

Part Name SPEED GEAR 4 TH. CPL.		Customer Part Number 250.1.3875.35	
Shown on Drawing No. 250.1.3875.35		Organization Part #	
Engineering Change Level c 35670		Dated 01 August 2014	
Additional Engineering Changes		Dated	
Safety and/or Government Regulation ☐ Yes ☒ No		Purchase Order No.	Weight (kg) 0,9330
Checking Aid No.	Checking Aid Engineering Change Level	Dated	
ORGANIZATION MANUFACTURING INFORMATION		CUSTOMER SUBMITTAL INFORMATION	
GETRAG MODUGNO		FORD	
Organization Name & Supplier/Vendor Code		Customer Name/Division	
VIA DEI CICLAMINI N°4			
Street Address		Buyer/Buyer Code	
MODUGNO BARI	70026	ITALY	TYP 250
City	Region	Postal Code	Country
			Application
MATERIALS REPORTING			
Has customer-required Substances of Concern information been reported?		☒ Yes ☐ No ☐ n/a	
Submitted by IMDS or other customer format:			
Are polymeric parts identified with appropriate ISO marking codes?		☐ Yes ☐ No ☒ n/a	
REASON FOR SUBMISSION (Check at least one)			
☐ Initial Submission		☐ Change to Optional Construction or Material	
☒ Engineering Change(s)		☐ Supplier or Material Source Change	
☐ Tooling: Transfer, Replacement, Refurbishment, or additional		☐ Change in Part Processing	
☐ Correction of Discrepancy		☐ Parts Produced at Additional Location	
☐ Tooling Inactive > than 1 year		☒ Other - please specify below	
REQUESTED SUBMISSION LEVEL (Check one)			
☐ Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.			
☐ Level 2 - Warrant with product samples and limited supporting data submitted to customer.			
☒ Level 3 - Warrant with product samples and complete supporting data submitted to customer.			
☐ Level 4 - Warrant and other requirements as defined by customer.			
☐ Level 5 - Warrant with product samples and complete supporting data reviewed at organization's manufacturing location.			
SUBMISSION RESULTS			
The results for ☒ dimensional measurements ☒ material and functional tests ☐ appearance criteria ☒ statistical process package			
These results meet all drawing and specification requirements: ☒ Yes ☐ NO (If "NO" - Explanation Required)			
Mold / Cavity / Production Process			
DECLARATION			
I hereby affirm that the samples represented by this warrant are representative of our parts which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at the production rate of _____ / _____ hours.			
I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from this declaration below.			
EXPLANATION / COMMENTS: New documentation for first PPAP lost			
Is each Customer Tool properly tagged and numbered? ☐ Yes ☐ No ☒ n/a			
Organization Authorized Signature		Date 14 Jan 2015	
Print Name Pennacchia Vincenzo	Phone No. tel 390805858580	Fax No.	
Title GPS Leader	E-mail vincenzo.pennacchia@getrag.com		
FOR CUSTOMER USE ONLY (IF APPLICABLE)			
Part Warrant Disposition: ☒ Approved ☐ Rejected ☐ Other			
Customer Signature		Date 14.01.15	
Print Name	Customer Tracking Number (optional)		



DIMENSIONAL TEST RESULTS

[illegible]

For registration information Technical keep free for release information

055.8.5383.00

250.1.3876.35

0.032 A

Leistungsgebohrt
POWERHOLED

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Rz 4

Rmax 8

M2

M1

B

M3

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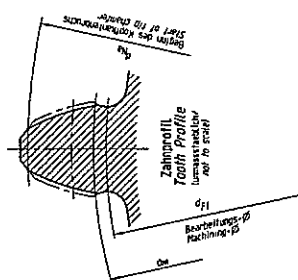
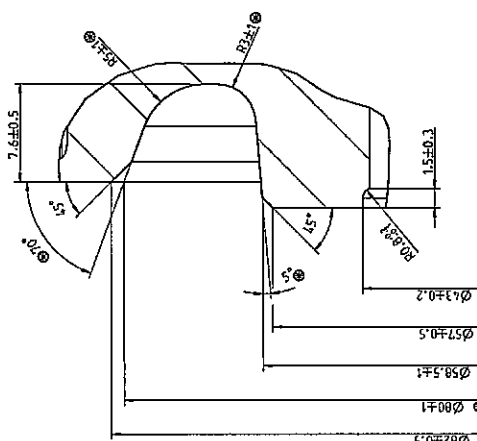
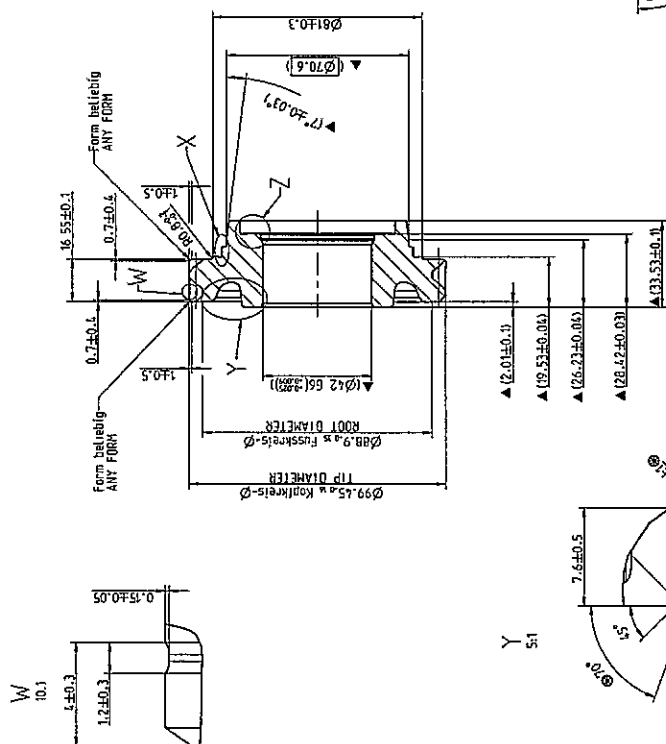
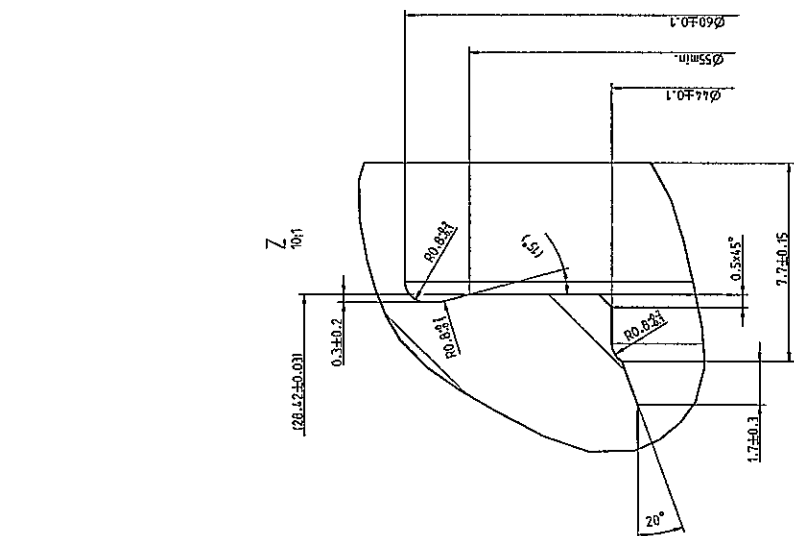
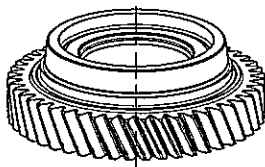
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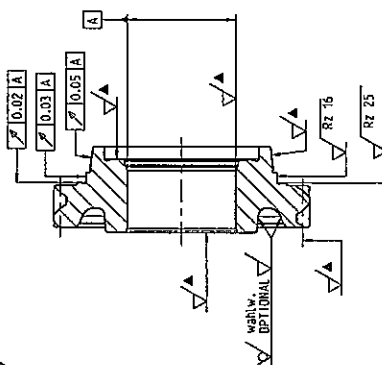
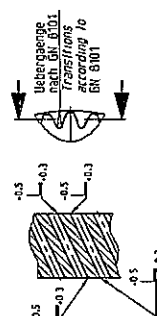
M319

M320

M321



Kanten an Laufverzahnungen \ Toolh chamfers
unmassstaeblch \ not to scale

[illegible]

© Rohitellgeometrie
RAW PART GEOMETRY

Haerteangaben siehe
Schaltrrad 4.Gg. vst. 250.1.3875.35
HEAT TREATMENT SEE
SPEED GEAR 4TH. CPL. 250.1.3875.35

[illegible]

vorbearbeitet, Fertigmass ▲ (...)
 siehe 250.1.3875.35
 PREMACHINED, FINISHED DIMENSION ▲ (...)
 SEE 250.1.3875.35

Nächste Angaben zur Verzahnung
Siehe Verzahnungsblatt gleicher Nummer
FURTHER GEAR DATA SEE
DATA SHEET SAME NUMBER

Istruzioni di controllo



PP Produzione GPS

Materiale: 2501387535
 Descrizione: Ruota dentata libera 4M con Stato: Rilasciato Produzione + Calcolo costi
 Operazione: 0230 Levigatura di potenza
 Centro di lavoro: HNW14340 LEVIGATURA DI POTENZA SG4

Indice del disegno finito:
 Data emissione:
 Data aggiornamento:

-
 11.11.2014 / Vito Fiore
 24.01.2014 / Rocco Tanzella

	Caratteristica	Misura nomin.	LTI	LTS	Strumento di controllo	Quantità	Frequenza RK1:	Quantità	Frequenza RK2:	Quantità	Frequenza Sala di misura	Cambio ut	Metodi di gestione / Documentazione
0004	Controllo 1° pz secondo Gear data 250.1.3875.35				MVZ-400249 EVOLVENTIMETRO						1° pz 2.3.1.1-R 2		Misu: controllo primo pezzo
					MOA-416121 RUGOSIMETRO TIPO PRK						1° pz 2.3.1.1-R 2		
					MZA-450311 Calcolatore di misura E9066 Marposs						1° pz 2.3.1.1-R 2		
0014	Diametro Mdk	96,335 mm	96,303	96,375	MZA-450311 Calcolatore di misura E9066 Marposs	1	Ultimo PZ. prima ravvivatu ra						CR1: calcolatore di misura
0024	Evolvente ed elica sec.G.D. con svergolamento				MVZ-400249 EVOLVENTIMETRO						Ultimo PZ. prima ravvivatu ra		Misu: diagramma di dentatura
0034	Errore globale di divisione	0,000 mm	0,000	0,050	MVZ-400249 EVOLVENTIMETRO						Ultimo PZ. prima ravvivatu ra		Misu: diagramma di dentatura
0036	Oscillazione radiale dentat. Fr	0,000 mm	0,000	0,032	MVZ-400249 EVOLVENTIMETRO						Ultimo PZ. prima ravvivatu ra		Misu: diagramma di dentatura
0044	Rugosità dente Rz	mm	0,000	0,004	MOA-416121 RUGOSIMETRO TIPO PRK						1° pz 2.3.1.1-R 2		Misu: controllo primo pezzo
0054	Rugosità dente Rmax	mm	0,000	0,008	MOA-416121 RUGOSIMETRO TIPO PRK						1° pz 2.3.1.1-R 2		Misu: controllo primo pezzo
0064	Aspetto, privo di bava, senza danni Controllo visivo					1	Ultimo PZ. prima ravvivatu ra						CR1: no documentazione
0074	Sup. dente completamente levigata Controllo visivo					1	100% di pezzi						CR1: no documentazione

