

311658

**GETRAG**

Production Part Approval

DIMENSIONAL TEST RESULTS

Organization: GETRAG									Part Number: 251.6.1076.35							
Supplier/Vendor Code: GETRAG Modugno									Part Name: Output Shaft 1							
INSPECTION FACILITY: NA									Design Record Change Level: 3 Index (C) 10/05/2016							
									Engineering Change Documents:							
									Organization Measurement Results (Data)							
Item	Dimension/Specification				Specification / Limits		<M>	Qty. Tested	1	2	3	4	5	Test distruttivo	Ok	Not Ok
1	Distanza	239,61	0,4	-0,4	240,01	239,21		5	239,60	239,59	239,63	239,61	239,62		ok	
2	Distanza	201,81	0,08	-0,08	201,89	201,73		5	201,821	201,805	201,794	201,811	201,794		ok	
3	Distanza	165,4	0,05	-0,05	165,48	165,38	x	5	165,415	165,411	165,412	165,418	165,414		ok	
4	Distanza	159,51	0,07	-0,07	159,58	159,44		5	159,488	159,484	159,485	159,491	159,487		ok	
5	Distanza	127,3	0,07	-0,07	127,32	127,18		5	127,22	127,21	127,19	127,23	127,22		ok	
6	Distanza	124,57	0,025	-0,025	124,60	124,55	x	5	124,558	124,554	124,553	124,558	124,555		ok	
7	Distanza	105,09	0,1	-0,1	105,19	104,99		5	105,084	105,084	105,084	105,080	105,088		ok	
8	Distanza	79,85	0,025	-0,025	79,88	79,83	x	5	79,828	79,826	79,825	79,826	79,825		ok	
9	Distanza	57,64	0,1	-0,1	57,74	57,54		5	57,59	57,60	57,61	57,58	57,60		ok	
10	Distanza	52,52	0,025	-0,025	52,55	52,50	x	5	52,515	52,515	52,515	52,515	52,515		ok	
11	Distanza	30,21	0,1	-0,1	30,31	30,11		5	30,214	30,212	30,212	30,211	30,210		ok	
12	Distanza	20,7	0,2	-0,2	20,9	20,5		5	20,74	20,76	20,75	20,76	20,75		ok	
13	Distanza	1,2	0,2	-0,2	1,4	1		5	1,096	1,090	1,083	1,099	1,097		ok	
14	Distanza	20,19	0,025	-0,025	20,215	20,165	x	5	20,207	20,207	20,207	20,206	20,208		ok	
15	Distanza	0,5	0,3	-0,3	0,8	0,2		5	0,589	0,578	0,568	0,592	0,575		ok	
16	Angolo	30°	3	-3	33°	27°		5	31,186°	31,352°	31,180°	31,074°	31,145°		ok	
17	Distanza	17,46	0,025	-0,025	17,485	17,435	x	5	17,459	17,459	17,459	17,460	17,458		ok	
18	Distanza	17,1	0,15	-0,15	17,25	16,95		5	17,082	17,083	17,082	17,068	17,080		ok	
19	Distanza	15,4	0,15	-0,15	15,55	15,25		5	15,343	15,334	15,339	15,330	15,346		ok	
20	Angolo	25°	3	-3	28°	22°		5	25,693°	26,032°	27,098°	26,182°	26,108°		ok	
21	Root diameter	41,8	0	-0,59	41,8	41,21		5	41,327	41,336	41,333	41,327	41,327		ok	
22	Tip diameter	43,89	0	-0,5	43,89	43,39		5	43,393	43,393	43,393	43,393	43,392		ok	
23	Diametro	36	0	-0,013	36	35,987	x	5	35,987	35,987	35,989	35,990	35,988		ok	
24	Diametro	25	0,031	0,018	25,031	25,018	x	5	25,021	25,020	25,022	25,023	25,022		ok	
25	Tip diameter	39,89	0	-0,5	39,89	39,39		5	39,448	39,449	39,448	39,450	39,448		ok	
26	Root diameter	37,80	0	-0,59	37,80	37,21		5	37,391	37,393	37,386	37,376	37,380		ok	
27	Tip diameter	39,89	0	-0,25	39,89	39,64		5	39,782	39,782	39,781	39,784	39,781		ok	
28	Diametro	41,89	0,1	-0,1	41,99	41,79		5	41,87	41,90	41,88	41,89	41,90		ok	
29	Diametro	40	0	-0,013	40	39,987	x	5	39,989	39,989	39,992	39,990	39,990		ok	
30	Diametro	40	0	-0,013	40	39,987	x	5	39,989	39,990	39,990	39,989	39,988		ok	
31	Tip diameter	43,89	0	-0,25	43,89	43,64		5	43,782	43,783	43,782	43,784	43,782		ok	
32	Diametro	45,8	0,1	-0,1	45,9	45,7		5	45,76	45,77	45,75	45,78	45,79		ok	
33	Diametro	40	0	-0,013	40	39,987	x	5	39,994	39,994	39,993	39,990	39,992		ok	
34	Diametro	48,21	0,018	0,002	48,228	48,212	x	5	48,221	48,222	48,222	48,213	48,223		ok	
35	Diametro	22	0,2	-0,2	22,2	21,8		5	21,95	21,96	21,95	21,97	21,96		ok	
36	Root diameter	43,05	0	-0,32	43,05	42,73		5	43,00	42,957	42,949	42,958	42,947		ok	
37	Tip diameter	59,2	0	-0,26	59,2	58,94		5	59,048	59,059	59,042	59,076	59,067		ok	
38	Angolo	30°	3	-3	33°	27°		5	31,685°	31,666°	31,385°	31,594°	31,222°		ok	
39	Distanza	143,3	0,3	-0,3	143,6	143		5	143,20	143,22	143,19	143,21	143,22		ok	
40	Distanza	102,67	0,3	-0,3	102,97	102,37		5	102,52	102,54	102,55	102,53	102,51		ok	
41	Distanza	60,38	0,3	-0,3	60,68	60,08		5	60,22	60,23	60,21	60,22	60,23		ok	
42	Distanza	27,7	0,3	-0,3	28	27,4		5	27,57	27,59	27,58	27,57	27,58		ok	

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DIMENSIONAL TEST RESULTS

Organization: GETRAG						Part Number: 251.6.1076.35							
Supplier/Vendor Code: GETRAG Modugno						Part Name: Output Shaft 1							
INSPECTION FACILITY: NA						Design Record Change Level: 3 Index (C) 10/05/2016 Engineering Change Documents: -							
						Organization Measurement Results (Data)							
Item	Dimension/Specification	Specification / Limits		<M>	Qty. Tested	1	2	3	4	5	Test distruttivo	Ok	Not Ok
43	Diametro 3 ± 0,2	3,2	2,8		5	2,99	2,98	2,99	2,97	2,97		ok	
44	Diametro 3 ± 0,2	3,2	2,8		5	2,97	2,98	2,98	2,99	2,99		ok	
45	Diametro 3 ± 0,2	3,2	2,8		5	2,98	2,97	2,97	2,96	2,98		ok	
46	Diametro 3 ± 0,2	3,2	2,8		5	2,97	2,97	2,98	2,99	2,97		ok	
47	Distanza 0,5 ± 0,4	0,9	0,1		5	0,502	0,572	0,558	0,562	0,558		ok	
48	Distanza 0,5 ± 0,4	0,9	0,1		5	0,543	0,518	0,529	0,528	0,527		ok	
49	Distanza 0,7 ± 0,4	1,1	0,3		5	0,801	0,673	0,655	0,707	0,670		ok	
50	Distanza 1 ± 0,5	1,5	0,5		5	0,978	1,087	1,143	1,075	1,127		ok	
51	Rz 16	0,016	0		5	0,0022	0,0020	0,0020	0,0021	0,0021		ok	
52	Rz 16	0,016	0		5	0,0021	0,0020	0,0021	0,0020	0,0019		ok	
53	0,05 A - B	0,05	0		5	0,028	0,023	0,041	0,025	0,029		ok	
54	0,05 A - B	0,05	0		5	0,013	0,034	0,031	0,036	0,054		ok	
55	Rz 1,2	0,0012	0		5	0,0004	0,0003	0,0007	0,0004	0,0005		ok	
	Rmax 2	0,002	0		5	0,0008	0,0003	0,0012	0,0005	0,0006		ok	
	Rpk 0,18	0,018	0		5	0	0	0	0	0		ok	
	Rk 0,3	0,003	0		5	0,0001	0,0001	0,0001	0,0002	0,0001		ok	
	Rvk 0,3	0,003	0		5	0	0	0,0002	0	0		ok	
56	Rz 4 dente	0,004	0		5	0,0012	0,0015	0,0013	0,0011	0,0014		ok	
	Rmax 8 dente	0,008	0		5	0,0013	0,0013	0,0016	0,0011	0,0012		ok	
57	0,032 A - B	0,032	0	x	5	0,004	0,018	0,017	0,025	0,016		ok	
58	0,02 A - B	0,02	0		5	0,006	0,008	0,009	0,007	0,006		ok	
59	0,04 A - B	0,04	0		5	0,005	0,003	0,008	0,006	0,006		ok	
60	0,04 A - B	0,04	0		5	0,008	0,008	0,009	0,009	0,010		ok	
61	0,02 A - B	0,02	0		5	0,004	0,003	0,004	0,006	0,007		ok	
62	0,02 A - B	0,02	0		5	0,005	0,003	0,006	0,006	0,006		ok	
63	0,02 A - B	0,02	0		5	0,005	0,004	0,006	0,007	0,005		ok	
64	0,02 A - B	0,02	0		5	0,005	0,004	0,006	0,007	0,005		ok	
65	0,02 A - B	0,02	0		5	0,006	0,004	0,006	0,006	0,006		ok	
66	0,04 A - B	0,04	0		5	0,005	0,006	0,005	0,007	0,006		ok	
67	0,02 A - B	0,02	0		5	0,005	0,003	0,004	0,006	0,004		ok	
68	0,006 G	0,006	0		5	0,0022	0,0027	0,0012	0,0011	0,0023			

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DIMENSIONAL TEST RESULTS

Organization: GETRAG					Part Number: 251.6.1076.35								
Supplier/Vendor Code: GETRAG Modugno					Part Name: Output Shaft 1								
INSPECTION FACILITY:					Design Record Change Level: 3 Index (C) 10/05/2016								
NA					Engineering Change Documents:								
					Organization Measurement Results (Data)								
Item	Dimension/Specification	Specification / Limits		<M>	Qty. Tested	1	2	3	4	5	Test distruttivo	Ok	Not Ok
82	0,004	0,004	-		5	0,0018	0,0020	0,0014	0,0008	0,0022		ok	
83	0,004	0,004	-		5	0,0006	0,0010	0,0004	0,0012	0,0003		ok	
84	Rz 2	0,002	-		5	0,0004	0,0005	0,0006	0,0006	0,0004		ok	
	Rmax 3,2	0,0032	-		5	0,0006	0,0006	0,0007	0,0009	0,0005		ok	
85	Rz 3	0,003	-		5	0,0024	0,0028	0,0022	0,0019	0,0022		ok	
	Rmax 4	0,004	-		5	0,0029	0,0038	0,0029	0,0024	0,0026		ok	
86	Rz 3	0,003	-		5	0,0028	0,0024	0,0024	0,0020	0,0024		ok	
	Rmax 4	0,004	-		5	0,0031	0,0028	0,0028	0,0022	0,0033		ok	
87	Rz 4	0,004	-		5	0,0023	0,0025	0,0019	0,0018	0,0026		ok	
88	Rz 25	0,025	-		5	0,0007	0,0007	0,0070	0,0080	0,0080		ok	
89	Rz 10	0,01	-		5	0,0010	0,0011	0,0012	0,0014	0,0009		ok	
90	Rz 10	0,01	-		5	0,0011	0,0009	0,0008	0,0010	0,0007		ok	
91	Rz 10	0,01	-		5	0,0024	0,0022	0,0024	0,0027	0,0058		ok	
92	Rz 10	0,01	-		5	0,0044	0,0036	0,0033	0,0010	0,0042		ok	
93	Rz 3	0,003	-		5	0,0027	0,0027	0,0023	0,0023	0,0027		ok	
	Rmax 4	0,004	-		5	0,0032	0,0035	0,0026	0,0031	0,0036		ok	
94	0,4 A - B	0,4	-		5	0,025	0,020	0,030	0,018	0,028		ok	
95	0,004	0,004	-		5	0,0005	0,0007	0,0009	0,0009	0,0007		ok	
96	0,004	0,004	-		5	0,0006	0,0006	0,0007	0,0004	0,0006		ok	
97	0,006 D	0,006	-		5	0,0011	0,0012	0,0012	0,0015	0,0012		ok	
98	0,02 A - B	0,02	-		5	0,0007	0,0006	0,0008	0,0006	0,0007		ok	
99	M1 HRA 80,5 + 2,5	83	80,5		1						81	ok	
100	M3 EHT 550 HV1 0,5 min.	-	0,5		1						0,9	ok	
101	M2 550 HV1 0,7 + 0,5	1,2	0,7		1						0,95	ok	
102	M4 HV10 300 min	-	300		1						351	ok	
103	Caratteristica V	-	-		5	ok	ok	ok	ok	ok		ok	
104	Caratteristica X	-	-		5	ok	ok	ok	ok	ok		ok	
105	Caratteristica U	-	-		5	ok	ok	ok	ok	ok		ok	
106	Caratteristica S	-	-		5	ok	ok	ok	ok	ok		ok	
107	Caratteristica Q	-	-		5	ok	ok	ok	ok	ok		ok	
108	Caratteristica R	-	-		5	ok	ok	ok	ok	ok		ok	
109	Caratteristica N	-	-		1	ok						ok	
110	Caratteristica Y	-	-		5	ok	ok	ok	ok	ok		ok	
111	Caratteristica Z	-	-		5	ok	ok	ok	ok	ok		ok	
111 bis	Diametro 39,5	39,500	39,484	x	5	39,496	39,492	39,495	39,493	39,491		ok	
112	Caratteristica P	-	-		5	ok	ok	ok	ok	ok		ok	
113	Caratteristica W	-	-		5	ok	ok	ok	ok	ok		ok	
114	Angolo 0,0685°	0,0835	0,0485		5	0,0788	0,0794	0,0729	0,0781	0,0768		ok	
115	Mdk I	58,044	57,984	x	5	57,960	57,968	57,972	57,990	57,985		ok	
116	Mdk IIa	46,231	46,167	x	5	46,208	46,201	46,206	46,208	46,215		ok	
117	Mdk IIb	46,065	45,992		5	46,026	46,019	46,019	46,023	46,018		ok	
118	Mdk IIIa	42,148	42,088	x	5	42,125	42,112	42,114	42,122	42,180		ok	
119	Mdk IIIb	41,992	41,923		5	41,943	41,952	41,934	41,943	41,938		ok	

SIGNATURE

TITLE

DATE



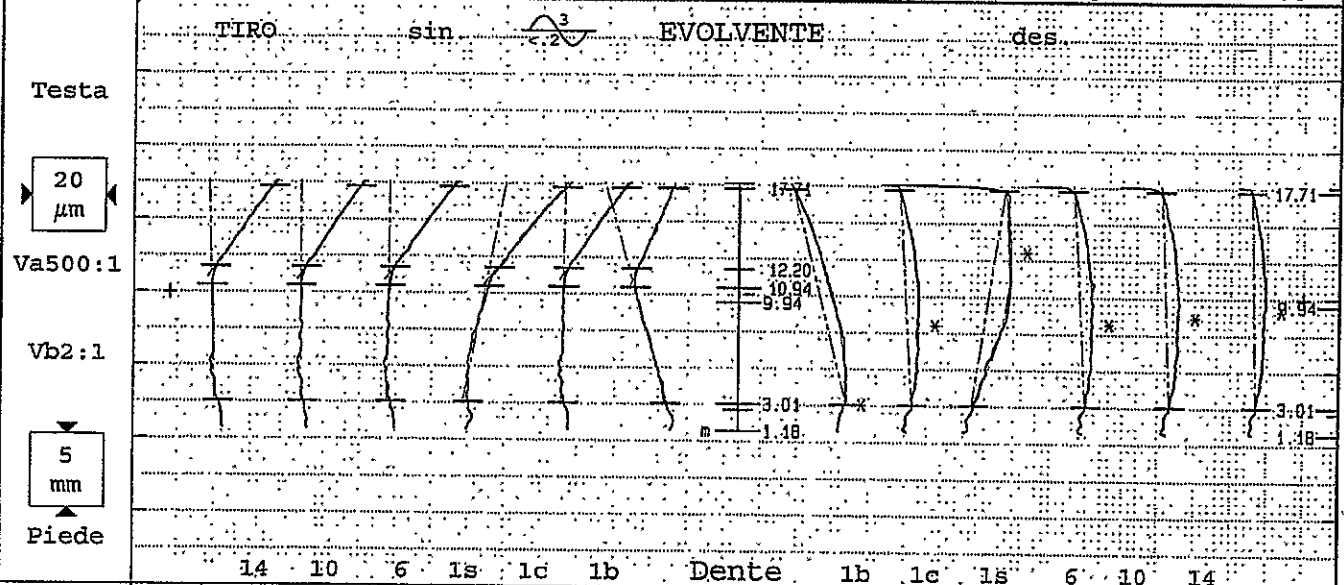
Production Part Approval

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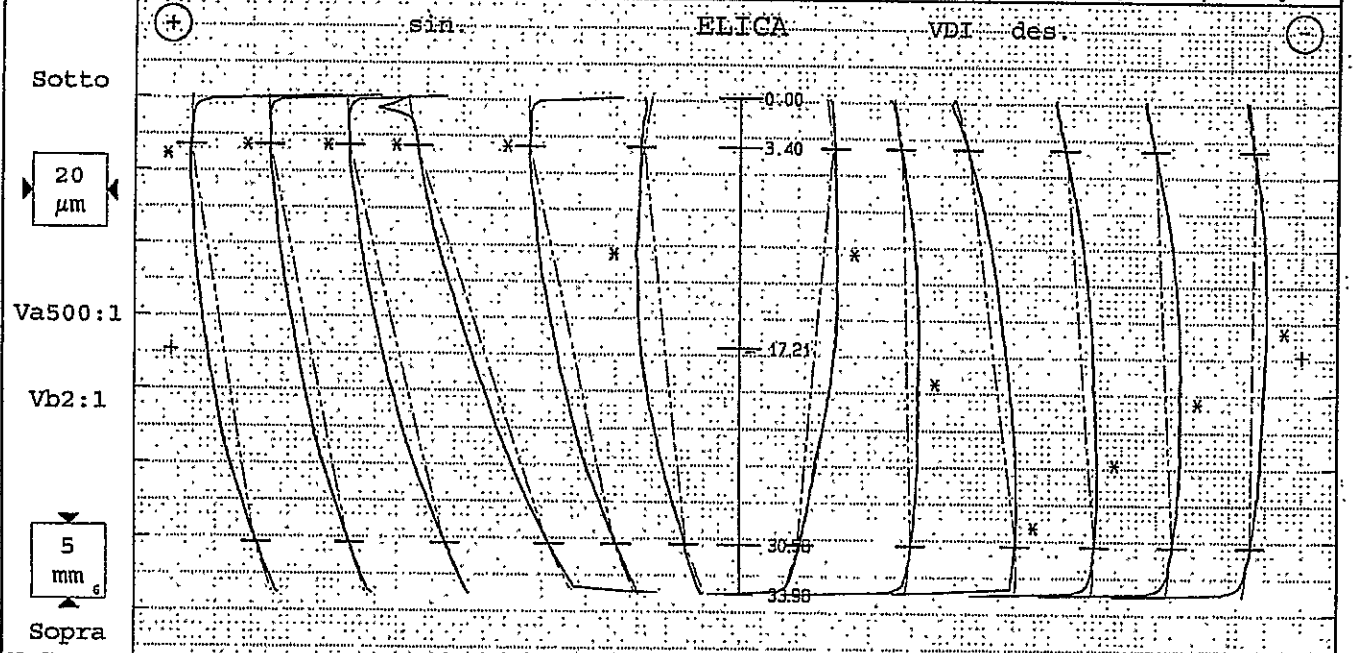
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410o05 0	P26 601265	Controllore:	turno d	Data:	15.12.2016 19:26
Denominazione:	Output Shaft 1		Numero denti z	17	Largh.fasc.dent. b	33.98mm
Numero disegno:	D51.6.1076.35-IF		Modulo m	2.68mm	Tratto evol. La	7.93/14.7mm
Comessa/serie nr.:	2 (1)		Angolo pressione	20°00'00"	Tratto elica LS	27.18mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	-24°00'00"	Inizio elab. M1	3.01mm
Untersuchungszweck:	Laufende Messung		Ø Base db	46.3299mm	Palpatore Ø	(#2D) 1mm
Werkzeug:	Charge:		Ang. Base	-22°28'14"	Fat.scor.pr. x	.6



Tolerance	Medio	Val.misur [μ m]							Qual	Tolerance	Val.misur [μ m]							Medio	Qual
fH _{am}	±6	0	fz _a 3							±6	fz _a 2							-2	
fH _a	±12	0	2	0	-1	-11	-1	17		±12	-15	-3	9	-3	-2	-1	-1	-2	
F _a		2	2	2	2	6	2	9			15	5	10	5	4	3	4		
ff _a	4	2	2	1	2	3	2	1		4	2	1	2	2	1	1	1		
C _a										1/5	4	3	5	3	3	3	3		
C _a											0	0	0	0	0	0	0		
C _a	-21/-13	-17	-17	-16	-17	-16	-16	-18											
ff _a f		0	0	0	0	0	0	0			0	0	1	0	0	0	0		
P/T-q (mm)		43.000	36	[42.73/43.05]							59.048	37	[58.94/59.2]						



N:Z	14	10	6	1t	1c	1p	Ø	Dente	1p	1c	1t	6	10	14
fH _{em} 30±6	28			fz _S 11				±6			fz _S 12			4
fH _S 30±13	28	22	27	33	45	29	15	±13	-12	3	17	10	6	-2
F _S	4	7	3	4	22	3	12		10	4	13	9	6	3
ff _S	4	1	1	1	1	1	1	4	1	1	1	1	1	1
C _S	2/6	5	5	4	5	4	5	2/6	5	3	4	3	4	4
Bd 30±8	30							30±8						29

Ruota cilindrica Divisione



Nr. prog.: STI0410005 0	P26 601265	Controllore: turno d	Data: 15.12.2016 19:26
Denominazione: Output Shaft 1	Numero denti z	17	Angolo pressione 20°00'00"
Numero disegno: D51.6.1076.35-IF	Modulo m	2.68mm	Angolo elicica -24°00'00"
Commessa/serie nr.: 2 (1)	Untersuchungszweck:	Laufende Messung	
Hasch.Nr.: M001	Spindel: Formtestzdg:	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

Corsa per misura divis.: 50.415 z=17.2mm

fianco sinistro / TIRO

fianco destro

	Val. misur	Qual.	Val. amn	Qual.	Val. misur	Qual.	Val. amn	Qual.
Gr. err. singoli divisione fp max	2		14		2		14	
Gr. salto di passo fu max	2		18		2		18	
Scarto di divisione Rp	4				4			
Err. globale di divisione Fp	7		40		8		40	
Err. cordale di divisione Fps/8	4				5			

Centricità Fr (Ø-sfera = 3.75mm)

⊙ : 2µm

20µm

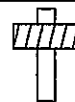
500:1

57

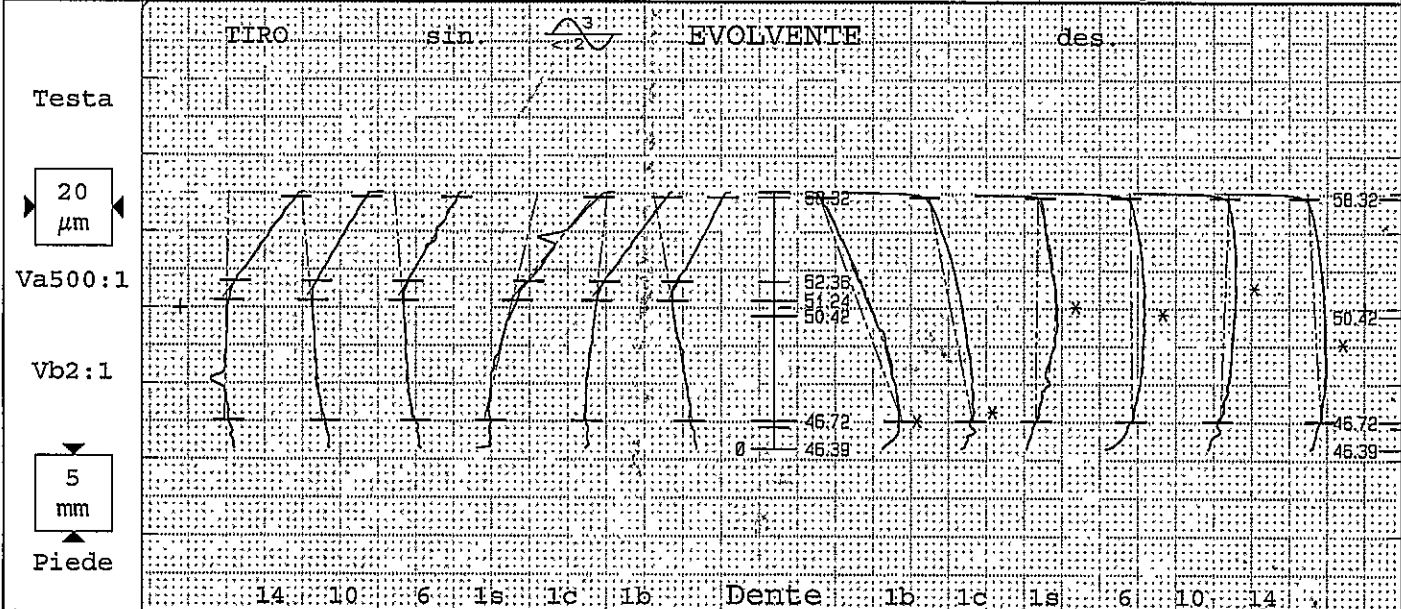
Err. di concentricità Fr	4	32	
Variaz. spessore dente Rs			



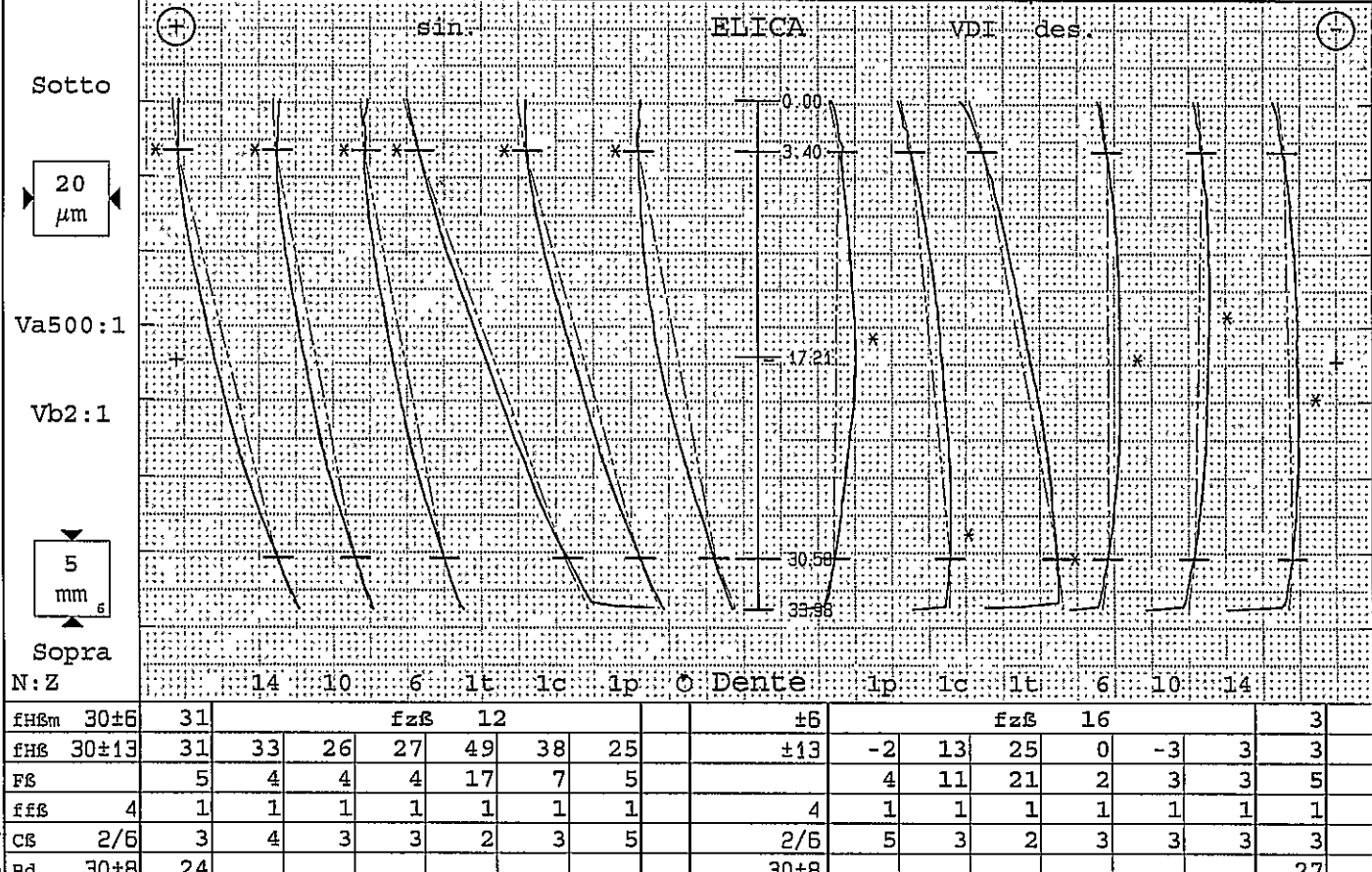
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0410o05 0	P26 B7681	Controllore: TURNO 12-18	Data: 15.01.2017 18:07
Denominazione: Output Shaft 1	Numero denti z 17	Largh.fasc.dent. b 33.98mm	
Numero disegno.: D51.6.1076.35-IF	Modulo m 2.68mm	Tratto evolv. La 7.93/14.7mm	
Commissa/serie nr.: 10 (2)	Angolo pressione 20°00'00"	Tratto elica 1/2 27.18mm	
Masch.Nr.: M001	Spindel: Forme	Angolo elica -24°00'00"	Inizio elab. M1 3.01mm
Untersuchungszweck: Laufende Messung	Ø Base db 46.3299mm	Palpatore Ø (#2C) 1mm	
Werkzeug: Charge:	Ang. Base -22°28'14"	Fat.scor.pr. x .6	

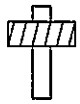


Tolerance	Medio	Val.misur [µm]							Qual	Tolerance	Val.misur [µm]							Medio	Qual
fHm	±6	1	fza 11							±6	fza 14							-4	
fHa	±12	1	-1	5	5	-14	-6	10		±12	-22	-12	1	-1	2	-3	-4		
Fa		4	5	4	3	8	3	5			21	13	5	4	4	5	7		
ffa	4	2	5	1	1	3	1	2		4	2	2	2	2	2	2	2		
Ca										1/5	3	3	5	4	3	3	3		
Ca											0	0	0	0	0	0	0		
Ca	-21/-13	-17	-18	-17	-17	-15	-15	-18											
ffa		0	0	0	0	0	0	1			0	0	0	0	0	0	0		
P/T-φ [mm]		42.957	36	[42.73/43.05]							59.059	37	[58.94/59.2]						



fHm	30±6	31	fzß 12							±6	fzß 16							3	
fHß	30±13	31	33	26	27	49	38	25		±13	-2	13	25	0	-3	3	3		
Fß		5	4	4	4	17	7	5			4	11	21	2	3	3	5		
ffa	4	1	1	1	1	1	1	1		4	1	1	1	1	1	1	1		
Cß	2/6	3	4	3	3	2	3	5		2/6	5	3	2	3	3	3	3		
Pd	70+8	24								70+8	24						27		

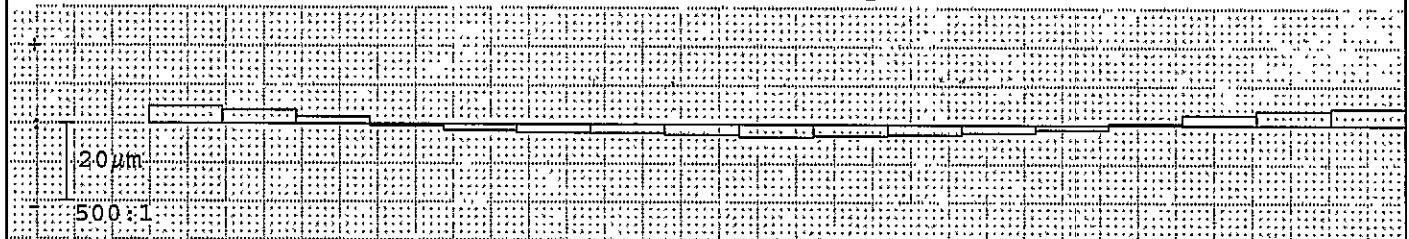
Ruota cilindrica Divisione



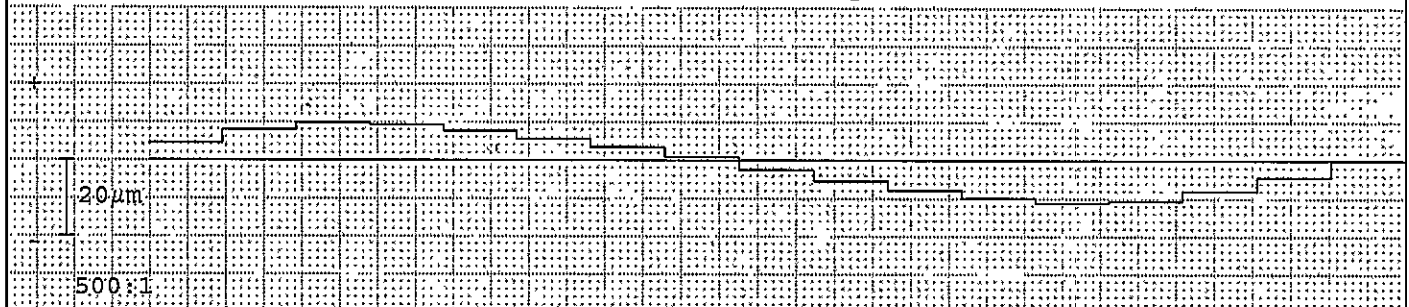
Nr. prog.: STI0410005 0	P26 B7681	Controllore: TURNO 12-18	Data: 15.01.2017 18:07
Denominazione: Output Shaft 1		Numero denti z 17	Angolo pressione 20°00'00"
Numero disegno: D51.6.1076.35-IF		Modulo m 2.68mm	Angolo elica -24°00'00"
Commessa/serie nr.: 10 (2)		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerkzeug:	Charge:	



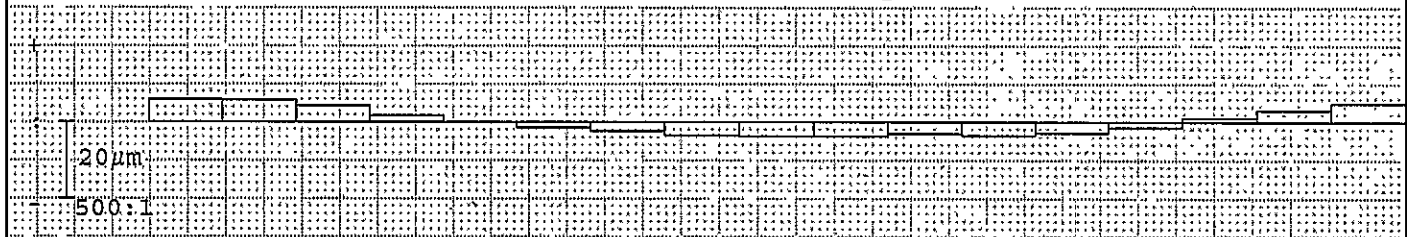
Errori singoli di divisione fp fianco sinistro



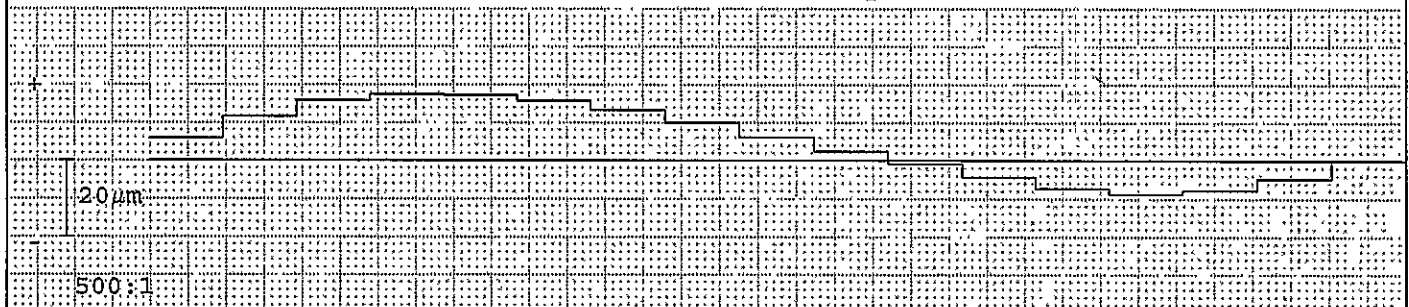
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



