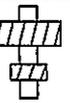




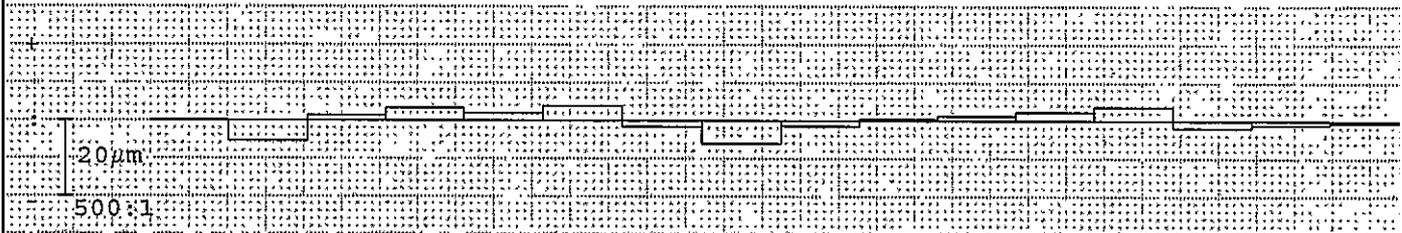
Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

# Ruota cilindrica Divisione

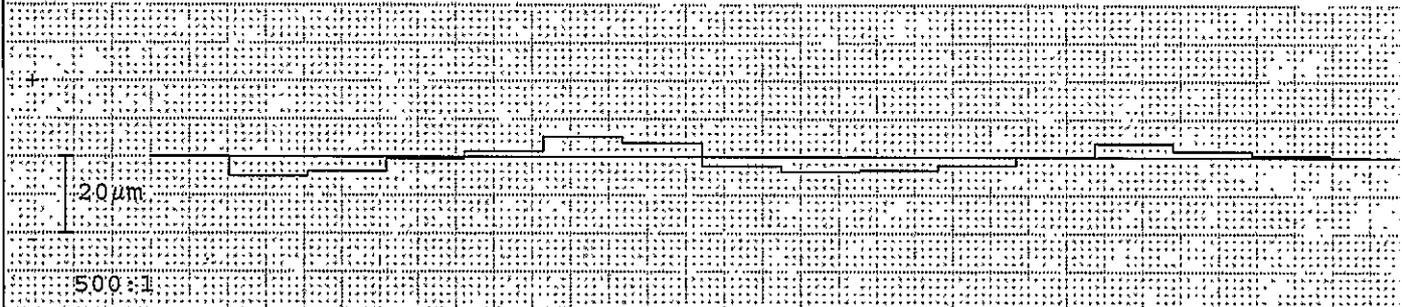


|                                     |                                      |                       |                        |
|-------------------------------------|--------------------------------------|-----------------------|------------------------|
| Nr. prog.: STI0410o05 0             | ZPK 117075                           | Controllore: TURNO a  | Data: 26.09.2016 13:27 |
| Denominazione: Input Shaft 1 Z16    | Numero denti z: 16                   | Angolo pressione: 30° |                        |
| Numero disegno.: D51.6.1073.35-RI H | Modulo m: 1mm                        | Angolo elica: 0°      |                        |
| Commessa/serie nr.: 26              | Untersuchungszweck: Laufende Messung |                       |                        |
| Masch.Nr.: M001                     | Spindel: FORMERZEUG                  | Charge:               |                        |

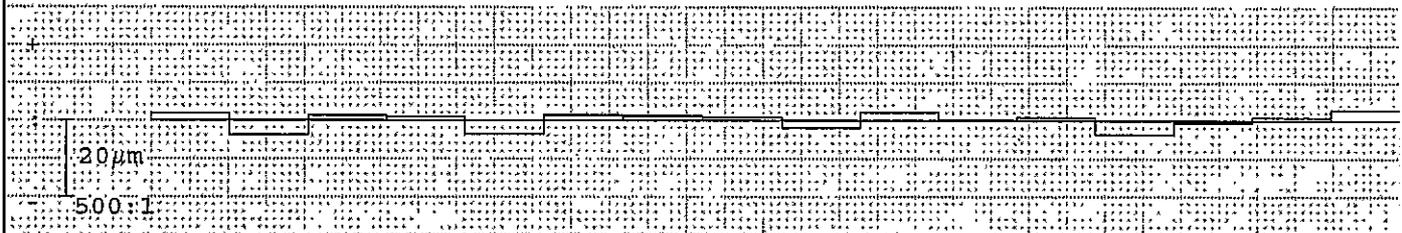
### Errori singoli di divisione fp fianco sinistro