Point	Caracteristic	Tolerance	Part 1	Part 2	Part 3	Part 4	Part 5
4	MDK	96,375/96,303	96,34	96,311	96,37	96,345	96,317

Manual measures by Marposs

SR4 2501 3876 35

09,Jan ,2015

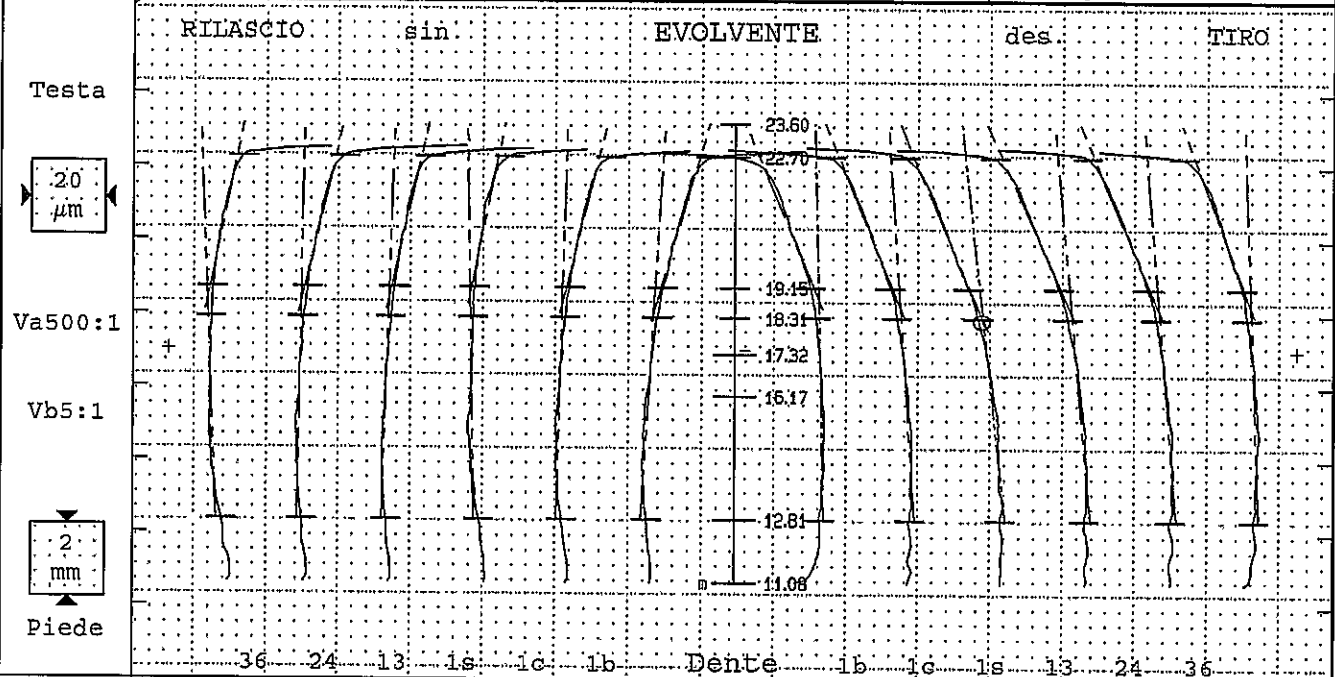
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GETRAG B7590

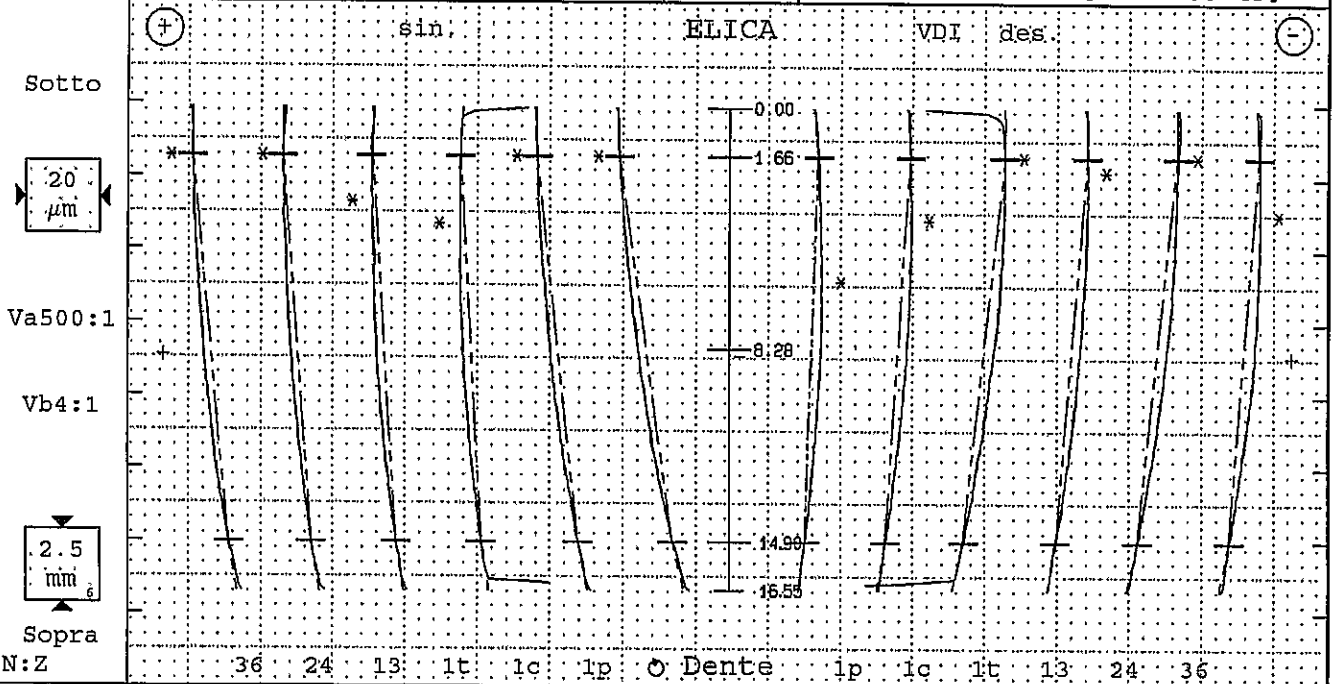
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI041005 0	P26 B7590	Controllore: TURNO c	Data: 09.01.2015 14:35
Denominazione: SR4		Numero denti z 47	Largh.fasc.dent. b 16.55mm
Numero disegno: 250.1.3876.35-IF		Modulo m 1.8mm	Tratto evolv. La 5.5mm
Commessa/serie nr.: PPAP N 1		Angolo pressione 17° 30' 00"	Tratto elica Ls 13.24mm
Masch.Nr.: M001	Spindel: FORME	Angolo elicale -24° 00' 00"	Inizio elab. Ml 12.81mm
Untersuchungszweck: Laufende Messung		Ø Base db 87.5391mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -22° 49' 29"	Fat.scor.pr. x .638



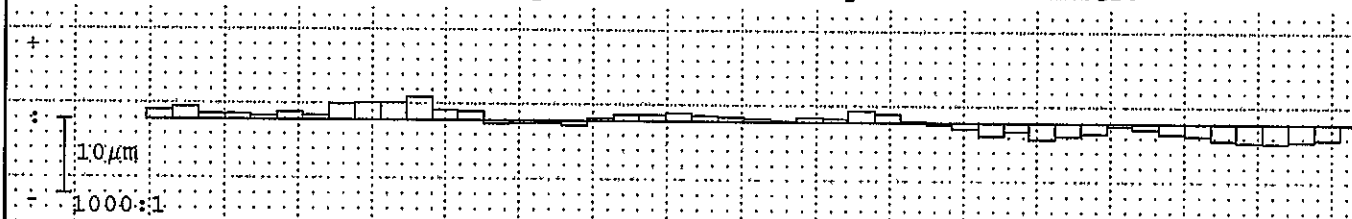
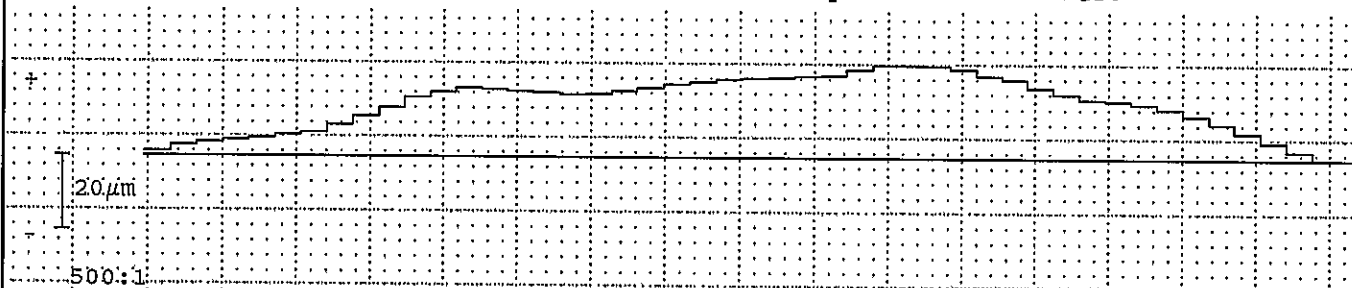
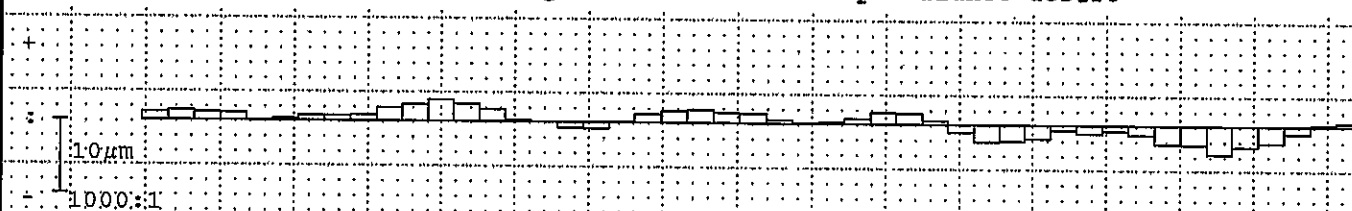
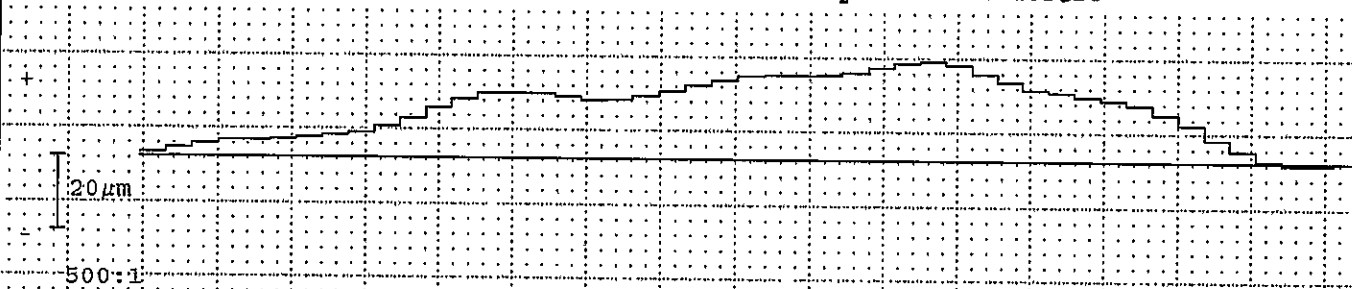
Tolerance	Medio	Val.misur[μ m]							Qual	Tolerance	Val.misur[μ m]							Medio	Qual
fH _{qm}	± 6	-1	Var 4							± 6	Var 3							-4	
fH _a	± 7	-1	2	-1	-2	1	-1	-3		± 7	-1	-4	-6	-5	-5	-2	-4		
F _a		3	3	2	2	3	3	4			3	4	7	6	5	4	5		
ff _a	4	2	2	2	2	3	2	2		4	2	2	3	3	3	2	3		
fK _o -13/-5		-9	-10	-9	-8	-8	-9	-10		-14/-6	-15	-14	-14	-14	-14	-14	-14		
P/T- ϕ [mm]		88.674	[88.55/88.9]								99.158	[99.15/99.45]							