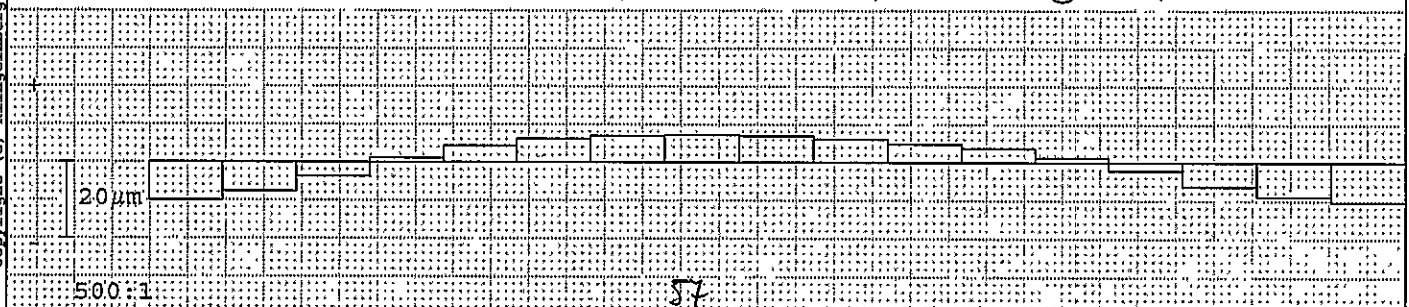
Errore somma di divisione Fp fianco destro



Corsa per misura divis.: 50.415 z=17,2mm		fianco sinistro / TIRO				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	4		14		6		14	
Gr. salto di passo	fu max	2		18		3		18	
Scarto di divisione	Rp	7				10			
Err. globale di divisione	Fp	21		40		26		40	
Err. cordale di divisione	Fpz/8	9				12			

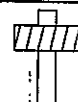
Centricità Fr (Ø-sfera = 3.75mm)

⊙ : 18µm



Err. di concentricità	Fr	18	32
Variaz. spessore dente	Rs		

Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI041005 0	P26 601265	Controllore:	TURNO C	Data:	16.01.2017 10:06
Denominazione:	Output Shaft 1		Numero denti z	17	Largh.fasc.dent. b	33.98mm
Numero disegno:	D51.6.1076.35-IF		Modulo m	2.68mm	Tratto evolv. La	7.93/14.7mm
Commessa/serie nr.:	29 (3)		Angolo pressione	20°00'00"	Tratto elica Ls	27.18mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	-24°00'00"	Inizio elab. Ml	3.01mm
Untersuchungszweck:	Laufende Messung		ø Base db	46.3299mm	Palpatore ø	(#2D) 1mm
Werkzeug:	Charge:		Ang. Base	-22°28'14"	Fat.scor.pr. x	1.6

Testa

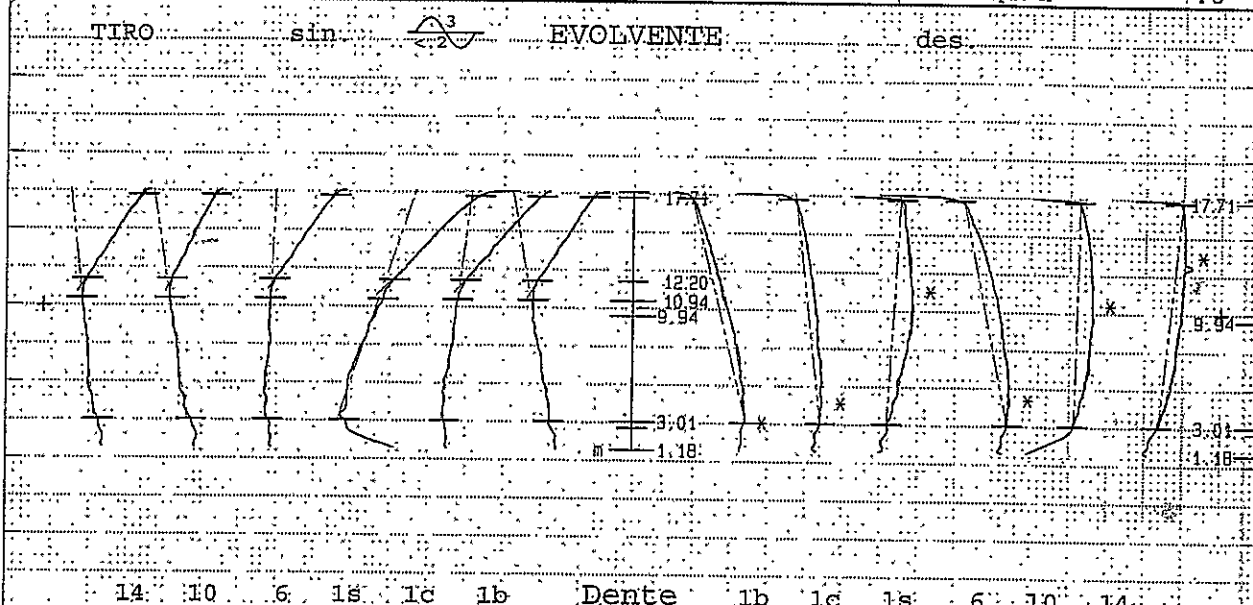
20
μm

Va500:1

Vb2:1

5
mm

Piede



Tolerance	Medio	Val.misur [μm]							Qual	Tolerance	Val.misur [μm]							Medio	Qual
fHm	±6	1	fza 17							±6	fza 18							1	3
fHa	±12	1	6	9	-3	-20	-8	10		±12	-15	-7	3	-12	1	6		1	3
Fa		4	5	6	2	11	4	5			15	8	6	13	4	9		9	
ffa	4	2	2	2	1	3	1	1		4	1	1	1	1	1	3		2	
Ca										1/5	2	2	5	4	4	3		3	
Ca											0	0	0	0	0	0		0	
Ca	-21/-13	-17	-18	-16	-15	-16	-18	-21											
ffa		0	0	0	0	0	0	1			0	0	1	0	0	0		0	
P/T-φ [mm]		42.949	36	[42.73/43.05]							59.042	37	[58.94/59.2]						

Sotto

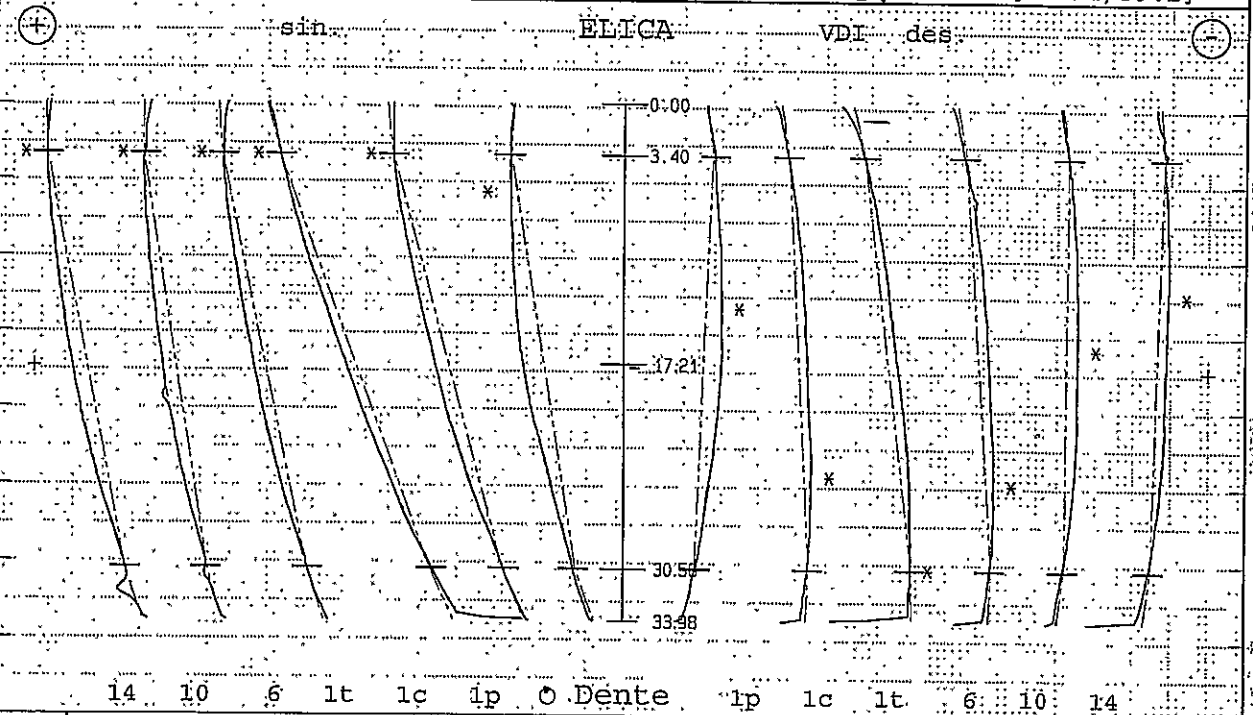
20
μm

Va500:1

Vb2:1

5
mm

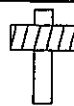
Sopra



FHSm 30±6	28	fzß 15							±6	fzß 12						3
FHS 30±13	28	26	21	28	50	36	22		±13	-6	7	16	8	-1	-4	3
Fß	6	7	9	2	18	6	7			5	5	13	7	2	5	5
fFß 4	1	1	2	1	1	1	1		4	1	1	1	2	1	1	1
Cß 2/6	4	4	4	3	3	4	5		2/6	5	2	3	3	3	3	3



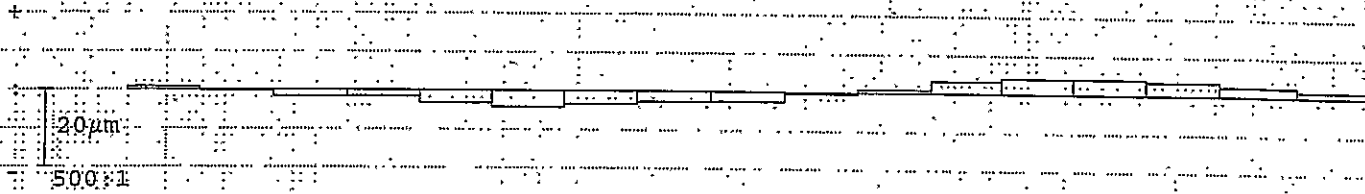
Ruota cilindrica Divisione



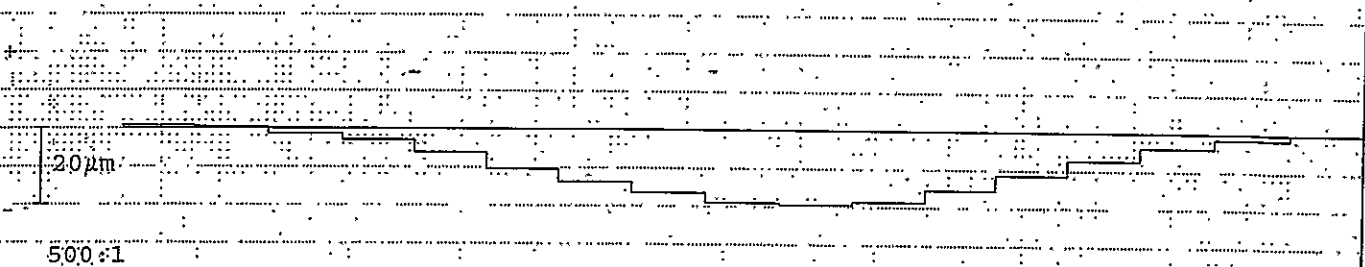
Nr. prog.: STI0410005 0 - P26 601265	Controllatore: TURNO C	Data: 16.01.2017 09:54
Denominazione: Output Shaft 1	Numero denti z: 17	Angolo pressione 20°00'00"
Numero disegno.: D51 6.1076.35-IF	Modulo m: 2.68mm	Angolo elica -24°00'00"
Commessa/serie nr.: 29 (3)	Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM 44	Charge:



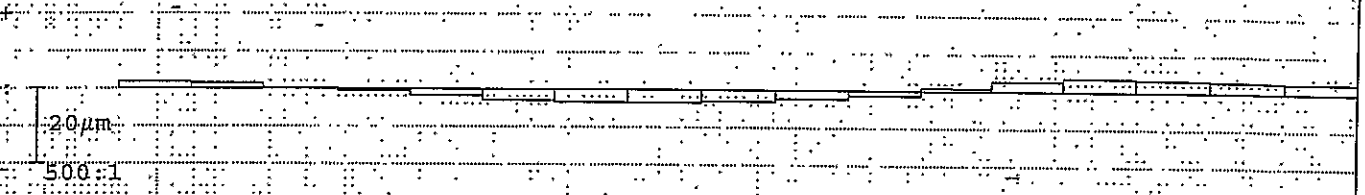
Errori singoli di divisione fp fianco sinistro



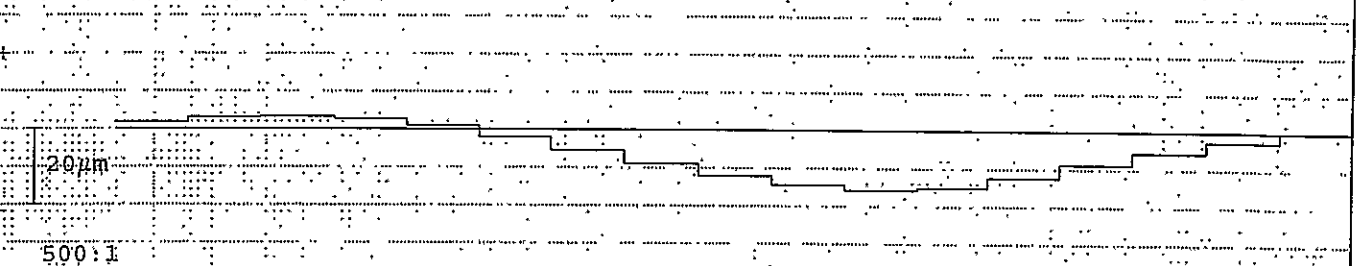
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



Corsa per misura divis.: 50.415 z=17.2mm

	fianco sinistro / TIRO				fianco destro			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	4		14		4		14	
Gr. salto di passo fu max	2		18		2		18	
Scarto di divisione Rp	8				7			
Err. globale di divisione Fp	20		40		19		40	
Err. cordale di divisione Fpz/θ	8				7			

Centricità Fr (Ø-sfera = 3.75mm)

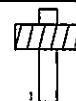
⊙ : 17µm



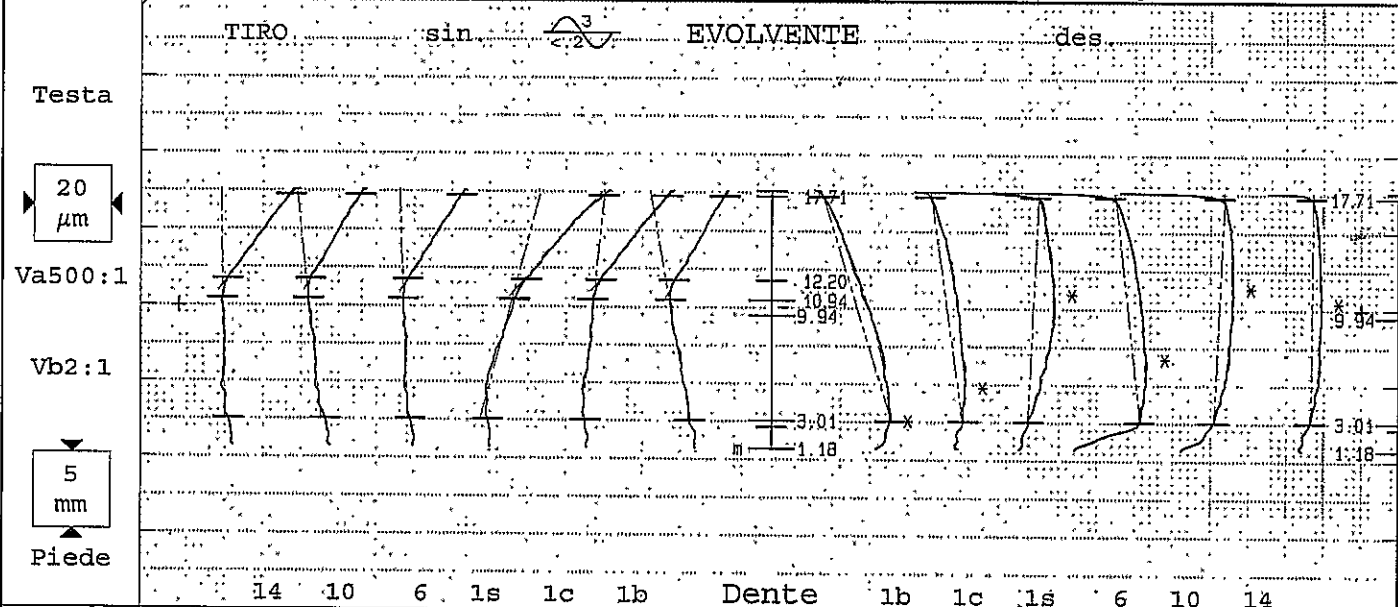
Err. di concentricità Fr	17	32
Variaz. spessore dente Rs		

Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

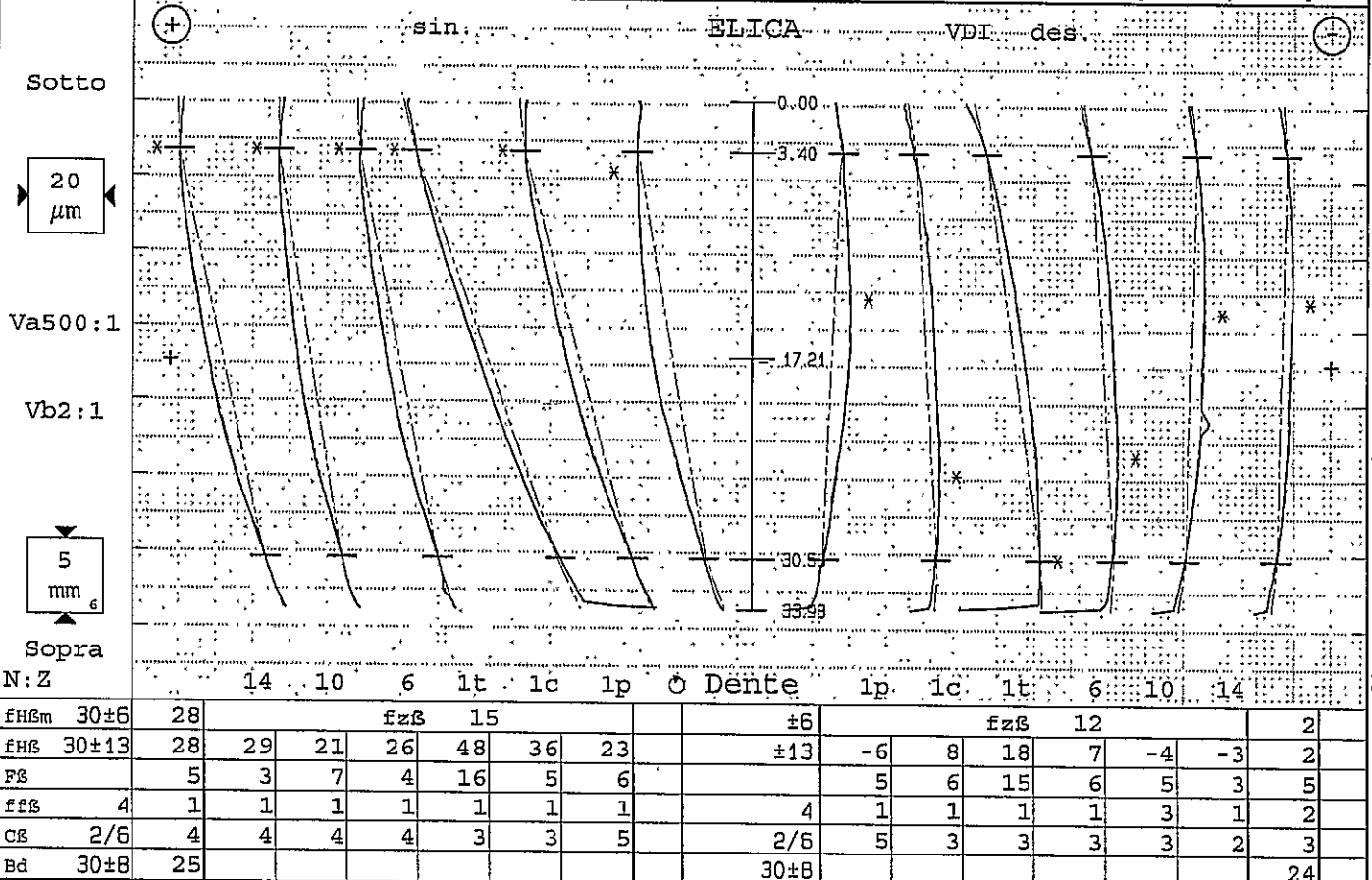
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI041005 0	P26 601265	Controllatore:	TURNO d	Data:	17.01.2017 19:26
Denominazione:	Output Shaft 1		Numero denti z	17	Largh.fasc.dent. b	33.98mm
Numero disegno:	D51.6.1076.35-IF		Modulo m	2.68mm	Tratto evolv. La	7.93/14.7mm
Commessa/serie nr.:	50 (4)		Angolo pressione	20°00'00"	Tratto elica LE	27.18mm
Masch.Nr.:	M001	Spindel: Formm	Angolo elica	-24°00'00"	Inizio elab. M1	3.01mm
Untersuchungszweck:	Laufende Messung		Ø Base db	46.3299mm	Palpatore Ø	(#2D) 1mm
Werkzeug:	Charge:		Ang. Base	-22°28'14"	Fat.scor.pr. x	1.6

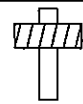


Tolerance	Medio	Val.misur [µm]							Qual	Tolerance	Val.misur [µm]							Medio	Qual
fHm	±6	1	fza 12							±6	fza 11							-3	
fHa	±12	1	1	6	2	-16	-6	10		±12	-18	-8	3	-6	3	1	1	-3	
Fa		3	2	5	2	8	3	5			18	9	6	9	4	2	6		
ffa	4	2	2	2	1	3	1	1		4	1	1	2	2	2	1	2		
Ca										1/5	3	3	5	4	3	2	3		
Ca											0	0	0	0	0	0	0		
Ca -21/-13		-17	-18	-16	-16	-15	-16	-19											
ffa		0	0	0	0	0	0	0			0	0	0	0	0	0	0		
P/T-φ [mm]		42.958	36	[42.73/43.05]							59.076	37	[58.94/59.2]						



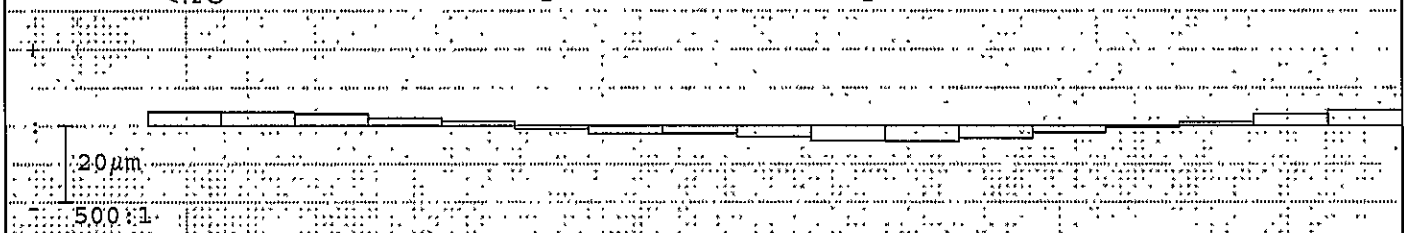
N:Z	14	10	6	1t	1c	1p	Ø Dente	1p	1c	1t	6	10	14
fHm	30±6	28											
fHs	30±13	28	29	21	26	48	36	23					
Fs		5	3	7	4	16	5	6					
ffa	4	1	1	1	1	1	1	1					
CS	2/6	4	4	4	4	3	3	5					
Bd	30±8	25											

Ruota cilindrica Divisione

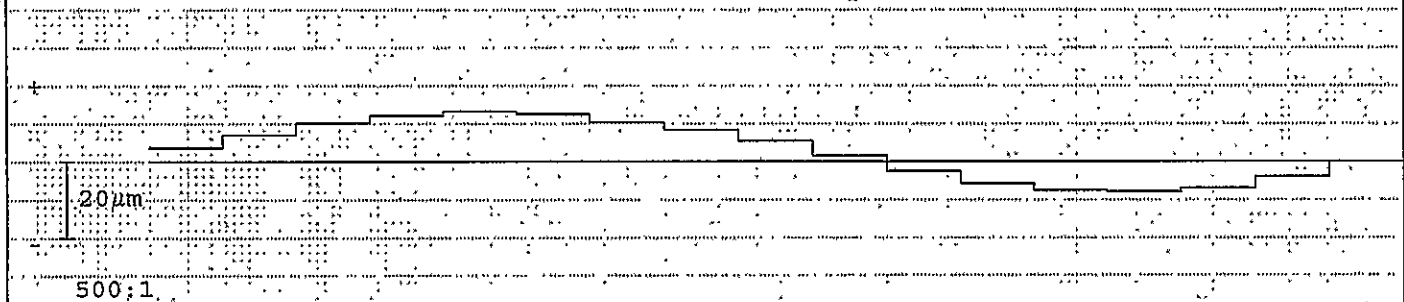


Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 17.01.2017 19:26
Denominazione: Output Shaft 1	Numero denti z 17	Angolo pressione 20°00'00"	
Numero disegno: D51.6.1076.35-IF	Modulo m 2.68mm	Angolo elicica -24°00'00"	
Commissa/serie nr.: 50 (4)	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: Form	Charge:	

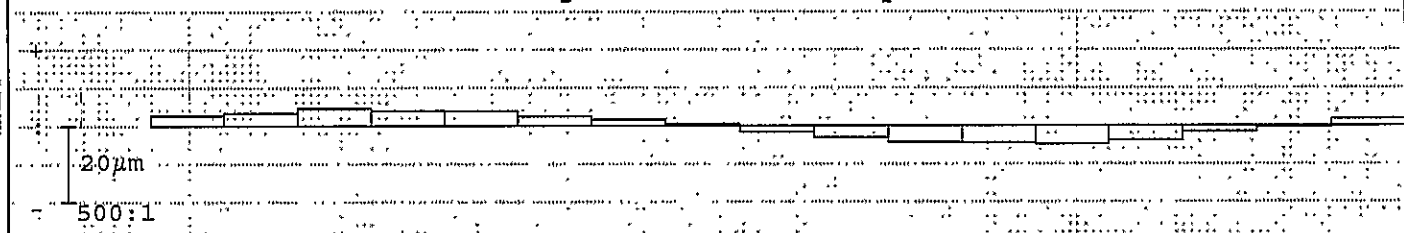
Errori singoli di divisione fp fianco sinistro



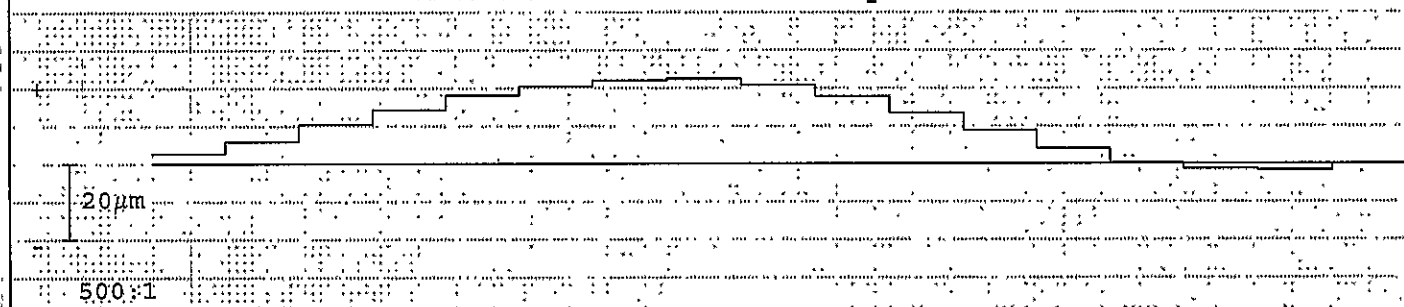
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro

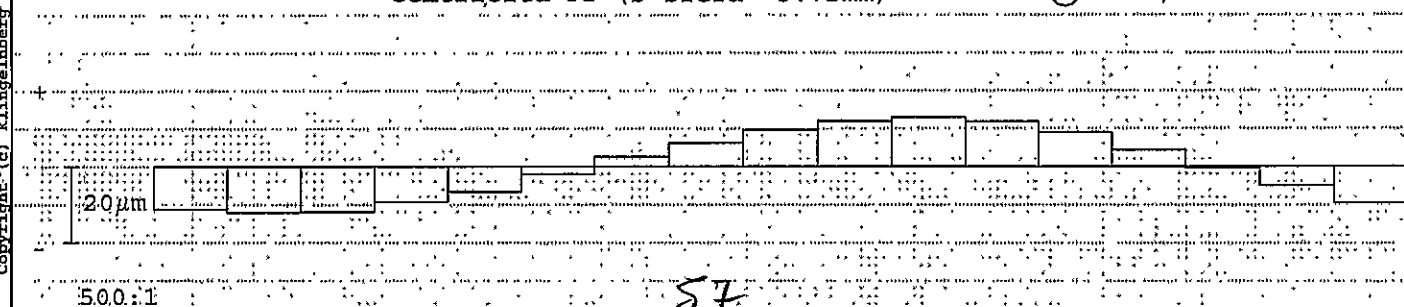


Corsa per misura divis.: 50.415 z=17.2mm

	fianco sinistro / TIRO				fianco destro			
	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		2		18	
Scarto di divisione Rp	8				10			
Err. globale di divisione Fp	21		40		24		40	
Err. cordale di divisione Fpz/8	8				9			

Centricità Fr (Ø-sfera = 3.75mm)

⊙ : 25µm

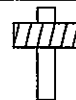


Err. di concentricità Fr	25	32
Variaz. spessore dente Rs		

Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria



Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	17.01.2017 19:32
Denominazione:	Output Shaft 1		Numero denti z	17	Largh.fasc.dent. b	33.98mm
Numero disegno.:	D51.6 1076.35-IF		Modulo m	2.68mm	Tratto evolvent. La	7.93/14.7mm
Commissa/serie nr.:	52 (5)		Angolo pressione	20°00'00"	Tratto elica Ls	27.18mm
Masch.Nr.:	M001	Spindel: FORMULA	Angolo elica	-24°00'00"	Inizio elab. M1	3.01mm
Untersuchungszweck:	Laufende Messung		Ø Base db	46.3299mm	Palpatore Ø	(#2D) 1mm
Werkzeug:	Charge:		Ang. Base	-22°28'14"	Val.scor.pr. x	.6

Testa

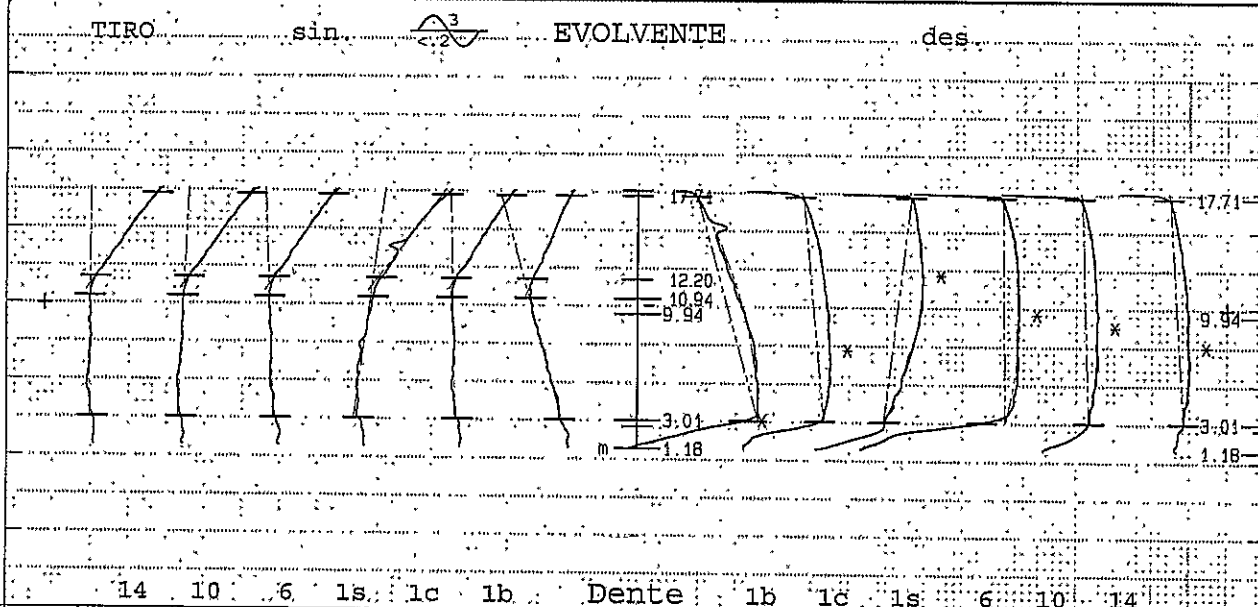
20
µm

Va500:1

Vb2:1

5
mm

Piede



Tolerance	Medio	Val.misur [µm]							Qual	Tolerance	Val.misur [µm]							Medio	Qual
fHm ±6	0	fza 5								±6	fza 5							-3	
fHa ±12	0	0	-3	2	-8	1	16			±12	-16	-6	7	-1	-2	-4	-3		
Fa	2	2	2	2	4	2	8				16	8	9	9	4	5	7		
ffa	4	1	2	1	2	1	1			4	7	2	1	7	1	1	3		
Ca										1/5	4	4	6	4	3	3	4		
Ca											0	0	0	0	0	0	0		
Ca -21/-13	-17	-17	-16	-18	-15	-15	-18												
ffa	0	0	0	0	0	0	1				0	0	1	0	0	0	0		
P/T-φ [mm]	42.947	36	[42.73/43.05]								59.067	37	[58.94/59.2]						

Sotto

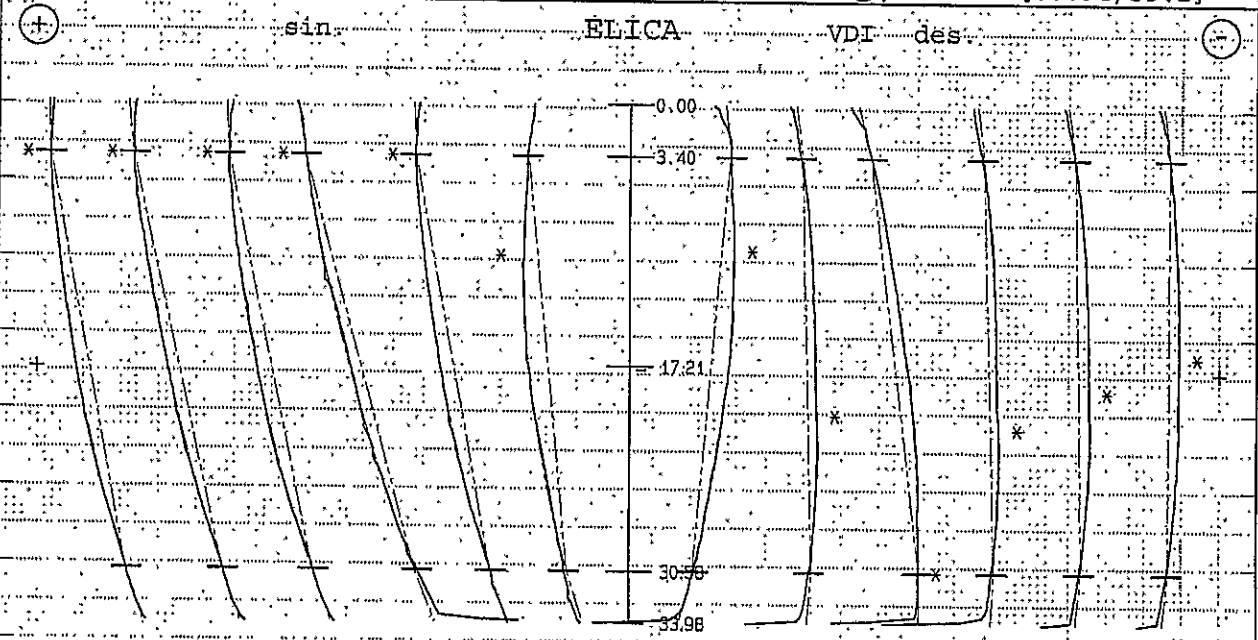
20
µm

Va500:1

Vb2:1

5
mm

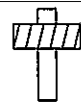
Sopra



Sopra																	
N:Z		14	10	6	1t	1c	1p	Ø Dente	1p	1c	1t	6	10	14			
fHsm	30±6	27	fzß 5							±6	fzß 5				2		
FHß	30±13	27	25	30	28	36	25	13		±13	-12	3	16	4	2	-1	2
Fß		4	4	2	3	6	5	15			10	3	13	3	3	1	3
ffß	4	1	1	1	1	2	1	1		4	1	1	1	1	1	1	1
Cß	2/6	4	4	3	4	3	4	5		2/6	5	3	3	2	3	3	3
Bd	30±8	23								30±8					28		



