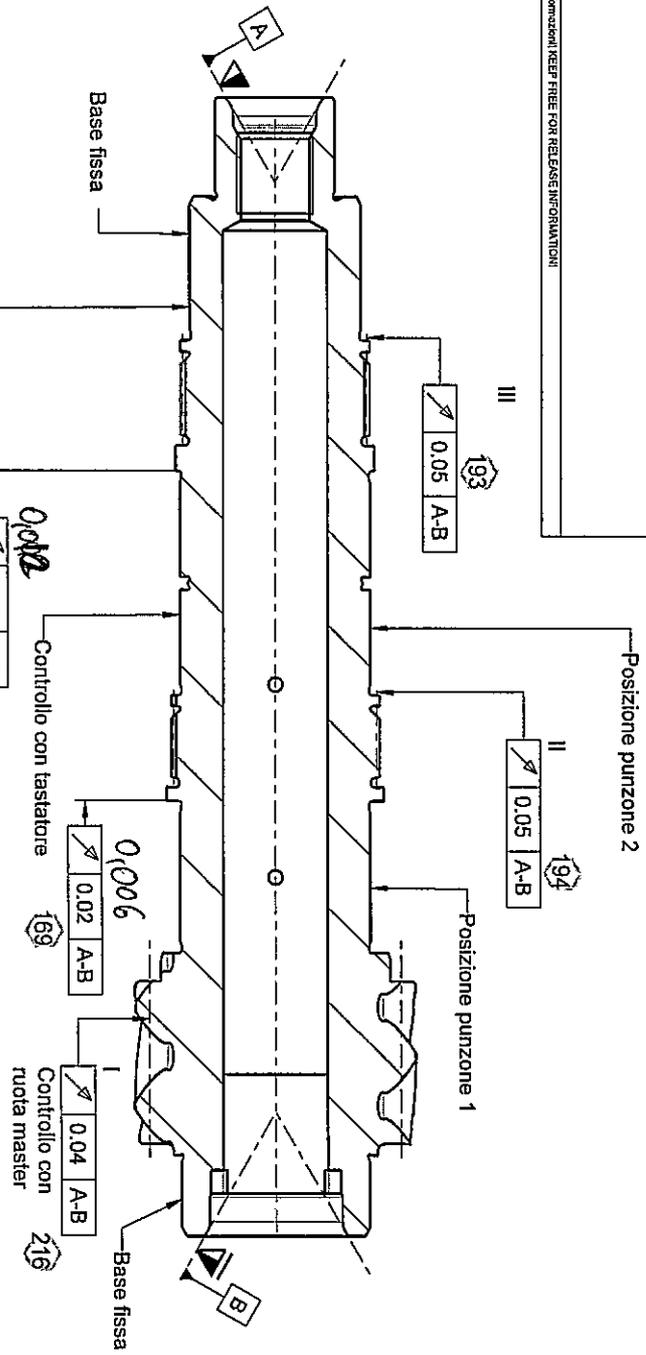


3M313

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▽ = Serraggio
▽ = Battuta

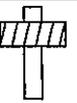
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<p>CAD File Export</p>		<p>Lettera N. variante</p>		<p>Versioni</p>	
<p>Scala / SCALE</p>		<p>CHANGENUMBER</p>		<p>MODIFICATIONS</p>	
<p>M: 1:1 (-)</p>		<p>REQUEST NO.</p>		<p>ONLY ALLOWED BY CAD. CHECK FMEA-</p>	
<p>Senza nessuna indicazione sul utilizzo e fissato, l'informazione su questo disegno sono non abilitate.</p>					
<p>INFORMATION ON THIS DRAWING PROVIDED WITHOUT OBLIGATION OF USE AND RELEASE ARE NOT SHOWN.</p>					
<p>EVALUATION OF THE DIAMETER MEASUREMENT IS CARRIED OUT ACCORDING TO THE GAUGE METHOD (ARITHMETICAL MEAN VALUE)</p>					
<p>Tolleranze di forma e posizione</p>					
<p>FORM AND POSITION TOLERANCES</p>					
<p>ISO 2768 - Y</p>					
<p>GENERAL TOLERANCES FOR LINEAR DIMENSIONS, FORM AND DIMENSIONS ISO 2768 - Y</p>					
<p>POSITION ISO 2768 - mH</p>					
<p>GENERAL TOLERANCES FOR ANGULAR DIMENSIONS ISO 2768 - Y</p>					
<p>ANGULAR DIMENSIONS ISO 2768 - Y</p>					
<p>DEPENDENZA GRECO</p>					
<p>DEPENDENCY GREEK</p>					
<p>UNIMACH, D.M.</p>					
<p>UNIMACH, D.M.</p>					
<p>MACHINING</p>					
<p>MACHINE</p>					
<p>Ø 63.5 x 238.1</p>					
<p>Trattamento Termico</p>					
<p>SEMIFINISHED</p>					
<p>GCG 805000_02_20MNC:SS</p>					
<p>Protezione secondo ISO 16016</p>					
<p>PROTECTION PER ISO 16016</p>					