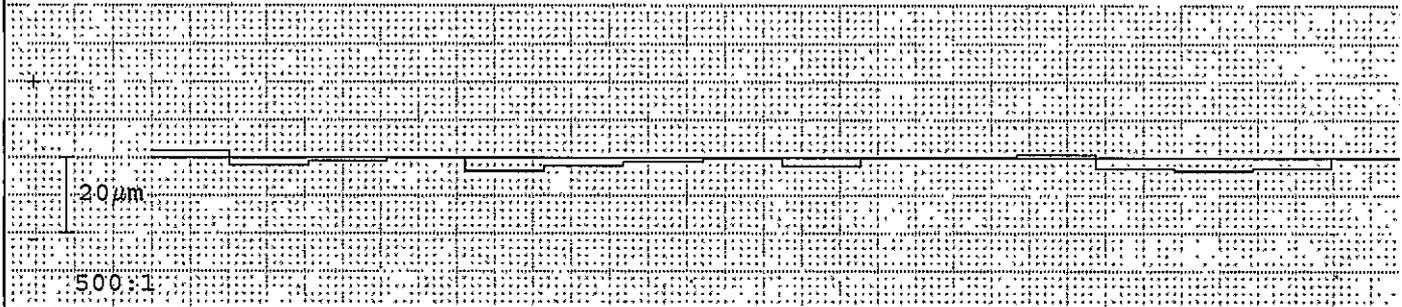
### Errore somma di divisione Fp fianco sinistro



### Errori singoli di divisione fp fianco destro

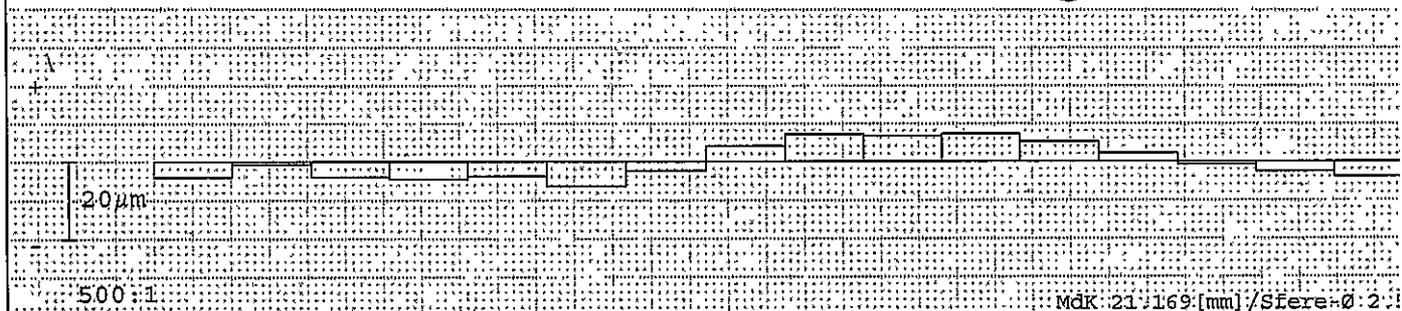


### Errore somma di divisione Fp fianco destro



| Correa per misura divis.: 17.094 z=15.8mm | fianco sinistro |       |          |       | fianco destro |       |          |       |
|---|-----------------|-------|----------|-------|---------------|-------|----------|-------|
|   | Val. misur      | Qual. | Val. amm | Qual. | Val. misur    | Qual. | Val. amm | Qual. |
| Gr. err. singoli divisione fp max         | 6               |       |          |       | 4             |       |          |       |
| Gr. salto di passo fu max                 | 7               |       |          |       | 6             |       |          |       |
| Scarto di divisione Rp                    | 10              |       |          |       | 7             |       |          |       |
| Err. globale di divisione Fp-e            | 10              |       | 36       |       | 5             |       | 36       |       |
| Err. cordale di divisione Fpz/8           | 8               |       |          |       | 5             |       |          |       |