fH _{qm}	10 ± 6	11	Var 6							-15 ± 6	Var 5							-11	
fH _a	10 ± 13	11	12	10	8	7	14	18		-15 ± 13	-4	-9	-15	-11	-14	-10	-11		
F _a		3	3	2	3	4	4	7			8	6	3	5	3	5	5		
ff _a	4	1	1	1	1	1	1	1		4	1	1	1	1	0	1	1		
C _B	0/4	2	2	2	2	2	2	2		0/4	3	3	3	2	3	3	3		
Bd	10 ± 8	11								10 ± 8							11		

GETRAG B7590**Ruota cilindrica Divisione**

Nr. prog.: STI0410005 0	P26 B7590	Controllatore: TURNO C	Data: 09.01.2015 14:35
Denominazione: SR4		Numero denti z 47	Angolo pressione 17° 30' 00"
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Angolo elica -24° 00' 00"
Commessa/serie nr.: PPAP N 1		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMN	Skizze:	Charge:

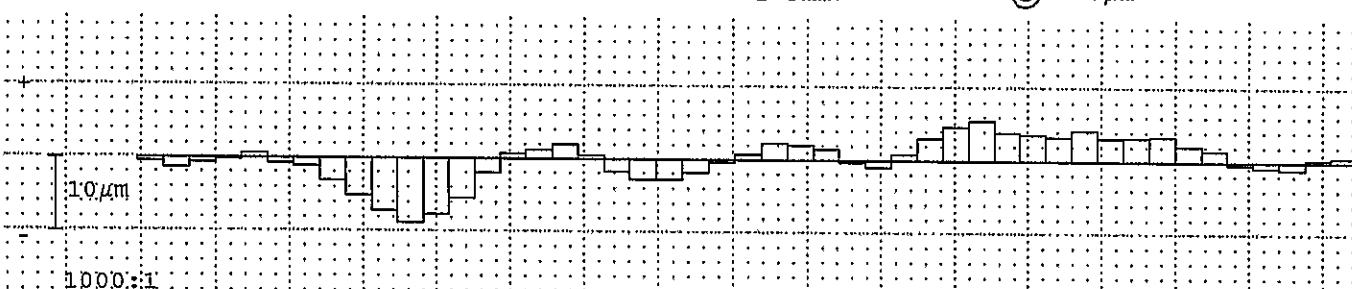
Errori singoli di divisione fp fianco sinistro**Errore somma di divisione Fp fianco sinistro****Errori singoli di divisione fp fianco destro****Errore somma di divisione Fp fianco destro**

Corso per misura divis.: 93.324 z=8.3mm

	fianco sinistro / RILASCIO				fianco destro / TIRO			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	3		14		4		14	
Gr. salto di passo fu max	2		18		1		18	
Scarto di divisione Rp	6				7			
Err. globale di divisione Fp	25		50		27		50	
Err. cordale di divisione Fpz/8	13				16			

Centricità Fr (Ø-sfera =2.5mm)

⊙ : 7µm



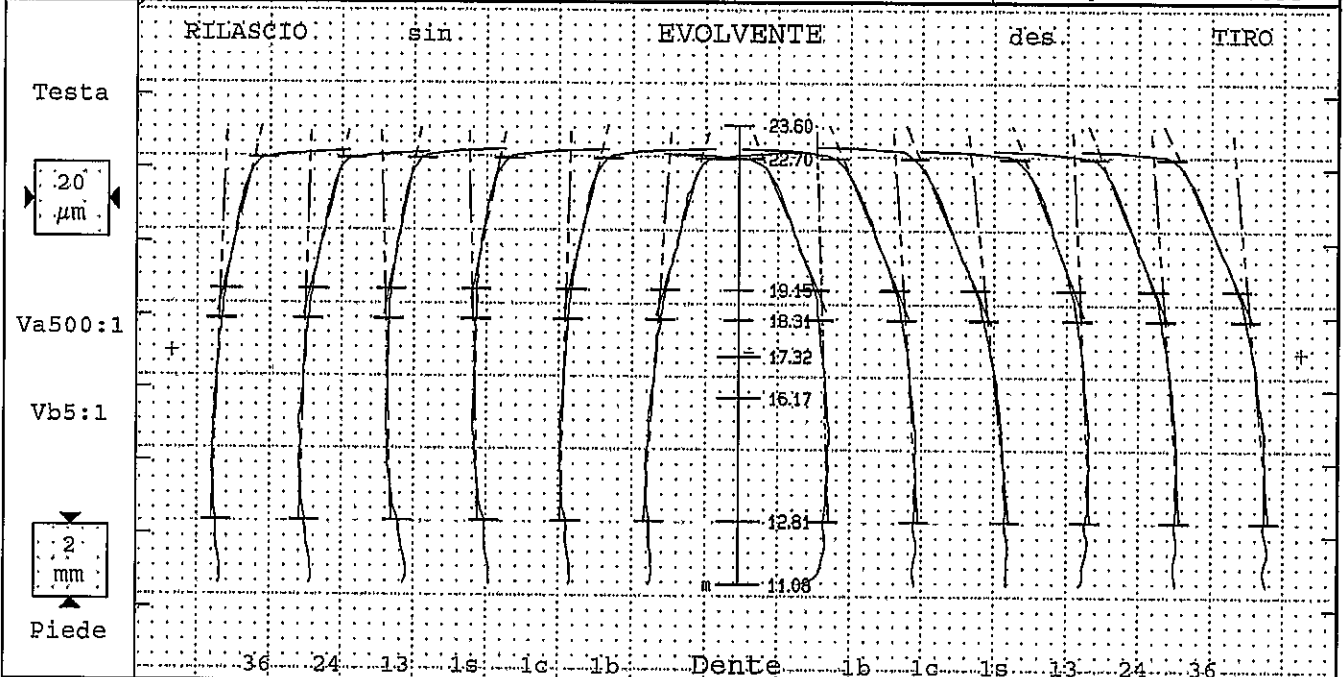
Err. di concentricità Fr	14	32	
Variaz. spessore dente Rs			

GETRAG B7590

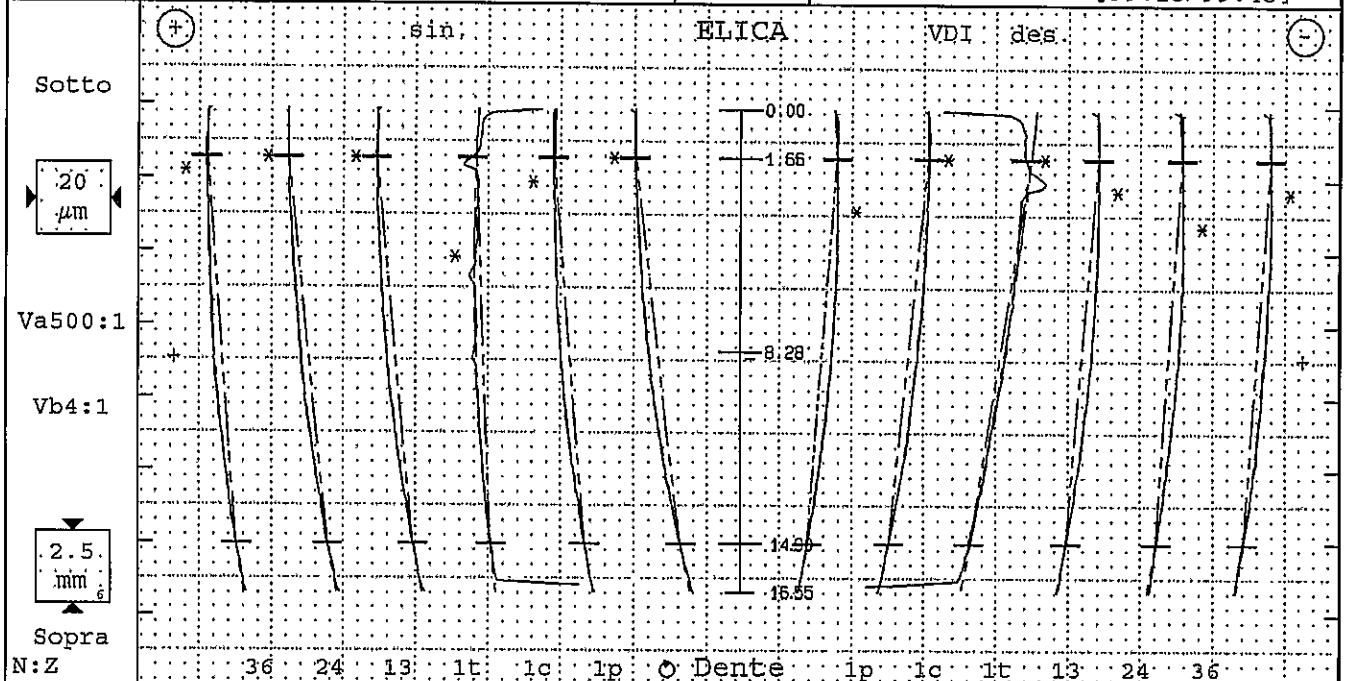
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0410005 0	P26 B7590	Controllore: TURNO c	Data: 09.01.2015 15:05
Denominazione: SR4		Numero denti z 47	Largh.fasc.dent. b 16.55mm
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Tratto evolv. La 5.5mm
Commessa/serie nr.: PPAP N 2		Angolo pressione 17° 30' 00"	Tratto elica Ls 13.24mm
Masch.Nr.: M001	Spindel: Formm	Angolo elica -24° 00' 00"	Inizio elab. Ml 12.81mm
Untersuchungszweck: Laufende Messung		Ø Base db 87.5391mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -22° 49' 29"	Fat.scor.pr. x .638