<p>Nome</p>		<p>ammetals s.p.a.</p>		<p>Nome</p>		<p>ammetals s.p.a.</p>	
<p>DATA</p>		<p>3/7/2016 11:41:04 AM</p>		<p>DATA</p>		<p>3/7/2016 11:41:04 AM</p>	
<p>Primo utilizzo</p>		<p>2531</p>		<p>Primo utilizzo</p>		<p>2531</p>	
<p>Denominazione / ITEM NAME</p>		<p>Albero di uscita 1</p>		<p>Denominazione / ITEM NAME</p>		<p>Albero di uscita 1</p>	
<p>La Massa</p>		<p>1.761 kg</p>		<p>La Massa</p>		<p>1.761 kg</p>	
<p>Superficie</p>		<p>64423 mm²</p>		<p>Superficie</p>		<p>64423 mm²</p>	
<p>SEMIFINISHED NUMBER</p>		<p>2516107635</p>		<p>SEMIFINISHED NUMBER</p>		<p>2516107635</p>	
<p>Codeex / ITEM NO.</p>		<p>350_804419</p>		<p>Codeex / ITEM NO.</p>		<p>350_804419</p>	
<p>Forma/size</p>		<p>A3</p>		<p>Forma/size</p>		<p>A3</p>	
<p>Revisioni</p>		<p>1</p>		<p>Revisioni</p>		<p>1</p>	