### Centricità Fr (Ø-sfera =2.5mm) ⊙ : 11µm



|                           |    |    |          |        |        |
|---------------------------|----|----|----------|--------|--------|
| Err. di concentricità Fr  | 14 | 40 | Val. amm | 21.108 | 21.061 |
| Variaz. spessore dente Rs |    |    | Val.     | 21.126 | 21.132 |



Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

# Ruota cilindrica Divisione



|                                    |                                      |                        |
|------------------------------------|--------------------------------------|------------------------|
| Nr. prog.: STI0410005 0 ZPK 117075 | Controllore: TURNO a                 | Data: 26.09.2016 13:20 |
| Denominazione: Input Inner Z13     | Numero denti z: 13                   | Angolo pressione: 20°  |
| Numero disegno: D51.6.1073.35-IG H | Modulo m: 2.1mm                      | Angolo elica: 23.25°   |
| Connessa/serie nr.: 26             | Untersuchungszweck: Laufende Messung |                        |
| Masch.Nr.: M001                    | Spindel: FORMERZEDG                  | Charge:                |

### Errori singoli di divisione fp fianco sinistro

|       |  |
|-------|--|
| 20µm  |  |
| 500:1 |  |

### Errore somma di divisione Fp fianco sinistro

|       |  |
|-------|--|
| 20µm  |  |
| 500:1 |  |

### Errori singoli di divisione fp fianco destro

|       |  |
|-------|--|
| 20µm  |  |
| 500:1 |  |

### Errore somma di divisione Fp fianco destro

|       |  |
|-------|--|
| 20µm  |  |
| 500:1 |  |

|                                   | fianco sinistro |       |          |       | fianco destro |       |          |       |
|-----------------------------------|-----------------|-------|----------|-------|---------------|-------|----------|-------|
|                                   | Val. misur      | Qual. | Val. amm | Qual. | Val. misur    | Qual. | Val. amm | Qual. |
| Gr. err. singoli divisione fp max | 6               |       |          |       | 7             |       |          |       |
| Gr. salto di passo fu max         | 10              |       |          |       | 10            |       |          |       |
| Scarto di divisione Rp            | 11              |       |          |       | 13            |       |          |       |
| Err. globale di divisione Fp      | 8               |       |          |       | 12            |       |          |       |
| Err. cordale di divisione Fpz/8   | 6               |       |          |       | 10            |       |          |       |