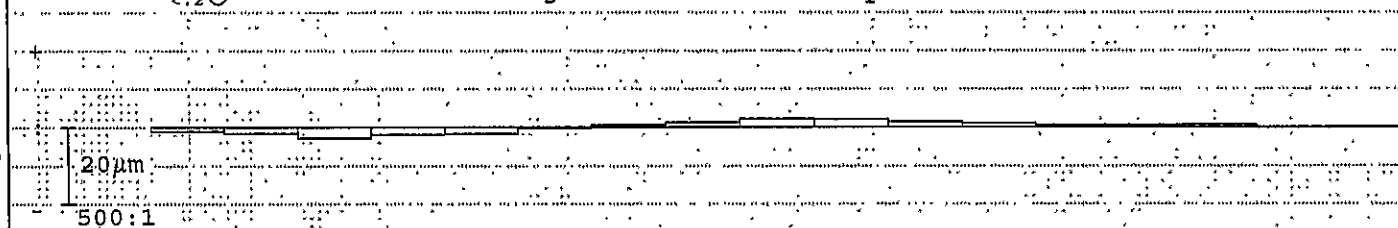
Ruota cilindrica Divisione



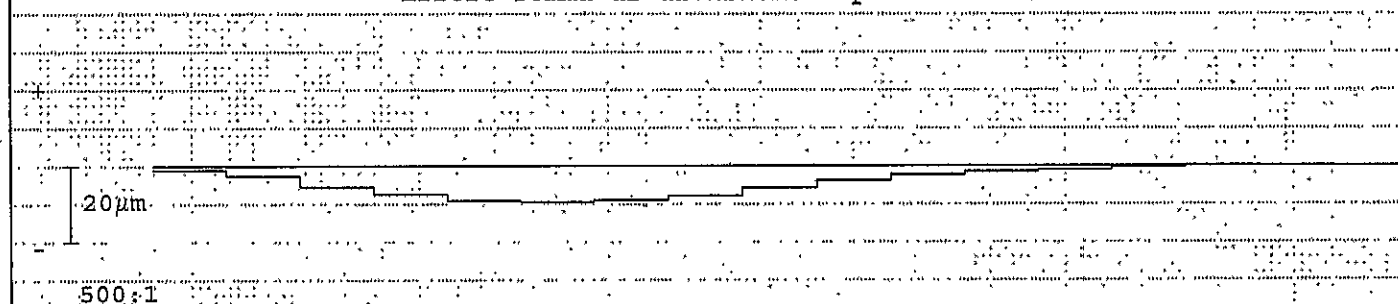
Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	17.01.2017 19:32
Denominazione:	Output Shaft 1		Numero denti z	17	Angolo pressione	20°00'00"
Numero disegno:	D51.6.1076.35-IF		Modulo m	2.68mm	Angolo elica	-24°00'00"
Comessa/serie nr.:	52 (5)		Untersuchungszweck:	Laufende Messung		
Masch.Nr.:	M001	Spindel: Formel	Art.Nr.:		Charge:	

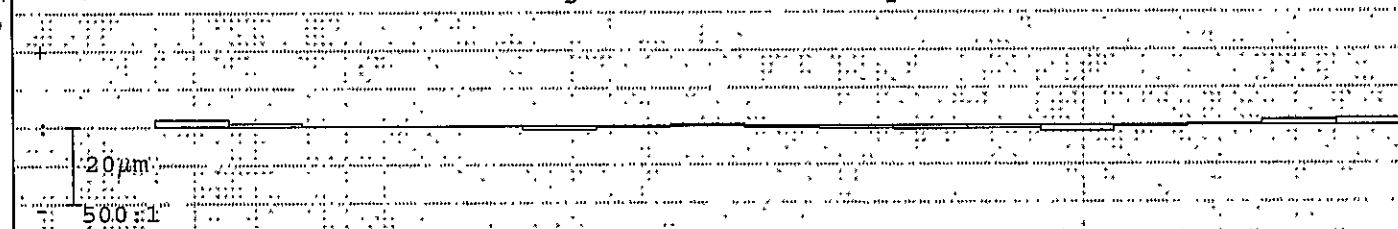
Errori singoli di divisione fp fianco sinistro



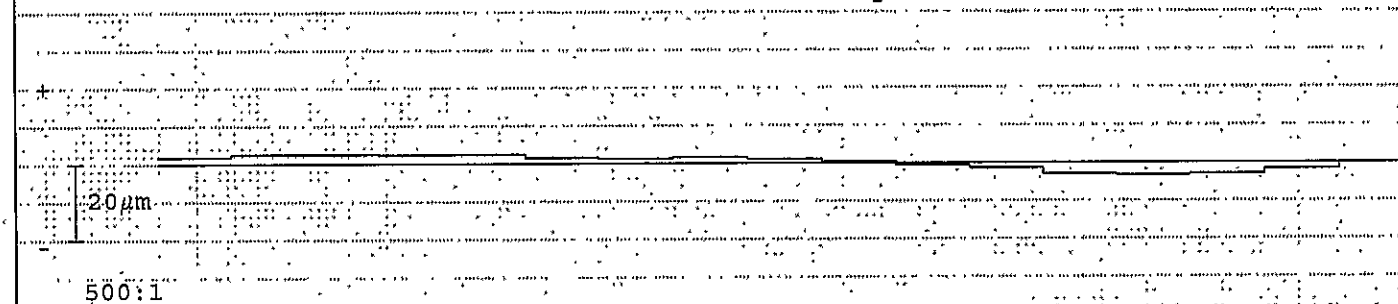
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro

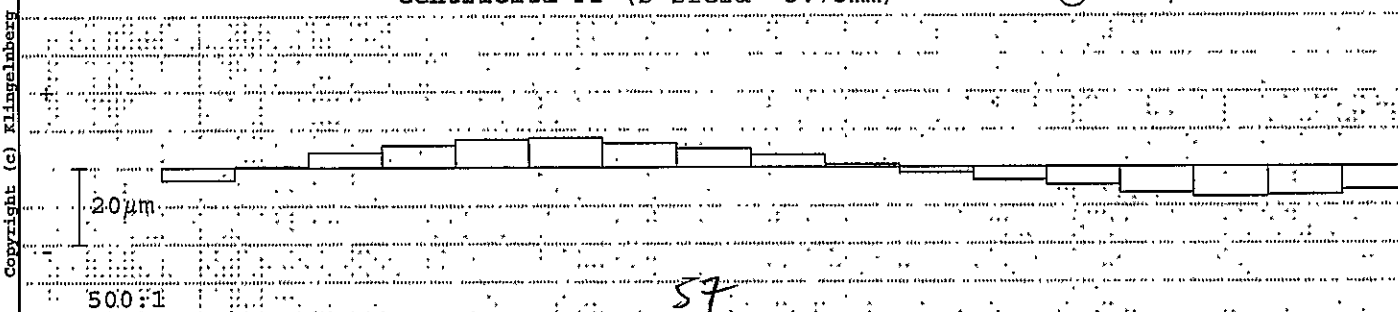


Corsa per misura divis.: 50.415 z=17.2mm

		fianco sinistro / TIRO				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	3		14		2		14	
Gr. salto di passo	fu max	1		18		1		18	
Scarto di divisione	Rp	5				4			
Err. globale di divisione	Fp	10		40		6		40	
Err. cordale di divisione	Fpz/8	5				4			

Centricità Fr (Ø-sfera = 3.75mm)

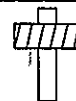
⊙ : 15µm



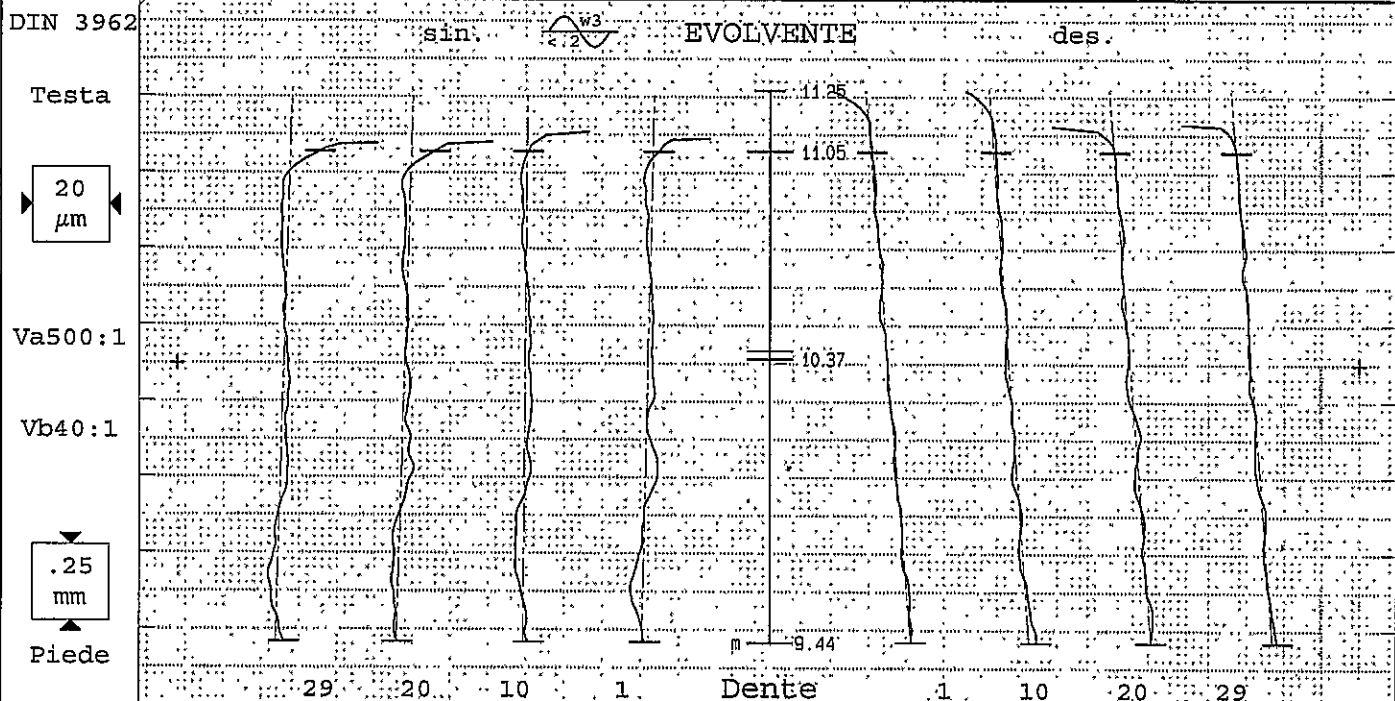
Err. di concentricità	Fr	16	32
Variaz. spessore dente	Rs		



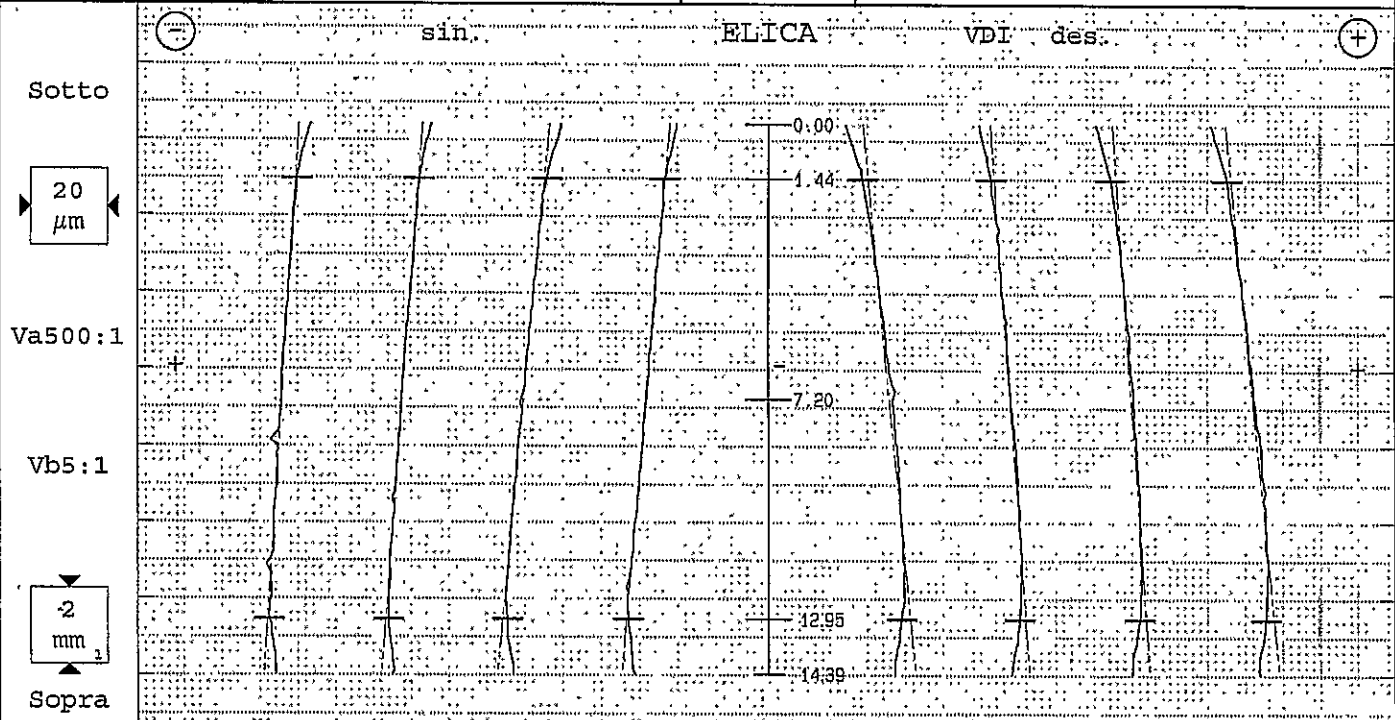
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:49
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno:	D51.6.1076.RIIIa H		Modulo m	1mm	Tratto evol. La	1.61mm
Commessa/serie nr.:	2 (A)		Angolo pressione	30°00'00"	Tratto elica Ls	11.51mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45

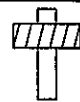


Tolerance	Medio	Val.misur [μm]				Qual	Tolerance	Val.misur [μm]				Medio	Qual
fHm ±14	-3	fza 3				4	±14 9	fza 1				-10	8
fHa ±14	-3	-4	-4	-1	-3	5	±14 9	-11	-10	-10	-10	-10	9
Fa 22	10	14	12	5	7	8	22 9	11	11	10	11	11	7
ffa 16	8	11	9	4	7	8	16 9	2	4	3	2	3	5
ffaef	0	0	0	0	0			0	2	0	1	0	
P/T-φ [mm]	37.391	26 [37.21/37.8]											



N:Z			29		20		10		1	Ø Dente	1		10		20		29
fHsm	±25	R 12	fzß 5						8	±25 9		fzß 4				L 12	8
fHs	±25	R 12	R 9	R 11	R 14	R 13	8	±25 9		L 14	L 10	L 10	L 14	L 12	8		
Fß	13	9	8	8	11	10	7	13 7		11	8	8	11	10	7		
ffß	14	2	3	2	2	1	3	14 9		4	2	2	3	3	5		

Ruota cilindrica Divisione

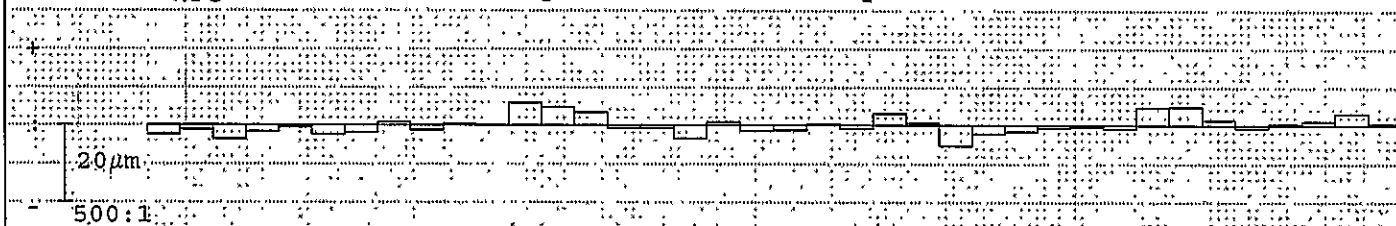


Nr. prog.: STI0410005 0 P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:49
Denominazione: Output Shaft 1	Numero denti z 38	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIIIa H	Modulo m 1mm	Angolo elicica 00°00'00"
Commessa/serie nr.: 2	Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMER	Charge:

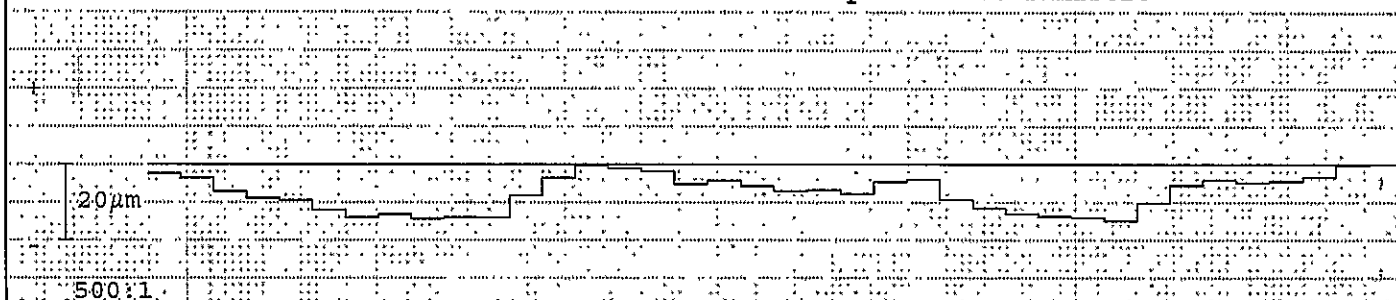
DIN 3962



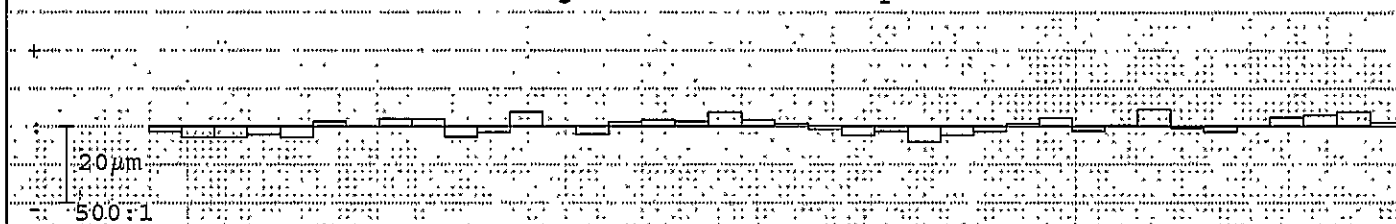
Errori singoli di divisione fp fianco sinistro



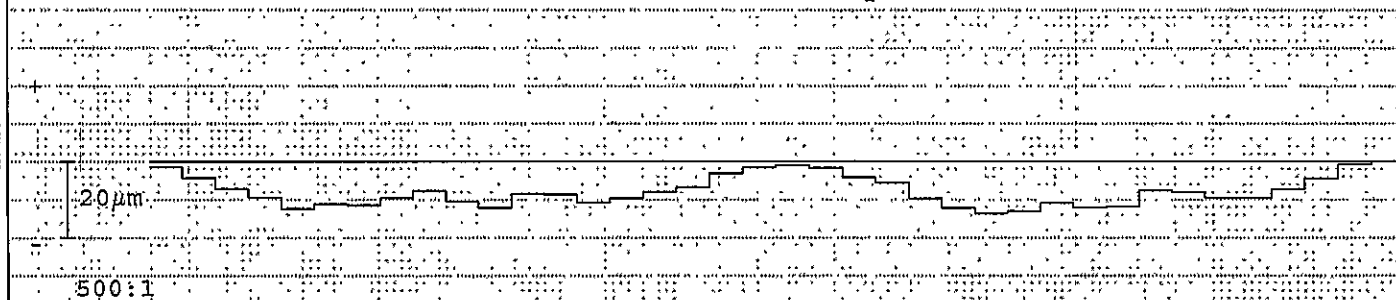
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



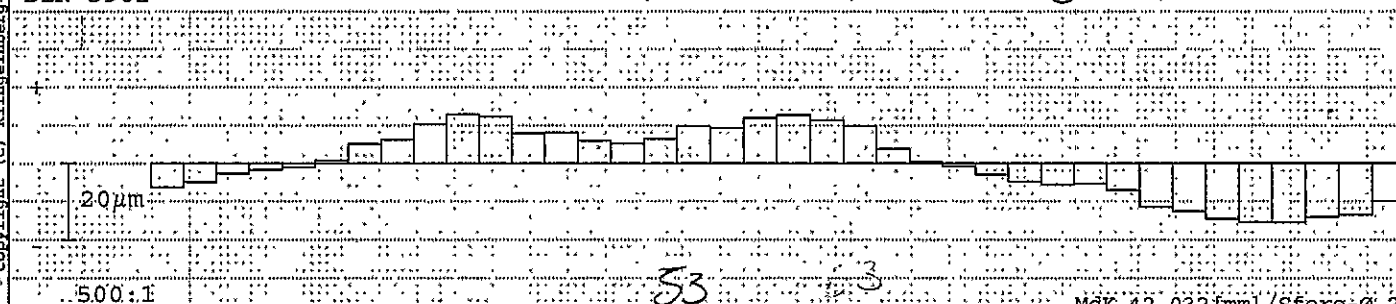
Corsa per misura divis.: 38.928 z=7.2mm

		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	6	6	18	9	4	5	18	9
Gr. salto di passo	fu max	6	5			5	5		
Scarto di divisione	Rp	11				8			
Err. globale di divisione	Fp-e	15	6	50	9	14	5	50	9
Err. cordale di divisione	Fpz/8	14	7			12	7		

DIN 3962

Centricità Fr (Ø-sfera =2mm)

⊙ : 24µm



Err. di concentricità	Fr	28	8	56	10	Val. amm	42.148	42.088	
Variaz. spessore dente	Rs					Val.	42.115	42.122	42.105

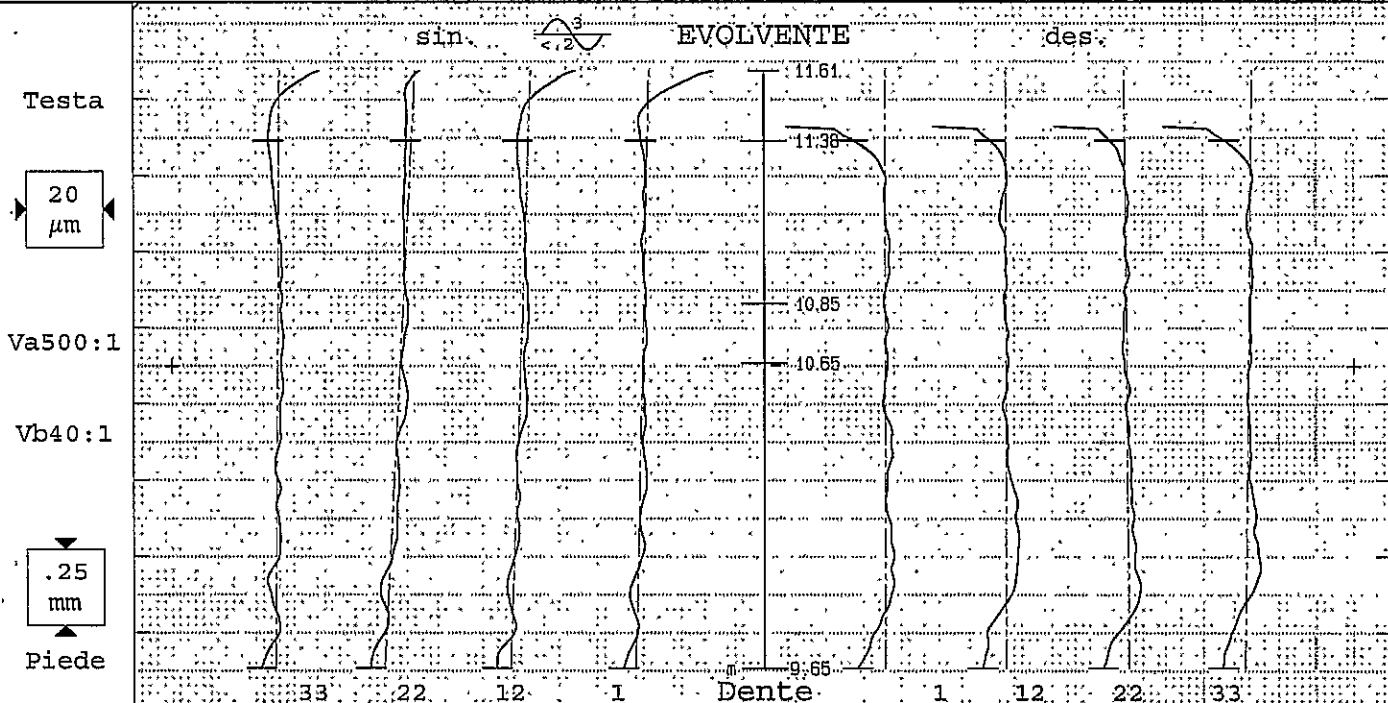
Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria



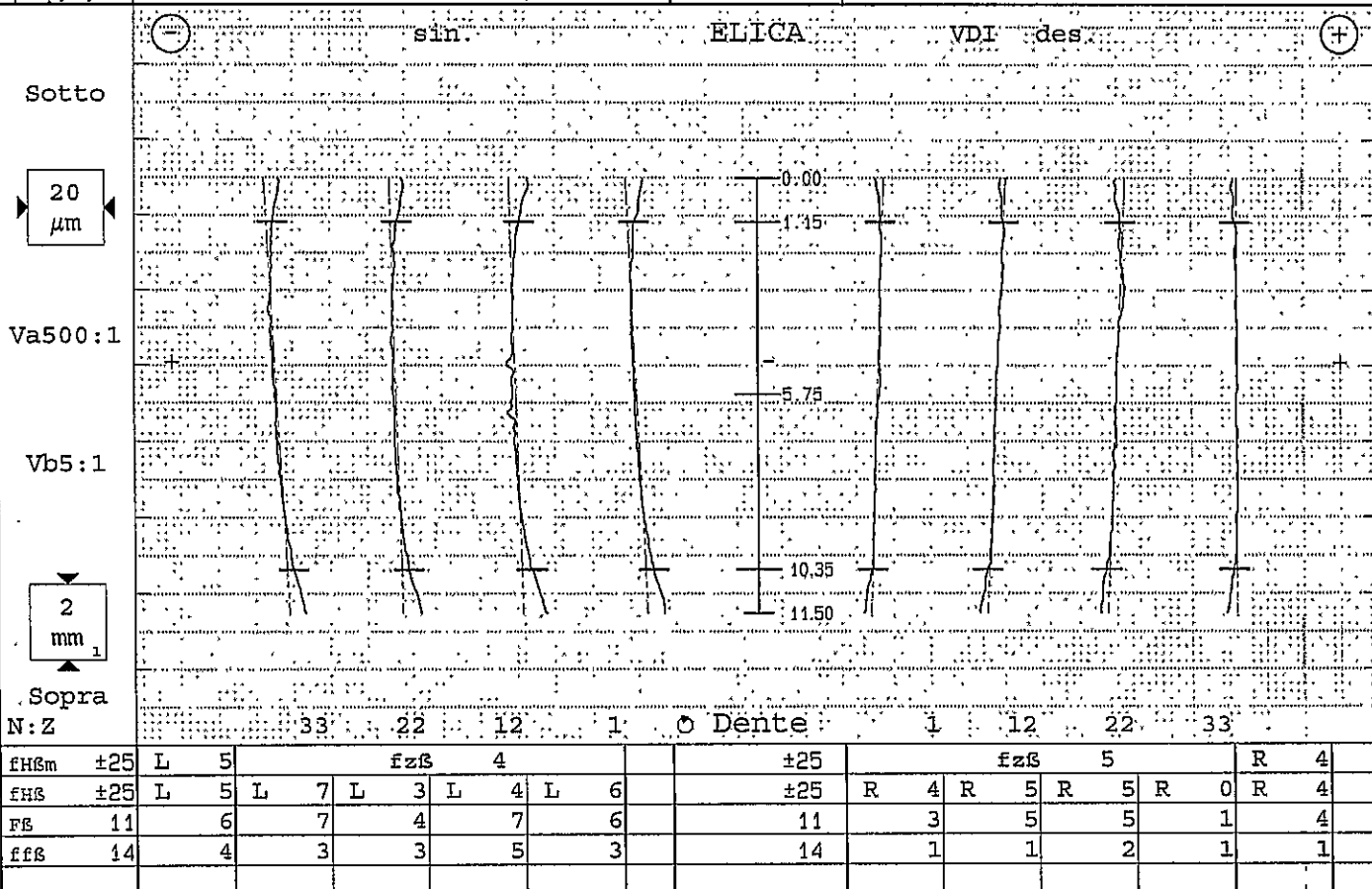
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI041005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:45
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa H		Modulo m	1mm	Tratto evolv. La	1.73mm
Commessa/serie nr.:	2		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: Formulasidelic	Angolo elic	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	-:05

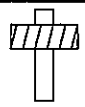


Tolerance	Medio	Val.misur [μ m]				Qual	Tolerance	Val.misur [μ m]				Medio	Qual
FHcm	± 14	-4	fza 6				± 14	fza 3				0	
FHa	± 14	-4	-1	-7	-5	-3	± 14	0	0	-1	2	0	
Fa	21	8	6	10	9	6	21	11	10	10	10	10	
ffa	16	6	5	6	6	5	16	11	10	10	11	11	
ffa	0	0	4	4	3	3	0	0	0	0	0	0	
P/T- ϕ [mm]	41.327	21	[41.21/41.8]										

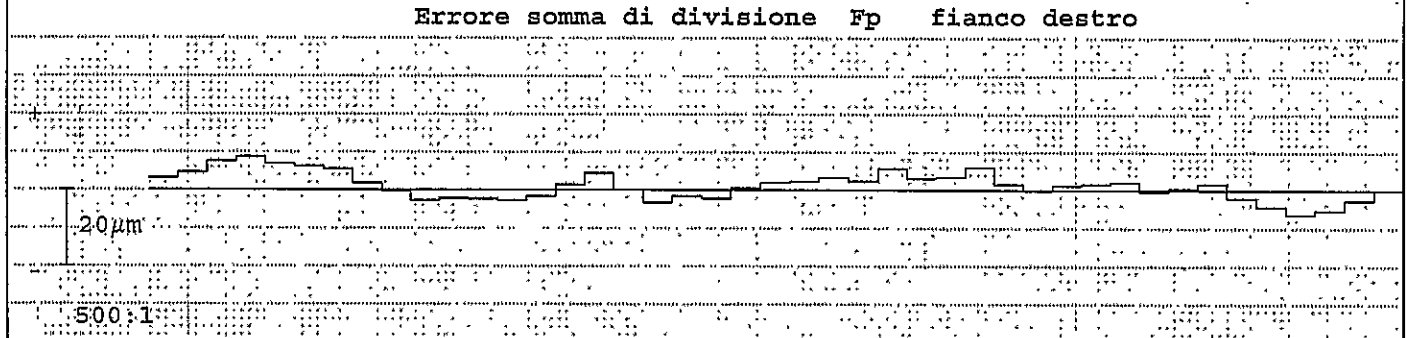
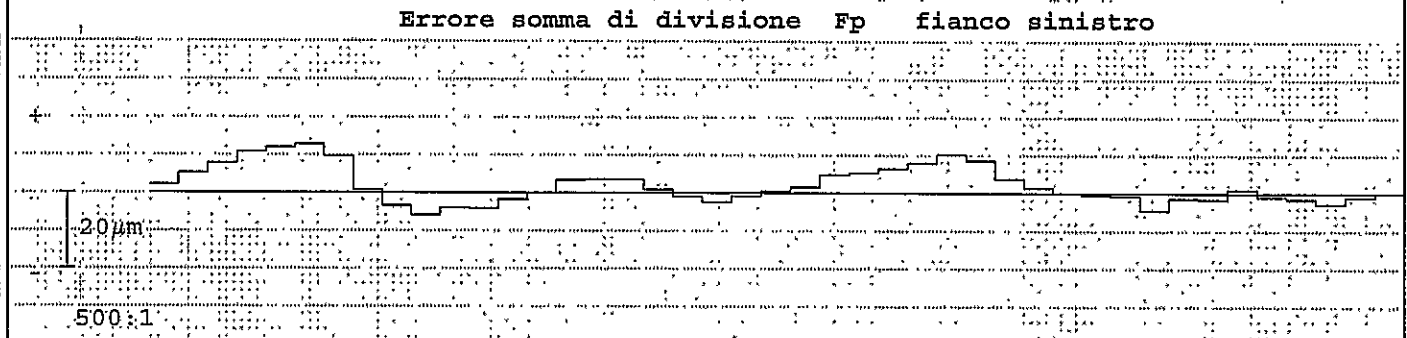


FHSm	±25	L	5	fzß 4					±25	fzß 5				R	4								
FHß	±25	L	5	L	7	L	3	L	4	L	6		±25	R	4	R	5	R	5	R	0	R	4
Fß	11		6		7		4		7		6		11		3		5		5		1		4
ffß	14		4		3		3		5		3		14		1		1		2		1		1

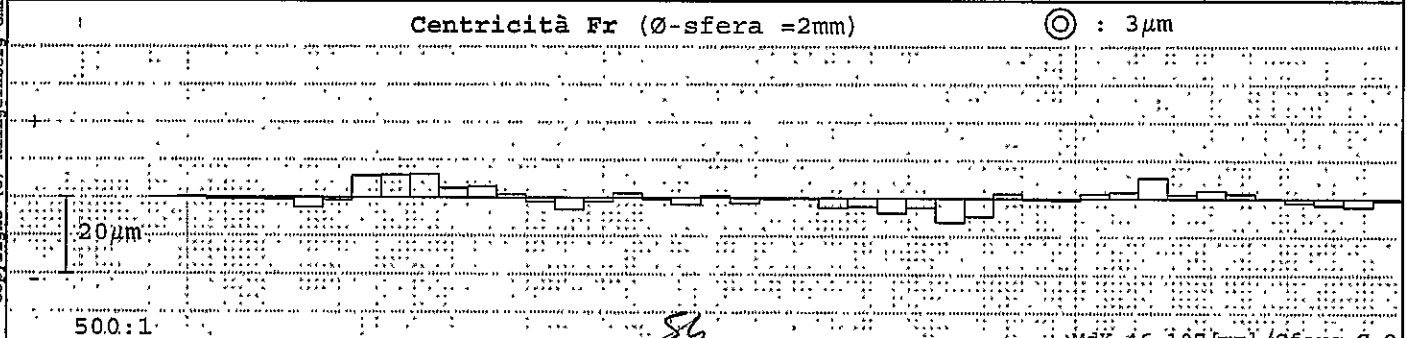
Ruota cilindrica Divisione



Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:45
Denominazione: Output Shaft 1	Numero denti z 43	Angolo pressione 30°00'00"	
Numero disegno: D51.6.1076.RIIa H	Modulo m 1mm	Angolo elica 00°00'00"	
Commessa/serie nr.: 2	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: FORMER	Charge:	



Corso per misura divis. 43.096 z=5.8mm		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	9		17		4		17	
Gr. salto di passo	fu max	7				7			
Scarto di divisione	Rp	12				7			
Err. globale di divisione	Fp-e	19		40		15		40	
Err. cordale di divisione	Fpz/8	18				13			



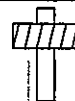
Err. di concentricità	Fr	13	50	Val. amm	46.231	46.167
Variaz. spessore dente	Rs			Val.	46.188	46.197
					46.178	

Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria

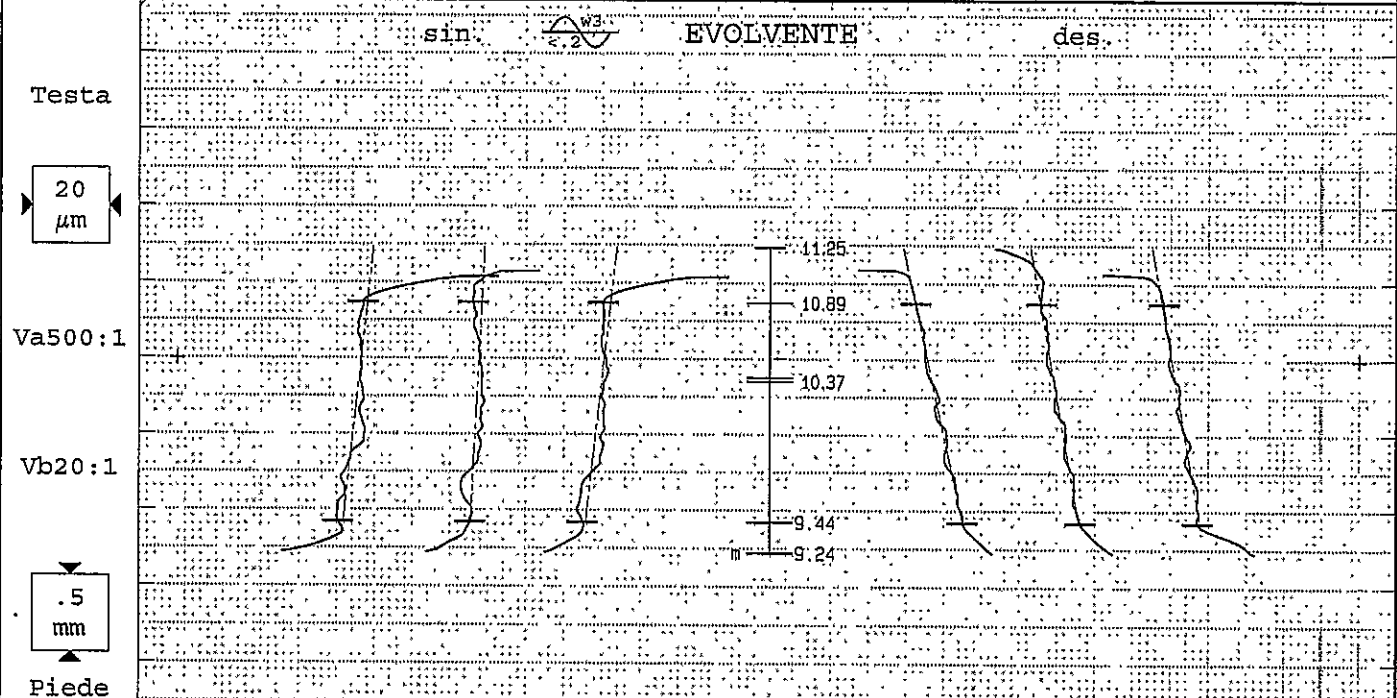


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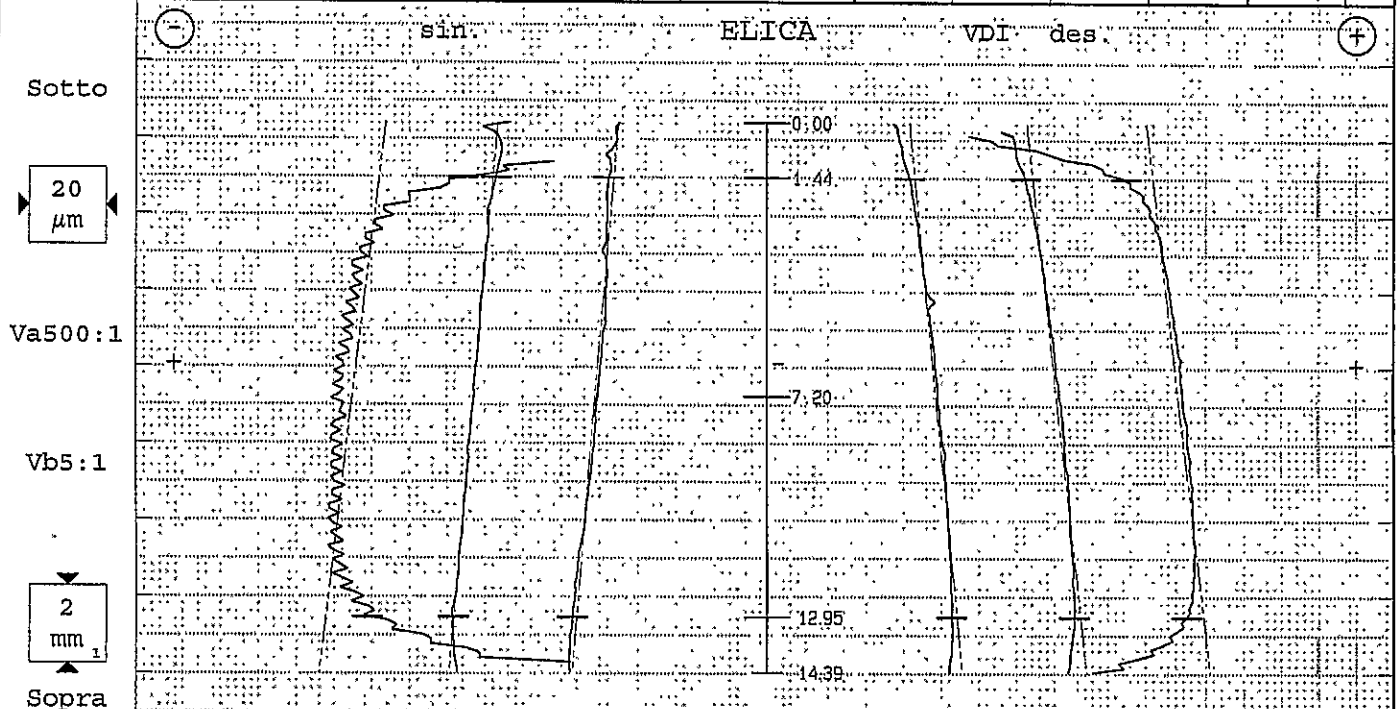
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:53
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51.6.1076.RIIIaSH		Modulo m	1mm	Tratto evol. La	1.45mm
Commessa/serie nr.:	2		Angolo pressione	30°00'00"	Tratto elica L3	11.51mm
Masch.Nr.:	M001	Spindel: FORM 2	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E) .5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	.45



Tolerance	Medio	Val.misur [μ m]	Qual	Tolerance	Medio	Qual
fHm ± 14	-5	fza 3		± 14	-11	
fHa ± 14	-5	-6 -3 -6		± 14	-11	
Fa 22	7	7 6 8		22	11	
ffa 16	5	5 5 5		16	2	
ffaef	0	15 11 10		6 8 13	0	

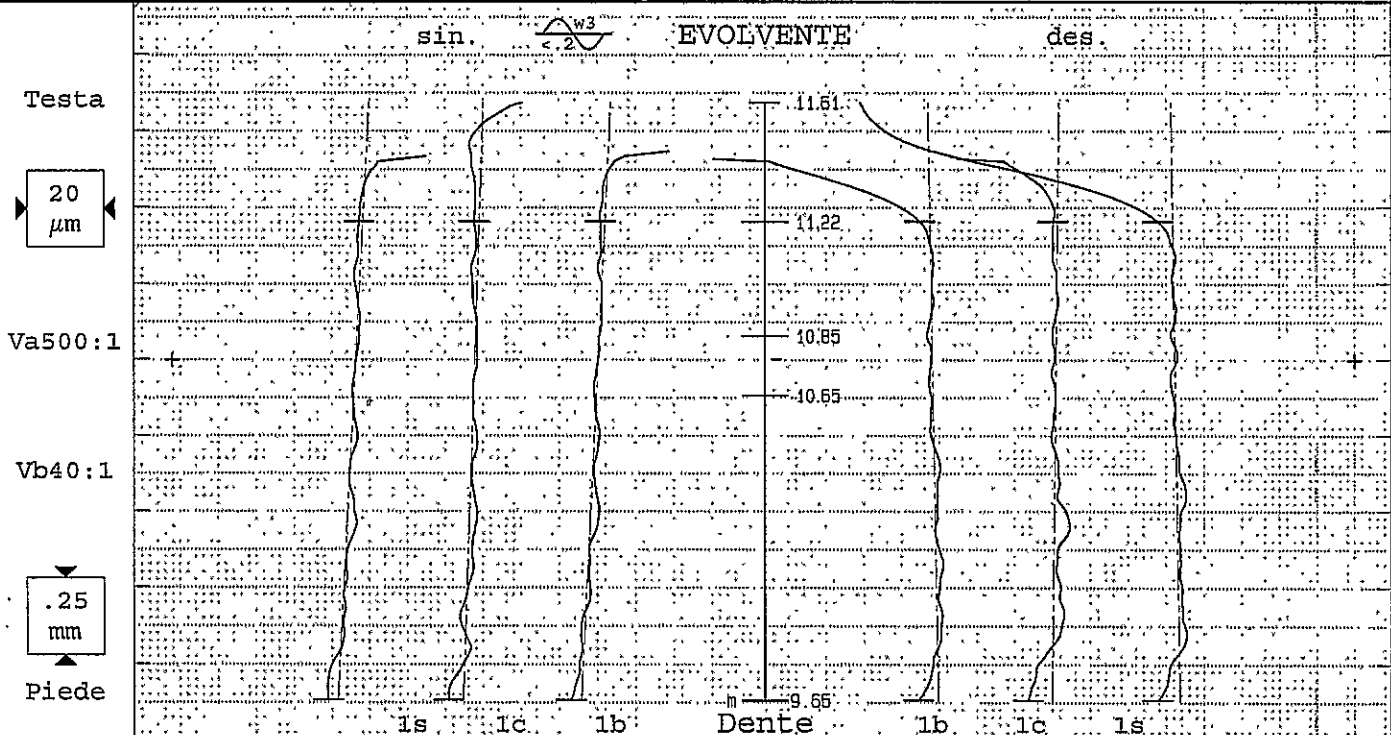


N:Z	lt	lc	lp	Ø Dente	lp	lc	lt
fHsm ± 25	R 14	fzß 6		± 25	L 14	L 16	L 16
fHs ± 25	R 14	R 18 R 13 R 12		± 25	L 14 L 16 L 17		L 16
Fß 13	19	36 12 10		13	11 13 18		14
ffß 14	11	28 2 3		14	4 3 9		5
Bd	6						3

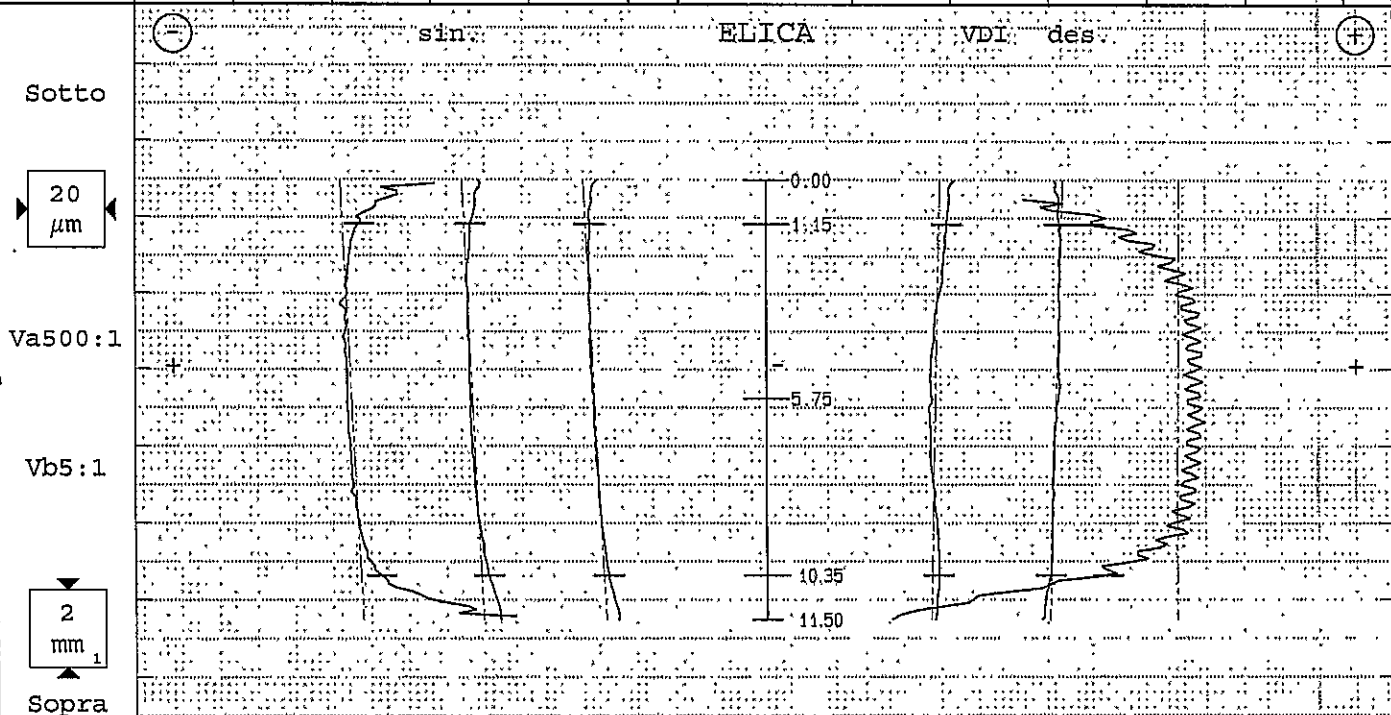
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:52
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa SH		Modulo m	1mm	Tratto evol. La	1.57mm
Commissa/serie nr.:	2		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	- .05



Tolerance	Medio	Val.misur [μ m]	Qual	Tolerance	Medio	Qual
fHgm	± 14	-6		fza	3	
fHa	± 14	-6		fza	3	
Fa	21	8		fza	3	
ffa	16	6		fza	3	
ffa	0	0		fza	3	

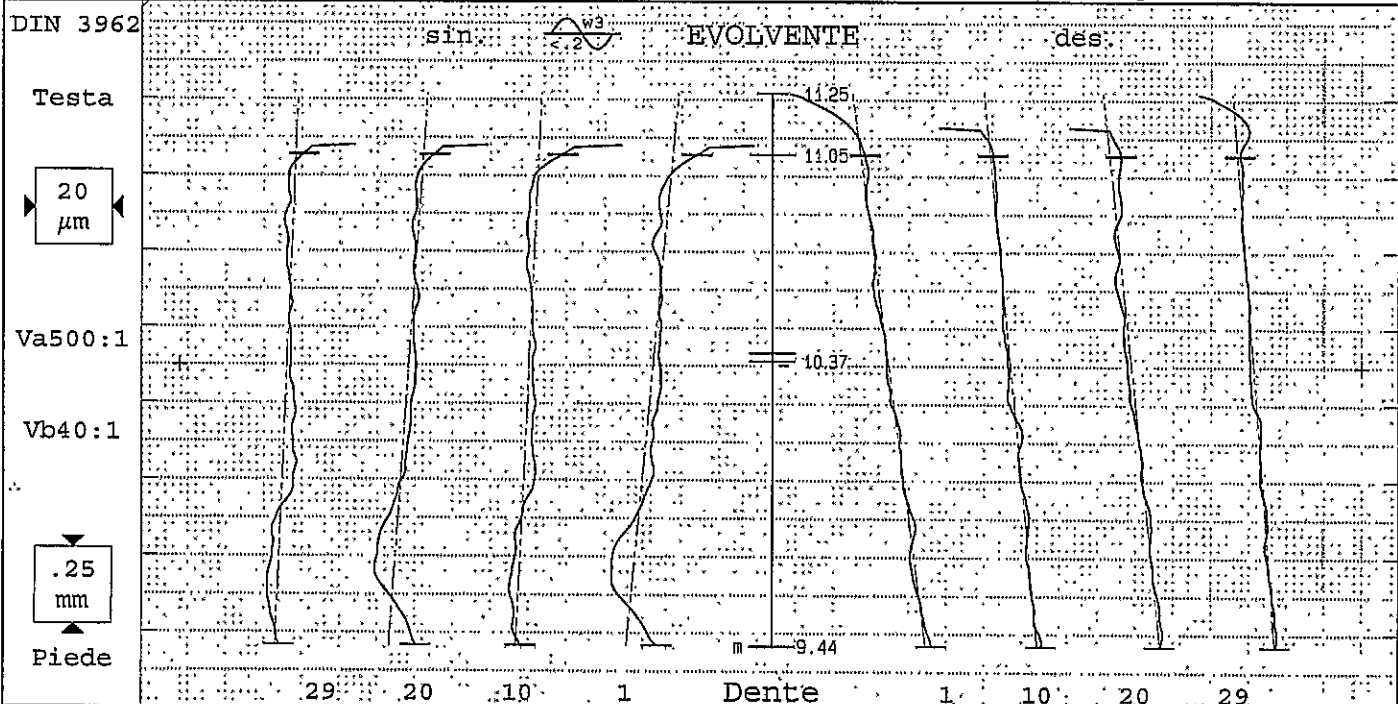


N:Z	lt	lc	lp	Ø Dente	lp	lc	lt
fHgm	± 25	L	6	Bd	0	fzß	1
fHß	± 25	L	6	L	5	L	6
Fß	11	7	11	6	5		
ffß	14	4	7	3	2		

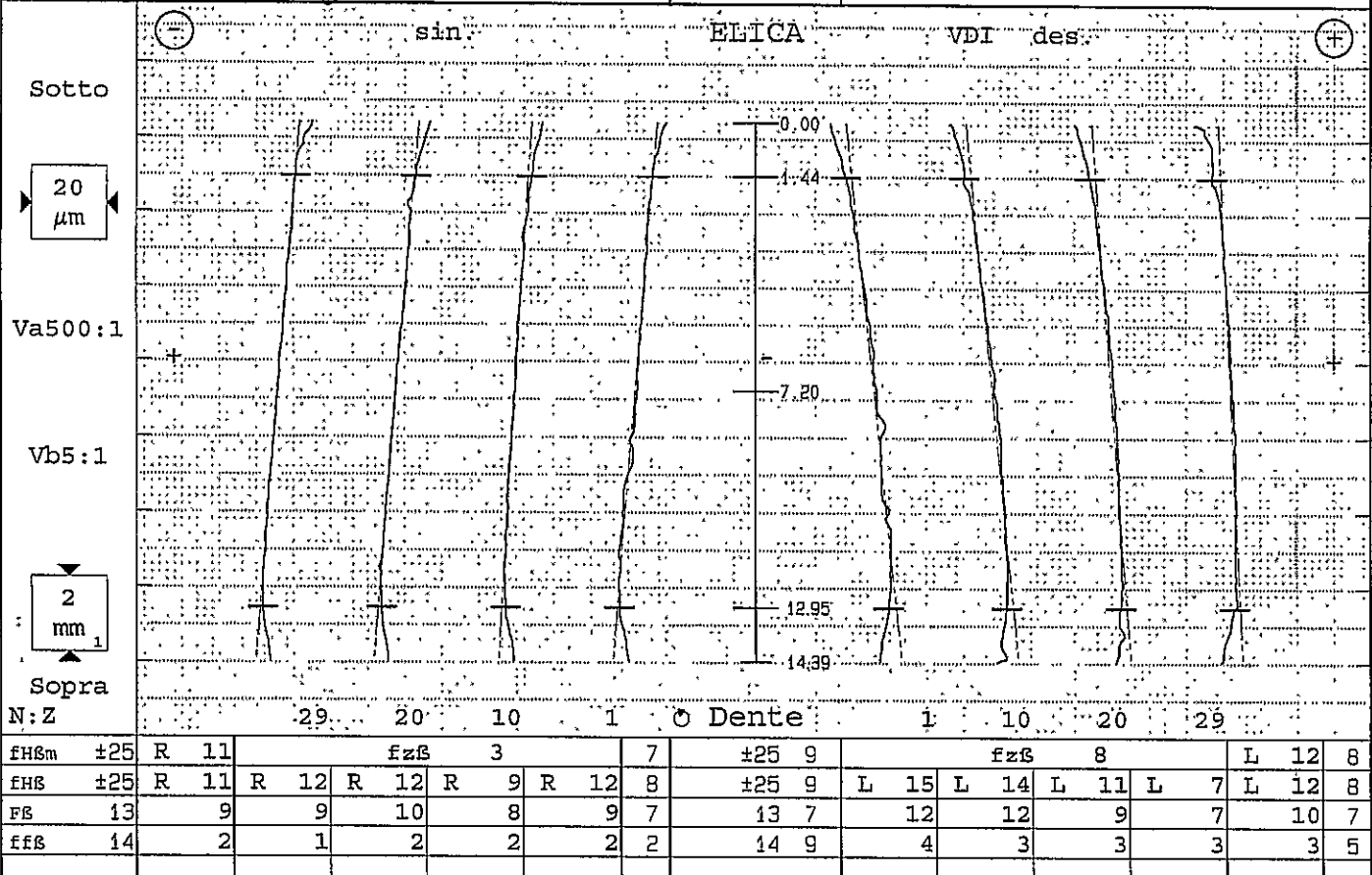
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:59
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51.6.1076.RIIIIa H		Modulo m	1mm	Tratto evolv. La	1.61mm
Commessa/serie nr.:	10 (2)		Angolo pressione	30°00'00"	Tratto elica Ls	11.51mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45

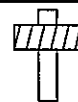


Tolerance	Medio	Val.misur [µm]					Qual	Tolerance	Val.misur [µm]					Medio	Qual
fHm	±14	-8	fza 7					±14 9	fza 7					-13	9
fHa	±14	-8	-5	-9	-6	-12	9	±14 9	-17	-13	-13	-10	-13	10	
fα	22	16	10	16	14	22	9	22 9	18	13	13	10	14	9	
ffa	16	10	6	12	9	14	9	16 9	3	3	5	5	4	6	
ffa	0	0	0	0	0	0			2	1	0	0	0		
P/T-φ [mm]	37.393	26	[37.21/37.8]												



fHsm	±25	R	11	fzß 3					7	±25 9	fzß 8					L	12	8						
fHß	±25	R	11	R	12	R	12	R	9	R	12	8	±25 9	L	15	L	14	L	11	L	7	L	12	8
Fß	13		9		9		10		8		9	7	13 7		12		12		9		7		10	7
ffß	14		2		1		2		2		2	2	14 9		4		3		3		3		3	5

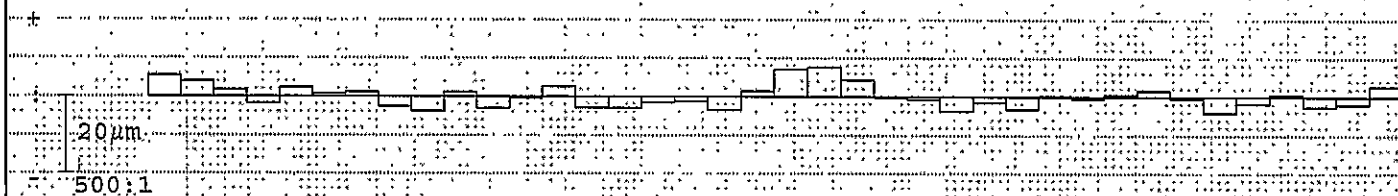
Ruota cilindrica Divisione



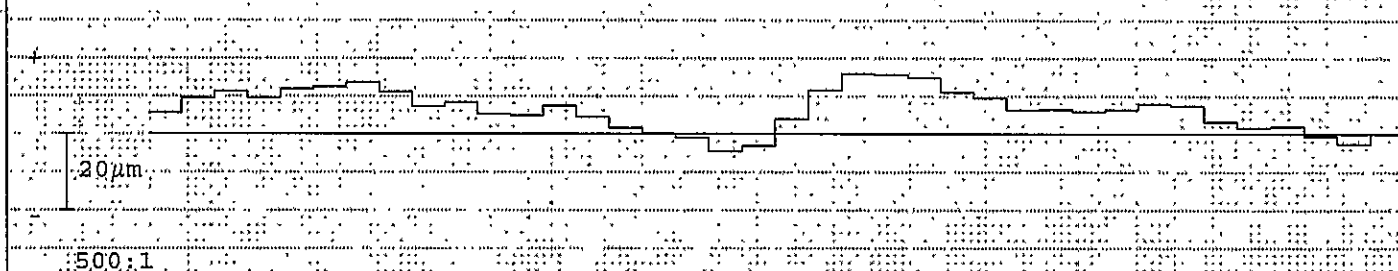
Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:59
Denominazione: Output Shaft 1	Numero denti z 38	Angolo pressione 30°00'00"	
Numero disegno: D51.6.1076.RIIIIa H	Modulo m 1mm	Angolo elica 00°00'00"	
Commissa/serie nr.: 10	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	

DIN 3962 

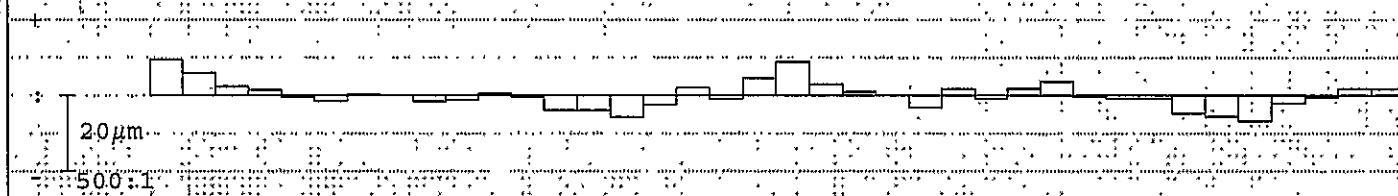
Errori singoli di divisione fp fianco sinistro



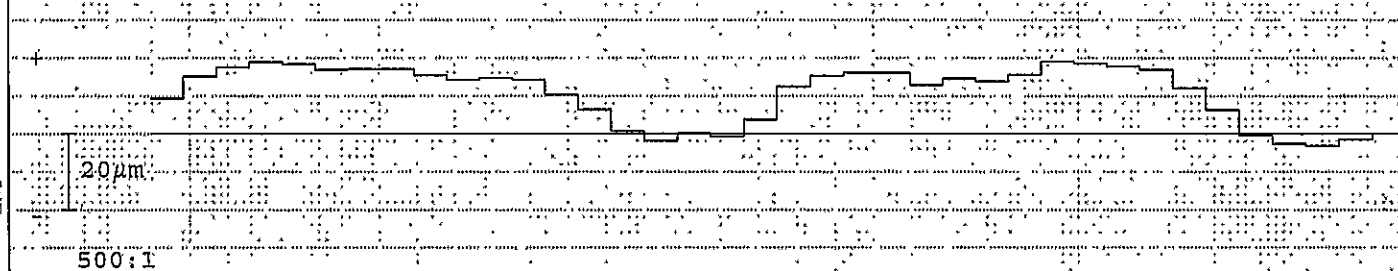
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



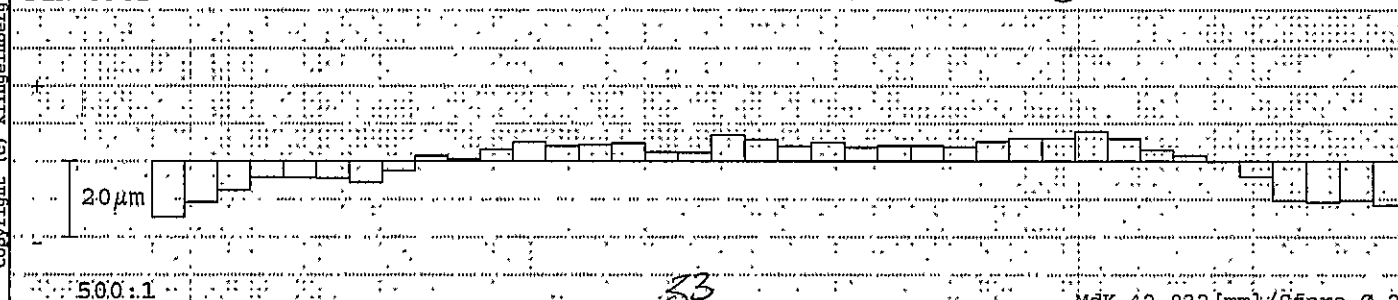
Corsa per misura divis.: 38.928 z=7.2mm

	fianco sinistro				fianco destro			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	8	7	18	9	9	7	18	9
Gr. salto di passo fu max	6	5			8	6		
Scarto di divisione Rp	12				16			
Err. globale di divisione Fp-e	20	7	50	9	22	7	50	9
Err. cordale di divisione Fpz/8	20	8			21	8		

DIN 3962

Centricità Fr (Ø-sfera =2mm)

⊙ : 15µm



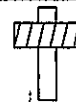
Err. di concentricità	Fr	23	8	56	10	Val. amm	42.148	42.088	
Variaz. spessore dente	Rs					Val.	42.117	42.126	42.106

Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria

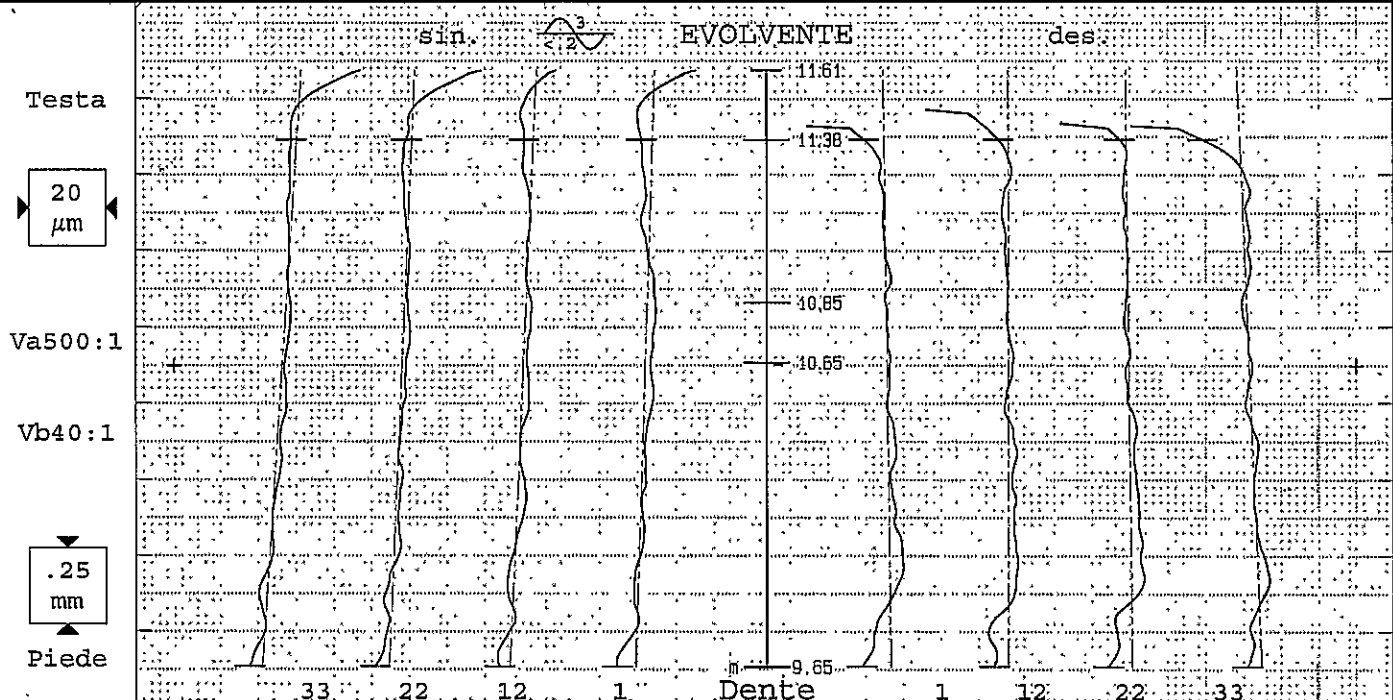


KUNGLINBERG

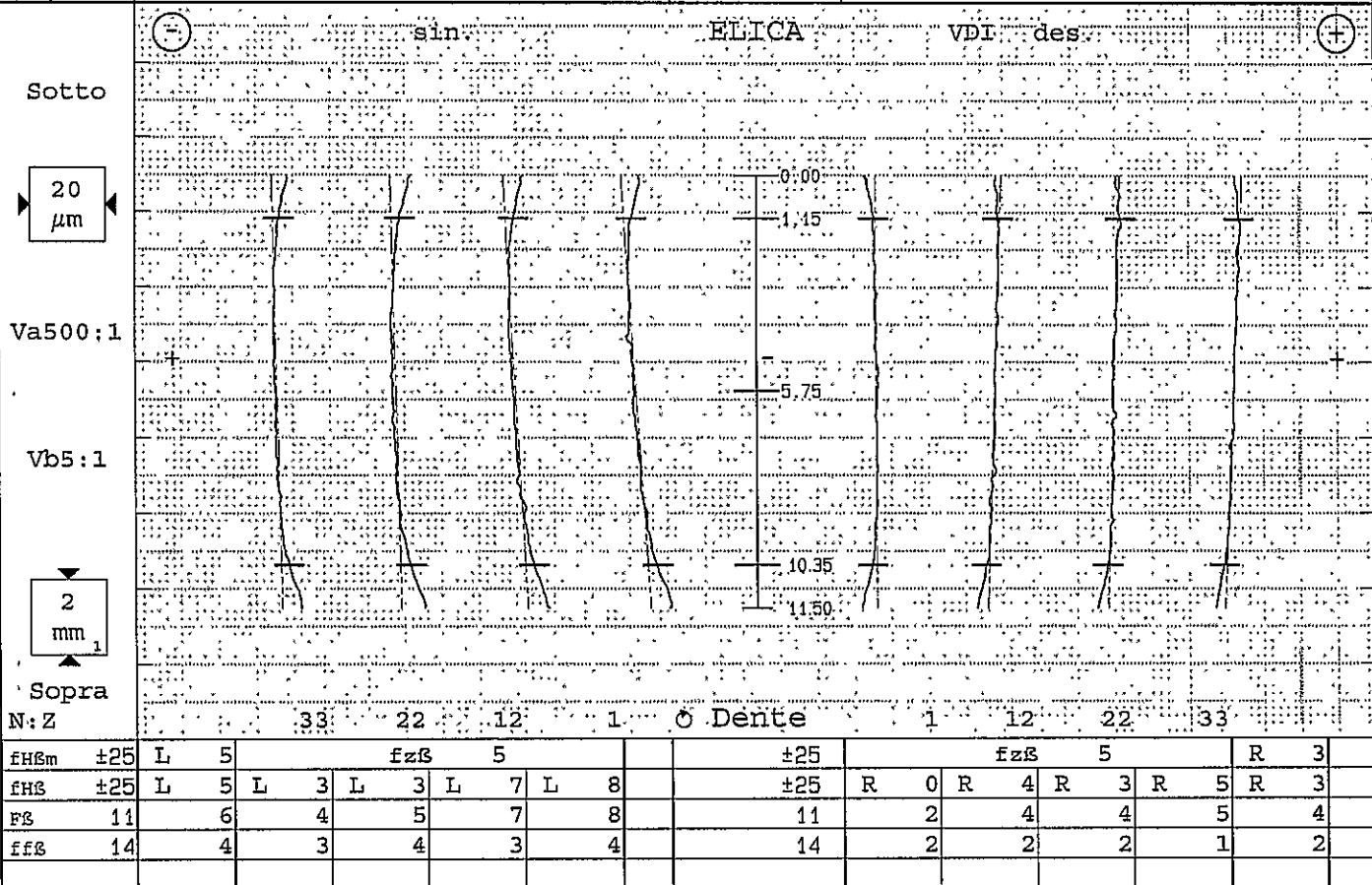
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:55
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa H		Modulo m	1mm	Tratto evol. La	1.73mm
Commessa/serie nr.:	10 (2)		Angolo pressione	30°00'00"	Tratto elica Lg	9.2mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	- 05

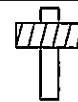


Tolerance	Medio	Val.misur [µm]				Qual	Tolerance	Val.misur [µm]				Medio	Qual
fHm ±14	-7	fza 4					±14	fza 6				-3	
fHa ±14	-7	-9	-6	-6	-5		±14	-2	0	-2	-6	-3	
Fa 21	10	11	9	9	10		21	11	8	10	18	12	
ffa 16	6	5	6	6	7		16	11	8	10	13	11	
ffa f	0	3	4	3	5			0	0	0	0	0	
P/T-q [mm]	41.336	21	[41.21/41.8]										



N: Z	33	22	12	1	Ø Dente	1	12	22	33													
fHm ±25	L	5	fzß 5				±25	fzß 5				R	3									
fHß ±25	L	5	L	3	L	3	L	7	L	8	±25	R	0	R	4	R	3	R	5	R	3	
Fß 11		6		4		5		7		8		11		2		4		4		5		4
ffß 14		4		3		4		3		4		14		2		2		2		1		2