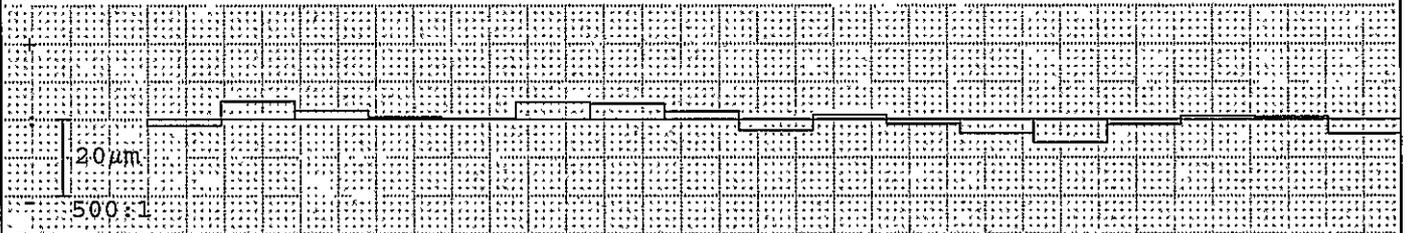


Ruota cilindrica Divisione

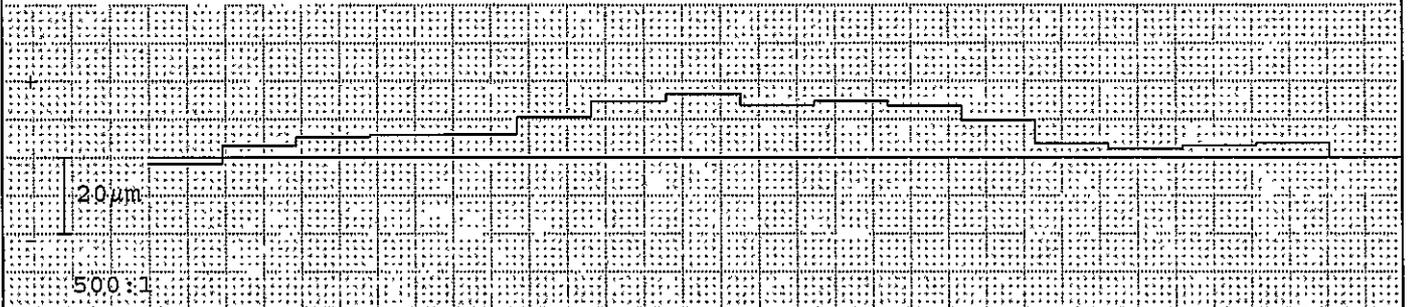


Nr. prog.: STI041005 0	ZPK 117057	Controllore: TURNO c	Data: 17.09.2016 13:26
Denominazione: Output Shaft 1	Numero denti z: 17	Angolo pressione: 20°	
Numero disegno.: D51.6.1076.35-IG H	Modulo m: 2.68mm	Angolo elica: -24°	
Comessa/serie nr.: 19	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	

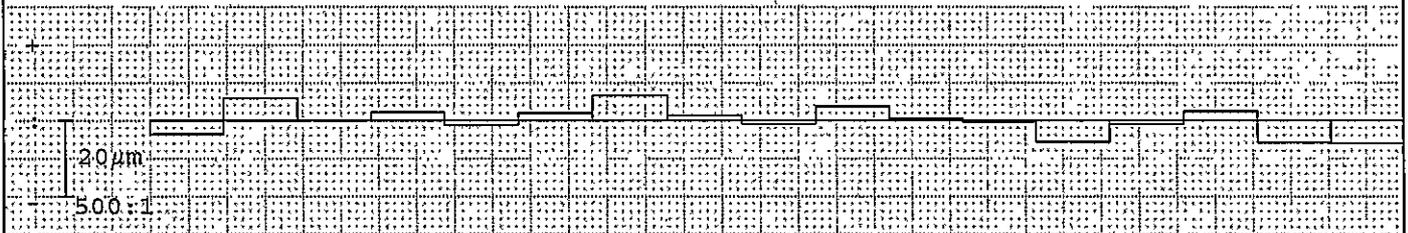
Errori singoli di divisione fp fianco sinistro



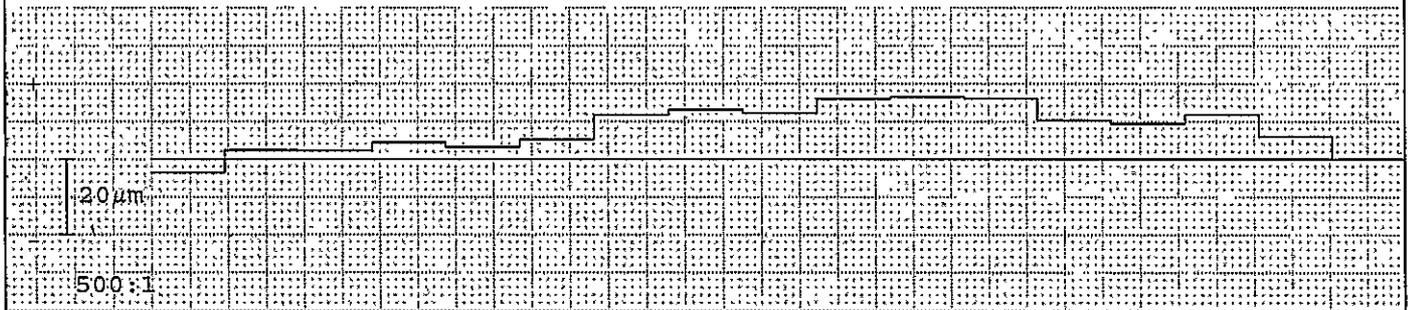
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro

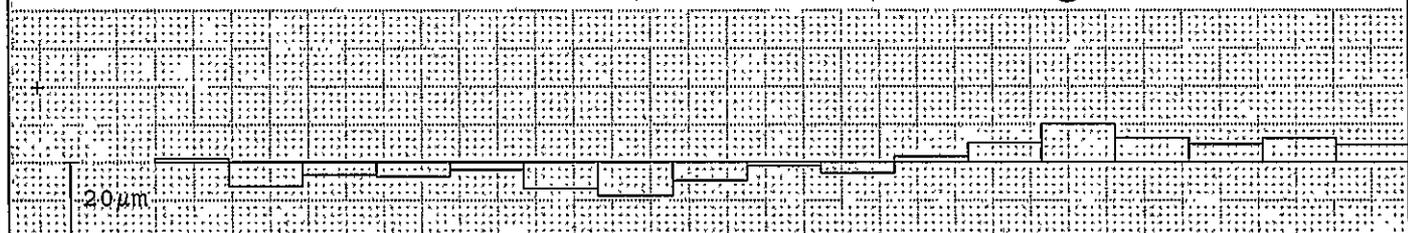


Errore somma di divisione Fp fianco destro



	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	6				9			
Scarto di divisione Rp	11				13			
Err. globale di divisione Fp	18				20			
Err. cordale di divisione Fpz/8	10				12			

Centricità Fr (Ø-sfera =4.5mm) ~ ☉ : 14µm

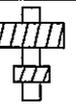


Mdk 58.128 [mm] / Sfere-Ø 4.5

Err. di concentricità Fr	19 216	40	Val. amm
Variar. spessore dente Rs			Val. 58.326 58.335 58.319

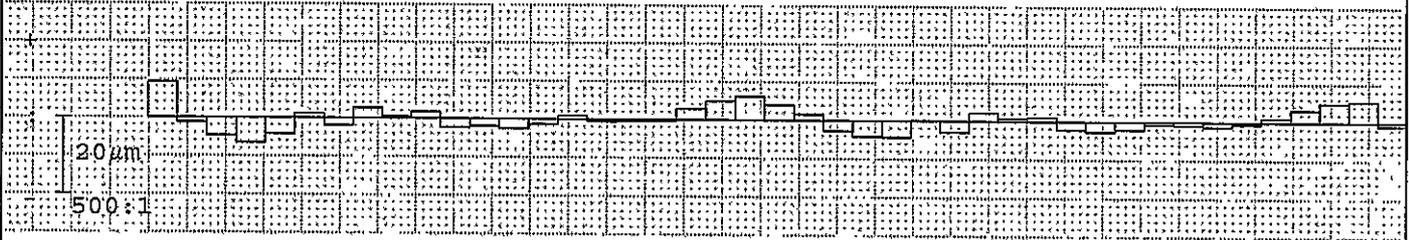


Ruota cilindrica Divisione

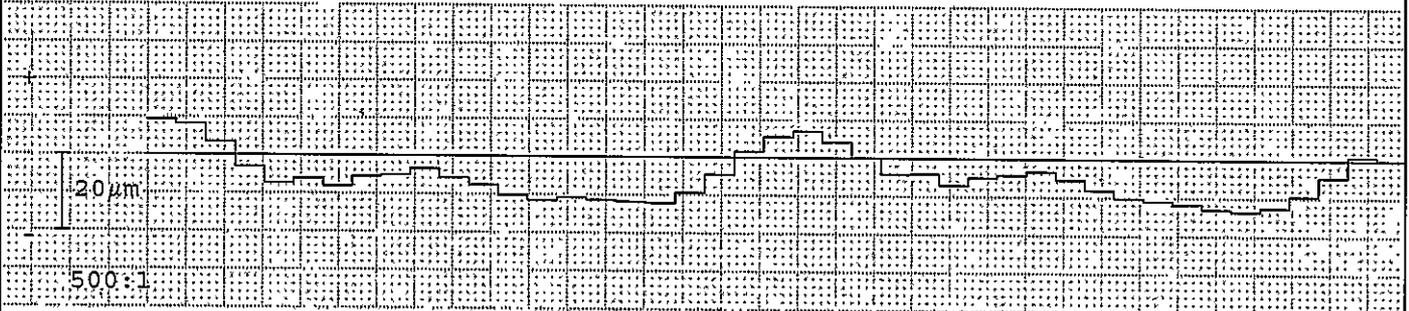


Nr. prog.: STI0410o05 0	ZPK 117057	Controllore: TURNO c	Data: 17.09.2016 13:33
Denominazione: Output Shaft 1		Numero denti z 43	Angolo pressione 30°
Numero disegno: D51.6.1076.RIIa H		Modulo m 1mm	Angolo elica 0°
Comessa/serie nr.: 19		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMER	Werkzeug:	Charge:

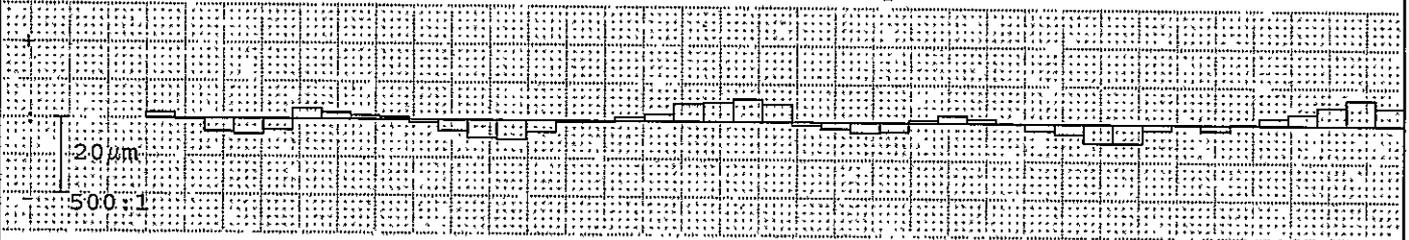
Errori singoli di divisione fp fianco sinistro



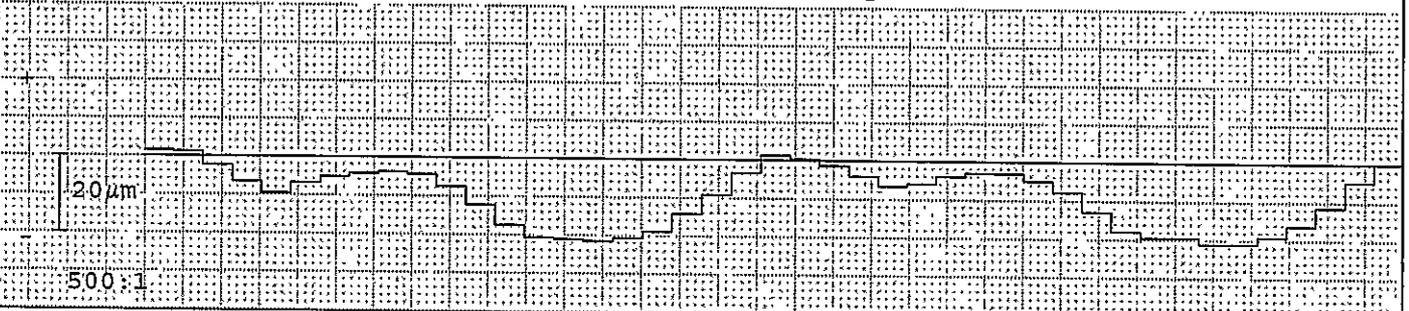
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro

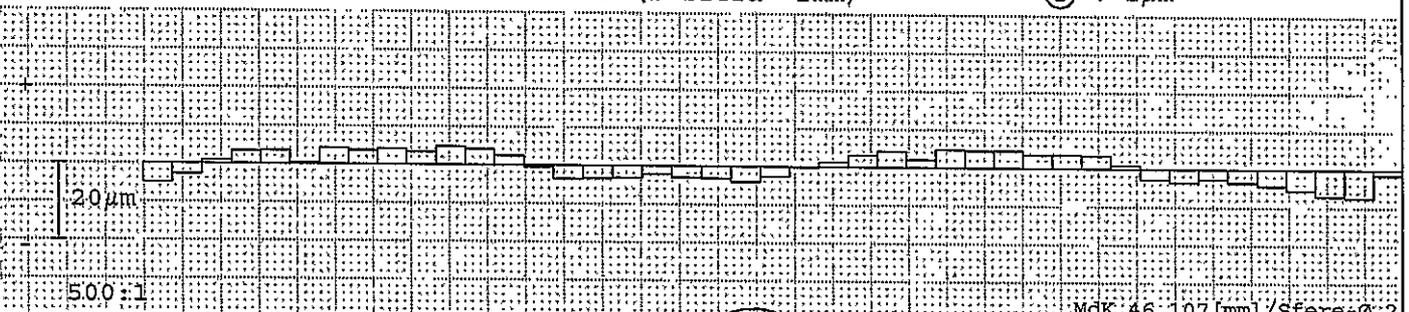


Corsa per misura divis.: 43.096 z=6.8mm

	fianco sinistro				fianco destro			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	9		17		7		17	
Gr. salto di passo fu max	10				6			
Scarto di divisione Rp	15				12			
Err. globale di divisione Fp-e	23		40		23		40	
Err. cordale di divisione Fpz/8	22				22			