Tolerance	Medio	Val.misur[μm]								Qual	Tolerance	Val.misur[μm]								Medio	Qual
fH _{om}	± 6	-1	Var 3								± 6	Var 2								-4	
fH _a	± 7	-1	-2	-2	1	1	-1	-4			± 7	-2	-4	-6	-3	-4	-5	-4			
F _a		3	3	3	3	3	2	4				3	4	6	3	5	6	5			
f _f _a	4	2	2	2	3	3	2	2			4	2	2	2	2	2	2	2			
f _{Ko} -13/-5		-9	-8	-9	-9	-8	-8	-9			-14/-6	-15	-14	-14	-14	-14	-14	-14			
P/T- φ [mm]		88.668	[88.55/88.9]									99.155	[99.15/99.45]								



N:Z	fH _{sm} 10 $\pm$ 6	11	Var 3								-15 $\pm$ 6	Var 5							-11	
fH _s 10 $\pm$ 13	11	10	13	12	5	10	15				-15 $\pm$ 13	-10	-14	-21	-11	-9	-9	-11		
F _s	4	3	4	4	5	3	5					5	3	10	5	6	6	5		
f _f _s	4	1	1	1	4	1	1				4	0	1	6	1	0	1	1		
C _s 0/4	2	2	2	2	2	2	3				0/4	3	3	1	3	3	2	3		
B _d 10 $\pm$ 8	10										10 $\pm$ 8								11	

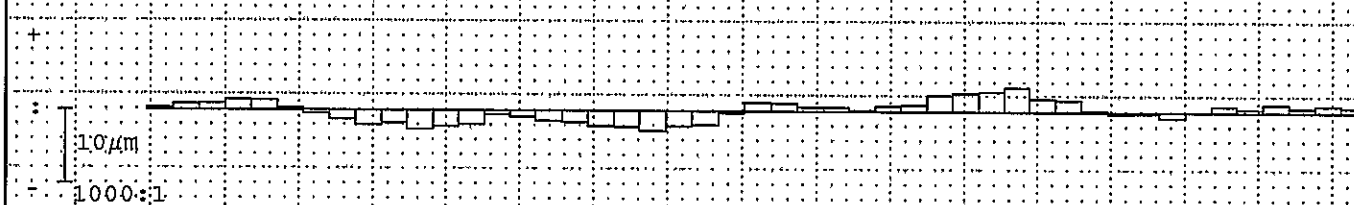
GETRAG B7590

Ruota cilindrica Divisione

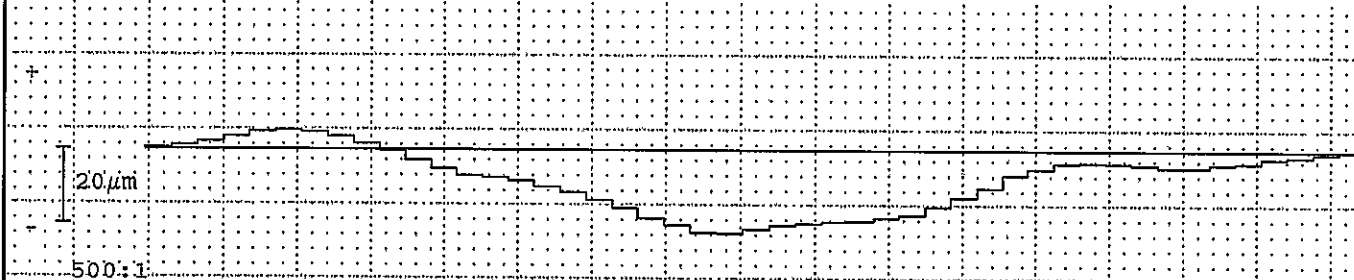


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Denominazione: SR4		Numero denti z 47	Angolo pressione 17° 30' 00"
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Angolo elica -24° 00' 00"
Commessa/serie nr.: PPAP N 2		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMI	Gr. Zeilg:	Charge:

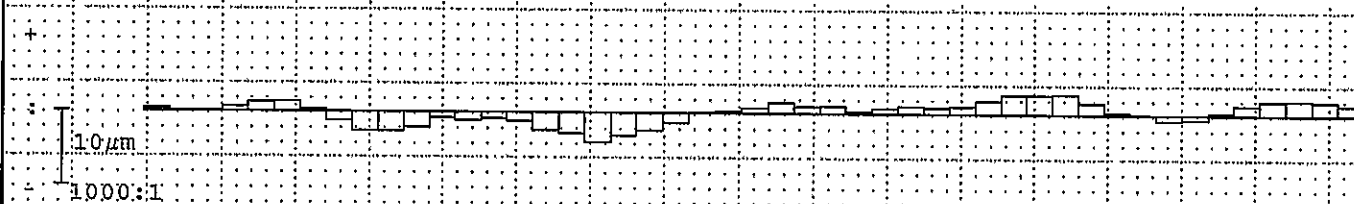
Errori singoli di divisione fp fianco sinistro



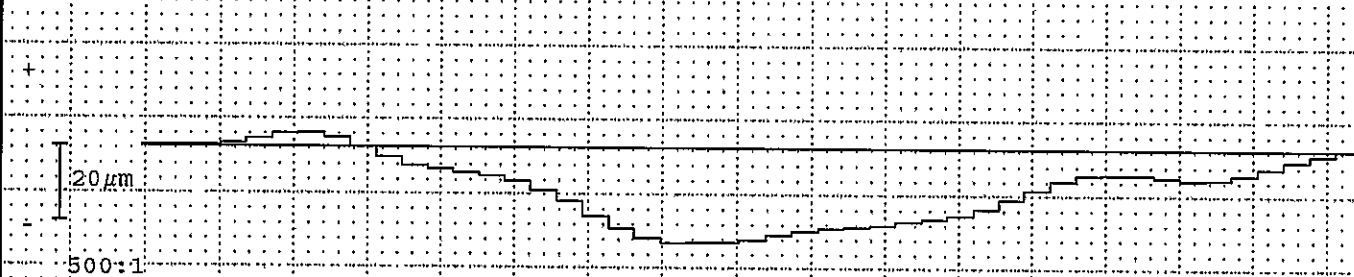
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro

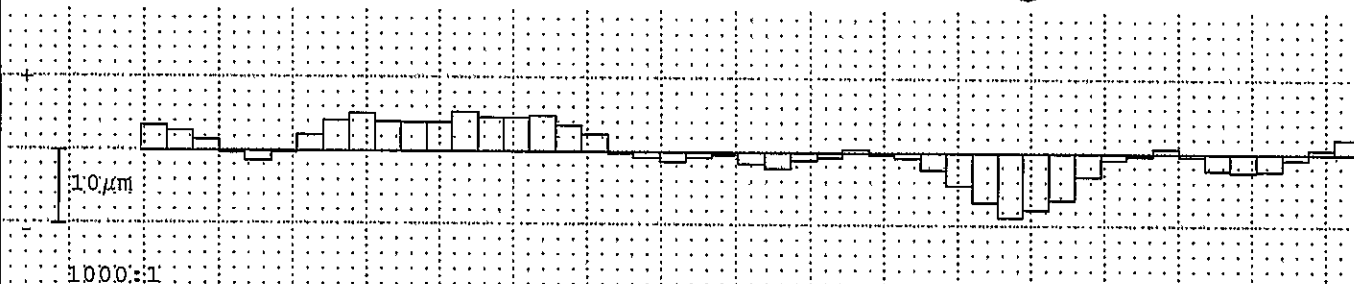


Corso per misura divis.: 93.324 z=8.3mm

	fianco sinistro / RILASCIO				fianco destro / TIRO			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione Fp max	3		14		4		14	
Gr. salto di passo fu max	2		18		2		18	
Scarto di divisione Rp	6				7			
Err. globale di divisione Fp	28		50		29		50	
Err. cordale di divisione Fpz/8	14				17			

Centricità Fr (Ø-sfera =2.5mm)

⊙ : 8µm



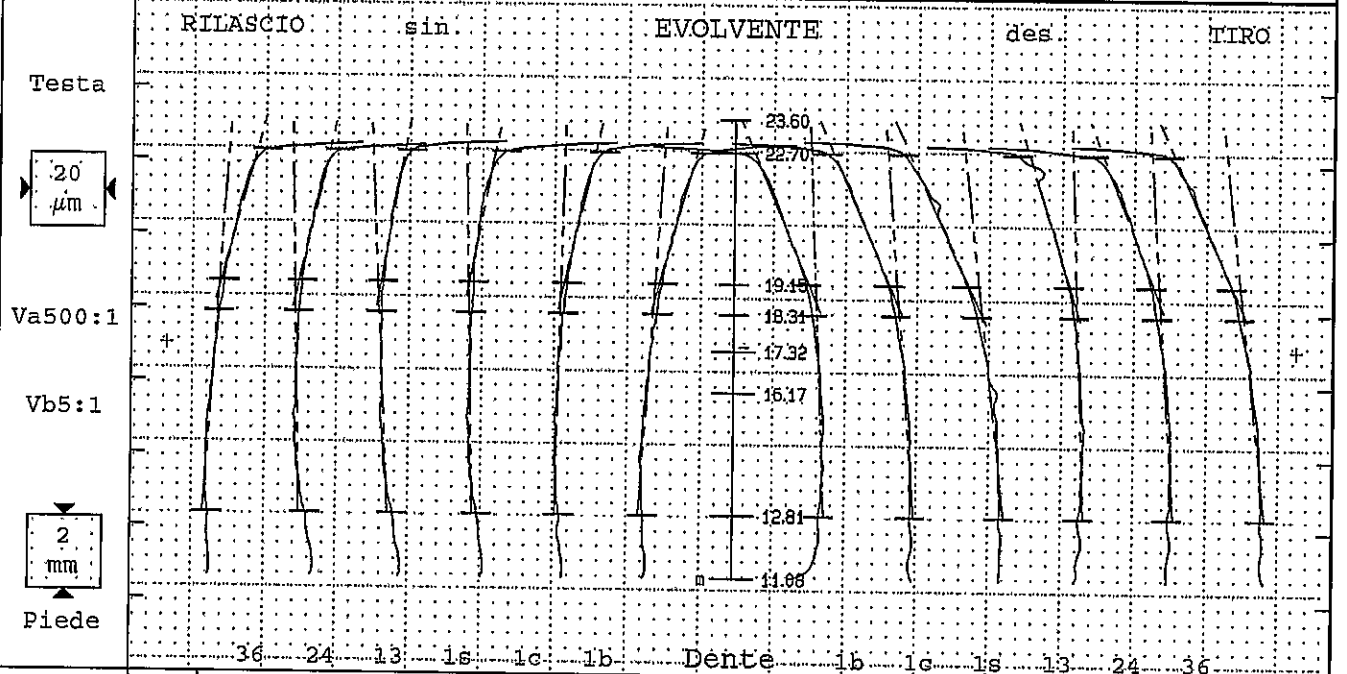
Err. di concentricità Fr	14	32	
Variaz. spessore dente Rs			