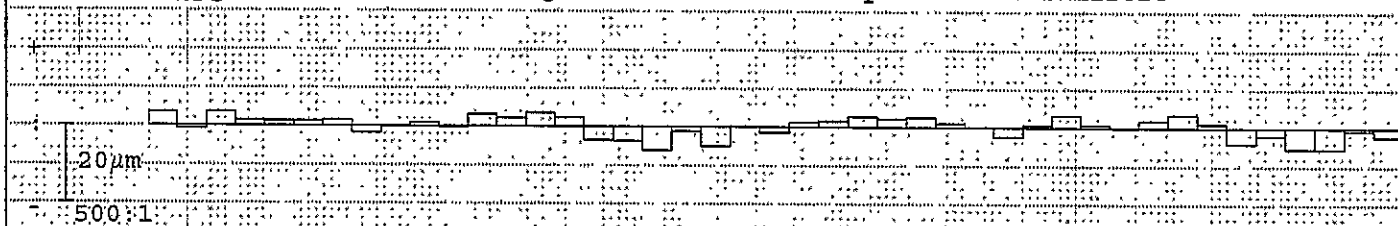
Ruota cilindrica Divisione



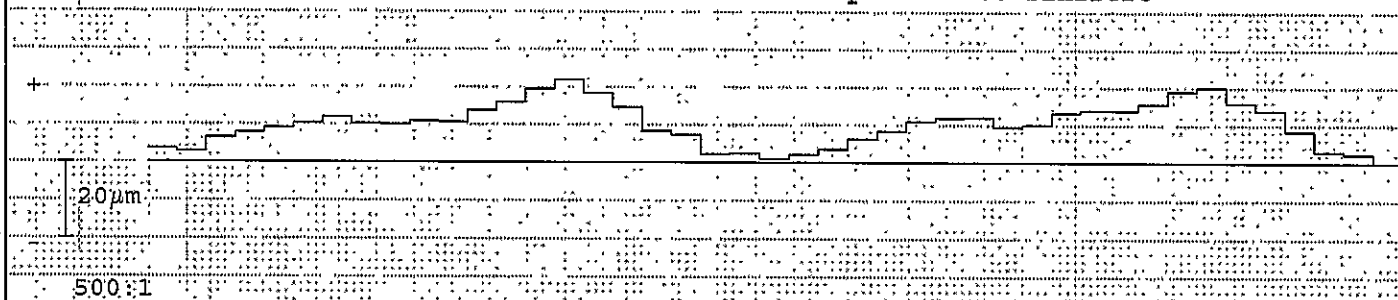
Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:55
Denominazione: Output Shaft 1		Numero denti z 43	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIa H		Modulo m 1mm	Angolo elica 00°00'00"
Comessa/serie nr.: 10		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM 1	Werkzeug: Charge:	



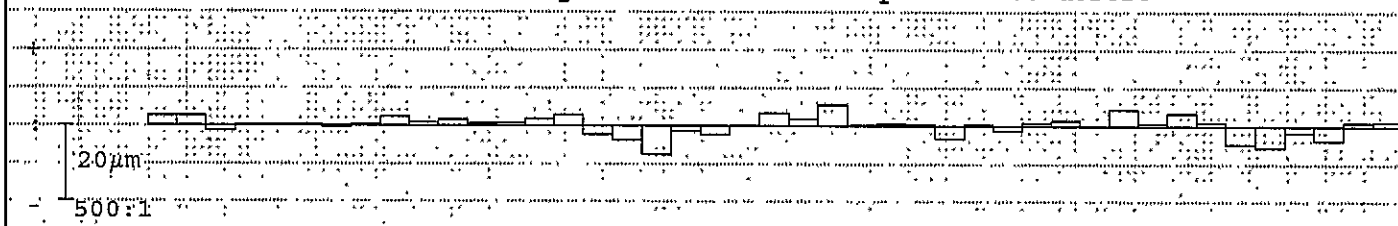
Errori singoli di divisione fp fianco sinistro



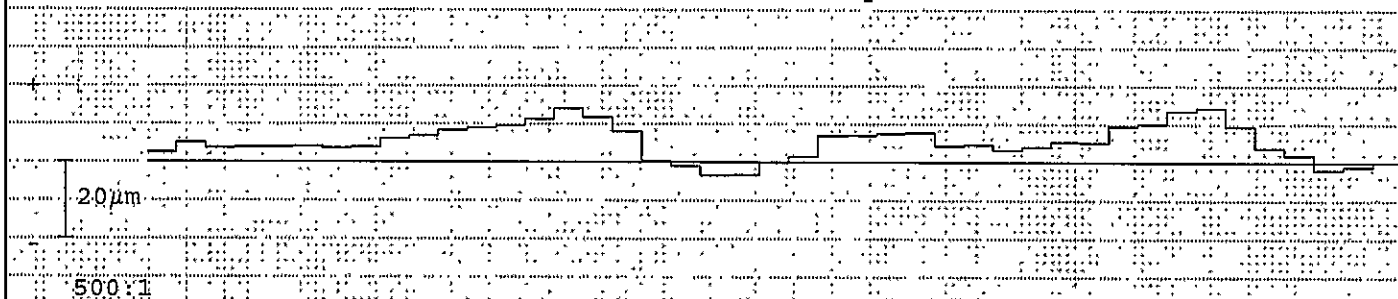
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



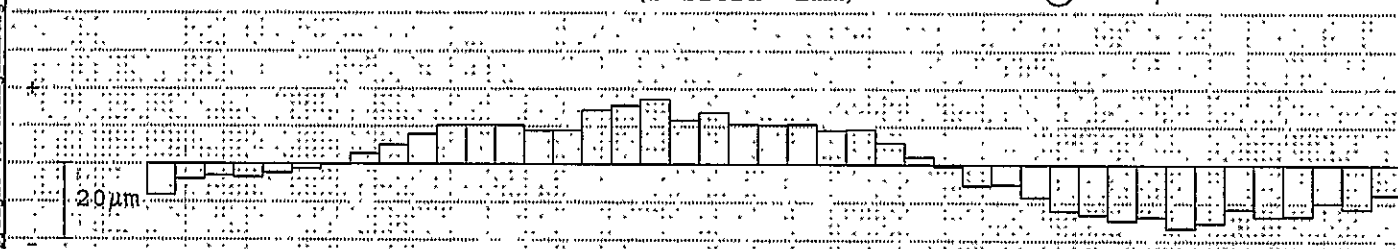
Errore somma di divisione Fp fianco destro



Corsa per misura divis. 143.096 z=5.8mm		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	6		17		8		17	
Gr. salto di passo	fu max	6				6			
Scarto di divisione	Rp	10				13			
Err. globale di divisione	Fp-a	22		40		18		40	
Err. cordale di divisione	Fpz/8	20				17			

Centricità Fr (Ø-sfera =2mm)

⊙ : 28µm



Err. di concentricità	Fr	34	50	Val. amm	46.231	46.167
Variaz. spessore dente	Rs			Val.	46.19	46.197 46.18

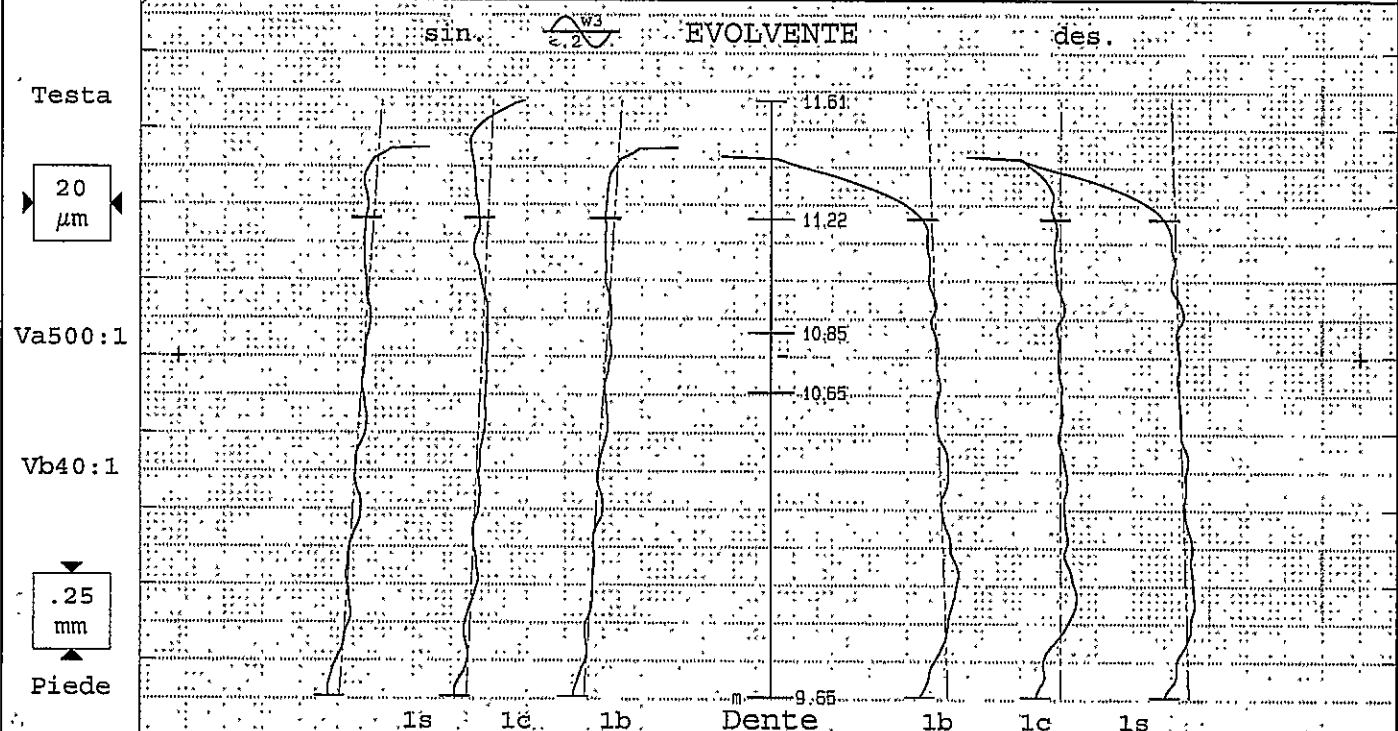
Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria



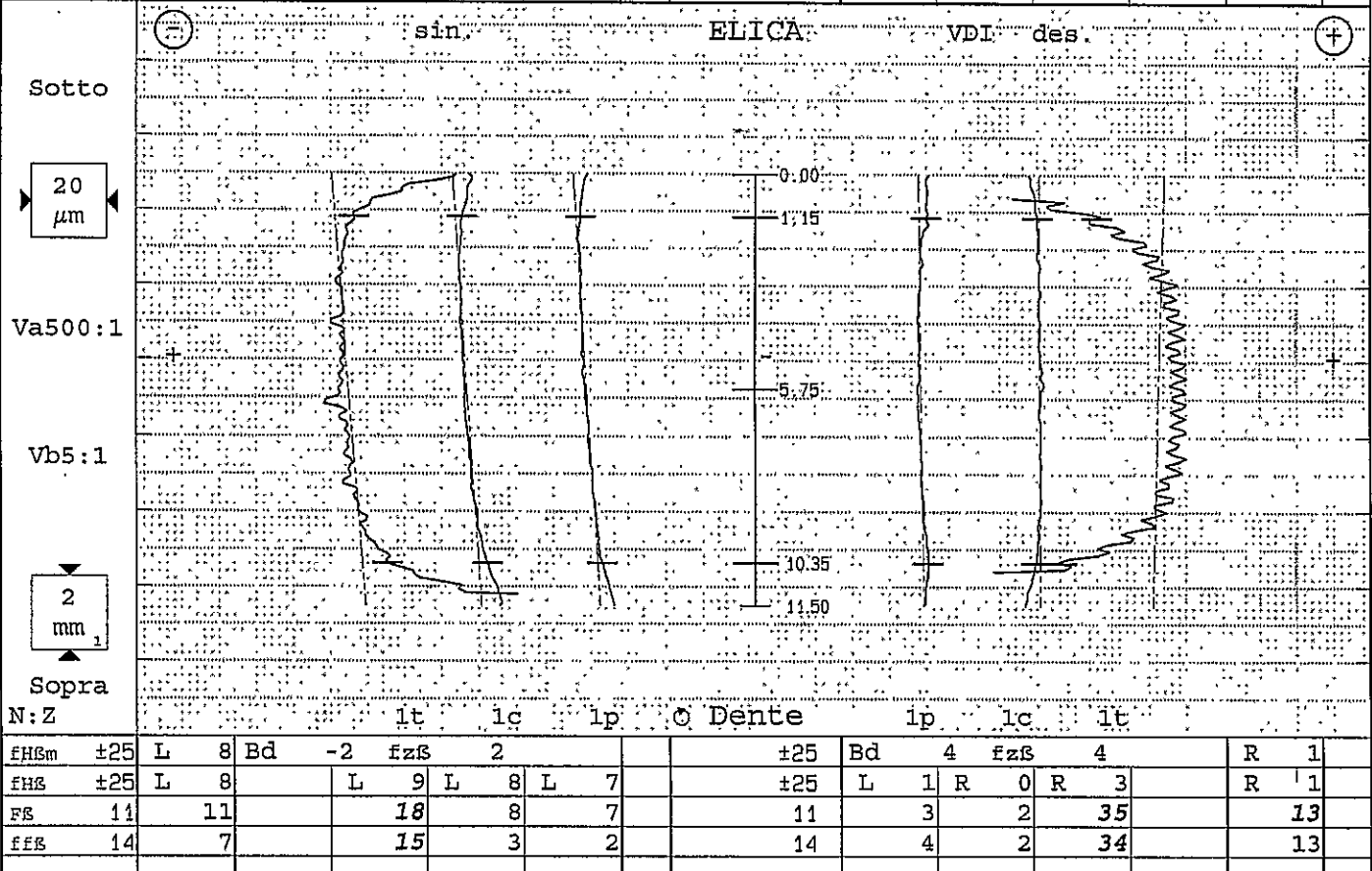
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:02
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa SH		Modulo m	1mm	Tratto evol. La	1.57mm
Commessa/serie nr.:	10		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	- .05



Tolerance	Medio	Val.misur [μ m]			Qual	Tolerance	Medio	Val.misur [μ m]			Qual
fHm	± 14	-8	fza	3		± 14	-4	0	-4	-3	
fHa	± 14	-8	-9	-6	-8	± 14	-4	0	-4	-3	
Fa	21	10	12	9	10	21	10	11	8	10	
ffa	16	6	6	7	5	16	11	11	9	10	
ffa	0	0	3	3	3	0	0	0	0	0	



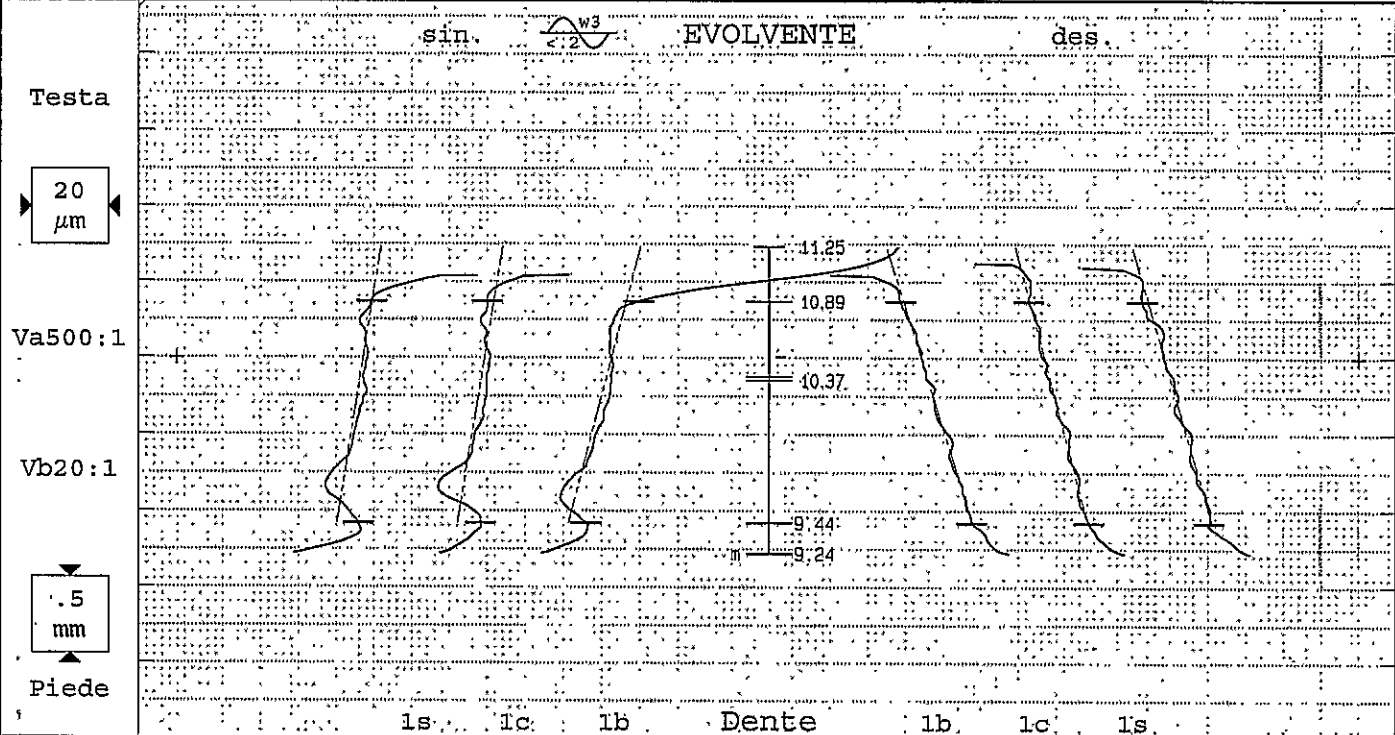
Tolerance	Medio	Val.misur [μ m]			Qual	Tolerance	Medio	Val.misur [μ m]			Qual
fHm	± 25	L 8	Bd -2	fzß 2		± 25	Bd 4	fzß 4		R 1	
fHß	± 25	L 8	L 9	L 8	L 7	± 25	L 1	R 0	R 3	R 1	
Fß	11	11	18	8	7	11	3	2	35	13	
ffß	14	7	15	3	2	14	4	2	34	13	



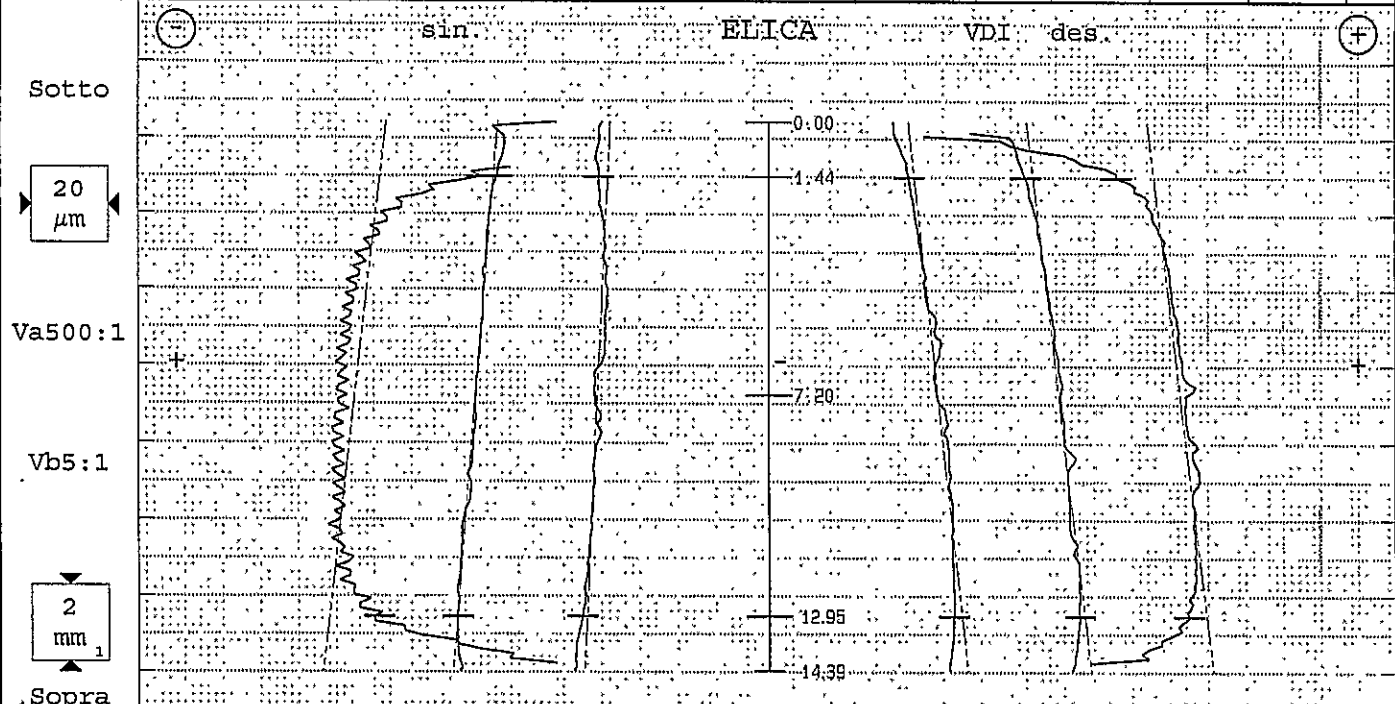
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410o05 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:03
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51.6.1076.RIIIIaSH		Modulo m	1mm	Tratto evol. La	1:45mm
Commessa/serie nr.:	10		Angolo pressione	30°00'00"	Tratto elica LS	11.51mm
Masch.Nr.:	M001	Spindel: Formm	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45



Tolerance	Medio	Val.misur[μ m]	Qual	Tolerance	Val.misur[μ m]	Medio	Qual
fHqm	± 14	-11		fza	6	-17	
fHa	± 14	-11			-9 -10 -15	-17	
Fa	22	16			12 14 21	18	
ffa	16	11			10 13 9	3	
ffa	0	10	3 5		7 7 8	0	



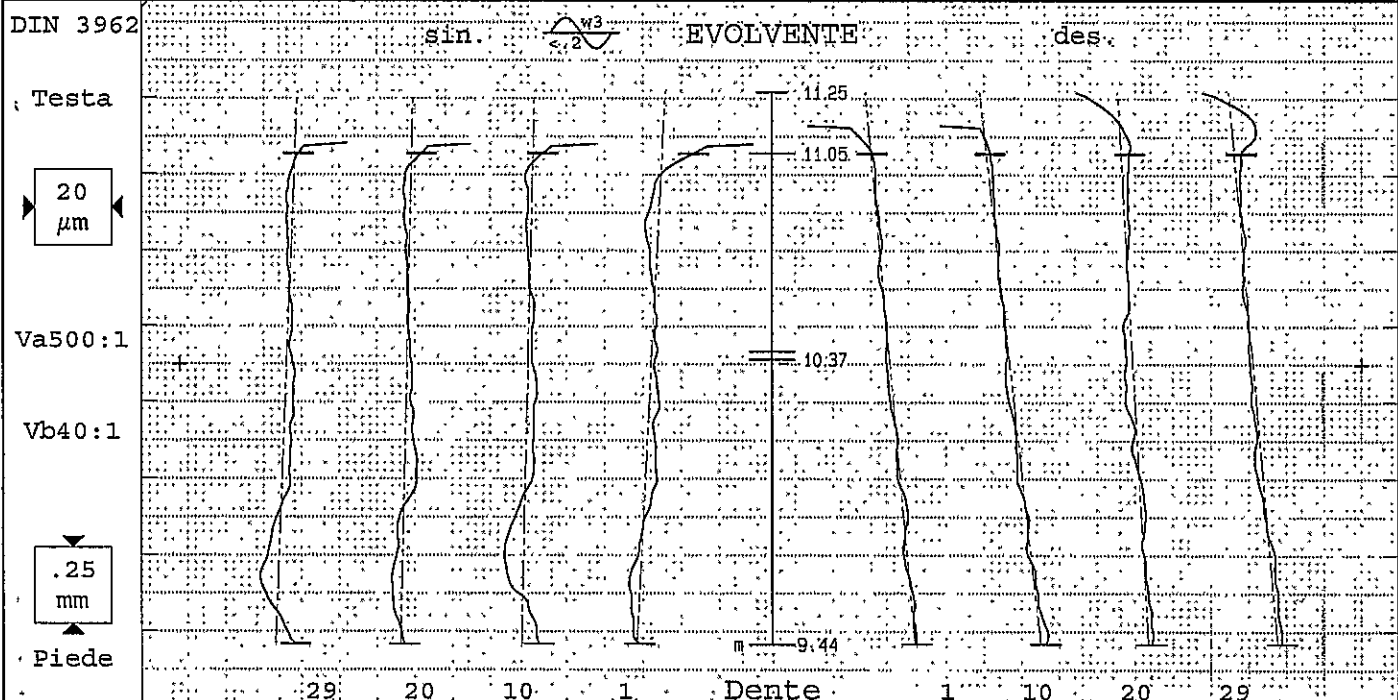
N:Z	1t	1c	1p	Ø Dente	1p	1c	1t
fHsm	± 25	R 12	fzß	10	± 25	L 17	L 17
fHs	± 25	R 12	R 17 R 12 R 7	± 25	L 16 L 17 L 17	L 17	L 17
Fß	13	20	41 11 7	13	12 14 22	16	16
ffß	14	13	33 2 4	14	5 5 14	8	8



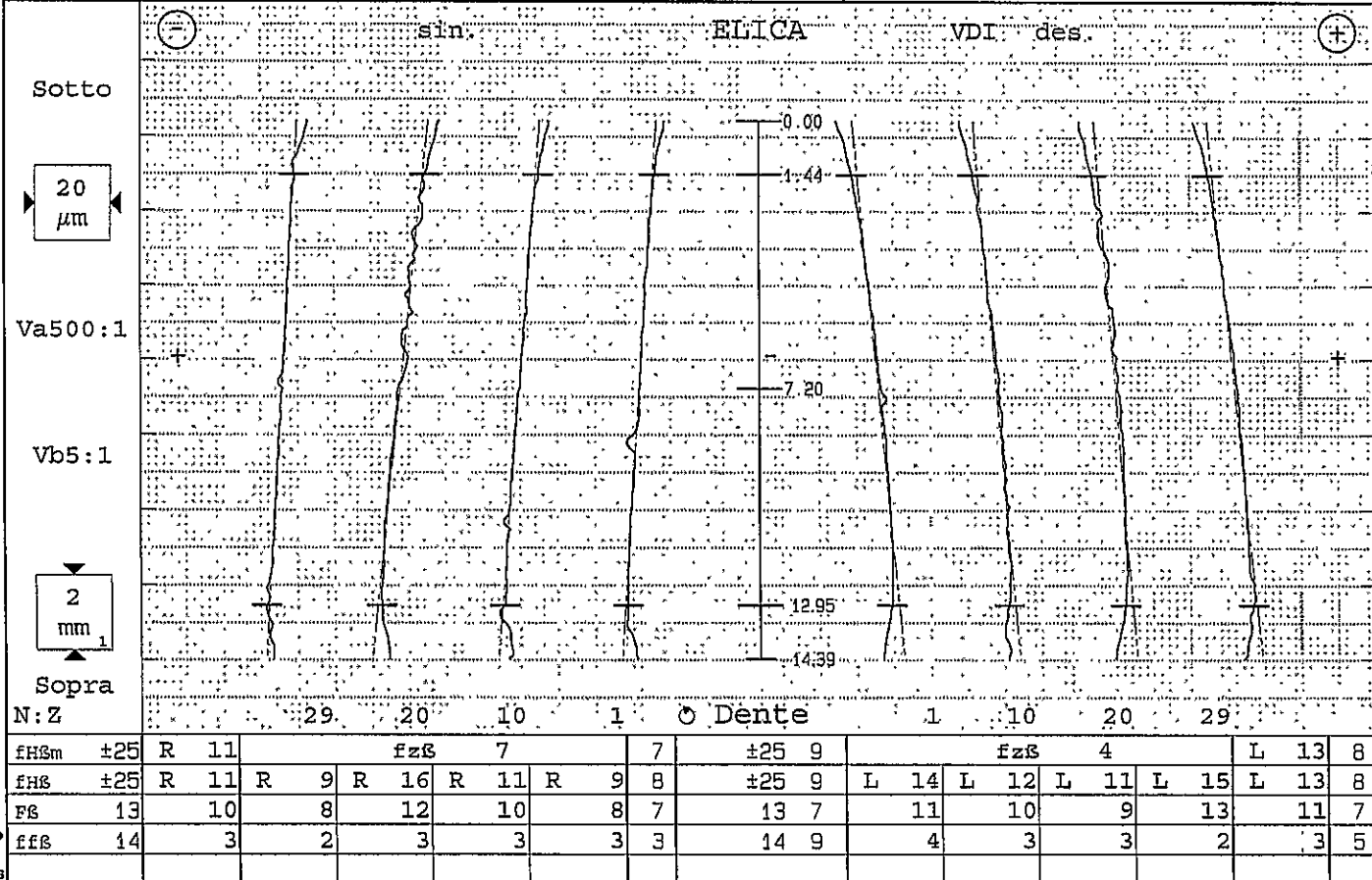
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410o05 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:10
Denominazione:	Output Shaft 1		Numero denti z	38	largh.fasc.dent. b	14.39mm
Numero disegno:	D51.6.1076.RIIIIa H		Modulo m	1mm	Tratto evol. La	1.61mm
Commessa/serie nr.:	29 (3)		Angolo pressione	30°00'00"	Tratto elica L3	11.51mm
Masch.Nr.:	M001	Spindel: Form	Angolo elic. 00°00'00"		Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45



Tolerance	Medio	Val.misur [µm]				Qual	Tolerance	Val.misur [µm]				Medio	Qual
fHsm	±14	-5	fza 4				6	±14 9	fza 7				-11 9
fHa	±14	-5	-5	-3	-3	-7	7	±14 9	-12	-14	-7	-12	-11 9
Fa	22	11	10	8	10	17	9	22 9	12	16	8	11	12 8
ffa	16	10	10	6	10	12	8	16 9	2	4	5	8	5 7
ffaf		0	0	0	0	0			1	1	1	1	0
P/T-φ [mm]	37.386 26 [37.21/37.8]												



fHsm	±25	R	11	fz3 7				7	±25 9	fz3 4				L	13	8								
fHs	±25	R	11	R	9	R	16	R	11	R	9	8	±25 9	L	14	L	12	L	11	L	15	L	13	8
F3	13		10		8		12		10		8	7	13 7		11		10		9		13		11	7
ff3	14		3		2		3		3		3	3	14 9		4		3		3		2		3	5

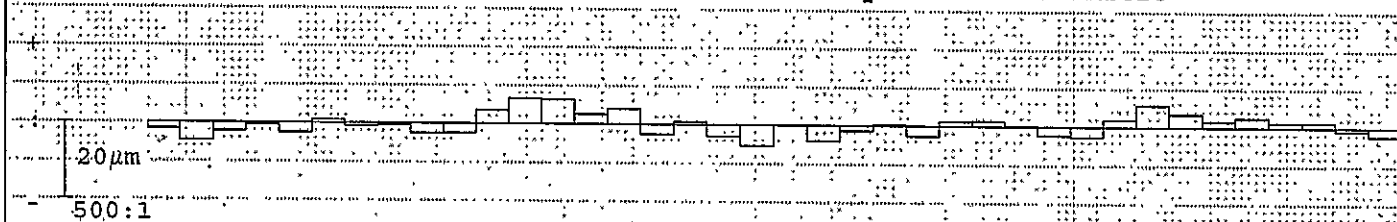
Ruota cilindrica Divisione



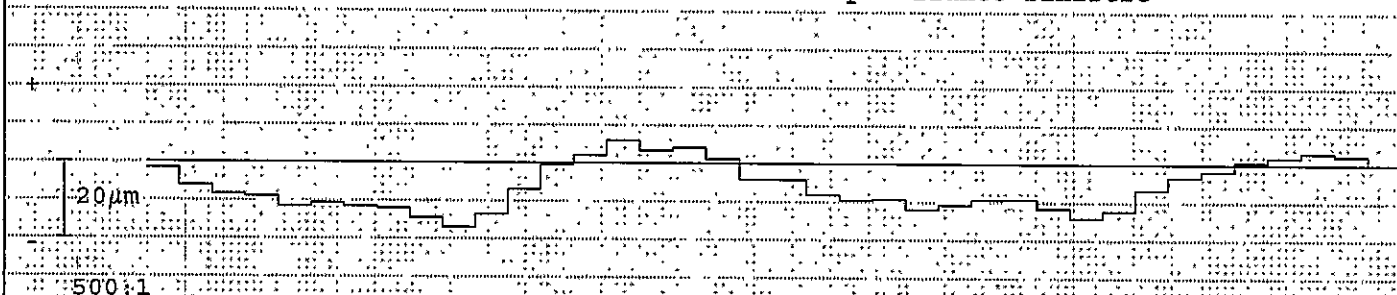
Nr. prog.: STI041005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 09:10
Denominazione: Output Shaft 1		Numero denti z 38	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIIA H		Modulo m 1mm	Angolo elica 00°00'00"
Comessa/serie nr.: 29		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerk	Charge:	

DIN 3962 $\frac{W3}{\sqrt{2}}$

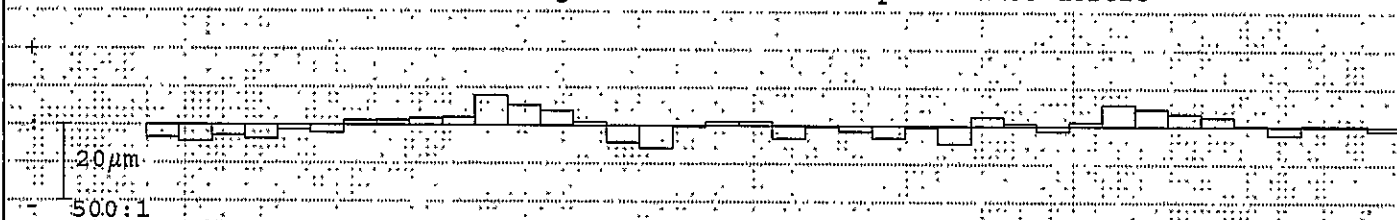
Errori singoli di divisione fp fianco sinistro



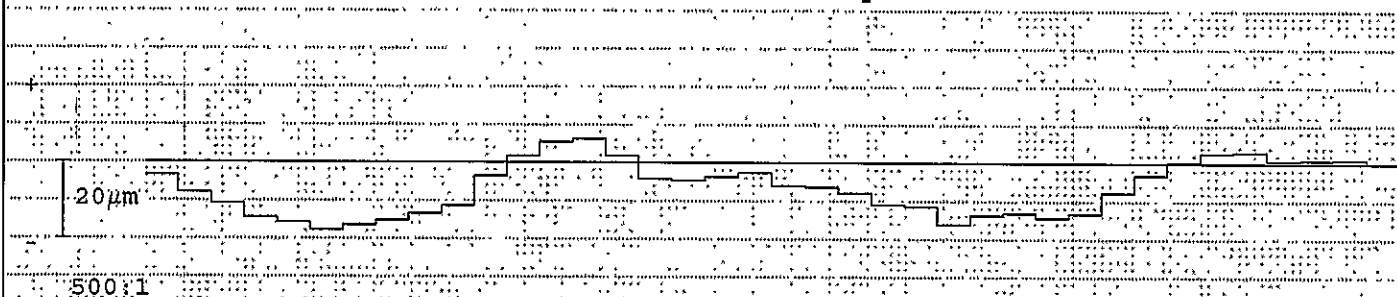
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



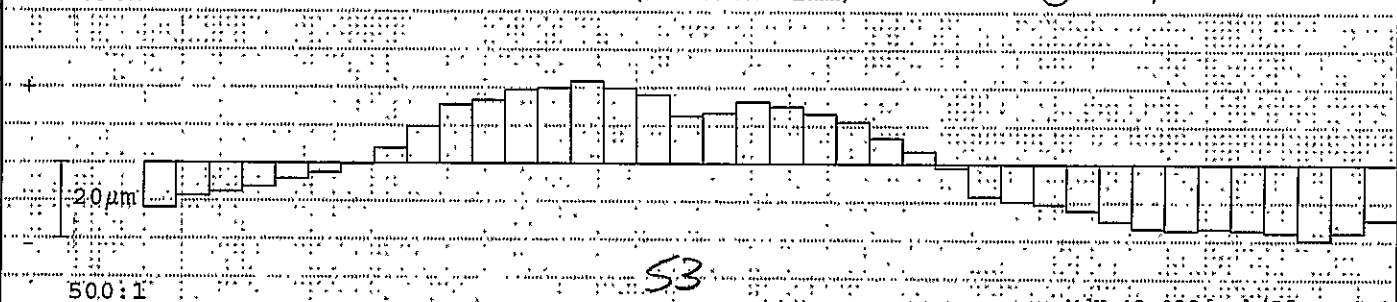
Corsa per misura divis.: 38.928 z=7.2mm

		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	Fp max	7	6	18	9	8	7	18	9
Gr. salto di passo	Fu max	6	5			7	6		
Scarto di divisione	Rp	12				14			
Err. globale di divisione	Fp-e	23	7	50	9	24	7	50	9
Err. cordale di divisione	Fpz/8	23	8			21	8		