Centricità Fr (Ø-sfera =2mm)

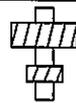
⊙ : 2µm



Err. di concentricità Fr	12	50	Val. amm	46.992	45.992	
Variaz. spessore dente Rs			Val.	46.208	46.217	46.197

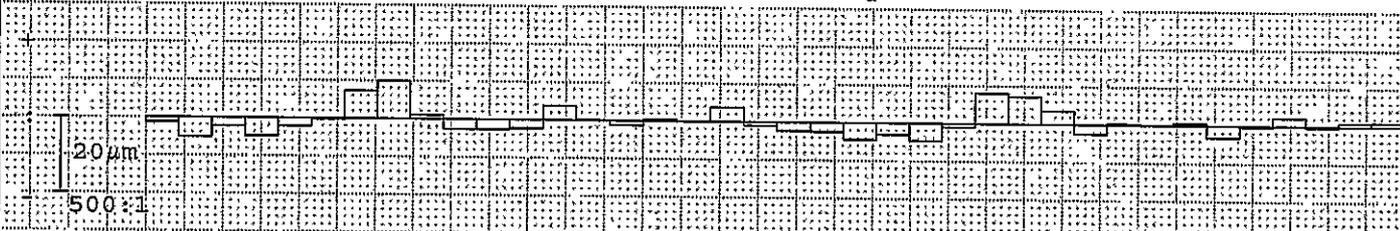


Ruota cilindrica Divisione

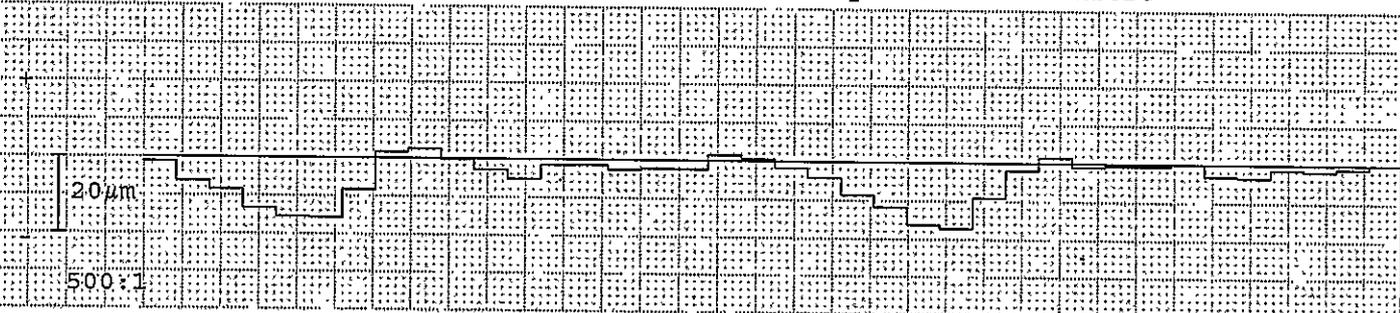


Nr. prog.: STI0410005 0	ZPK 117057	Controllatore: TURNO c	Data: 17.09.2016 13:35
Denominazione: Output Shaft 1		Numero denti z 38	Angolo pressione 30°
Numero disegno: D51.6.1076.RIIIIa H		Modulo m 1mm	Angolo elica 0°
Comessa/serie nr.: 19		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	