GETRAG B7590

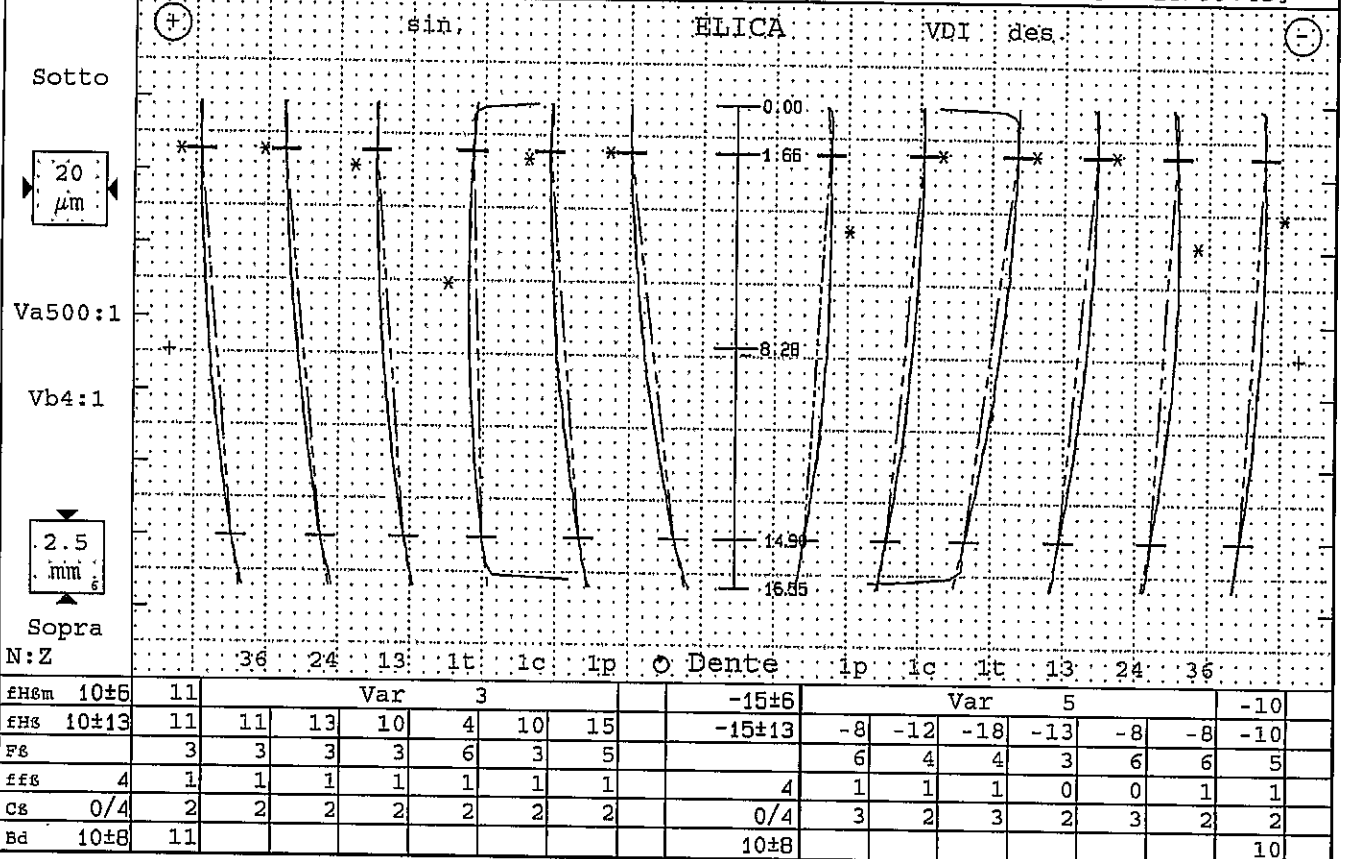
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0410005 0	P26 B7590	Controllatore: TURNO C	Data: 09.01.2015 15:11
Denominazione: SR4		Numero denti z 47	Largh.fasc.dent. b 16.55mm
Numero disegno: 250.1.3876.35-IF		Modulo m 1.8mm	Tratto evol. La 5.5mm
Commessa/serie nr.: PPAP N 3		Angolo pressione 17° 30' 00"	Tratto elica Lg 13.24mm
Masch.Nr.: M001	Spindel: FORMULA	Angolo elicale -24° 00' 00"	Inizio elab. Ml 12.81mm
Untersuchungszweck: Laufende Messung		Ø Base db 87.5391mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -22° 49' 29"	Fat.scor.pr. x .638



Tolerance	Medio	Val.misur[μm]							Qual	Tolerance	Val.misur[μm]							Medio	Qual
fHm ± 6	0	Var 7								± 6	Var 4							-4	
fHa ± 7	0	-4	1	3	1	-1	-4			± 7	-2	-4	-6	-2	-4	-6	-4		
Fa	3	4	3	4	3	2	4				3	5	7	3	4	6	5		
ffa 4	2	2	3	2	2	2	2			4	2	2	3	2	2	2	2		
fKo -13/-5	-9	-8	-10	-9	-8	-8	-9			-14/-6	-16	-14	-15	-12	-13	-14	-14		
P/T- ϕ [mm]	88.669	[88.55/88.9]									99.154	[99.15/99.45]							



fHm	10 ± 6	11	Var 3							-15 ± 6	Var 5							-10	
fHs	10 ± 13	11	11	13	10	4	10	15		-15 ± 13	-8	-12	-18	-13	-8	-8	-10		
Fs	3	3	3	3	6	3	5				6	4	4	3	6	6	5		
ffs	4	1	1	1	1	1	1			4	1	1	1	0	0	1	1		
Cs	0/4	2	2	2	2	2	2			0/4	3	2	3	2	3	2	2		
Bd	10 ± 8	11								10 ± 8							10		

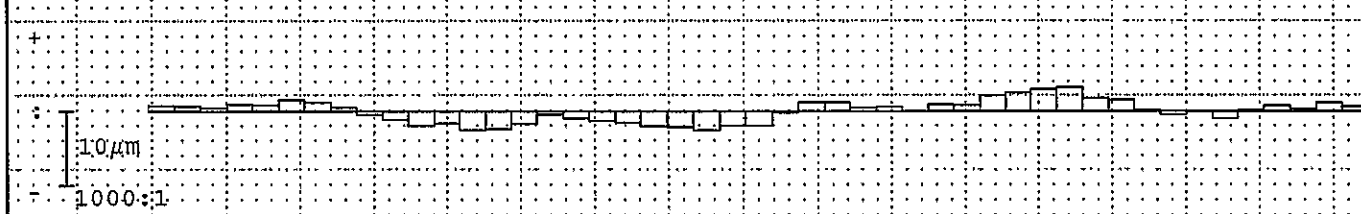
GETRAG B7590

Ruota cilindrica Divisione

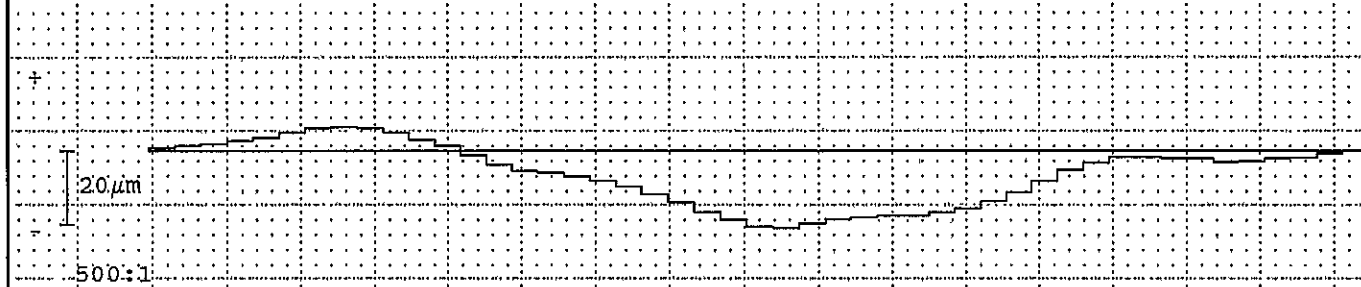


Nr. prog.:	STI0410005 0	P26 B7590	Controllore:	TURNO c	Data:	09.01.2015 15:11
Denominazione:	SR4		Numero denti z	47	Angolo pressione	17° 30' 00"
Numero disegno:	250.1.3876.35-IF		Module m	1.8mm	Angolo elica	-24° 00' 00"
Commessa/serie nr.:	PPAP N 3		Untersuchungszweck:	Laufende Messung		
Masch.Nr.:	M001	Spindel: FORM1	Gr. Eszdg:	Charge:		

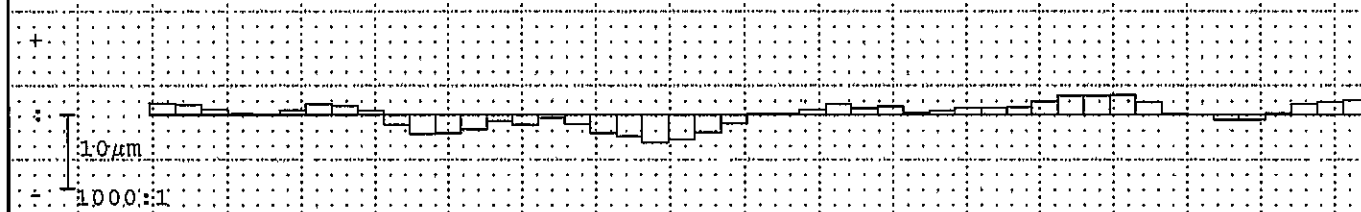
Errori singoli di divisione fp fianco sinistro