### Centricità Fr (Ø-sfera =5mm)

⊙ : 7µm

|       |  |
|-------|--|
| 20µm  |  |
| 500:1 |  |

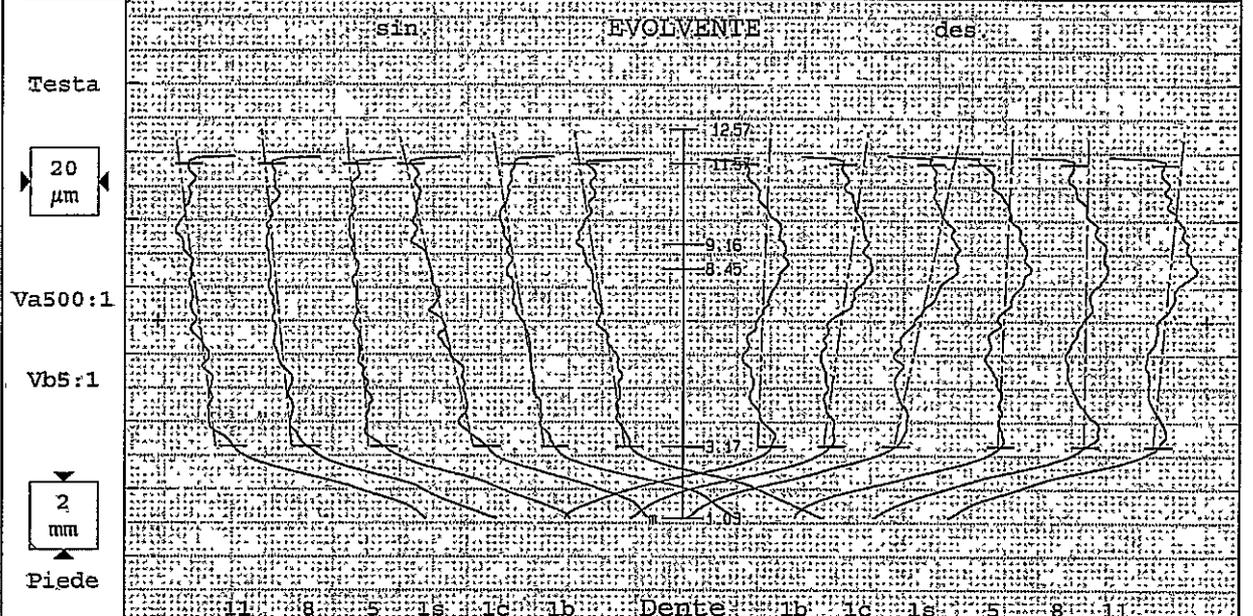
|                           |    |    |                           |        |
|---------------------------|----|----|---------------------------|--------|
| Err. di concentricità Fr  | 12 | 45 | Val. amm 40.664           | 40.617 |
| Variab. spessore dente Rs |    |    | Val. 40.876 40.883 40.871 |        |



