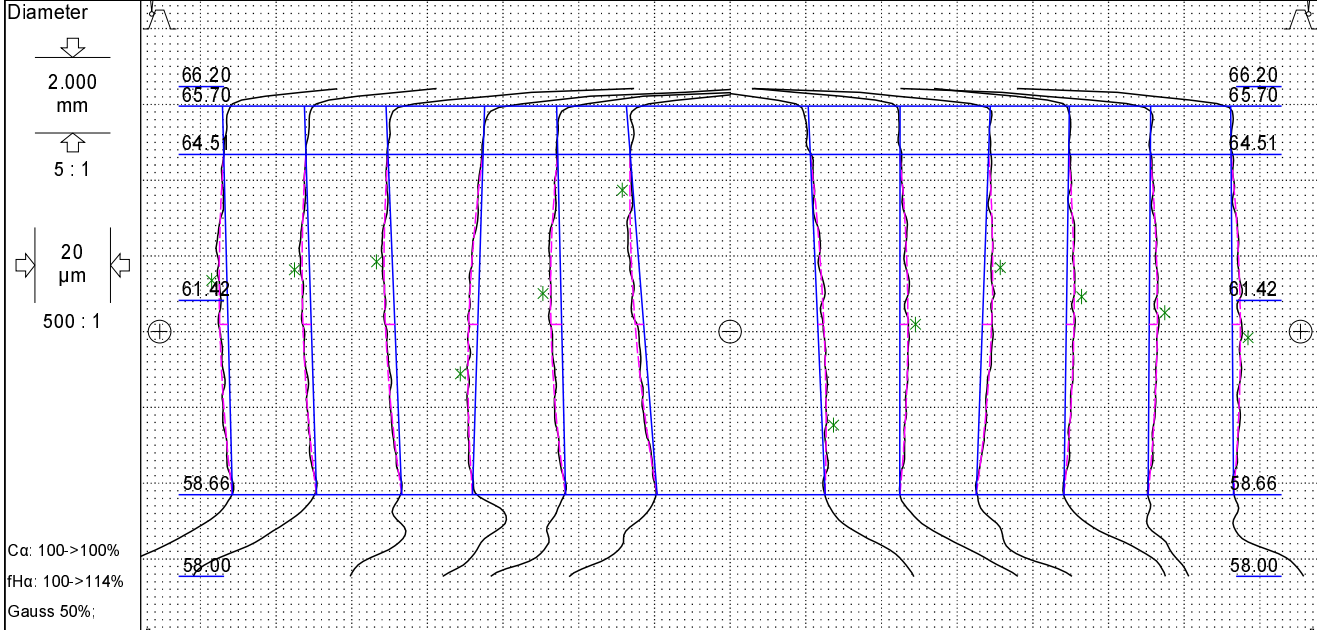


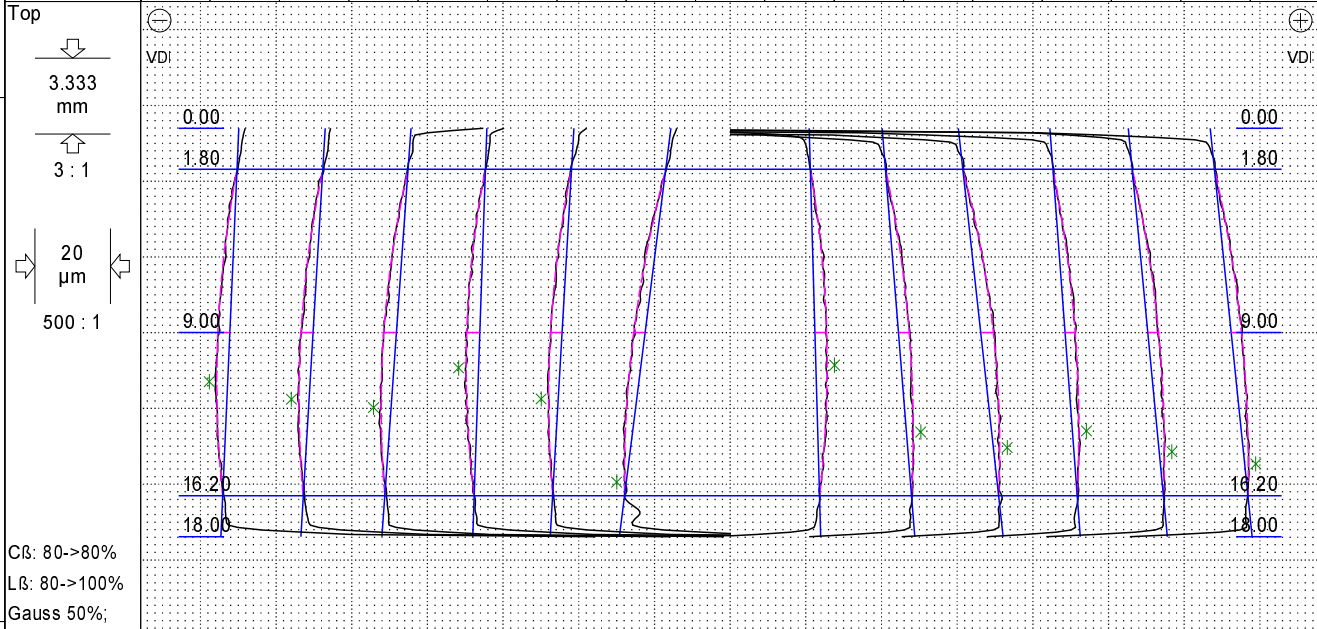
SIA LEAX Rezekne - Profile and Lead Inspection (Distortion) (1/2)