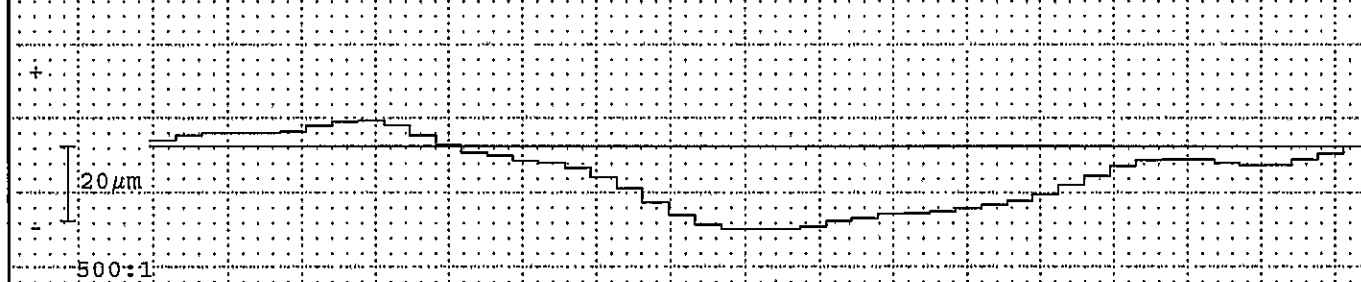
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



Corso per misura divis. 193.324 z=8.3mm

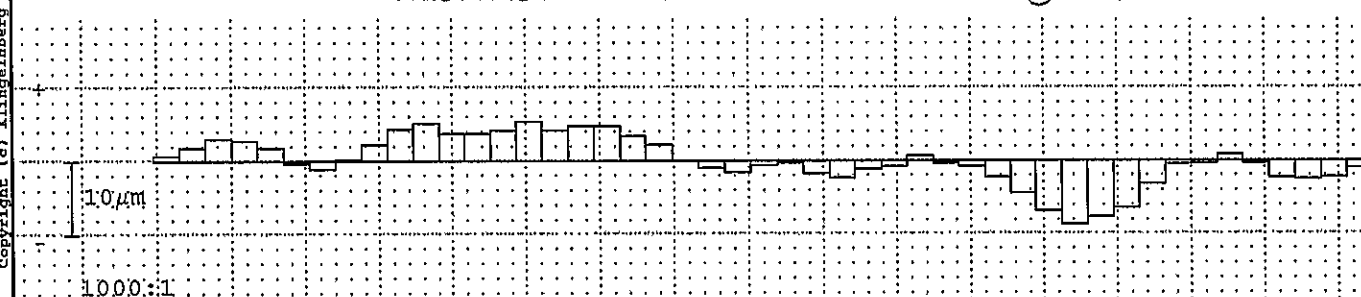
fianco sinistro / RILASCIO

fianco destro / TIRO

	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	3		14		4		14	
Gr. salto di passo fu max	2		18		2		18	
Scarto di divisione Rp	6				7			
Err. globale di divisione Fp	27		50		29		50	
Err. cordale di divisione Fpz/8	14				17			

Centricità Fr (Ø-sfera =2.5mm)

⊙ : 7µm



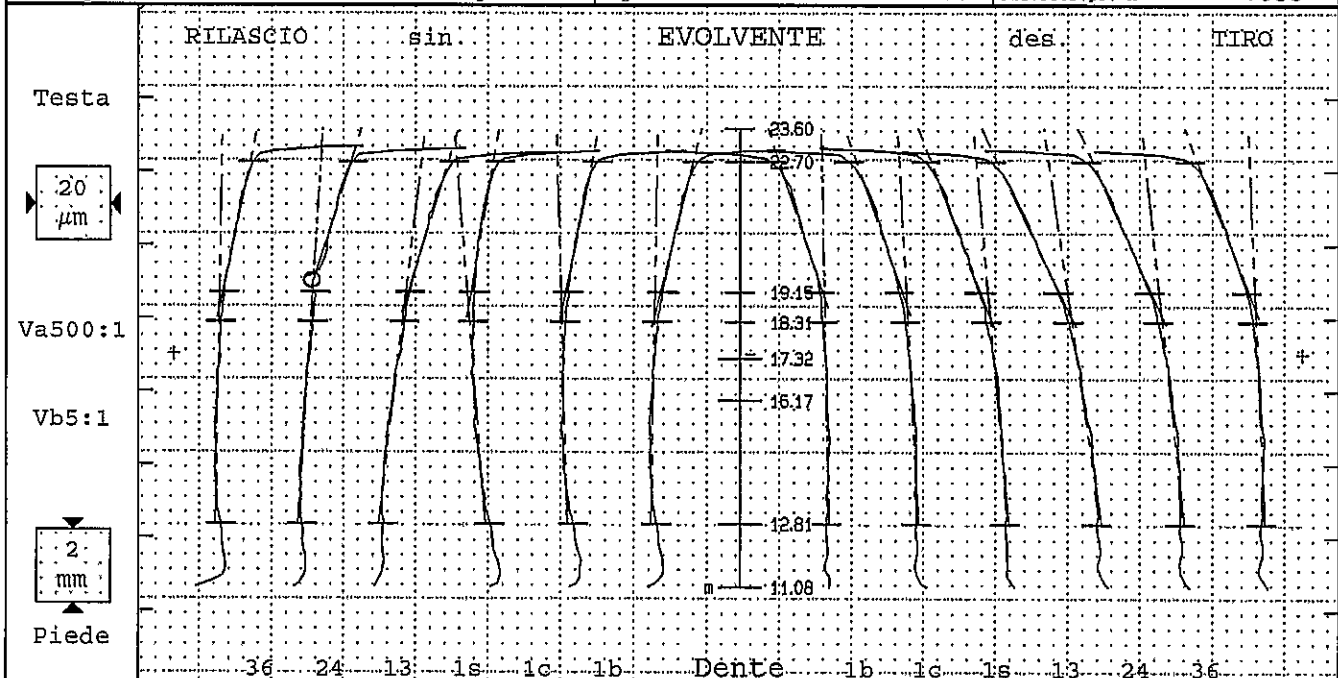
Err. di concentricità Fr	14	32	
Variaz. spessore dente Rs			

GETRAG B7590

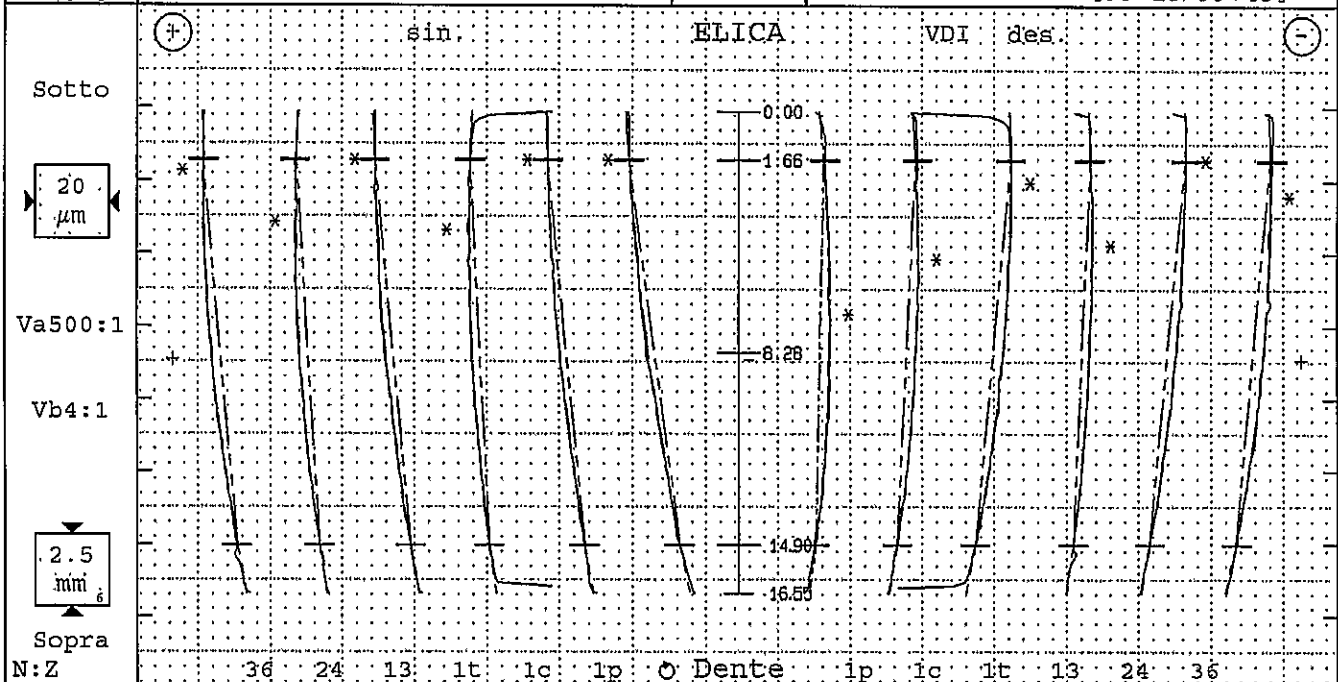
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0410005 0	P26 B7590	Controllora: TURNO c	Data: 09.01.2015 15:24
Denominazione: SR4		Numero denti z 47	Largh.fasc.dent. b 16.55mm
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Tratto evolv. La 5.5mm
Commessa/serie nr.: PPAP N 4		Angolo pressione 17° 30' 00"	Tratto elica Ls 13.24mm
Masch.Nr.: M001	Spindel: Forme evolvente	Angolo elica -24° 00' 00"	Inizio elab. Ml 12.81mm
Untersuchungszweck: Laufende Messung		Ø Base db 87.5391mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -22° 49' 29"	Fat.scor.pr. x .638



Tolerance	Medio	Val.misur[μ m]							Qual	Tolerance	Val.misur[μ m]							Medio	Qual
fHm	± 6	-3	Var 8							± 6	Var 6							-5	
fHa	± 7	-3	-1	-3	-7	4	1	-1		± 7	-1	-3	-5	-7	-6	-2	-5		
Fa		4	2	4	6	5	3	2			2	3	6	8	6	3	5		
ffa	4	3	2	4	2	2	3	2		4	1	2	2	2	2	2	2		
fKo -13/-5		-8	-8	-8	-7	-10	-9	-10		-14/-6	-12	-12	-13	-14	-14	-14	-14		
P/T- ϕ [mm]		88.723	[88.55/88.9]								99.200	[99.15/99.45]							