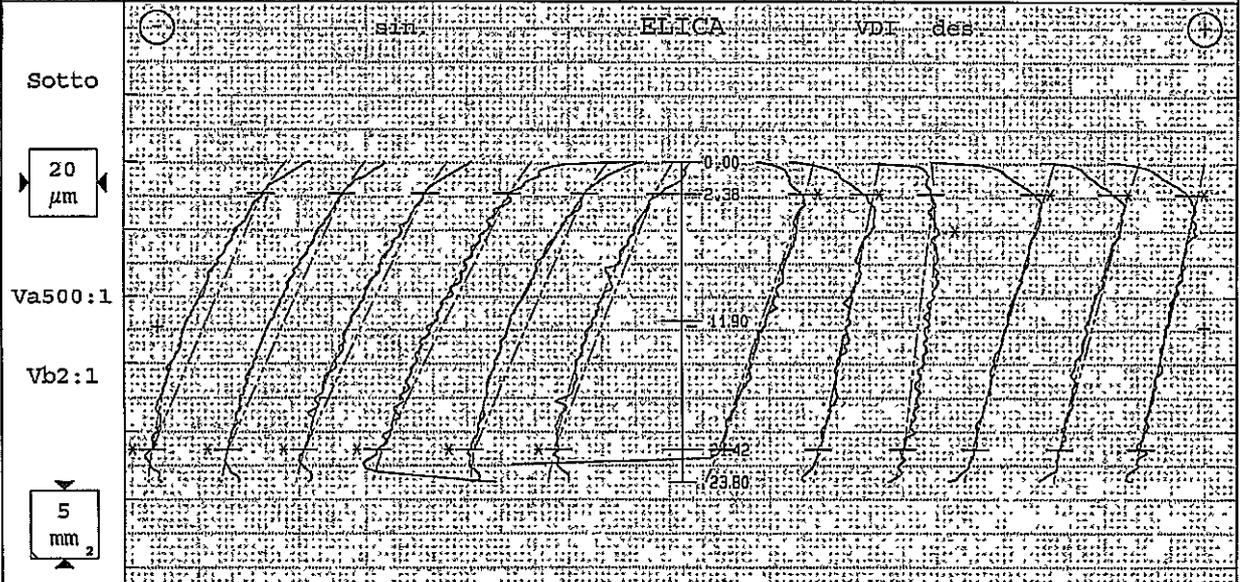
# Ruota cilindrica Evolvente/Elica



|                     |                    |               |                  |           |                    |            |       |
|---------------------|--------------------|---------------|------------------|-----------|--------------------|------------|-------|
| Nr. prog.:          | STI0410005 0       | ZPK 117075    | Controllore:     | TURNO a   | Data:              | 26.09.2016 | 13:20 |
| Denominazione:      | Input Inner Z13    |               | Numero denti z   | 13        | Largh.fasc.dent. b | 23.8mm     |       |
| Numero disegno.:    | DS1.6.1073.35-IG H |               | Modulo m         | 2.1mm     | Tratto evolv. La   | 8.4mm      |       |
| Commessa/serie nr.: | 26                 |               | Angolo pressione | 20°       | Tratto elica Lg    | 19.04mm    |       |
| Manch.Nr.:          | M001               | Spindel: FORM | Angolo elica     | 23.25°    | Inizio elab. M1    | 3.17mm     |       |
| Untersuchungszweck: | Laufende Messung   |               | Ø Base db        | 27.6244mm | Palpatore Ø        | (#1) 1mm   |       |
| Werkzeug:           | Charge:            |               | Ang. Base        | 21.773°   | Fat.scor.pr. x     | .8         |       |



| Tolerance  | Medio  | Val. misur [µm] |    |    |            |     |    |  |  | qual | Tolerance | Val. misur [µm] |    |    |            |     |  |  |  | Medio | Qual |
|------------|--------|-----------------|----|----|------------|-----|----|--|--|------|-----------|-----------------|----|----|------------|-----|--|--|--|-------|------|
|            |        | fza             |    |    |            | fza |    |  |  |      |           | fza             |    |    |            | fza |  |  |  |       |      |
| fHm ±5     | 10     |                 |    |    |            |     |    |  |  | 8    | ±6        |                 |    |    |            |     |  |  |  | 6     |      |
| fHc        | 10     | 11              | 8  | 6  | 20         | 14  | 14 |  |  | 3    | 12        | 18              | 4  | 1  | 8          | 6   |  |  |  |       |      |
| Fa         | 14     | 17              | 12 | 11 | 23         | 16  | 16 |  |  | 14   | 16        | 20              | 15 | 13 | 16         | 15  |  |  |  |       |      |
| ffa        | 8      | 9               | 7  | 7  | 8          | 8   | 9  |  |  | 14   | 14        | 15              | 16 | 12 | 14         | 14  |  |  |  |       |      |
| ffaf       | 0      | 0               | 0  | 0  | 0          | 0   | 0  |  |  | 4    | 2         | 0               | 1  | 1  | 2          | 0   |  |  |  |       |      |
| P/T-φ [mm] | 25.524 |                 |    |    | [27.55/28] |     |    |  |  |      | 36.858    |                 |    |    | [40.74/41] |     |  |  |  |       |      |



| Tolerance | Medio | Val. misur [µm] |    |    |    |     |    |  |  | qual | Tolerance | Val. misur [µm] |    |    |    |     |  |  |  | Medio | Qual |
|-----------|-------|-----------------|----|----|----|-----|----|--|--|------|-----------|-----------------|----|----|----|-----|--|--|--|-------|------|
|           |       | fzB             |    |    |    | fzB |    |  |  |      |           | fzB             |    |    |    | fzB |  |  |  |       |      |
| fHm ±5    | 43    |                 |    |    |    |     |    |  |  | 4    | ±6        |                 |    |    |    |     |  |  |  | 24    |      |
| fHc       | 43    | 41              | 43 | 45 | 47 | 41  | 37 |  |  | 33   | 20        | 11              | 27 | 25 | 22 | 24  |  |  |  |       |      |
| Fz        | 36    | 36              | 35 | 38 | 44 | 35  | 32 |  |  | 25   | 17        | 11              | 20 | 20 | 18 | 19  |  |  |  |       |      |
| FFB       | 3     | 3               | 2  | 4  | 4  | 3   | 6  |  |  | 4    | 5         | 4               | 4  | 7  | 5  | 5   |  |  |  |       |      |
| CB 1/5    | 5     | 5               | 4  | 4  | 3  | 5   | 3  |  |  | 1/5  | 1         | 0               | 3  | 0  | -1 | 0   |  |  |  |       |      |
| Bd        | 10    |                 |    |    |    |     |    |  |  |      |           |                 |    |    |    |     |  |  |  |       | -22  |