VCC32249127/33742588/HardGrinding-160		Sun Gear 8.57	
Remark:		Unit of measure: mm	
Number: VCC32249127 #10	Gear Data: 33742588; Rev:002	Tool ID: -	
Order no.: VCCS	Part Drawing: 3374317; Rev:1	Tool ID2: -	
z: 37	an: 17°0'0"	db: 57.6106	x: 0.205882
mn: 1.43	β: 30°0'0" L	d: 61.0952	b: 18



Left Flank								Right Flank								
[...]	x	#29	#20	#10	#1*	#1	#1*	Tooth	#1*	#1	#1*	#10	#20	#29	x	[...]
0/4	2	2	1	1	1	2	2	ffa	1	2	3	2	2	3	2	0/4
-7/9	3	3	3	4	-3	2	8	fHa*	-4	0	4	2	1	-1	0	-7/9
-3/5	3							fHam							0	-3/5
0/4	2	2	2	3	2	3	2	Ca	2	2	2	2	2	2	2	0/4
0/8	2							fsa							3	0/8
					-11			Bias			8					
					16.200	9.000	1.800	Height	1.800	9.000	16.200					
					Bottom	Center	Top	Position	Top	Center	Bottom					



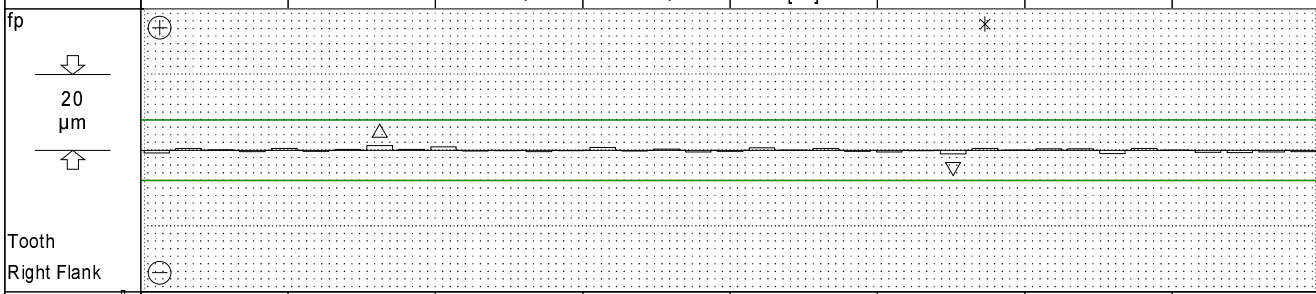
Left Flank								Right Flank								
[...]	x	#29	#20	#10	#1*	#1	#1*	Tooth	#1*	#1	#1*	#10	#20	#29	x	[...]
0/4	1	1	1	1	1	1	1	ffβ	1	1	1	1	1	1	1	0/4
-1/15	6	5	6	8	4	6	14	fHβ	-3	-9	-12	-8	-10	-11	-10	-18/-2
3/11	6							fHβm							-10	-14/-6
1/7	3	3	3	3	3	3	3	Cβ	3	3	3	3	3	3	3	0/6
0/8	3							fsβ							3	0/8
-21/-5					-10			Bd			-9					-21/-5
					63.803	61.424	58.657	Diameter	58.657	61.424	63.803					
					Tip	Center	Root	Position	Root	Center	Tip					

SIA LEAX Rezekne - Pitch and Runout Test (2/2)