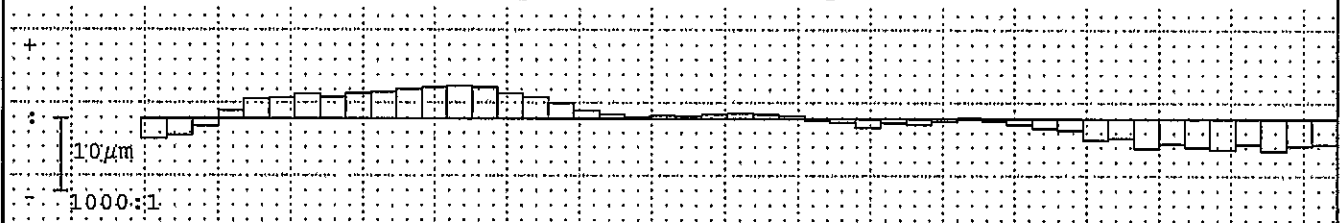


fH3m	10 $\pm$ 6	11	Var 5							-15 $\pm$ 6	Var 6							-9	
fH3	10 $\pm$ 13	11	12	8	12	7	13	17		-15 $\pm$ 13	-3	-7	-12	-6	-12	-12	-9		
F3		3	3	3	3	4	3	6			10	7	5	8	3	4	6		
ff3	4	1	1	1	1	1	1	1		4	1	1	1	1	1	1	1		
C3	0/4	2	3	2	2	2	2	2		0/4	3	3	3	2	2	3	3		
Bd	10 $\pm$ 8	10								10 $\pm$ 8							9		

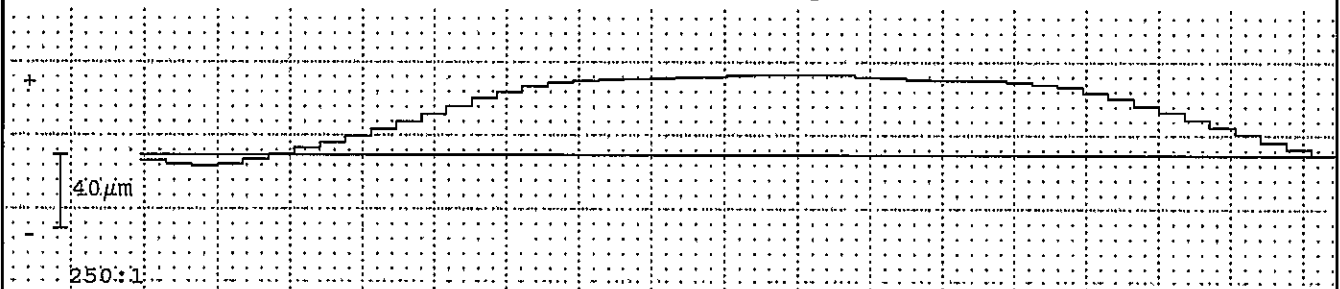


Nr. prog.: STI0410005 0	P26 B7590	Controllore: TURNO C	Data: 09.01.2015 15:24
Denominazione: SR4		Numero denti z 47	Angolo pressione 17° 30' 00"
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Angolo elica -24° 00' 00"
Commessa/serie nr.: PPAP N 4		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM	Gezdg:	Charge:

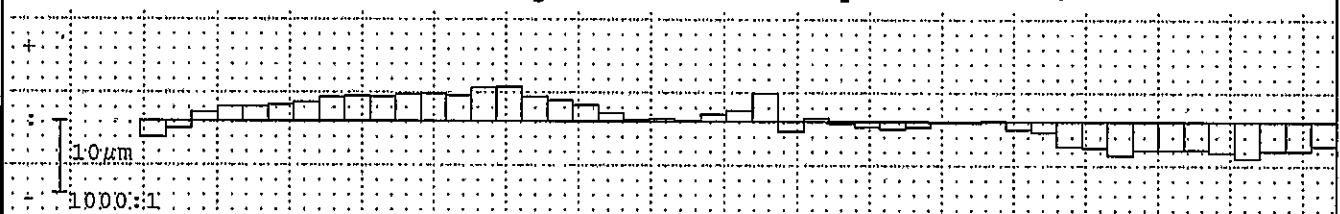
Errori singoli di divisione fp fianco sinistro



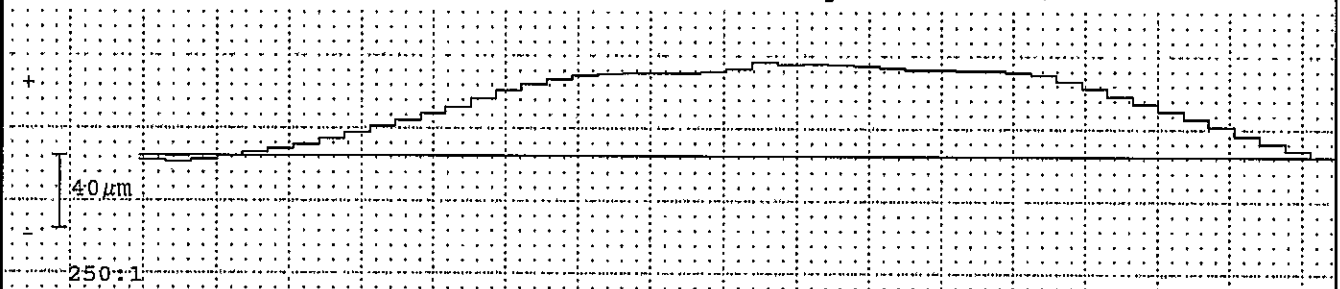
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



Corso per misura divis.: 93.324 z=8.3mm

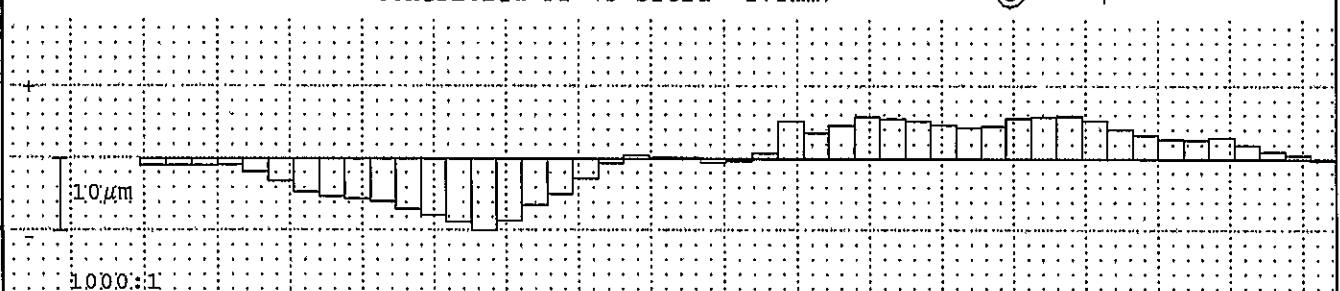
fianco sinistro / RILASCIO

fianco destro / TIRO

	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	4		14		5		14	
Gr. salto di passo fu max	2		18		5		18	
Scarto di divisione Rp	8				10			
Err. globale di divisione Fp	50		50		50		50	
Err. cordale di divisione Fpz/8	24				26			

Centricità Fr (Ø-sfera = 2.5mm)