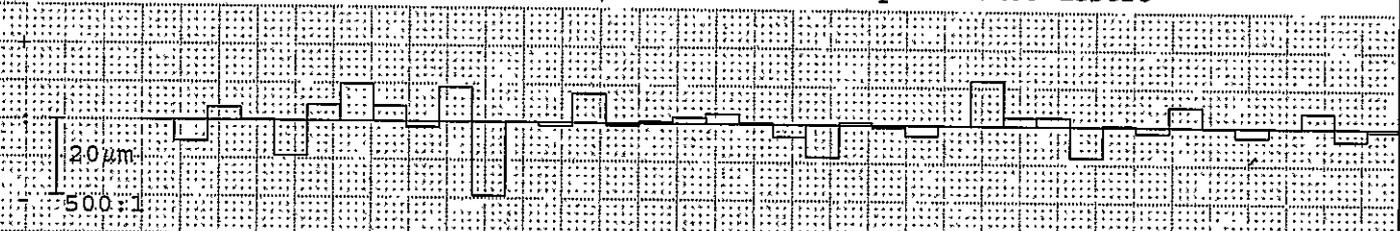
Errori singoli di divisione fp fianco sinistro



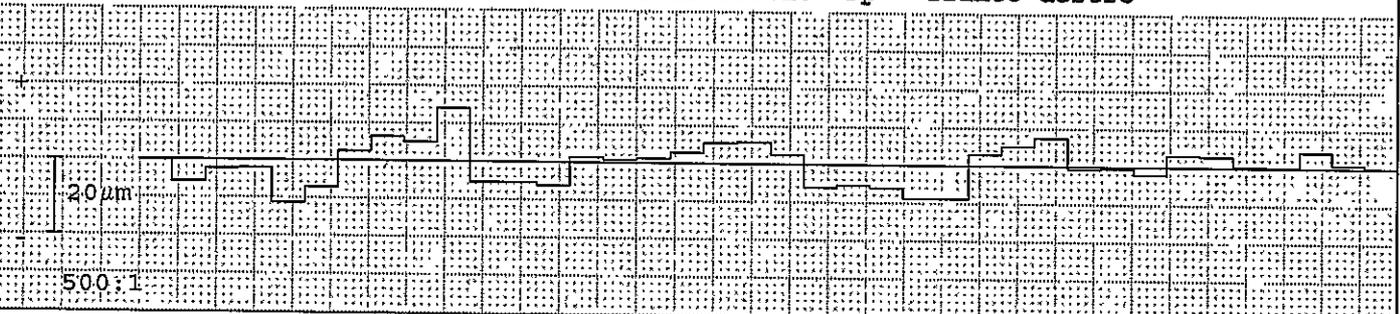
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



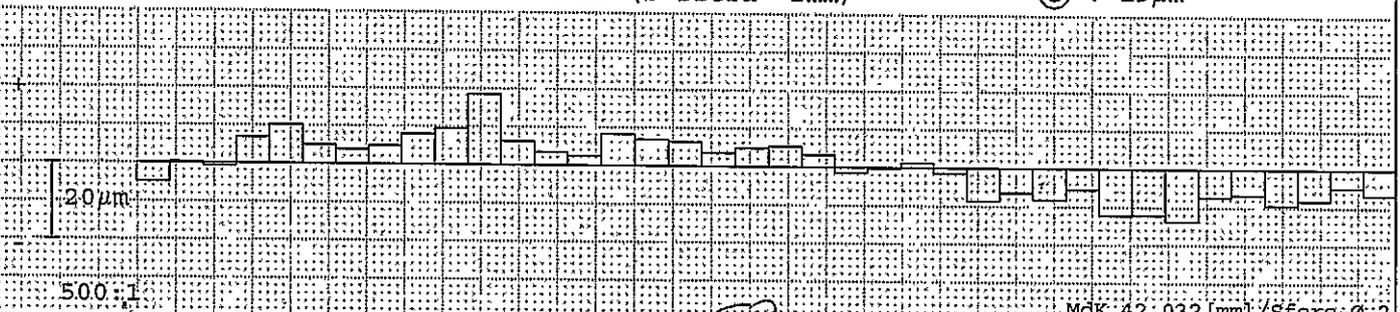
Errore somma di divisione Fp fianco destro



	fianco sinistro		fianco destro					
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	10		17		19	x	17	
Gr. salto di passo fu max	9				28			
Scarto di divisione Rp	15				31			
Err. globale di divisione Fp-e	20		40		25		40	
Err. cordale di divisione Fpz/8	17				25			

Centricità Fr (Ø-sfera =2mm)

⊙ : 19µm



		Mdk: 42.032 [mm] / Sfere-Ø: 2	
Err. di concentricità Fr	32	50	Val. amm 42.148 42.088
Variaz. spessore dente Rs			Val 42.147 42.152 42.117