.7+0.5
M3 (AFTER GRINDING) : CHD (Eht) = 0.5 min
M4 (INSIDE BASE OF TOOTH) : min 300 HV10

Fuer SETRAG intern.
Dieses Bauteil ist Bestandteil der Gruppen Nummer 250.6.6478.00
Lieferant/Hersteller: Barl
SETRAG INTERNAL ONLY:
THIS COMPONENT IS PART OF GROUP NUMBER 250.6.6478.00
SUPPLIER/MANUFACTURER: Barl

Fuer die Lieferung und Kennzeichnung im Data Matrix Code (Bauteil und/oder Verpackung)
muss die Gruppen Nummer 250.6.6478.00 verwendet werden.
FOR SHIPPMENT AND IDENTIFICATION WITHIN THE DATA MATRIX CODE (COMPONENT AND/OR PACKAGING)
THE GROUP NUMBER 250.6.6478.00 HAS TO BE USED.

PPAP nach / ACCORDING TO 250.6.3973.35

Naehere Angaben zur Verzahnung
siehe Verzahnungsblatt gleicher Nummer
FURTHER GEAR DATA SEE
DATA SHEET SAME NUMBER

312653

GCG 803001	0	<M>						
	0	<C>						
	0	<M>						
GN 3010	0	<E>	C	6X	35670	View F (257) nach/AS 257-87, View E(6) Markierung Taxi. Gemeinsamkeit Masse/MEASUREMENTS OF ... ...NEW	20140729	B
	0	<A>	D	1X	35510_5	Bemerkung/NOTE neu/NEW	20140725	
	a		1X	36042	VIEW M neu/NEW (Erkennungsrille neu/IDENTIFICATION GROOVE NEW)		20140515	
	--	--	35510_3	SPECIFICATION MATURITY LEVEL F APPROVED			20131209	
CAD Model								
Massstab / SCALE M: 1:1 (--)	Bauteil Angert. NUMBER	Aend.-Nr. CHANGE NUMBER	Aenderung: ...nur mittels CAD zulaessig PMEA updaten... ...ONLY ALLOWED BY CAD CHECK PMEA...					Datum DATE

Informationen auf dieser Zeichnung sind ohne Angaben zu Verwendung und Freigabe unverbindlich.
INFORMATION ON THIS DRAWING PROVIDED WITHOUT OBLIGATION OF USAGE AND RELEASE ARE NOT SHOWN.

Allgemeintoleranzen fuer Langenmasse.
Form und Lage ISO 2768 - mK
gebrochene Kanten, Radien und Winkelmass ISO 2768 - v
GENERAL TOLERANCES FOR LINEAR DIMENSIONS, FORM AND POSITION ISO 2768 - mK
CHAMFERS, RADII AND ANGULAR DIMENSIONS ISO 2768 - v

Auswertung der Durchmessermessung erfolgt nach der Gauss-Methode (Arithmetischer Mittelwert)
EVALUATION OF THE DIAMETER MEASUREMENT IS CARRIED OUT ACCORDING TO THE GAUSS METHOD (ARITHMETICAL MEAN VALUE)

Form- und Lagetoleranzen FORM AND POSITION TOLERANCES	Toleranzangaben TOLERANCING	Oberflaechenangaben SURFACE TEXTURE	Wertebereichsangaben BREAK EDGES
EN ISO 1101	ISO 8015	EN 4287	ISO 13715

Werkstoff / MATERIAL: GCS_805000_02_20MnCrS5

Haertung	-
SEMI-FINISHED	-
Gesamtoberflaeche / TOTAL SURFACE	59135 mm²
Masse / MASS	1,146 kg

Schutzvermerk nach ISO 16016 beachten
PROTECTION NOTE ISO 16016

Benennung / ITEM NAME: Abtriebswelle 1
OUTPUT SHAFT 1

Ersatz fuer / SUBSTITUTE FOR: -

ARTIKEL-Nr. / ITEM NO.: 2506397335
BLATT/SHEET 1 von/OF 1
CAD-Modell: 2506397335

	INITIALIN DATA		DATUM DATE
GEZ. / DRAWN	Barl	Barl	14.04.2014
GEPR. / CHECK	Barl	Barl	14.04.2014
FREIG. / RELEASE	Barl	Barl	14.04.2014

Setrag Getriebe- und Zahnradfabrik Hermann Hagenmeyer GmbH & Co KG

Schutzvermerk nach DIN 34 beachten
Gedruckt am: 10.11.2014 Uhrzeit: 12:23:45

Blattgroesse / FORMAT	Massstab / SCALE	Gewicht / WEIGHT	Werkstoffnummer / MATERIAL NUMBER	Blatt / SHEET
A0	F			

Revision: 20140811084016, printed at 2014-11-10, 12:23:45 by Cicirelli, Giacomo