DIN 3962

Centricità Fr (Ø-sfera =2mm)

⊙ : 38µm



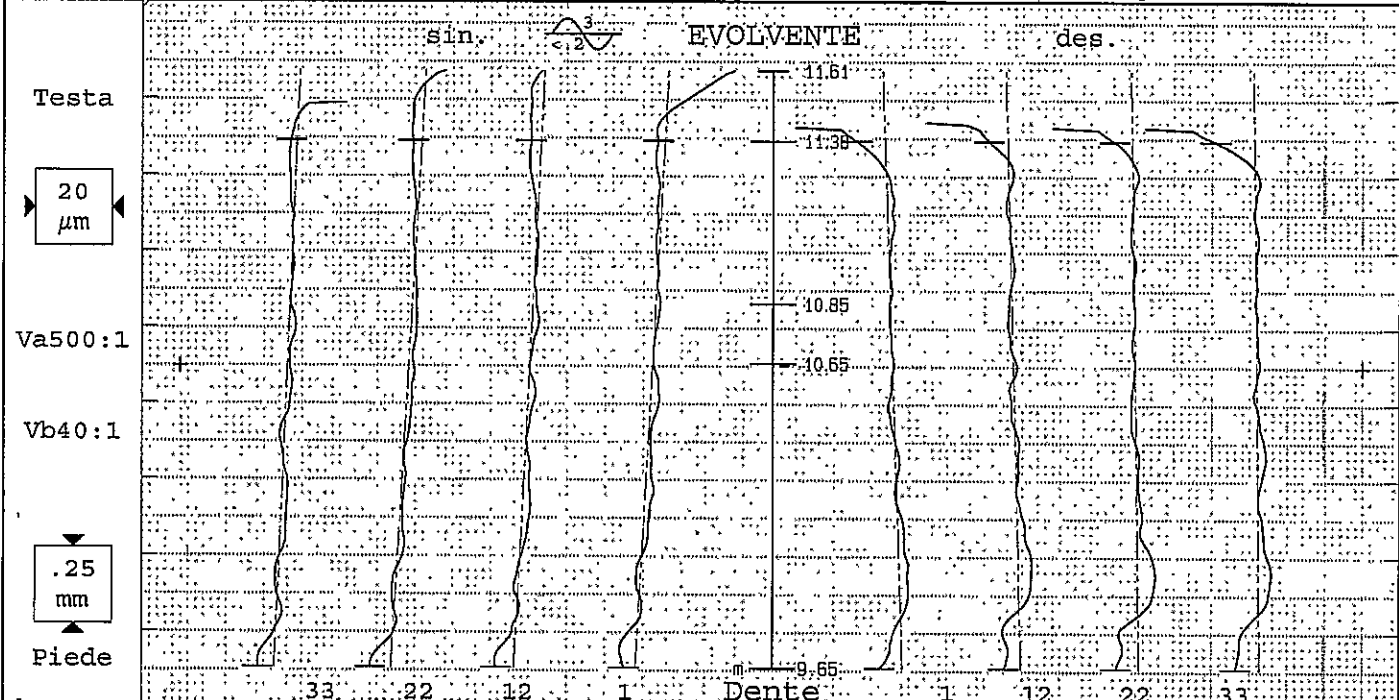
						Mdk.42.032 [mm]./Sfere-Ø 2	
Err. di concentricità	Fr	41	10	56	10	Val. amm	42.148 42.088
Variaz. spessore dente	Rs					Val.	42.111 42.116 42.102



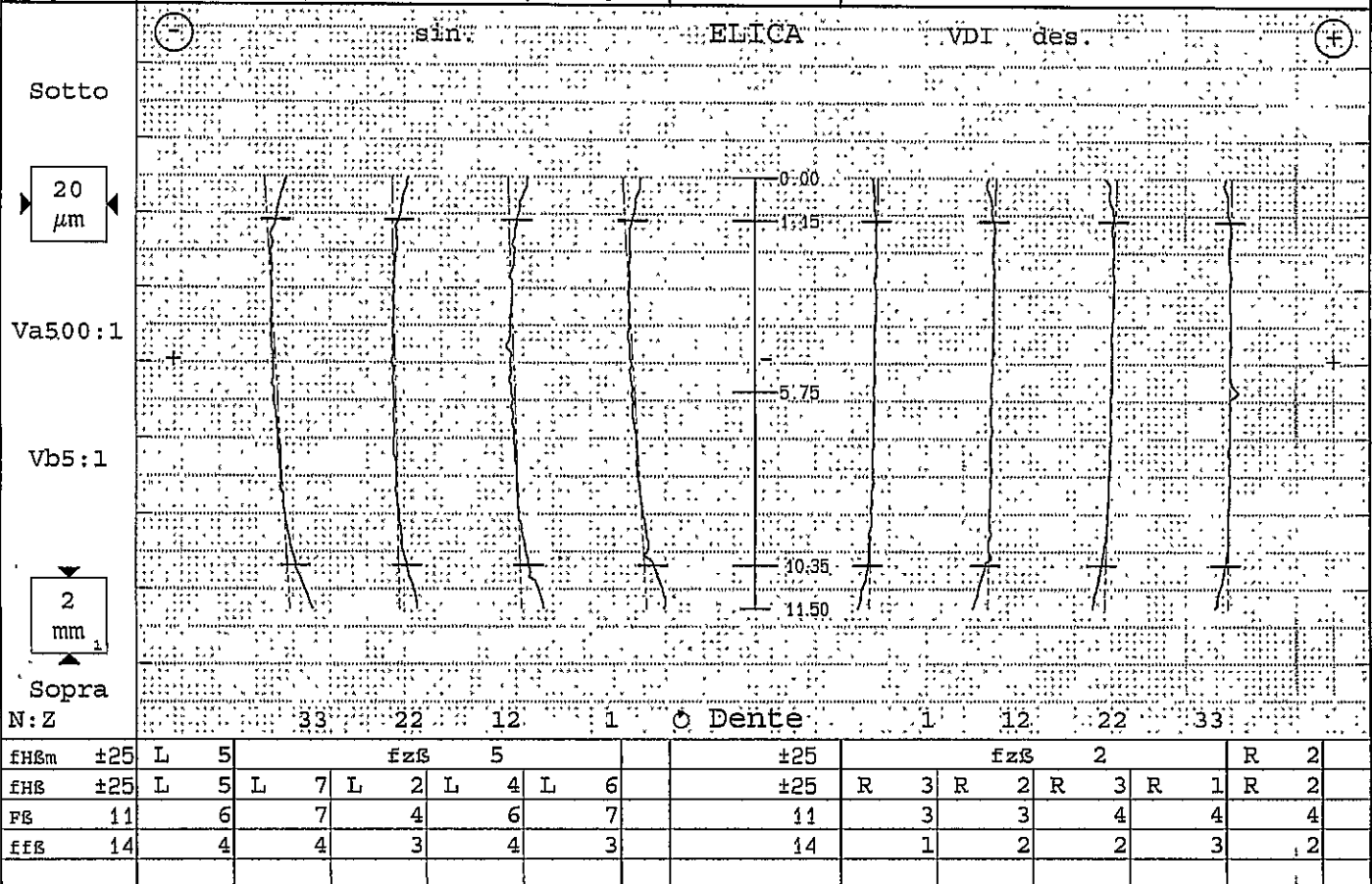
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:06
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa H		Modulo m	1mm	Tratto evolv. La	1.73mm
Comessa/serie nr.:	29		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elic	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	-.05

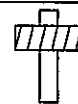


Tolerance	Medio	Val.misur [μ m]					Qual	Tolerance	Val.misur [μ m]					Medio	Qual
fHm	± 14	-7	fza 2					± 14	fza 4					-3	
fHa	± 14	-7	-6	-8	-7	-8		± 14	-5	-4	-2	-1	-3		
Fa	21	11	10	12	12	11		21	14	12	11	15	13		
ffa	16	7	6	7	7	7		16	10	9	11	14	11		
ffa	0	4	6	5	3			0	0	0	0	0	0		
P/T- ϕ [mm]	41.333 21 [41.21/41.8]														



fHsm	±25	L	5	fzß				5			±25	fzß				2		R	2					
fHß	±25	L	5	L	7	L	2	L	4	L	6		±25	R	3	R	2	R	3	R	1	R	2	
Fß	11		6		7		4		6		7		11		3		3		4		4		4	
fFß	14		4		4		3		4		3		14		1		2		2		3		2	

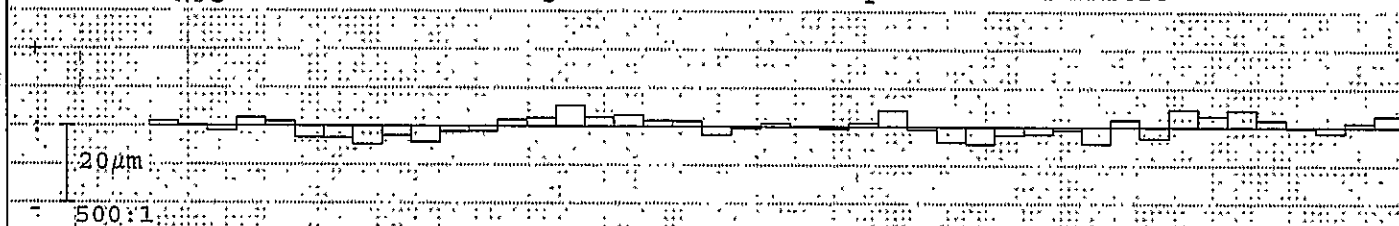
Ruota cilindrica Divisione



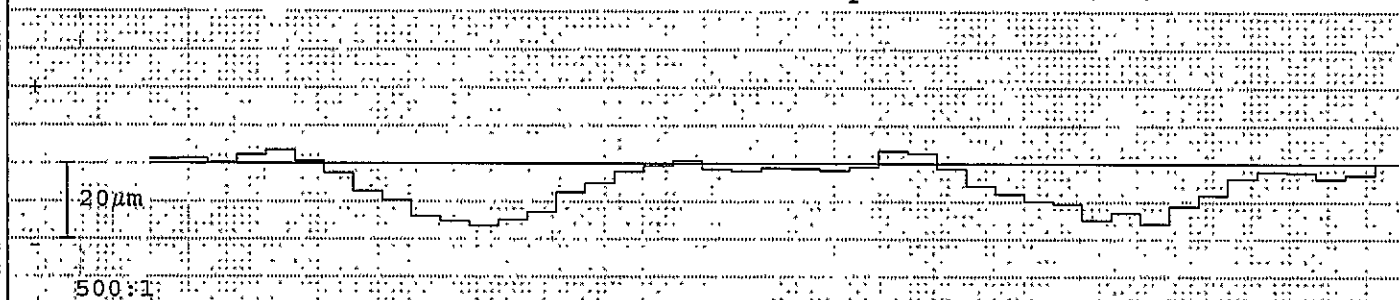
Nr. prog.: STI0410005 0	P26 601265	Controllora: TURNO d	Data: 02.02.2017 09:06
Denominazione: Output Shaft 1		Numero denti z 43	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIa H		Modulo m 1mm	Angolo elicica 00°00'00"
Comessa/serie nr.: 29		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	



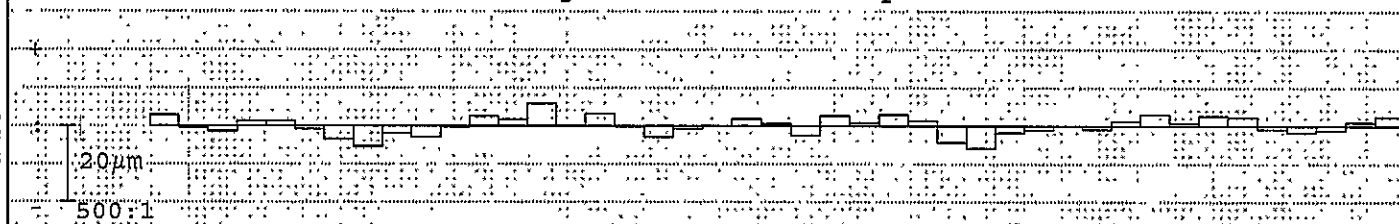
Errori singoli di divisione fp fianco sinistro



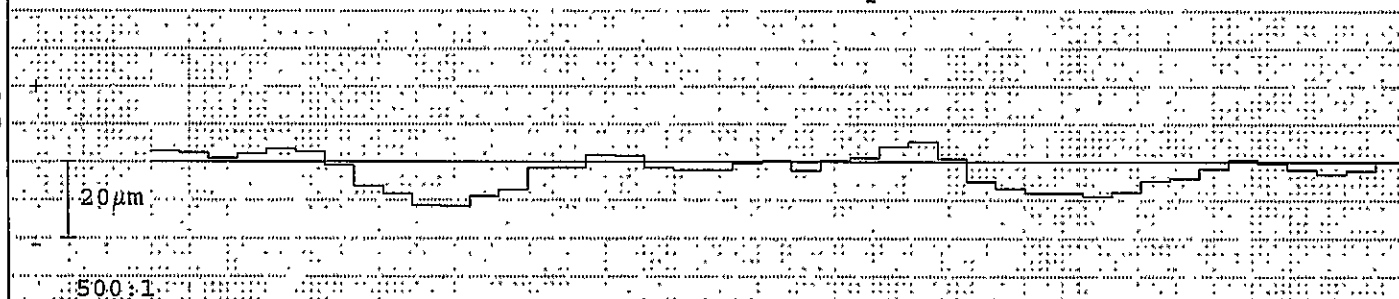
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



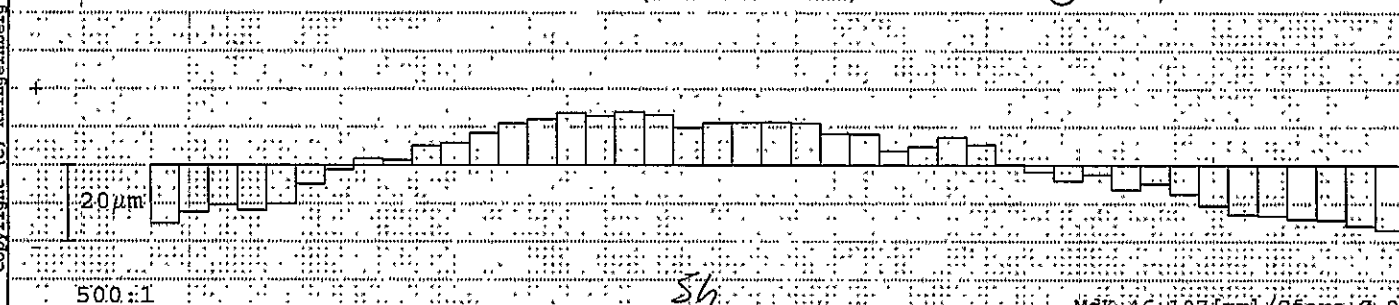
Errore somma di divisione Fp fianco destro



Corso per misura divis.: 43.096 z=5.8mm		fianco sinistro		fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.
Gr. err. singoli divisione	fp max	5		17		6	17
Gr. salto di passo	fu max	7				6	
Scarto di divisione	Rp	10				12	
Err. globale di divisione	Fp-e	20		40		17	40
Err. cordale di divisione	Fpz/8	17				15	

Centricità Fr (Ø-sfera = 2mm)

⊙ : 27µm



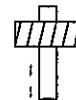
Err. di concentricità	Fr	31	50	Val. amm	46.231	46.167
Variaz. spessore denta	Ra			Val.	46.189	46.196
					46.18	

Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria

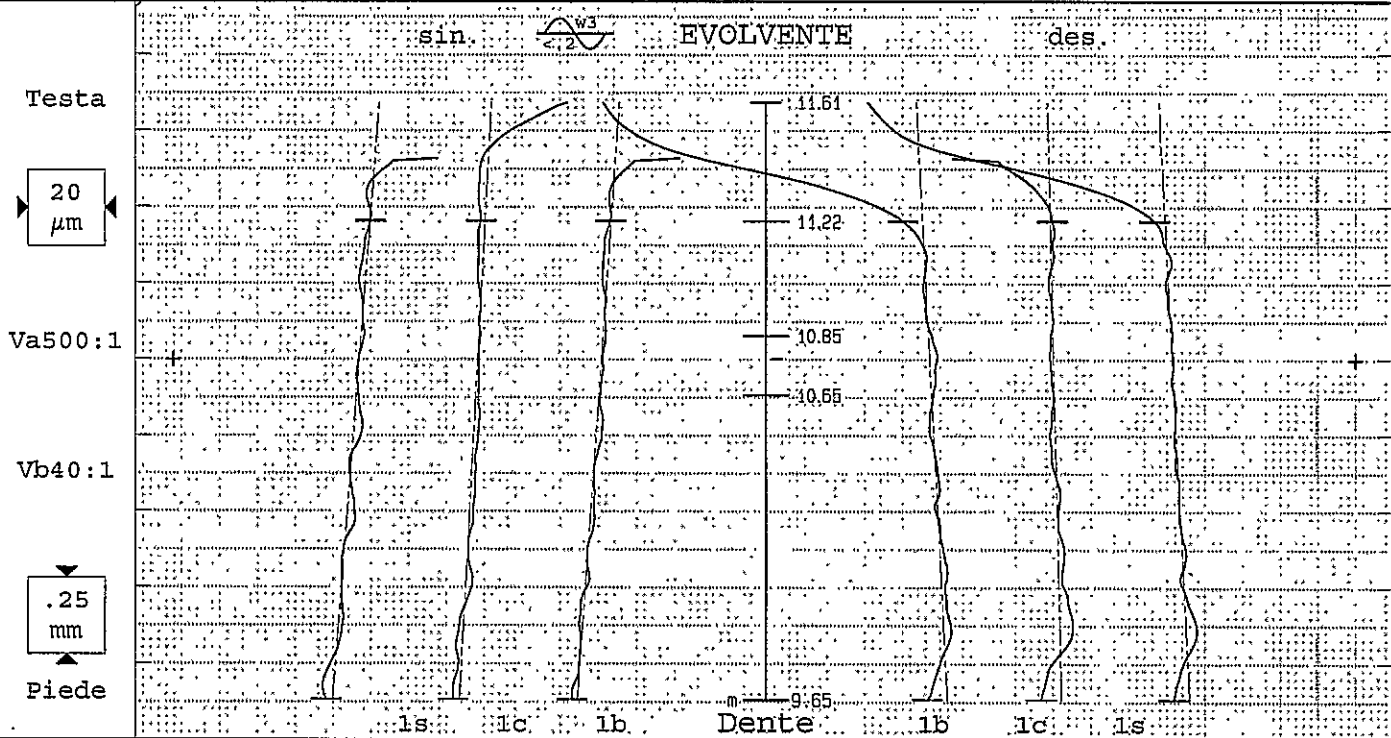




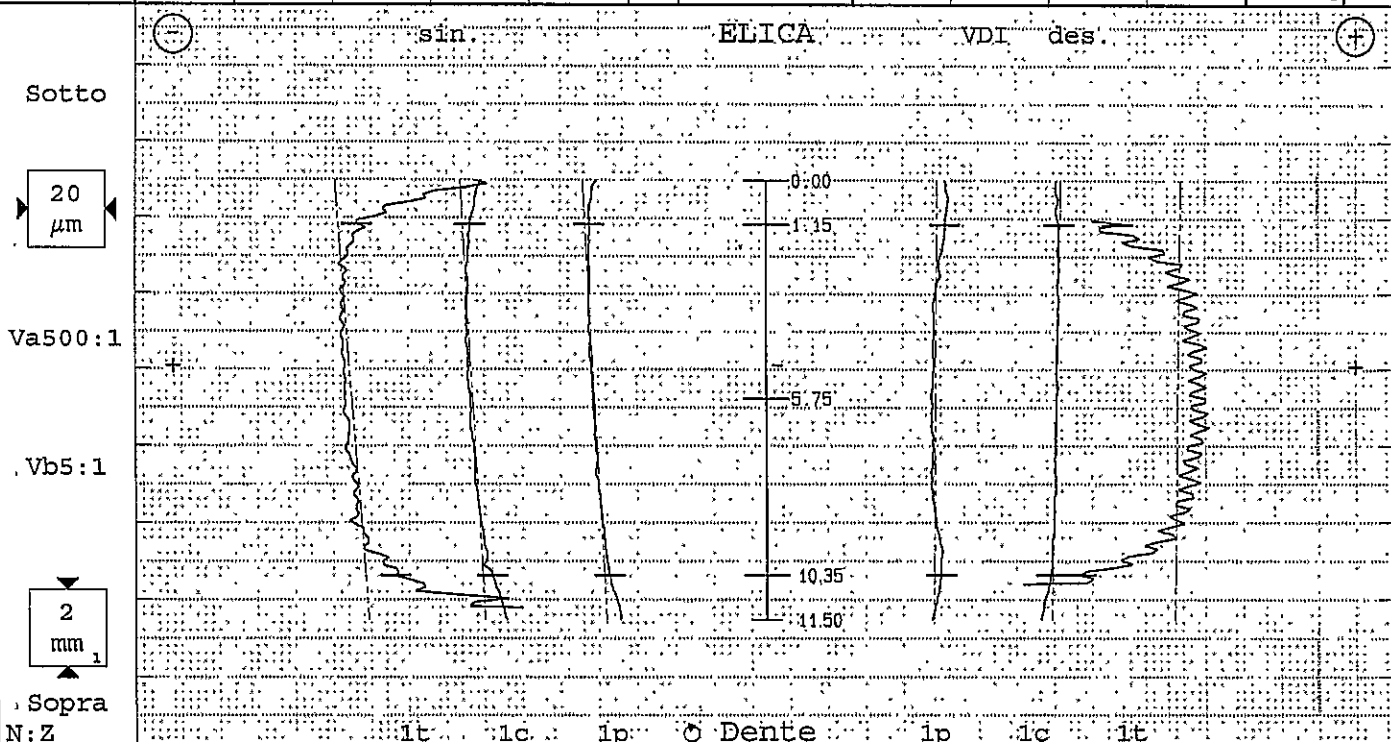
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:13
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa SH		Modulo m	1mm	Tratto evol. La	1.57mm
Connessa/serie nr.:	29		Angolo pressione	30°00'00"	Tratto elica LE	9.2mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	-105



Tolerance	Medio	Val.misur [μ m]			Qual	Tolerance	Val.misur [μ m]			Medio	Qual
fH _{am} ±14	-9	fz _a	3			±14	fz _a	4		-5	
fH _a ±14	-9	-10	-7	-9		±14	-7	-3	-6	-5	
F _a 21	10	13	8	10		21	13	8	11	11	
ff _a 16	4	5	4	3		16	7	9	7	8	
ff _a f	0	2	2	2		0	0	0	0	0	



N:Z	1t	1c	1p	Ø Dente	1p	1c	1t
fH _{sm} ±25	L 7	Bd -3	fz _B 3		±25	Bd 1	fz _B 2
fH _S ±25	L 7	L 9	L 6	L 6	±25	R 1	R 3
F _B 11	10	16	7	6	11	4	3
ff _B 14	6	12	4	2	14	3	1

Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 09:14
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno:	D51.6.1076.RIIIaSH		Modulo m	1mm	Tratto evol. la	1.45mm
Comessa/serie nr.:	29		Angolo pressione	30°00'00"	Tratto elica LS	11.51mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45

Testa

20
µm

Va500:1

Vb20:1

.5
mm

Piede

Tolerance		Medio	Val.misur[µm]			Qual	Tolerance		Val.misur[µm]			Medio	Qual
fHm	±14	-7	fza	3			±14		fza	3		-12	
fHa	±14	-7	-7	-6	-9		±14	-14	-11	-12		-12	
Fa	22	11	9	9	15		22	14	11	11		12	
ffa	16	7	6	7	7		16	2	2	3		2	
ffa	0	0	13	8	7			5	7	9		0	

Sotto

20
µm

Va500:1

Vb5:1

2
mm

Sopra

N:Z		lt	lc	lp	Ø Dente	lp	lc	lt		
fHm	±25	R 11	fzß	6		±25	fzß	3	L 16	
fHß	±25	R 11	R 14	R 10	R 8	±25	L 14	L 16	L 17	L 16
Fß	13	19	42	8	7	13	12	13	23	16
ffß	14	14	36	3	2	14	2	4	14	7
ffß	6									

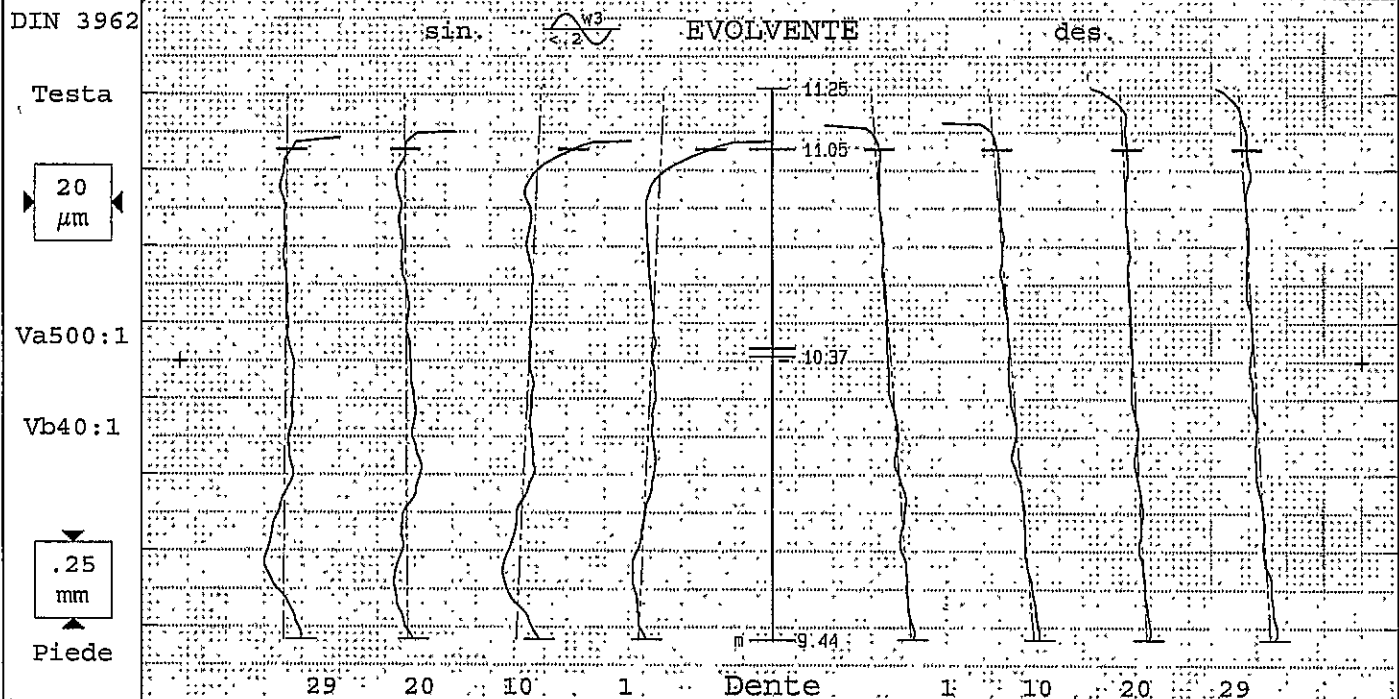




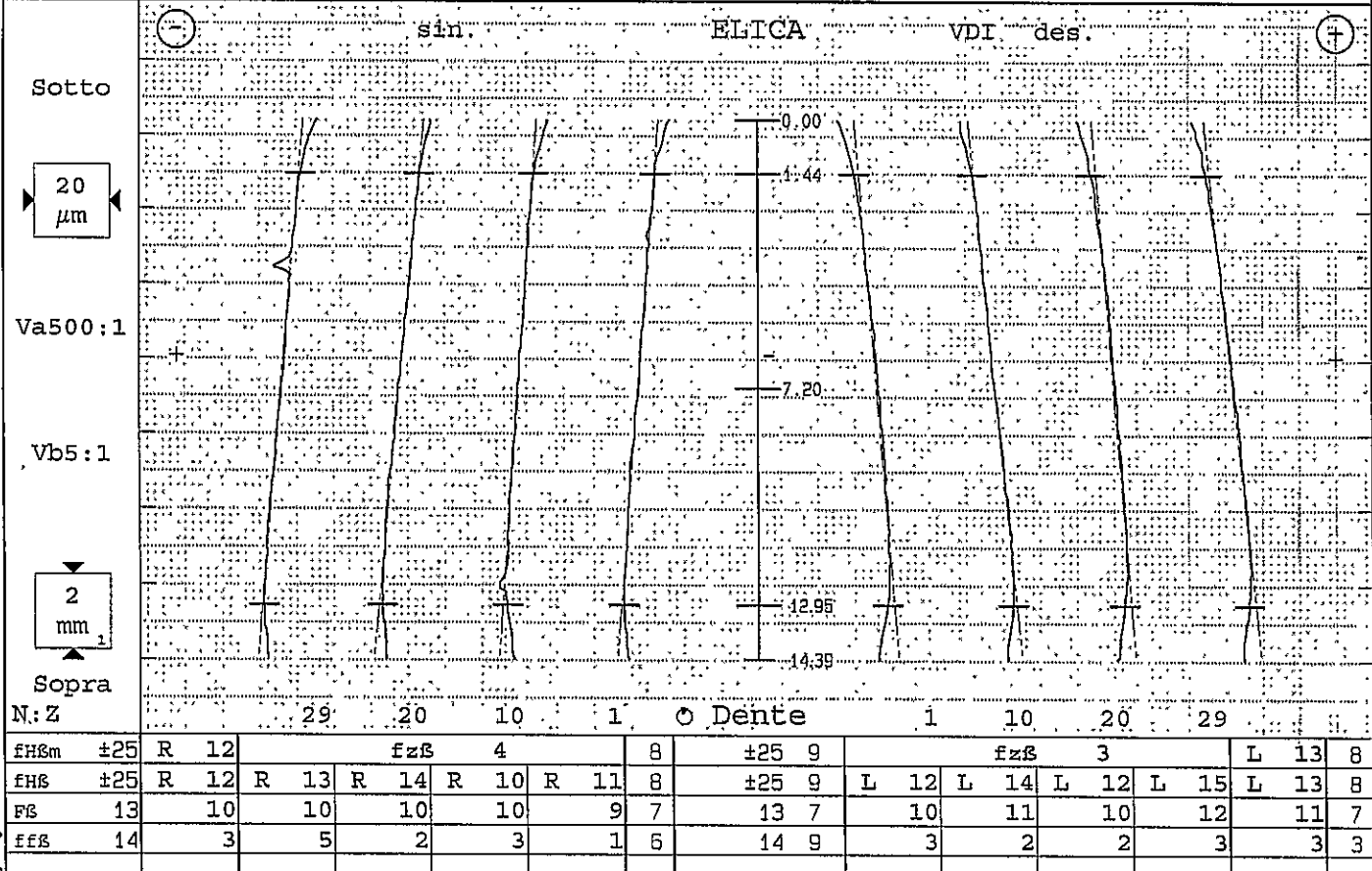
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:22
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51 6.1076.RIIa H		Modulo m	1mm	Tratto evolv. La	1.61mm
Comessa/serie nr.:	50 (6)		Angolo pressione	30°00'00"	Tratto elica LS	11.51mm
Masch.Nr.:	M001	Spindel: Forme	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45

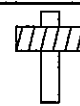


Tolerance	Medio	Val.misur [µm]				Qual	Tolerance	Val.misur [µm]				Medio	Qual
fHm ±14	-3	fza 7				4	±14 9	fza 5				-9	8
fHa ±14	-3	-1	1	-6	-6	7	±14 9	-9	-11	-6	-8	-9	9
Fa 22	14	10	7	19	21	9	22 9	10	11	7	9	9	7
ffa 16	12	10	8	14	16	9	16 9	3	4	2	3	3	5
ffaf	0	0	0	0	0			0	1	1	1	0	
P/T-φ [mm]	37.376	26	[37.21/37.8]										



fHm ±25	R 12	fzß 4				8	±25 9	fzß 3				L 13	8
fHß ±25	R 12	R 13	R 14	R 10	R 11	8	±25 9	L 12	L 14	L 12	L 15	L 13	8
Fß 13	10	10	10	10	9	7	13 7	10	11	10	12	11	7
ffß 14	3	5	2	3	1	6	14 9	3	2	2	3	3	3

Ruota cilindrica Divisione

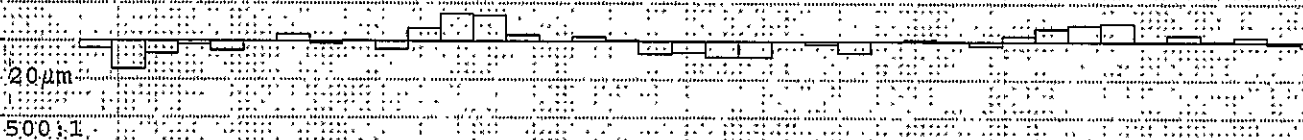


Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:22
Denominazione: Output Shaft 1		Numero denti z 38	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIIa H		Modulo m 1mm	Angolo elica 00°00'00"
Comessa/serie nr.: 50		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMER	Charge:	

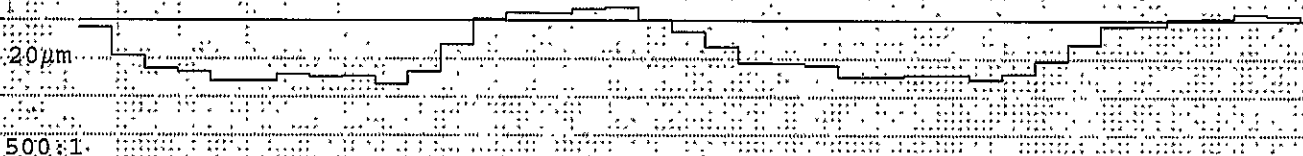
DIN 3962



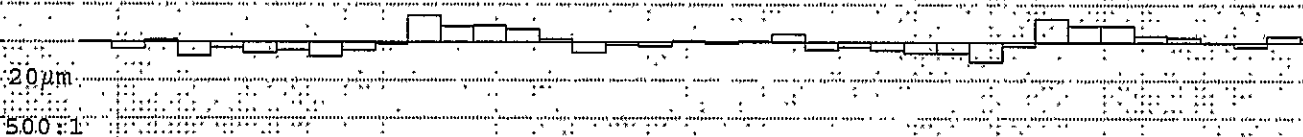
Errori singoli di divisione fp fianco sinistro



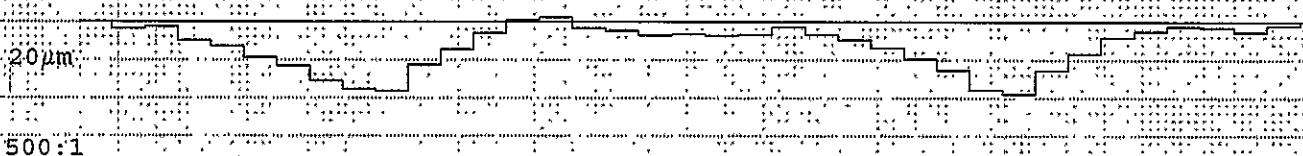
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



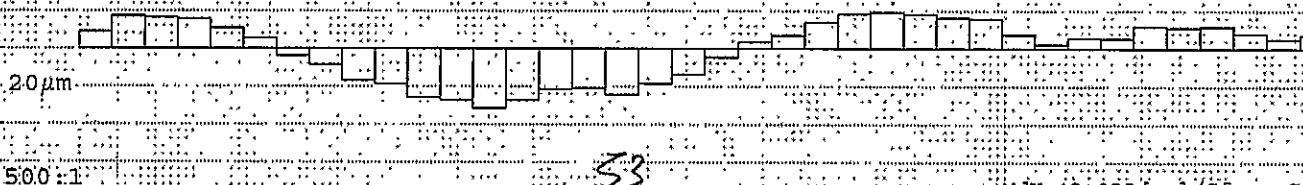
Corsa per misura divis.: 38.928 z=7.2mm

	fianco sinistro				fianco destro			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	7	6	18	9	7	6	18	9
Gr. salto di passo fu max	5	5			7	6		
Scarto di divisione Rp	14				12			
Err. globale di divisione Fp-e	20	7	50	9	20	7	50	9
Err. cordale di divisione Fpz/8	19	8			19	8		

DIN 3962

Centricità Fr (Ø-sfera =2mm)

⊙ : 18µm



Err. di concentricità	Fr	25	8	56	10	Val. amm	42.148	42.088	
Variaz. spessore dente	Rs					Val.	42.112	42.127	42.099

Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria



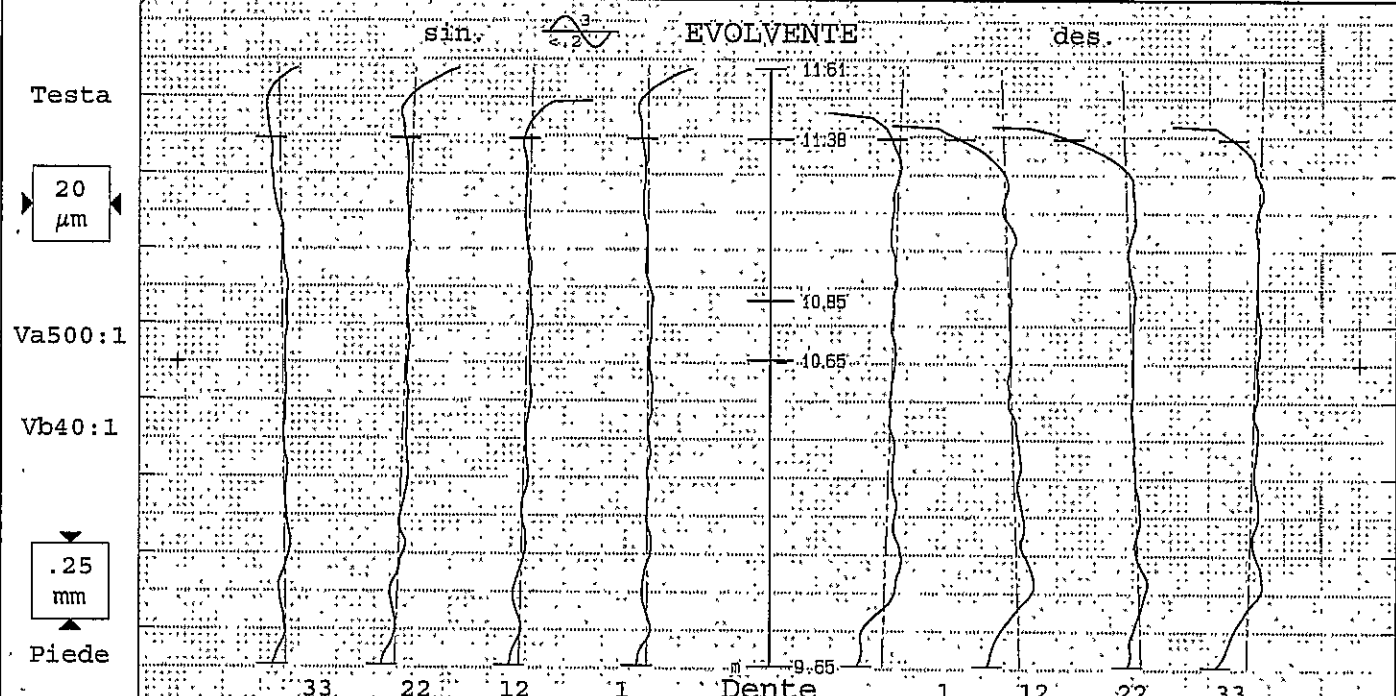
KUNGLINBERG



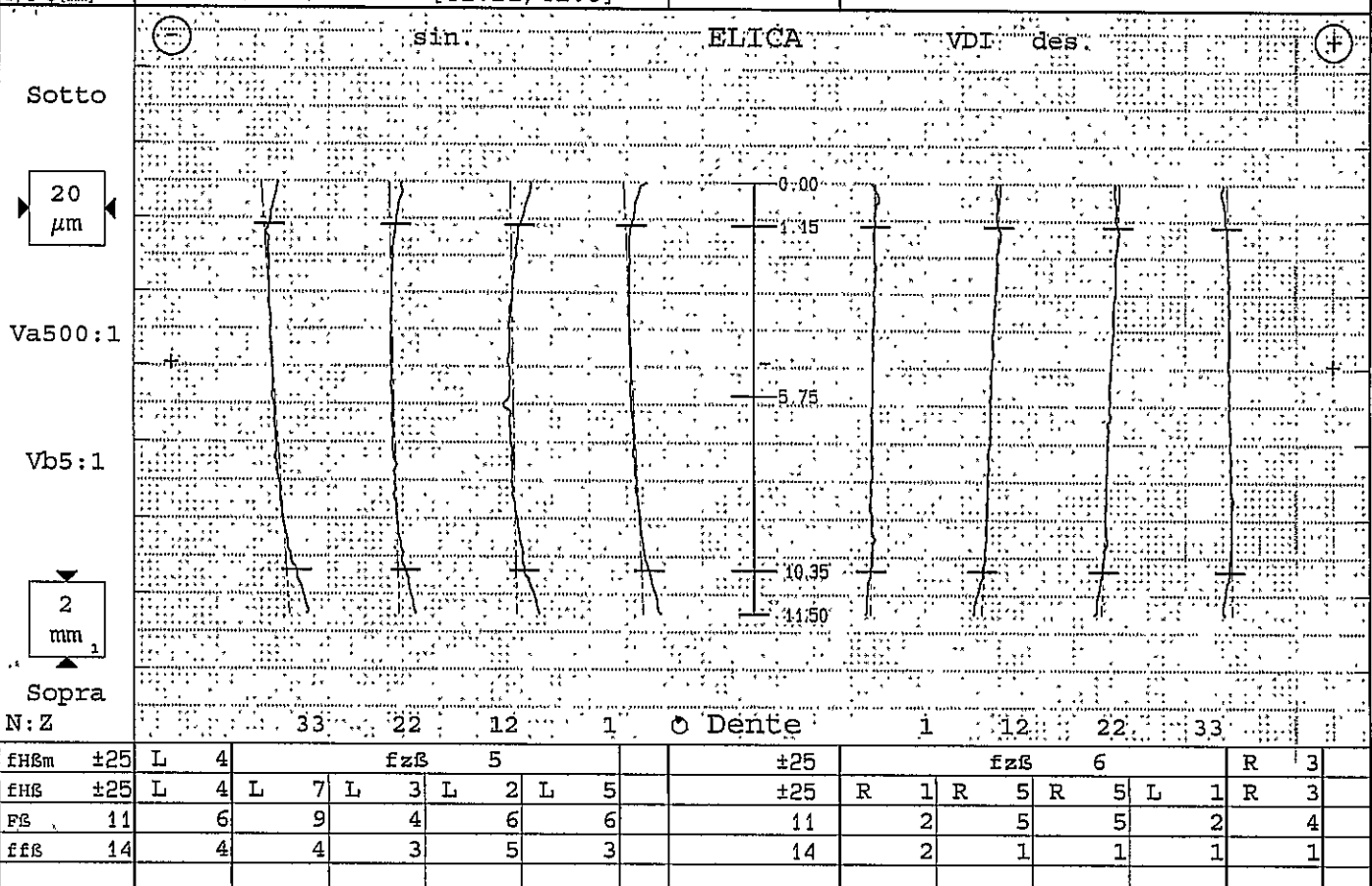
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:18
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno:	D51.6.1076.RIIa H		Modulo m	1mm	Tratto evolv. La	1.73mm
Commessa/serie nr.:	50		Angolo pressione	30°00'00"	Tratto elica L8	9.2mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E) .5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	- .05

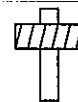


Tolerance	Medio	Val.misur [µm]				Qual	Tolerance	Val.misur [µm]				Medio	Qual
fHm	±14	-2	fza 7				±14	fza 10				10	
fHa	±14	-2	2	-5	-3	0	±14	5	-5	-5	4	0	
Fa	21	6	7	7	6	4	21	12	20	21	13	17	
ffa	16	5	5	5	4	4	16	11	16	17	12	14	
ffaf		0	4	3	3	3		0	0	0	0	0	
F/T-φ [mm]	41.327 21 [41.21/41.8]												



N: Z				33		22		12		1	Ø Dente		1		12		22		33				
fHßm	±25	L	4	fzß						5			±25	fzß						6	R	3	
fHß	±25	L	4	L	7	L	3	L	2	L	5		±25	R	1	R	5	R	5	L	1	R	3
Fß	11		6		9		4		6		6		11		2		5		5		2		4
ffß	14		4		4		3		5		3		14		2		1		1		1		1

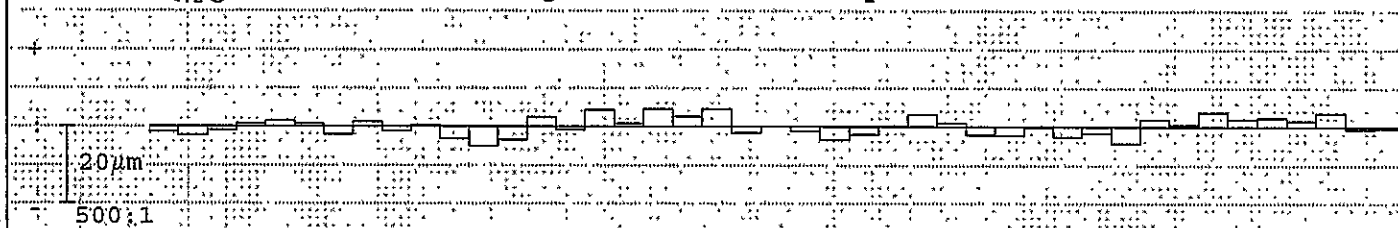
Ruota cilindrica Divisione



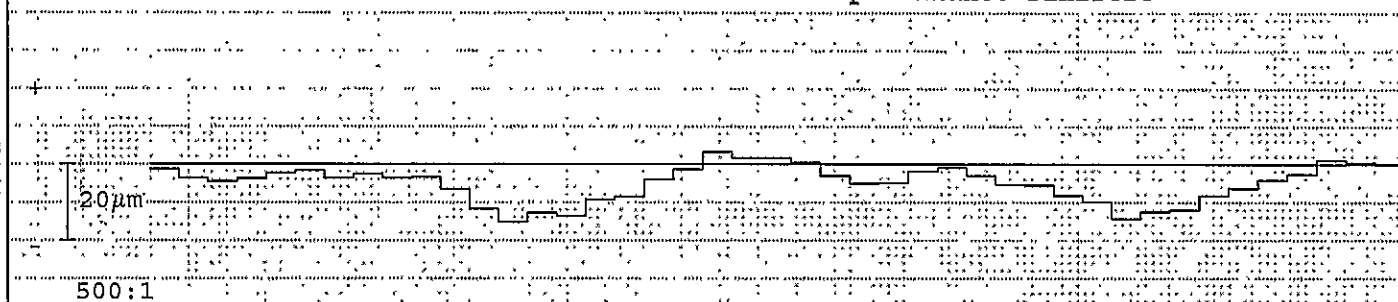
Nr. prog.: STI0410005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:18
Denominazione: Output Shaft 1		Numero denti z 43	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIa H		Modulo m 1mm	Angolo elica 00°00'00"
Commissa/serie nr.: 50		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMUL	Charge:	



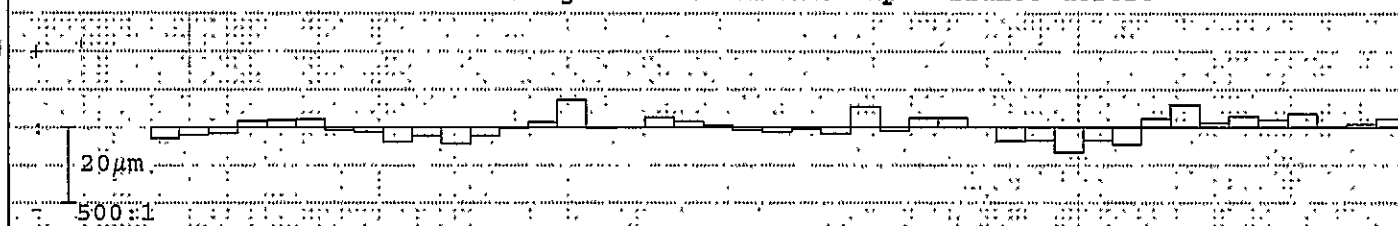
Errori singoli di divisione fp fianco sinistro



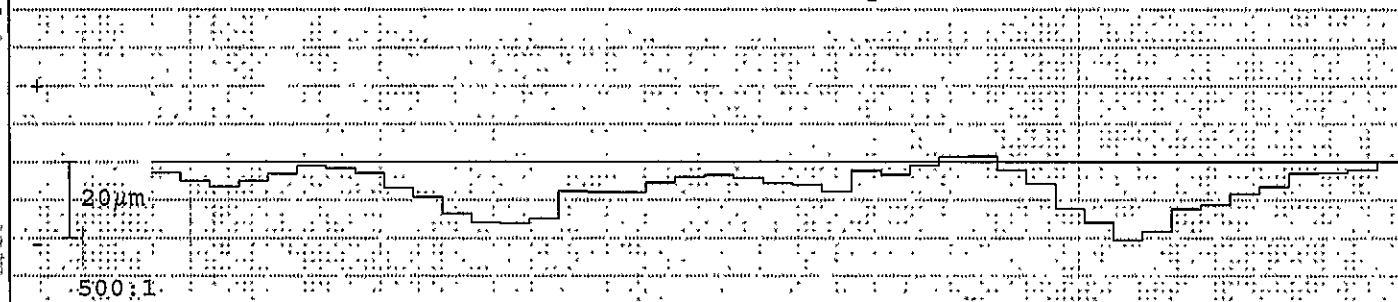
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro

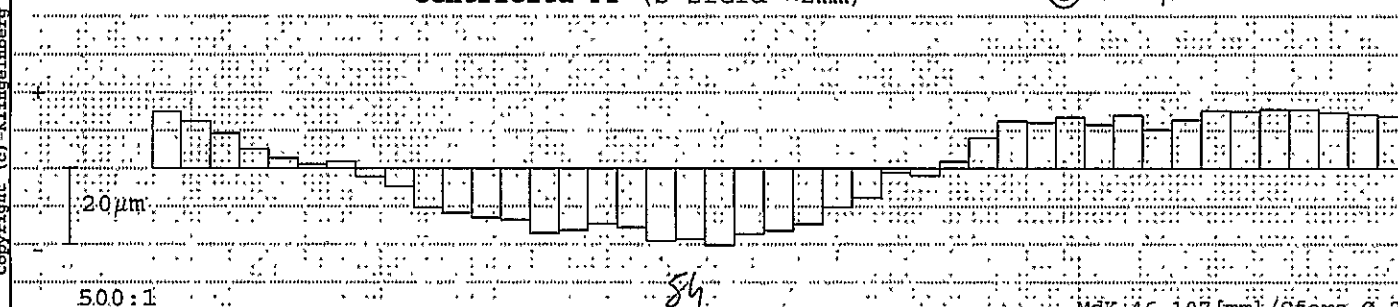


Correa per misura divis.: 43.096 z=5.8mm

		fianco sinistro		fianco destro	
		Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	5		17	
Gr. salto di passo	fu max	6		7	
Scarto di divisione	Rp	10		14	
Err. globale di divisione	Fp-e	18		40	
Err. cordale di divisione	Fpz/8	17		22	

Centricità Fr (Ø-sfera =2mm)

⊙ : 35µm



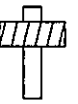
Err. di concentricità	Fr	36	50	Val. amm	46.231	46.167
Variaz. spessore dente	Rs			Val.	46.188	46.2 46.182

Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

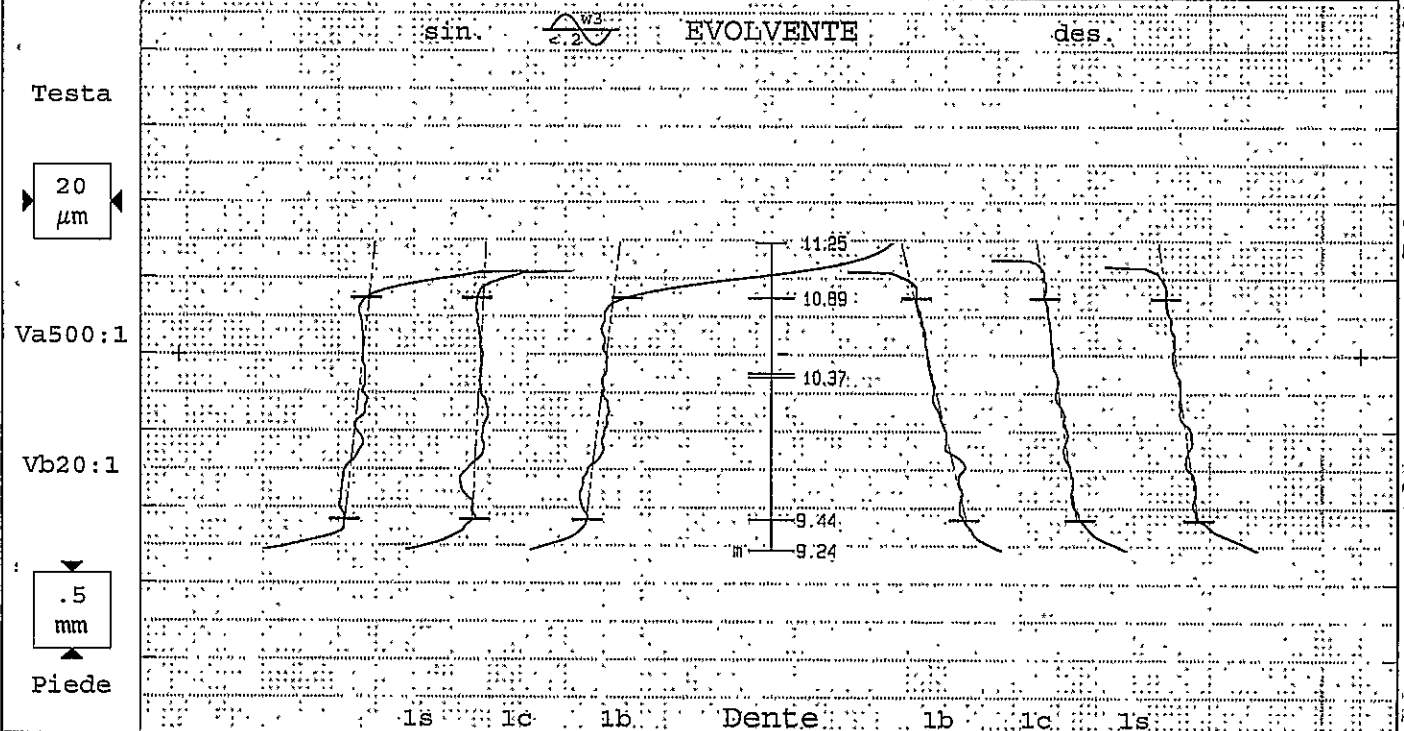




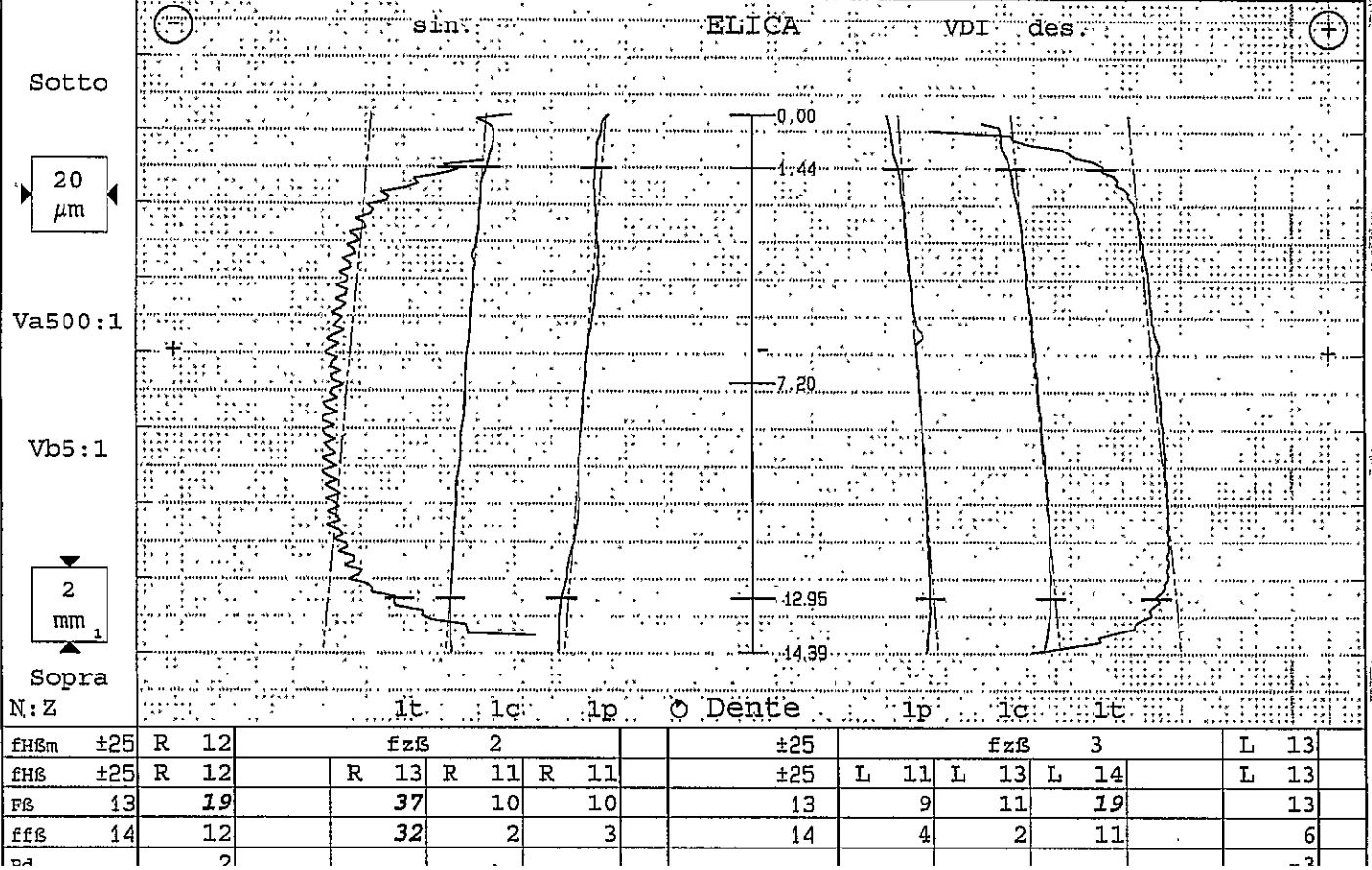
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllere:	TURNO d	Data:	02.02.2017 08:28
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51.6.1076.RIIIIaSH		Modulo m	1mm	Tratto evol. La	1.45mm
Commessa/serie nr.:	50		Angolo pressione	30°00'00"	Tratto elica Ls	11.51mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E) .5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	.45



Tolerance	Medio	Val.misur[μm]	Qual	Tolerance	Val.misur[μm]	Medio	Qual
fH _{om} ±14	-5	fz _a 4		±14	fz _a 6	-10	
fH _a ±14	-5	-6 -3 -7		±14	-14 -9 -8	-10	
F _a 22	9	8 7 12		22	13 9 9	10	
ff _a 16	6	5 7 6		16	4 2 3	3	
ff _{af}	0	21 17 14			7 12 15	0	



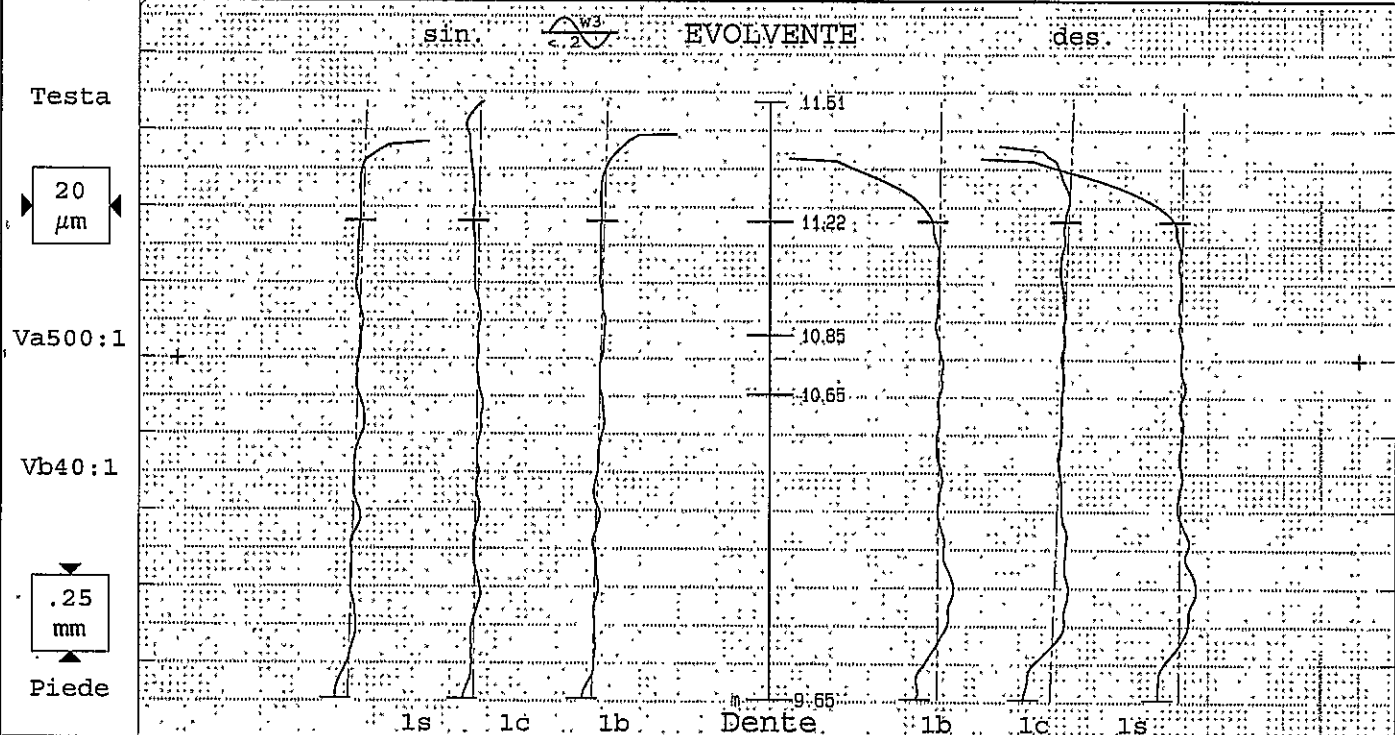
N:Z	1t	1c	1p	Ø Dente	1p	1c	1t
fH _{sm} ±25	R 12		fz _ß 2		±25	fz _ß 3	L 13
fH _ß ±25	R 12	R 13 R 11 R 11		±25	L 11 L 13 L 14		L 13
F _ß 13	19	37 10 10		13	9 11 19		13
ff _ß 14	12	32 2 3		14	4 2 11		6



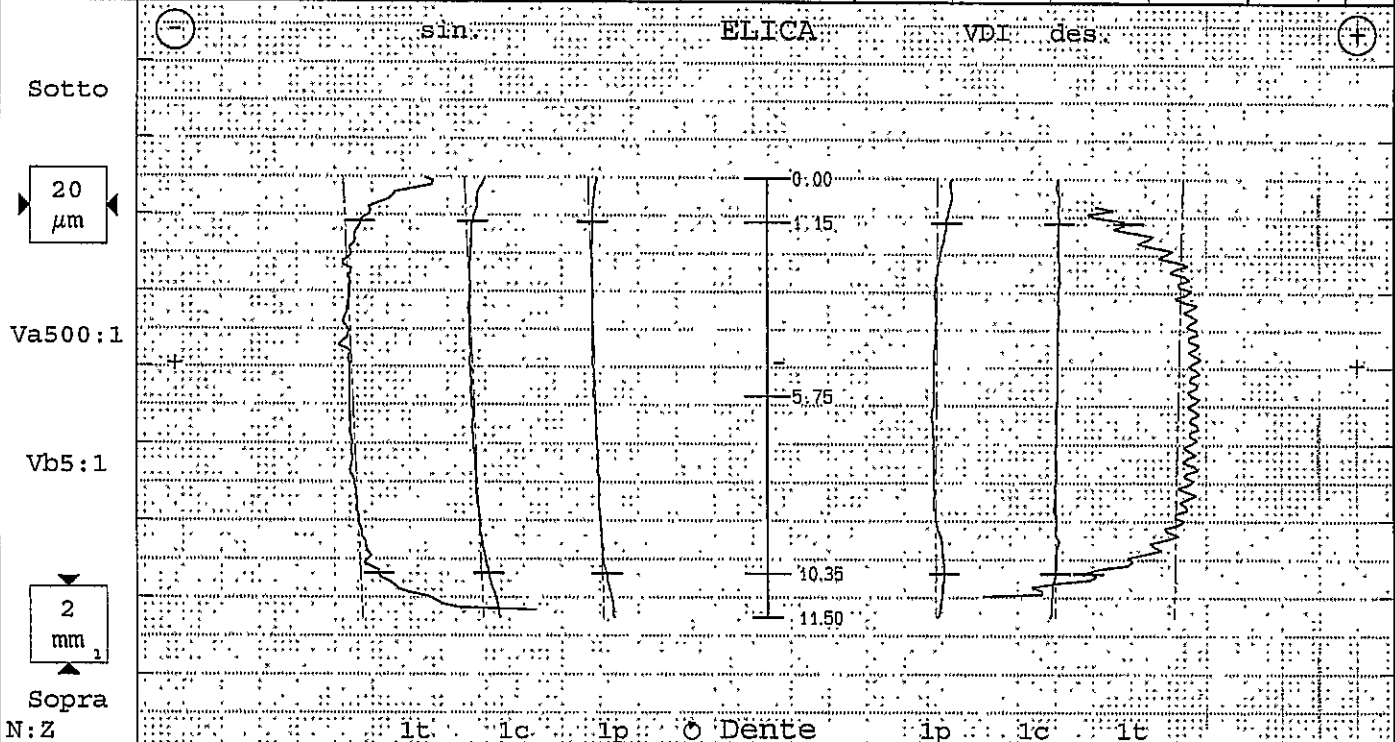
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410o05 0	P26 601265	Controllora:	TURNO d	Data:	02.02.2017 08:26
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa SH		Modulo m	1mm	Tratto evol. La	1.57mm
Commessa/serie nr.:	50		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E).5mm
Werkzeug:		Charge:	Ang. Base	00°00'00"	Fat.scor.pr. x	- .05



Tolerance	Medio	Val.misur[μ m]			Qual	Tolerance	Val.misur[μ m]			Medio	Qual
fHm	± 14	-3	fza 3			± 14	fza 4			2	
fHa	± 14	-3	-4	-1	-3	± 14	1	5	1	2	
Fa	21	6	8	5	6	21	10	12	10	11	
ffa	16	5	6	5	4	16	10	11	10	10	
ffaf		0	3	3	3		0	0	0	0	

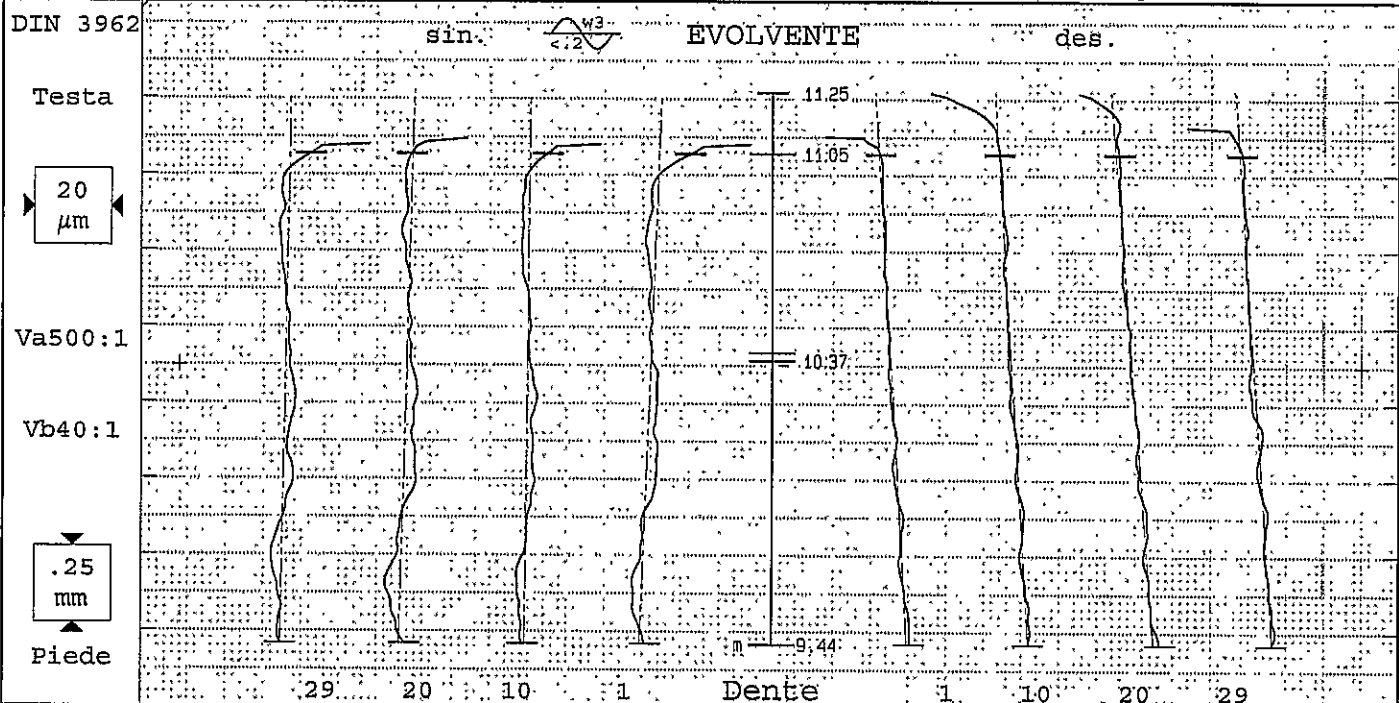


N:Z	1t	1c	1p	Ø Dente	1p	1c	1t	
fHm	± 25	L 5	Bd -1	fzß 1	± 25	Bd 2	fzß 2	R 2
fHß	± 25	L 5	L 5	L 4	± 25	R 1	R 1	R 3
Fß	11	7	11	5	4	4	2	30
ffß	14	4	8	3	2	4	2	29

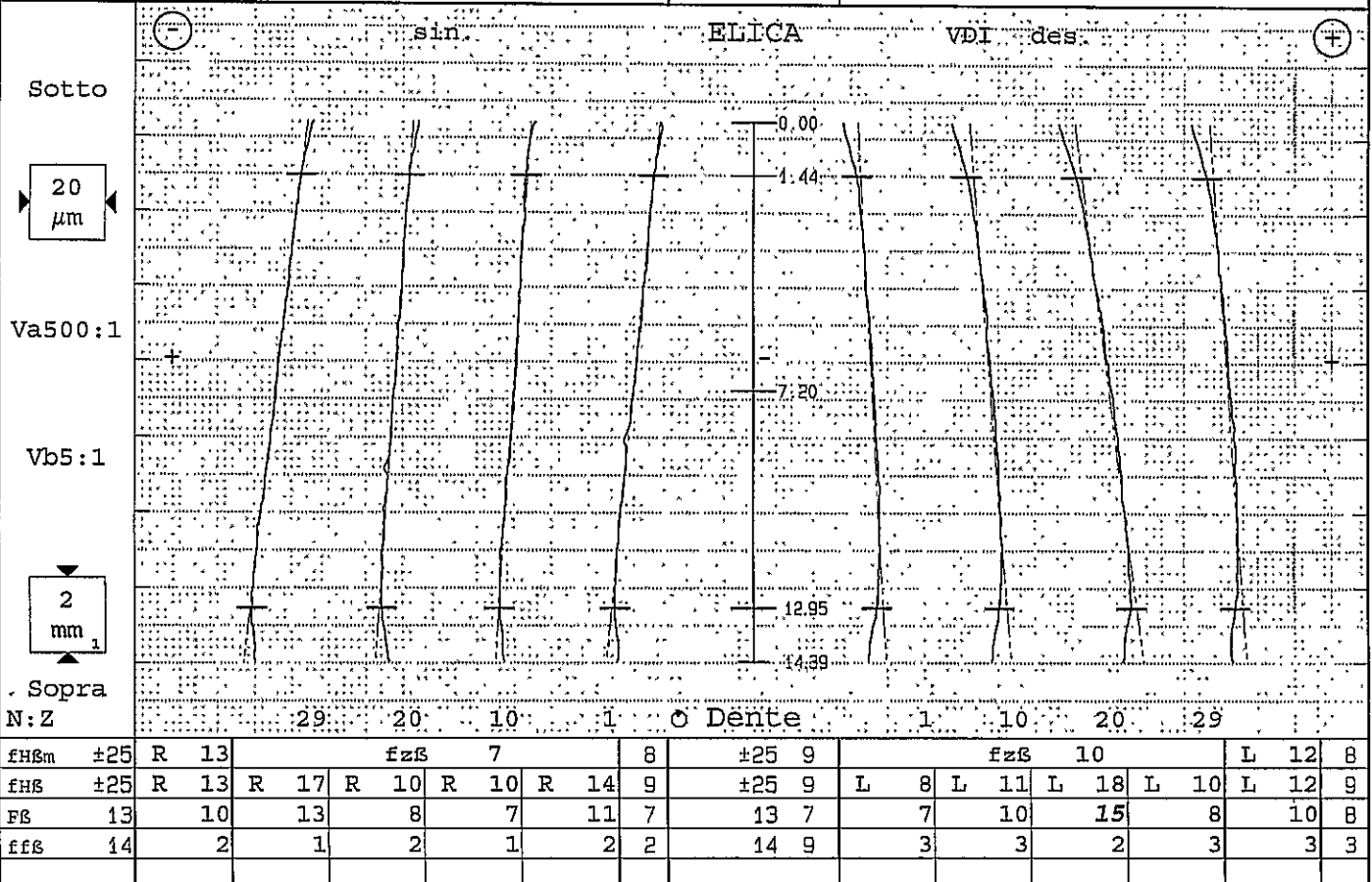
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:36
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno.:	D51.6.1076.RIIIa H		Modulo m	1mm	Tratto evol. La	1.61mm
Commessa/serie nr.:	52 (5)		Angolo pressione	30°00'00"	Tratto elica Ls	11.51mm
Masch.Nr.:	M001	Spindel: FORME	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	.45