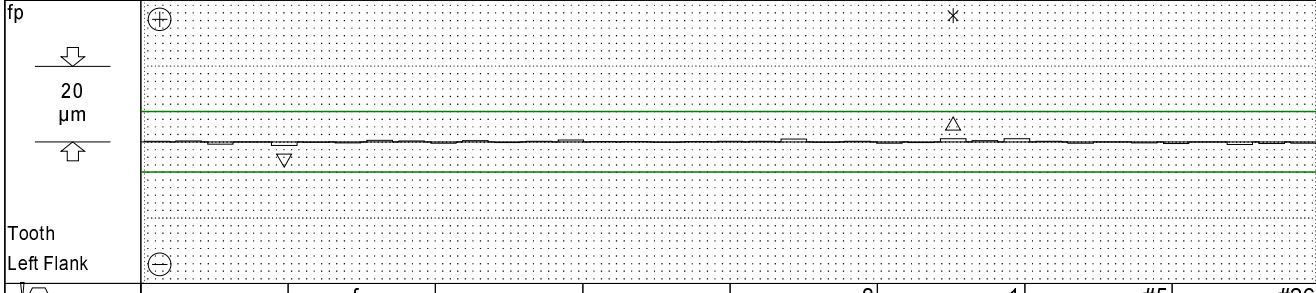


VCC32249127/33742588/HardGrinding-160		Sun Gear 8.57	
Remark:		Unit of measure: mm	φ1
Number: VCC32249127 #10	Gear Data: 33742588; Rev:002	Tool ID: -	
Order no.: VCCS	Part Drawing: 3374317; Rev:1	Tool ID2: -	
z: 37	αn: 17°0'0"	db: 57.6106	x: 0.205882
mn: 1.43	β: 30°0'0" L	d: 61.0952	b: 18
		Dev clockwise	

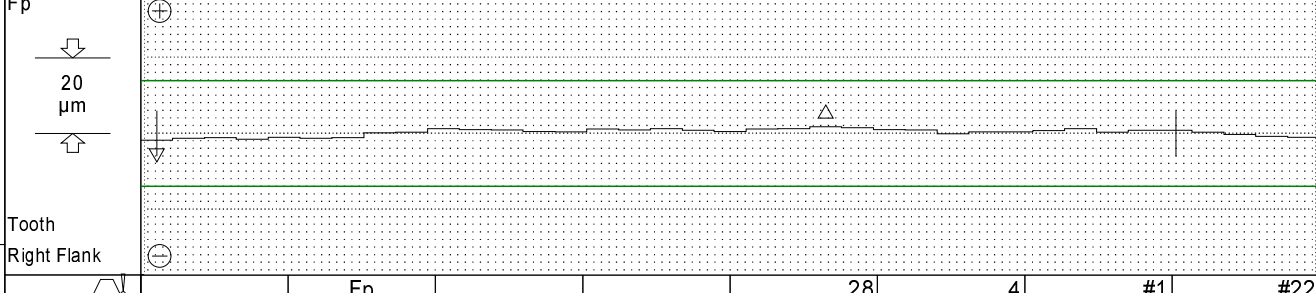
	Standard	!=Q	=Q	[...]	Dev	Min.	Max.
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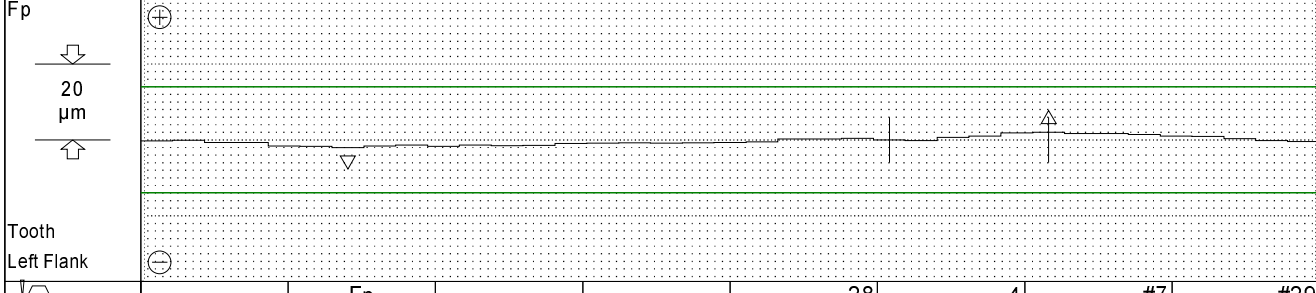
fp	8	1	#26	#8
fu	9	1		#27
fum		1		



fp	8	1	#5	#26
fu	9	1		#26
fum		0		



Fp	28	4	#1	#22
Fpz/8		3	#33	#1



Fp	28	4	#7	#29
Fpz/8		2	#24	#29



Fr	22	5	#30	#10
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Task	Actual	Min.	Max.	Nominal	U.tol	L.tol	Dev
Span measurement(n = 6)	24.497	24.495	24.499	24.492	0.021	-0.021	0.005
Dim. over two balls(D= 2.500, Z= 9.000)	65.186	65.185	65.187	65.171	0.060	-0.060	0.015

Measurement protocol SIA LEAX Rezekne

VCC32249127/33742588/Tip&Root-160

Number	Gear Data	Order no.	Part Drawing
VCC32249127 #10	33742588; Rev:002	VCCS	3374317; Rev:1

Inspector	Date	Time	Serial-No.
Laboratory	08.11.2019	13:54:12	

Def	Task	Sy	Actual	Nominal	U.tol	L.tol	Dev	Exc
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Unit of measure: mm / Angle system: DEG

Tip circle (Z)= 9.000 / Reference: Gaussian

Diameter	4P D	65.932	66.000	0.000	-0.100	-0.068	--
	MIN	65.928					
	MAX	65.935					

Root circle (Z)= 9.000 / Reference: Gaussian

Diameter	4P D	56.631	56.700	0.000	-0.200	-0.069	++
	MIN	56.625					
	MAX	56.636					