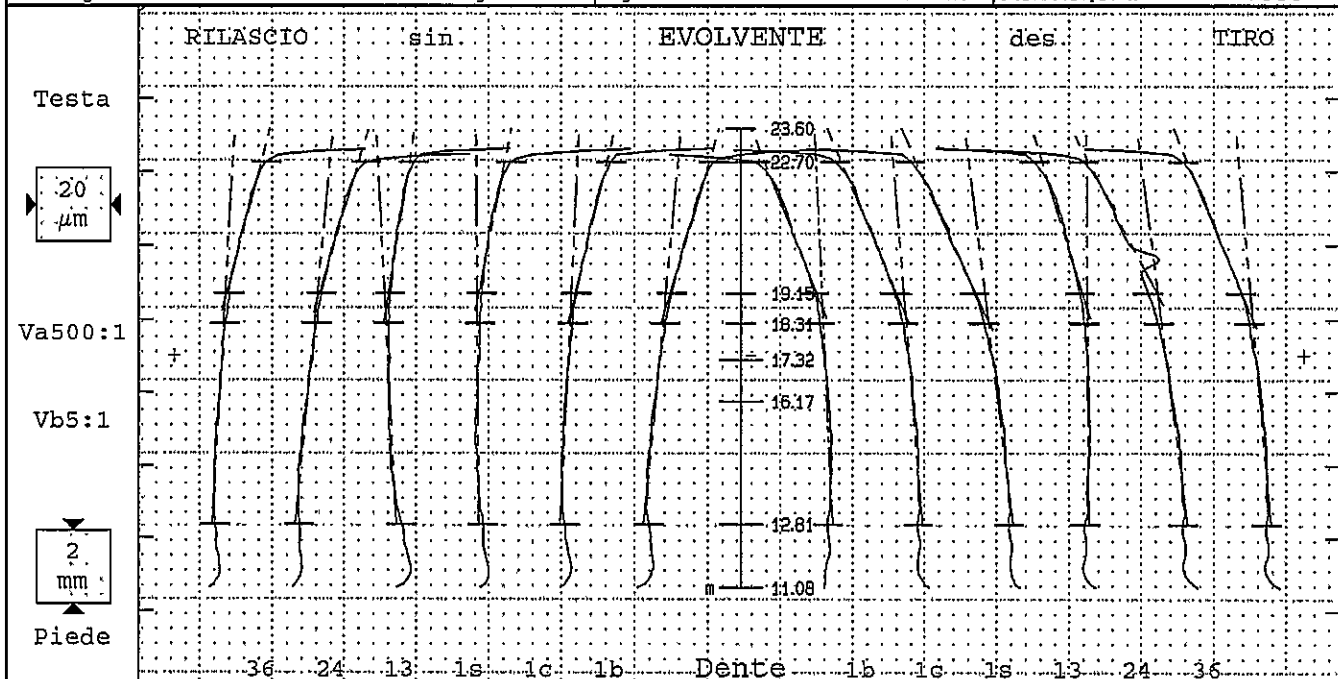
⊙ : 12μm



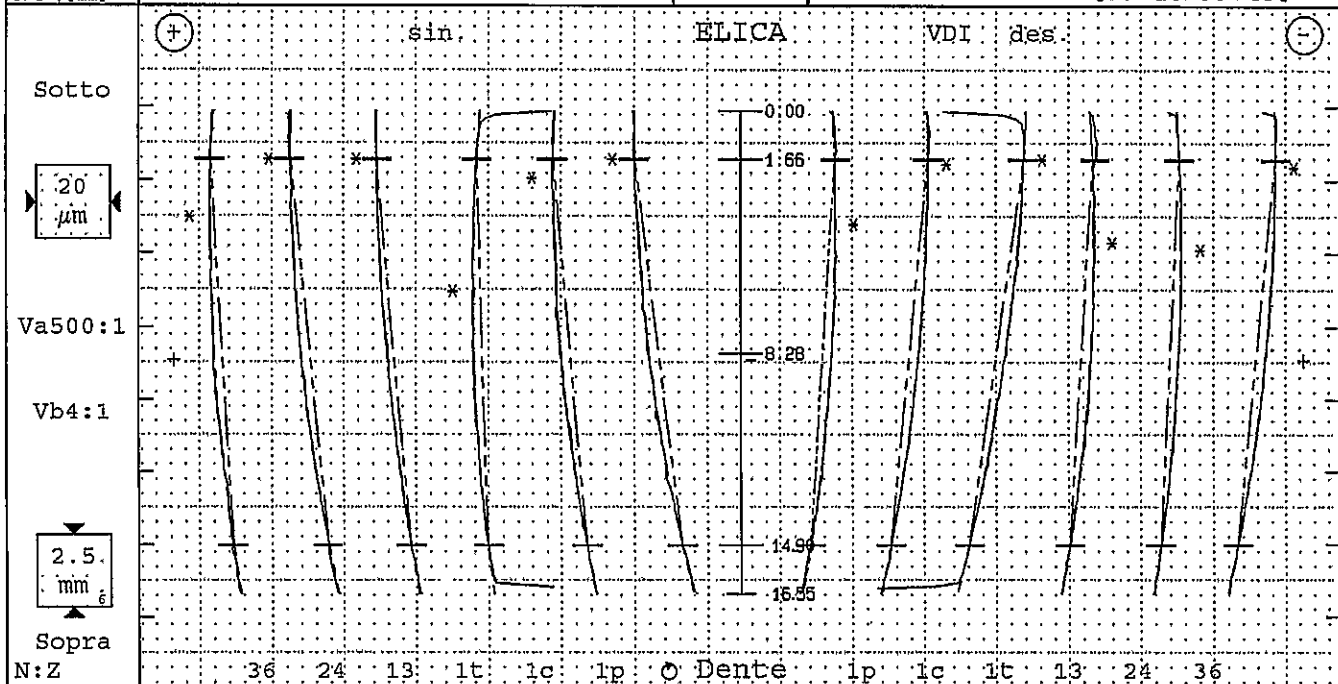
Err. di concentricità Fr	16	32	
Variaz. spessore dente Rs			

GETRAG B7590**Ruota cilindrica Evolvente/Elica**

Nr. prog.:	STI0410005 0	P26 B7590	Controllore:	TURNO c	Data:	09.01.2015 15:30
Denominazione:	SR4		Numero denti z	47	Largh. fasc. dent. b	16.55mm
Numero disegno:	250.1.3876.35-IF		Modulo m	1.8mm	Tratto evolvent. La	5.5mm
Commessa/serie nr.:	PPAP N 5		Angolo pressione	17° 30' 00"	Tratto elica Ls	13.24mm
Masch.Nr.:	M001	Spindel: Formm	Angolo elica	-24° 00' 00"	Inizio elab. Ml	12.81mm
Untersuchungszweck:	Laufende Messung		Ø Base db	87.5391mm	Palpatore Ø	(#2C)1mm
Werkzeug:	Charge:		Ang. Base	-22° 49' 29"	Fat. scor. pr. x	.638



Tolerance	Medio	Val. misur [μ m]							Qual	Tolerance	Val. misur [μ m]							Medio	Qual
fHm	± 6	-2	Var 8							± 6	Var 7							-4	
fHs	± 7	-2	-3	-5	3	0	-3	-5		± 7	-3	-5	-7	0	-7	-5	-4		
F α		4	3	5	4	2	3	5			3	5	7	2	7	5	5		
ff α	4	2	1	2	2	2	2	2		4	2	2	2	1	3	2	2		
fKo	-13/-5	-8	-8	-8	-9	-8	-8	-9		-14/-6	-14	-14	-15	-12	-14	-14	-14		
F/T- ϕ [mm]		88.719	[88.55/88.9]								99.195	[99.15/99.45]							

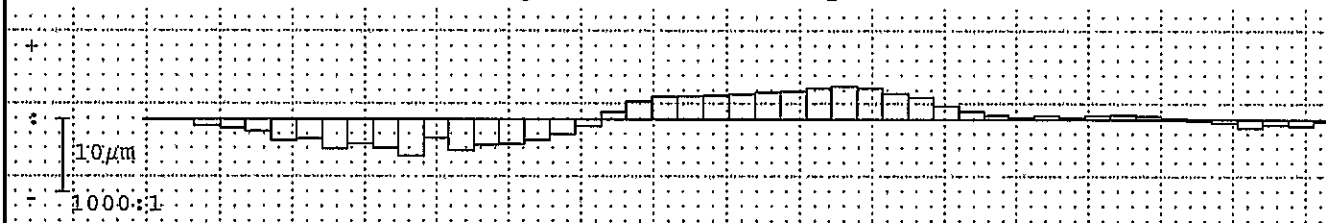


Tolerance	Medio	Val. misur [μ m]							Qual	Tolerance	Val. misur [μ m]							Medio	Qual
fHm	10 $\pm$ 6	11	Var 5							-15 $\pm$ 6	Var 7							-10	
fHs	10 $\pm$ 13	11	8	13	12	4	11	16		-15 $\pm$ 13	-8	-13	-19	-8	-6	-13	-10		
F β		4	3	4	3	6	4	6			6	4	5	6	7	4	5		
ff β	4	1	1	1	1	1	1	1		4	1	0	1	1	0	0	0		
C β	0/4	2	2	2	2	2	3	3		0/4	3	3	3	3	2	3	3		
Bd	10 $\pm$ 8	12								10 $\pm$ 8								11	

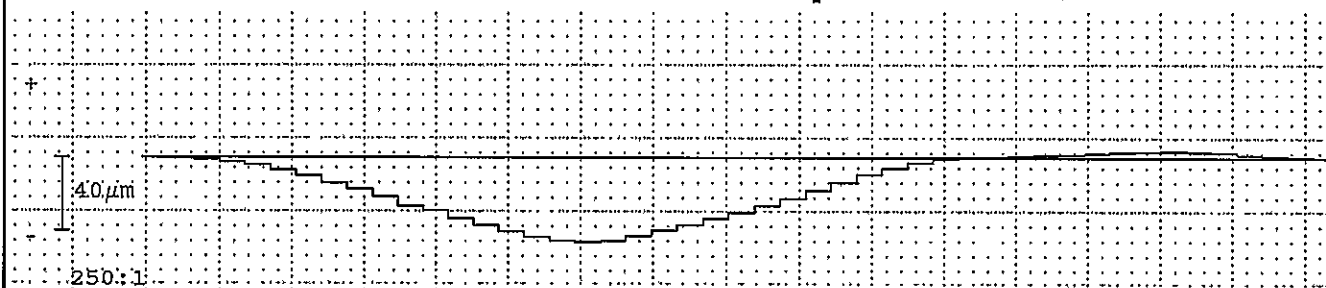


Nr. prog.: STI0410005 0	P26 B7590	Controllore: TURNO C	Data: 09.01.2015 15:30
Denominazione: SR4		Numero denti z 47	Angolo pressione 17° 30' 00"
Numero disegno.: 250.1.3876.35-IF		Modulo m 1.8mm	Angolo elica -24° 00' 00"
Commessa/serie nr.: PPAP N 5		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM 1	Getrag: 1	Charge:

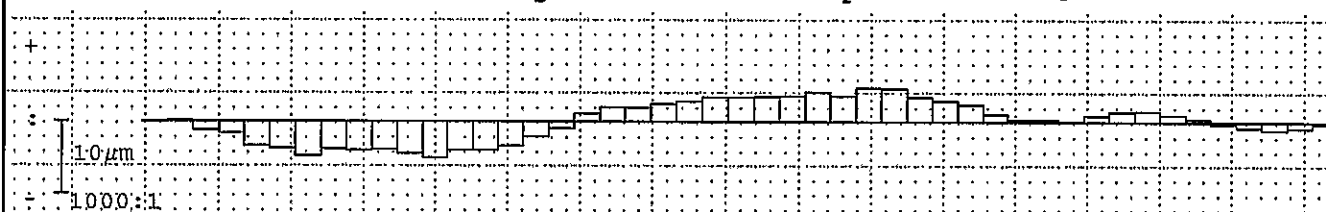
Errori singoli di divisione fp fianco sinistro



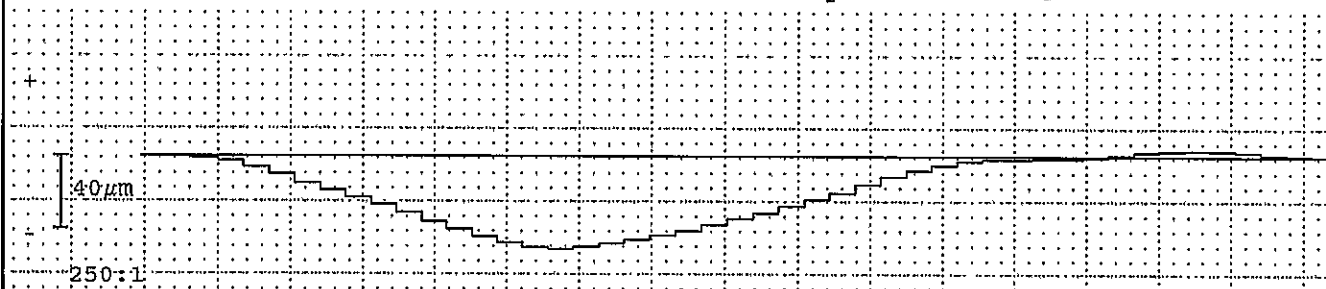
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



Correa per misura divis.: 93.324 z=8.3mm

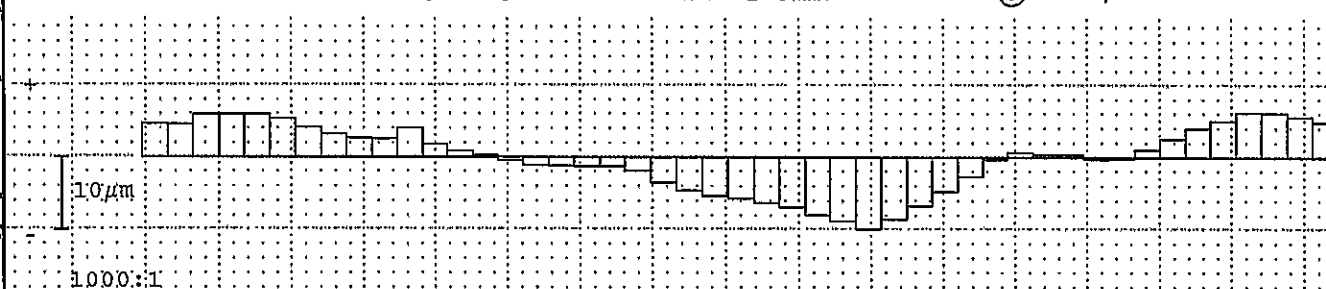
fianco sinistro / RILASCIO

fianco destro / TIRO

	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	5		14		5		14	
Gr. salto di passo fu max	2		18		2		18	
Scarto di divisione Rp	10				10			
Err. globale di divisione Fp	49		50		48	x	50	
Err. cordale di divisione Fps/s	24				26			

Centricità Fr (Ø-sfera = 2.5mm)

⊙ : 12μm



Err. di concentricità Fr	16	32	
Variaz. spessore dente Rs			