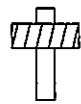


Tolerance	Medio	Val.misur [μ m]				Qual	Tolerance	Val.misur [μ m]				Medio	Qual
fHm	± 14	-3	fza 4				± 14	9	fza 2				-9 8
fHa	± 14	-3	-2	-4	-1	-5 6	± 14	9	-8	-8	-10	-9	-9 8
Fa	22	11	10	9	8	15 8	22	9	8	8	11	9	9 7
ffa	16	8	8	7	7	11 8	16	9	2	2	3	3	3 4
ffa	0	0	0	0	0				1	0	2	0	0
P/T- ϕ [mm]	37.380	26	[37.21/37.8]										



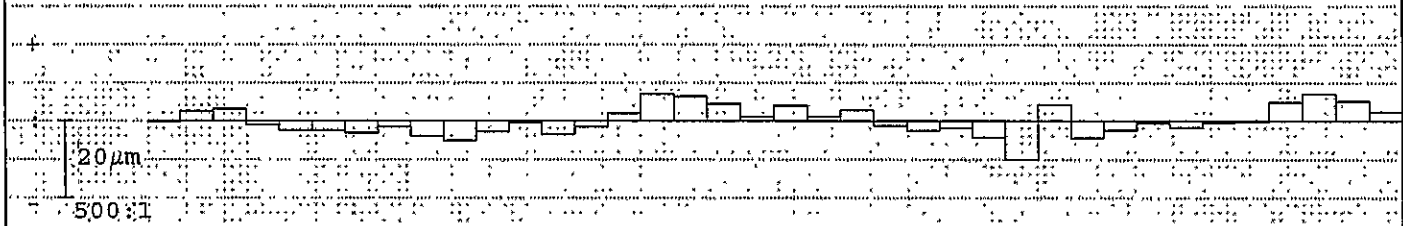
fHSm	±25	R 13	fzS 7					8	±25 9		fzS 10				L 12	8
fHS	±25	R 13	R 17	R 10	R 10	R 14	9	±25 9		L 8	L 11	L 18	L 10	L 12	9	
FS	13	10	13	8	7	11	7	13 7		7	10	15	8	10	8	
ffS	14	2	1	2	1	2	2	14 9		3	3	2	3	3	3	

Ruota cilindrica Divisione

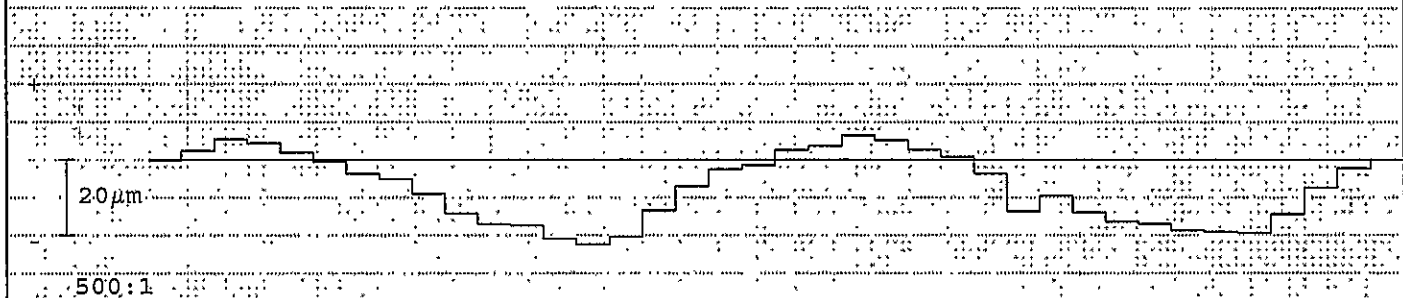


Nr. prog.: STI041005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:36
Denominazione: Output Shaft 1		Numero denti z 38	Angolo pressione 30°00'00"
Numero disegno.: D51.6.1076.RIIIa H		Modulo m 1mm	Angolo elica 00°00'00"
Comessa/serie nr.: 52		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM 1	Charge:	

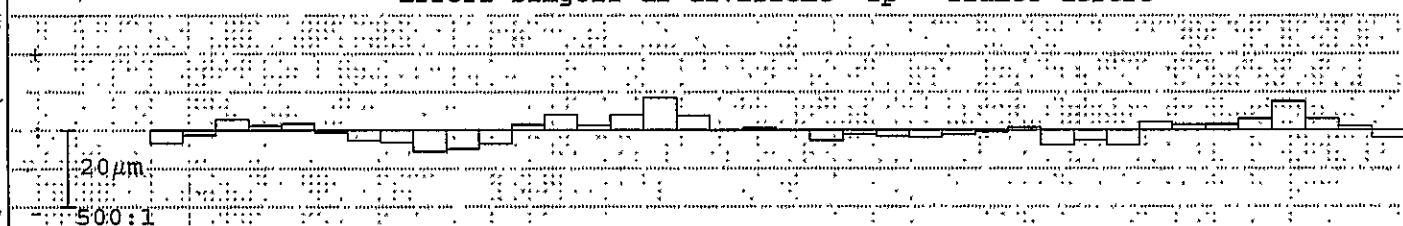
DIN 3962 $\frac{W3}{2}$ Errori singoli di divisione fp fianco sinistro



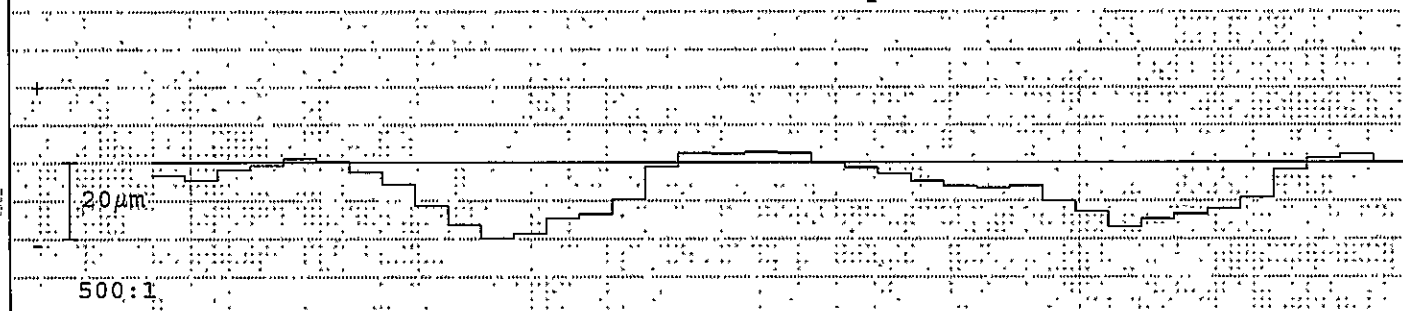
Errori singoli di divisione fp fianco sinistro



Errori singoli di divisione fp fianco destro

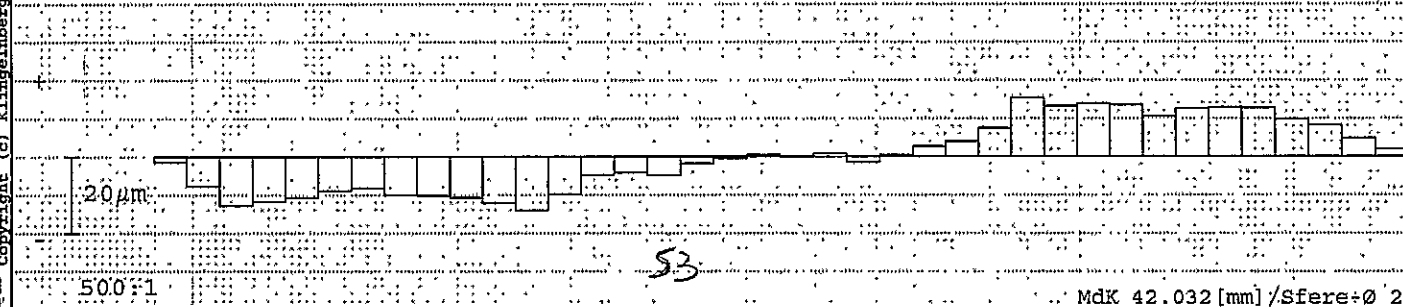


Errori singoli di divisione fp fianco destro



Corso per misura divis.: 38.928 z=7.2mm		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	10	8	18	9	8	7	18	9
Gr. salto di passo	fu max	14	8			6	5		
Scarto di divisione	Rp	17				14			
Err. globale di divisione	Fp-e	29	8	50	9	23	7	50	9
Err. cordale di divisione	Fpz/8	23	8			21	8		

DIN 3962 Centricità Fr (Ø-sfera =2mm) © : 24µm

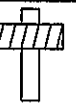


Err. di concentricità	Fr	29	9	56	10	Val. amm	42.148	42.088
Variaz. spessore dente	Rs					Val. l	42.113	42.121 42.098

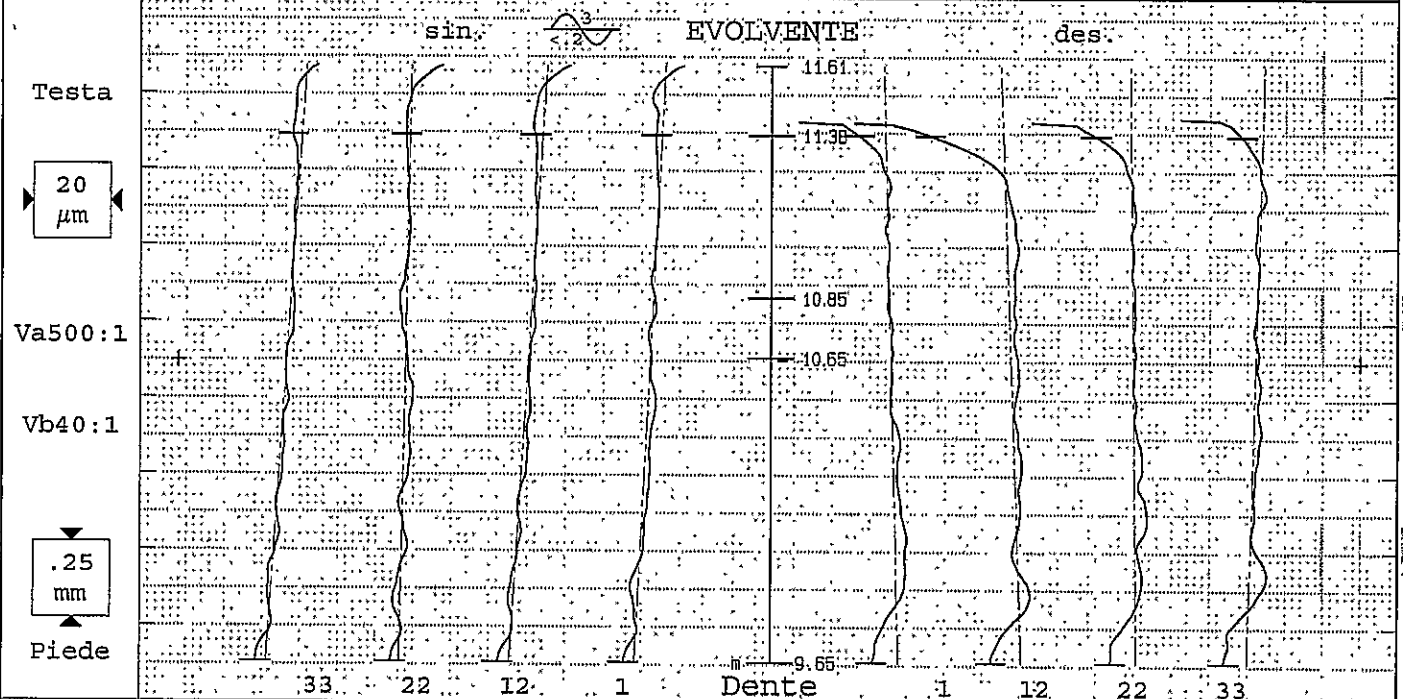
Docum.archiviato elettronicamente.Archiviazione cartacea non necessaria



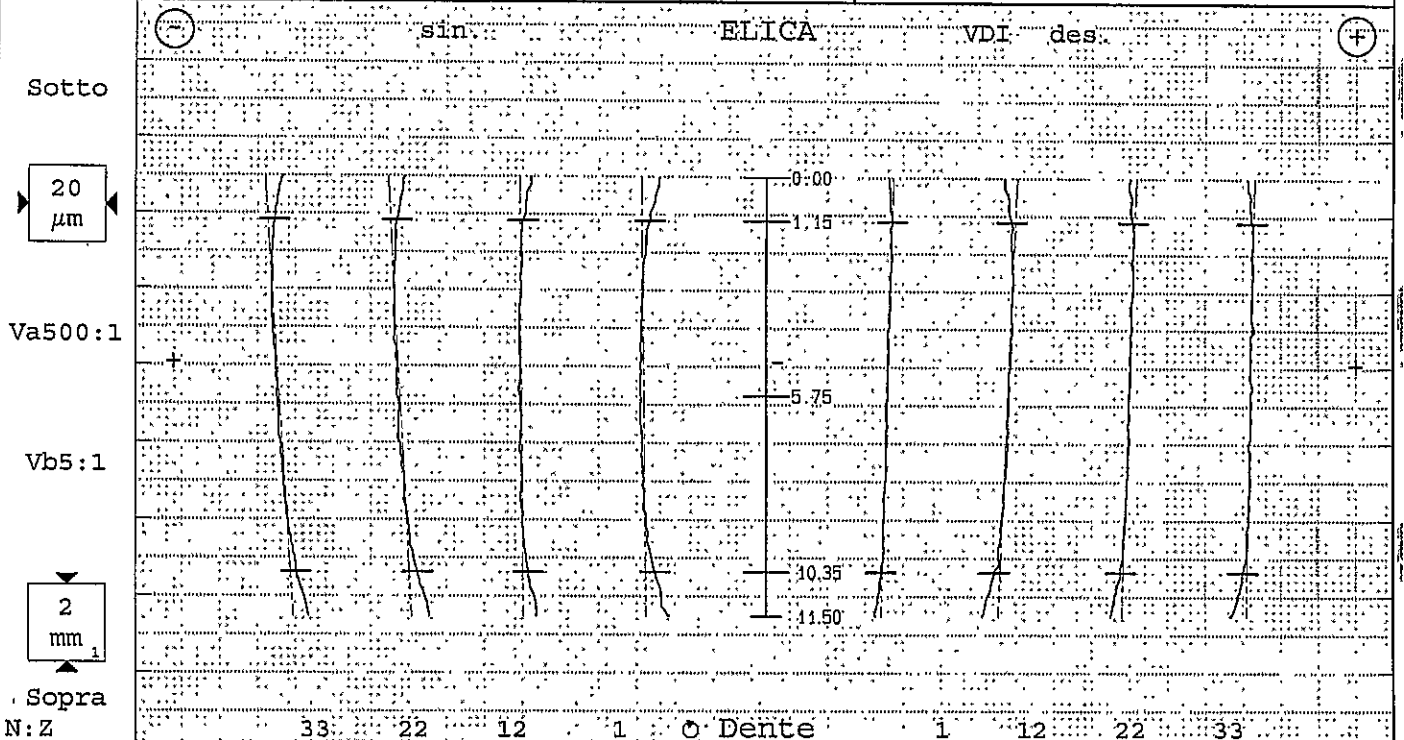
Ruota cilindrica Evolvente/Elica



Nr. prog.:	STI0410005 0	P26 601265	Controllora:	TURNO d	Data:	02.02.2017 08:32
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa H		Modulo m	1mm	Tratto evolv. La	1.73mm
Commessa/serie nr.:	52		Angolo pressione	30°00'00"	Tratto elica L8	9.2mm
Masch.Nr.:	M001	Spindel: Form	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	-.05



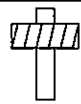
Tolerance	Medio	Val.misur [µm]					Qual	Tolerance	Val.misur [µm]					Medio	Qual
fHm	±14	-7	fza 6					±14	fza 9					-2	
fHa	±14	-7	-9	-3	-9	-7		±14	-4	-5	-2	4		-2	
Fa	21	9	11	6	10	9		21	13	27	14	11		16	
ffa	16	5	4	5	5	5		16	10	22	13	11		14	
faf		0	3	2	3	3			0	0	0	0		0	
P/T-φ [mm]	41.327 21 [41.21/41.8]														



fHßm	±25	L	4	fzß				7		±25	fzß				3	R	4						
fHß	±25	L	4	L	8	L	6	L	1	L	1		±25	R	3	R	5	R	4	R	2	R	4
Fß	11		5		7		6		3		4		11		3		5		4		3		4
ffß	14		3		3		3		2		3		14		1		2		1		2		2



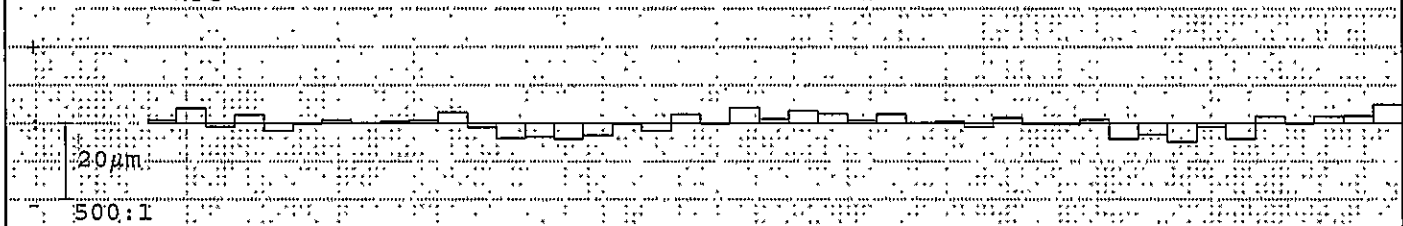
Ruota cilindrica Divisione



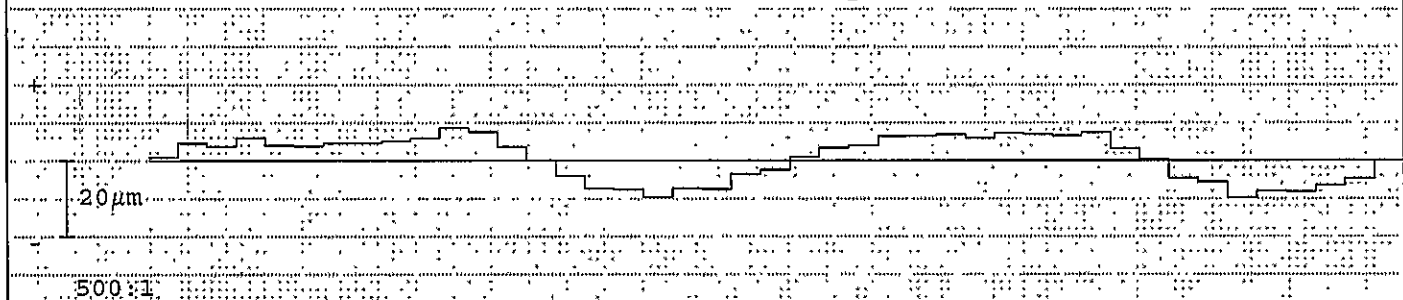
Nr. prog.: STI041005 0	P26 601265	Controllore: TURNO d	Data: 02.02.2017 08:32
Denominazione: Output Shaft 1		Numero denti z 43	Angolo pressione 30°00'00"
Numero disegno: D51.6.1076.RIIa H		Modulo m 1mm	Angolo elicica 00°00'00"
Comessa/serie nr.: 52		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerk	Charge:	



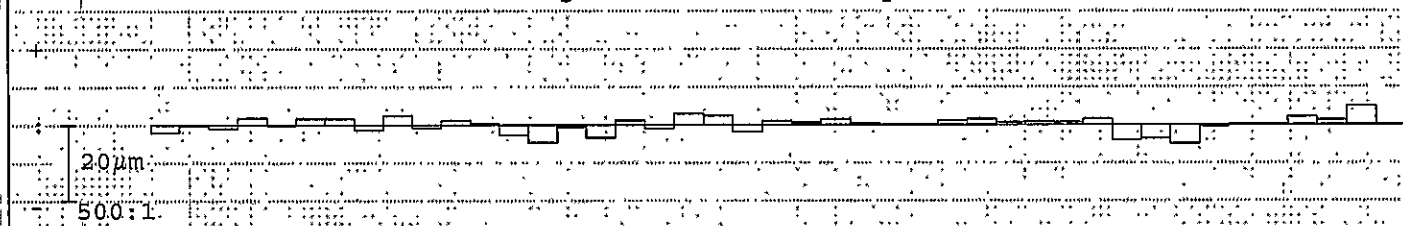
Errori singoli di divisione fp fianco sinistro



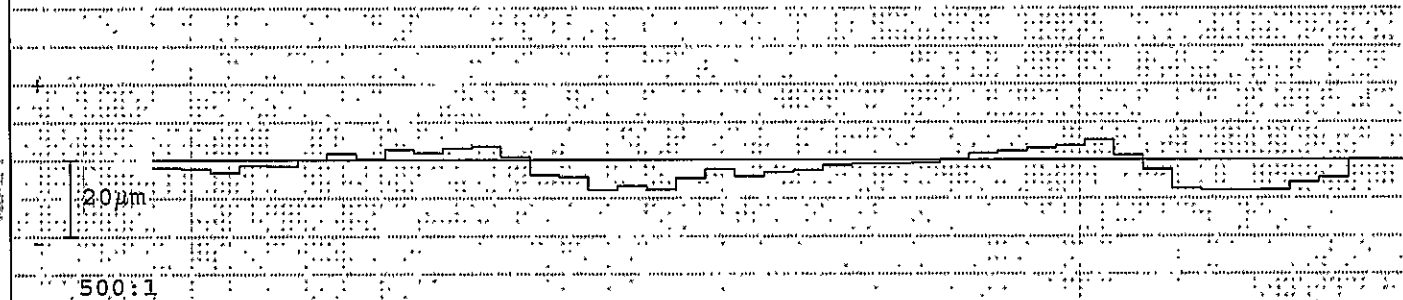
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro



Errore somma di divisione Fp fianco destro



Corso per misura divis.: 43.096 z=5.8mm

		fianco sinistro				fianco destro			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	5		17		5		17	
Gr. salto di passo	fu max	6				6			
Scarto di divisione	Rp	10				10			
Err. globale di divisione	Fp-e	18		40		13		40	
Err. cordale di divisione	Fpz/8	17				13			

Centricità Fr (Ø-sfera =2mm)

© : 27µm



Err. di concentricità	Fr	31	50	Val. amm	46.231	46.167
Variaz. spessore dente	Rs			Val.	46.189	46.198

Mdk 46.107 [mm] / Sfere-Ø 2

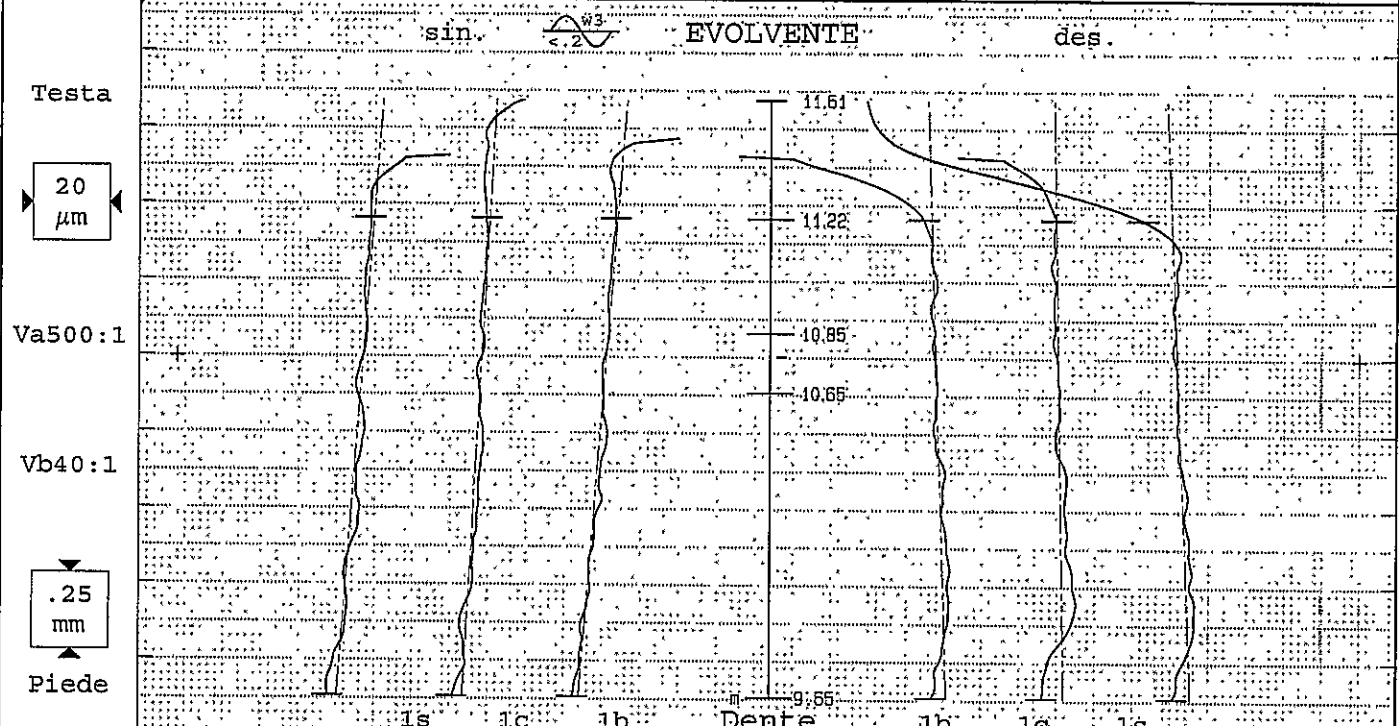


Docum. archiviato elettronicamente. Archiviazione cartacea non necessaria

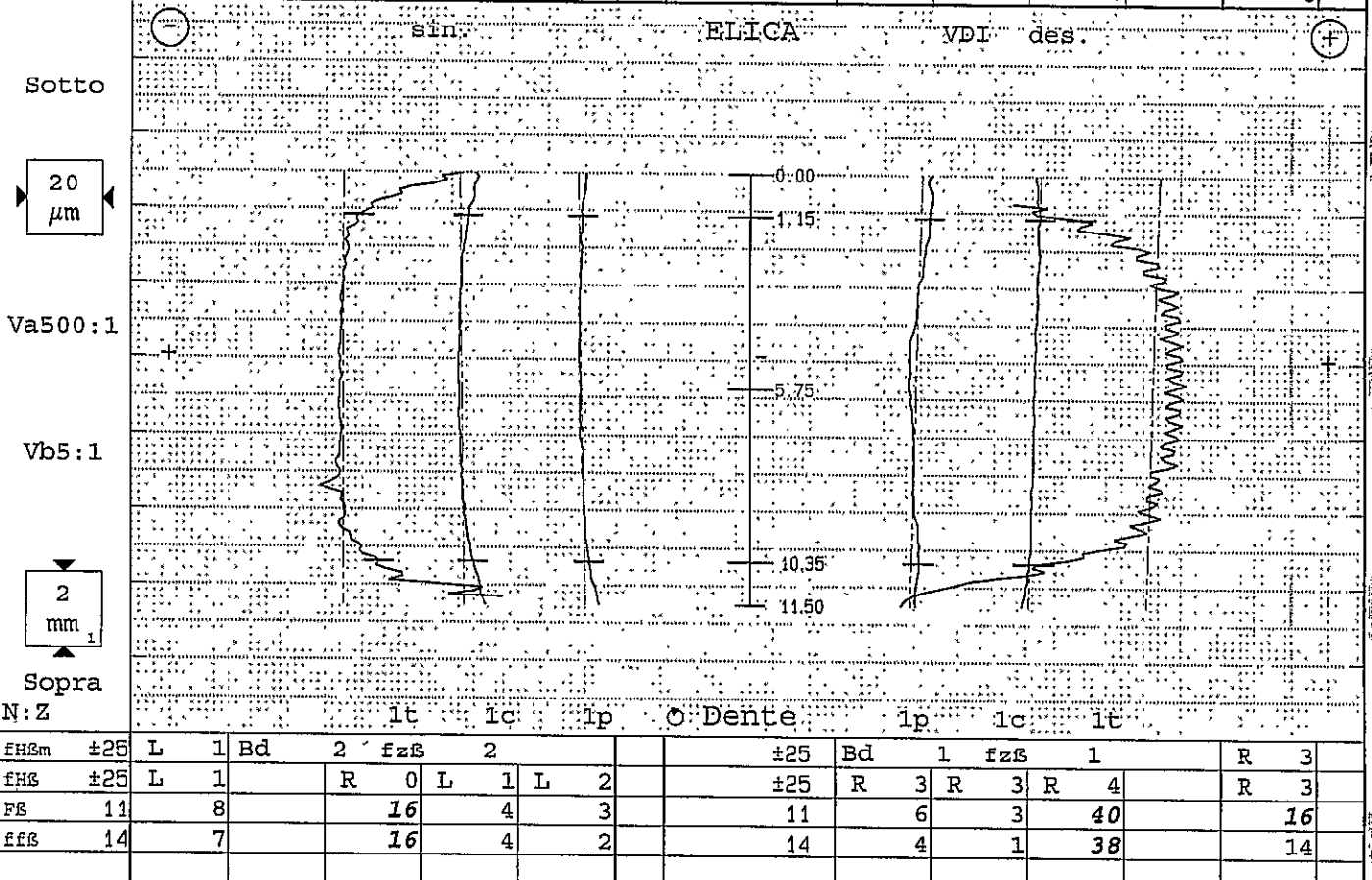
Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllora:	TURNO d	Data:	02.02.2017 08:40
Denominazione:	Output Shaft 1		Numero denti z	43	Largh.fasc.dent. b	11.5mm
Numero disegno.:	D51.6.1076.RIIa SH		Modulo m	1mm	Tratto evol. La	1.57mm
Commissa/serie nr.:	52		Angolo pressione	30°00'00"	Tratto elica Ls	9.2mm
Masch.Nr.:	M001	Spindel: FORME	Angolo elica	00°00'00"	Inizio elab. M1	9.65mm
Untersuchungszweck:	Laufende Messung		Ø Base db	37.2391mm	Palpatore Ø	(#5E).5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.pr. x	-.05



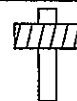
Tolerance	Medio	Val.misur [μ m]	Qual	Tolerance	Val.misur [μ m]	Medio	Qual
fHm	± 14	-9		± 14	-4		
fHa	± 14	-9		± 14	-4		
Fa	21	10		21	10		
ffa	16	5		16	9		
ffaF	0	2		0	0		



fHm	± 25	L	1	Bd	2	fzB	2		± 25	Bd	1	fzB	1		R	3	
fHs	± 25	L	1		R	0	L	1	± 25	R	3	R	3	R	4	R	3
Fs	11		8			16		4	11		6		3		40		16
ffs	14		7			16		4	14		4		1		38		14



Ruota cilindrica Svergolamento



Nr. prog.:	STI0410005 0	P26 601265	Controllore:	TURNO d	Data:	02.02.2017 08:41
Denominazione:	Output Shaft 1		Numero denti z	38	Largh.fasc.dent. b	14.39mm
Numero disegno:	D51.6.1076.RIIIaSH		Modulo m	1mm	Tratto evol. La	1.45mm
Commessa/serie nr.:	52		Angolo pressione	30°00'00"	Tratto elica Ls	11.51mm
Masch.Nr.:	M001	Spindel: Formu	Angolo elica	00°00'00"	Inizio elab. M1	9.44mm
Untersuchungszweck:	Laufende Messung		Ø Base db	32.909mm	Palpatore Ø	(#5E) .5mm
Werkzeug:	Charge:		Ang. Base	00°00'00"	Fat.scor.gr. x	.45

Testa

20
µm

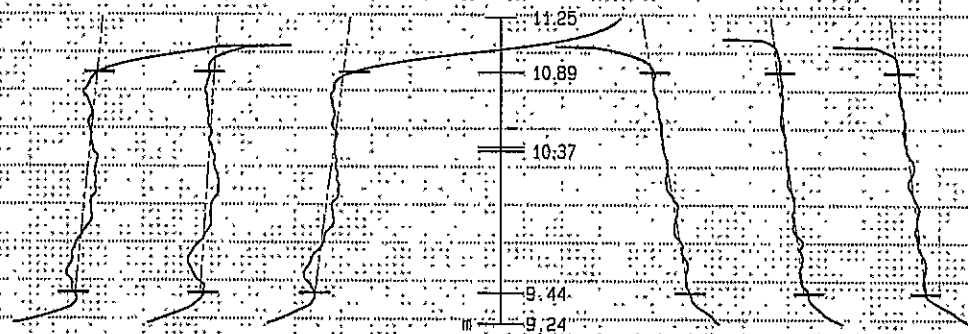
Va500:1

Vb20:1

.5
mm

Piede

sin. EVOLVENTE des.



ls lc lb Dente lb lc ls

Tolerance	Medio	Val.misur [µm]			Qual	Tolerance	Val.misur [µm]			Medio	Qual
fHsm ±14	-6	fza 3				±14	fza 3			-8	
fHa ±14	-6	-6	-4	-7		±14	-10	-7	-8	-8	
Fa 22	10	9	8	13		22	10	8	7	8	
ffa 16	6	6	7	6		16	2	2	2	2	
ffaaf	0	16	13	12			7	9	11	0	

Sotto

20
µm

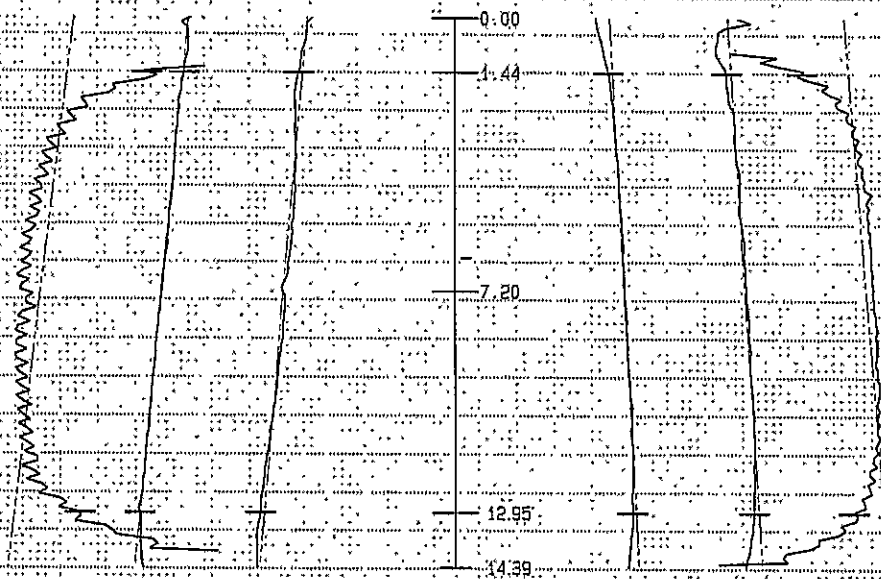
Va500:1

Vb5:1

2
mm

Sopra

sin. ELICA VDI des.



N:Z	lt	lc	lp	Ø Dente	lp	lc	lt		
fHßm ±25	R 15	fzß 5			±25	fzß 4			L 10
fHß ±25	R 15	R 18	R 14	R 13	±25	L 8	L 9	L 12	L 10
Fß 13	20	39	12	10	13	7	8	22	12
ffß 14	12	31	1	3	14	2	2	17	7
Bd	5								-4