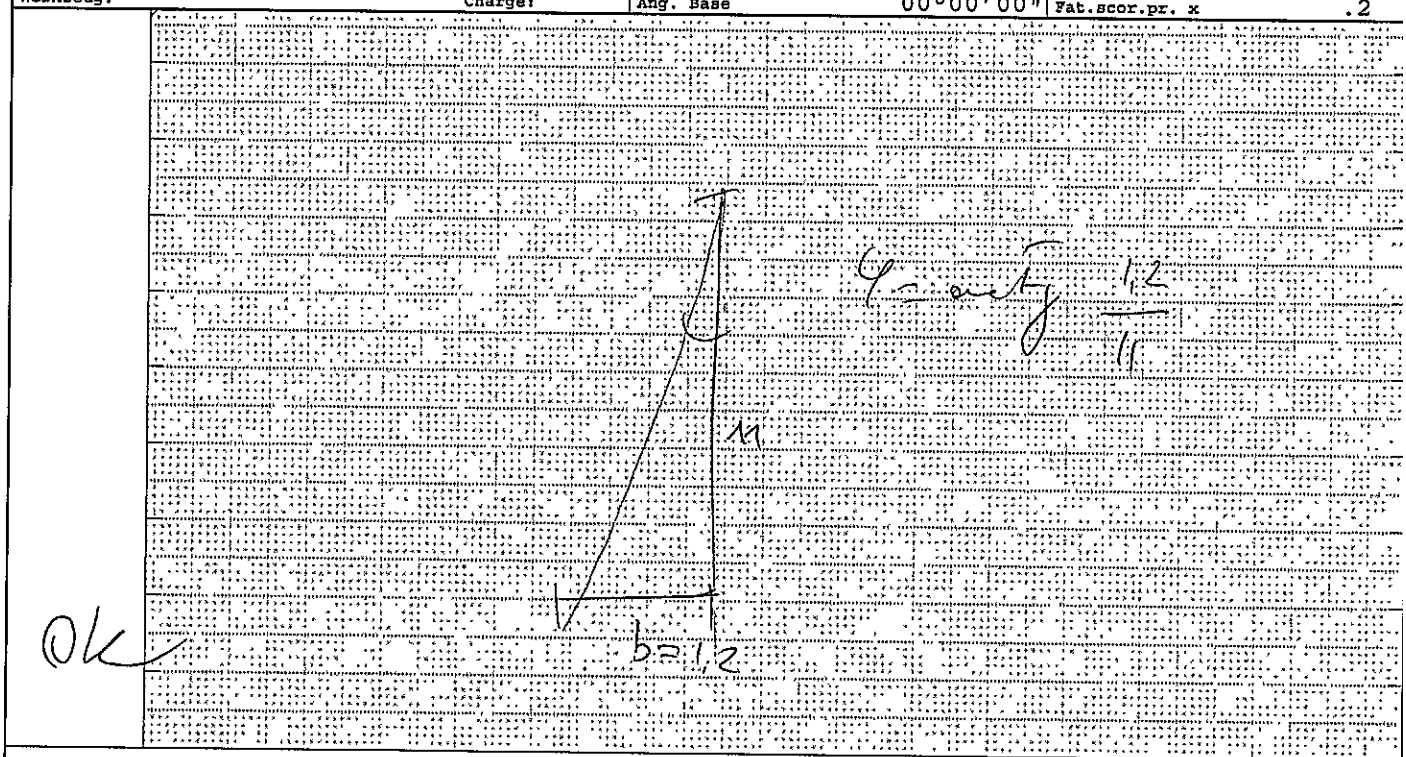
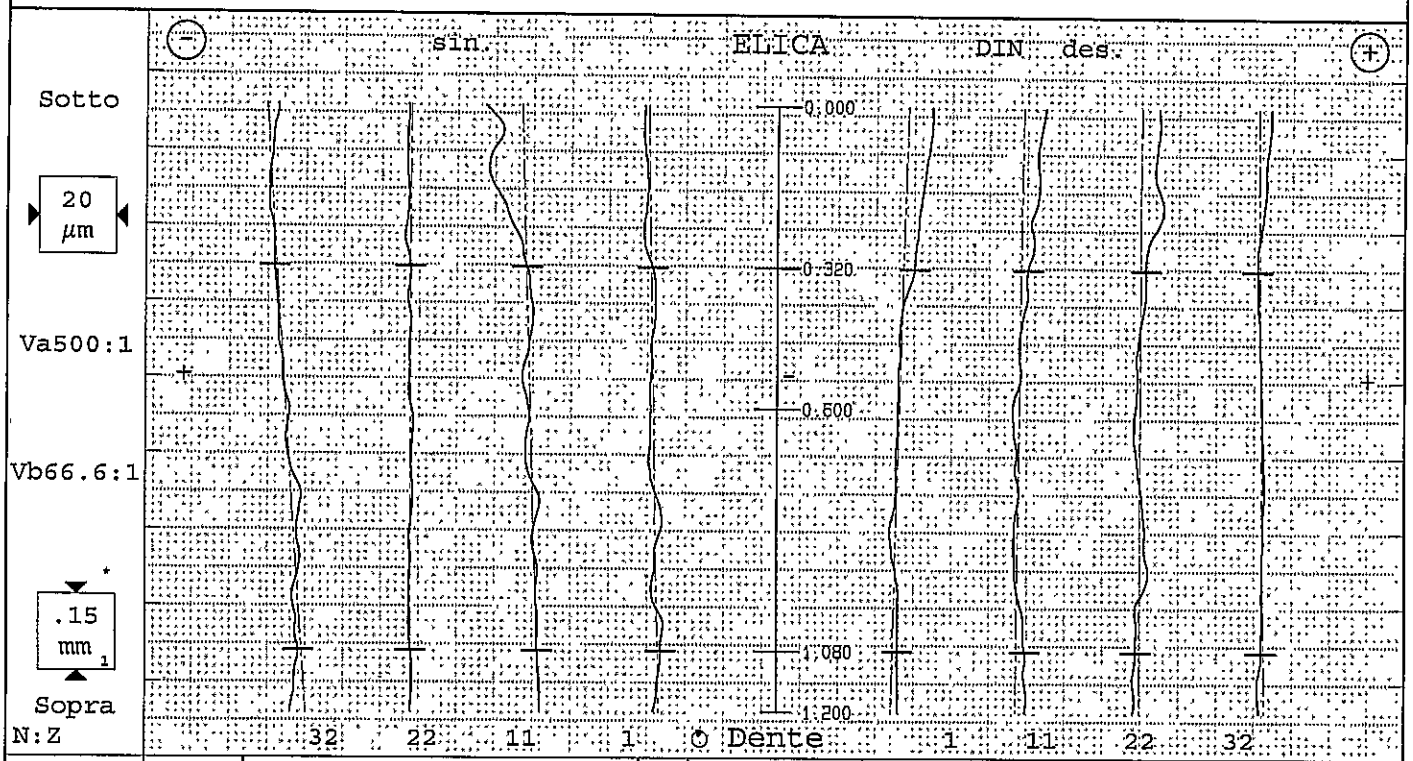
# GETRAG B7590

# Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 P26 B7590 | Controllore: | TURNO c | Data: | 21.05.2014 15:20 |
| Denominazione: | CA SR3 di pezzo | Numero denti z | 42 | Largh.fasc.dent. b | 1.2mm |
| Numero disegno.: | 250.1.5169.75-KK H | Modulo m | 2mm | Tratto evolv. La | 2.29mm |
| Commessa/serie nr.: | 1 | Angolo pressione | 30°00'00" | Tratto elica Lß | .76mm |
| Masch.Nr.: | | Angolo elica | 04°30'00"/-04°30'00" | Inizio elab. M1 | 21.91mm |
| Untersuchungszweck: | | Ø Base db | 72.7461mm | Palpatore ø | (#2C) 1mm |
| Werkzeug: | Charge: | Ang. Base | 00°00'00" | Fat.scor.pr. x | .2 |




N:Z 32 22 11 1 ⊙ Dente 1 11 22 32

| | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| fHßm ±16 | -5 | Var 11 | | | | | ±16 | Var 6 | | | | 1 | |
| fHß | -5 | -11 | 0 | -5 | -3 | | | 4 | 2 | 0 | -2 | 1 | |
| Fß | 5 | 7 | 2 | 5 | 4 | | | 7 | 4 | 4 | 2 | 4 | |
| ffß | 3 | 4 | 1 | 4 | 3 | | | 5 | 4 | 4 | 2 | 4 | |
| Cß | 0 | -2 | -1 | 1 | 2 | | | -3 | -3 | -1 | 1 | -2 | |

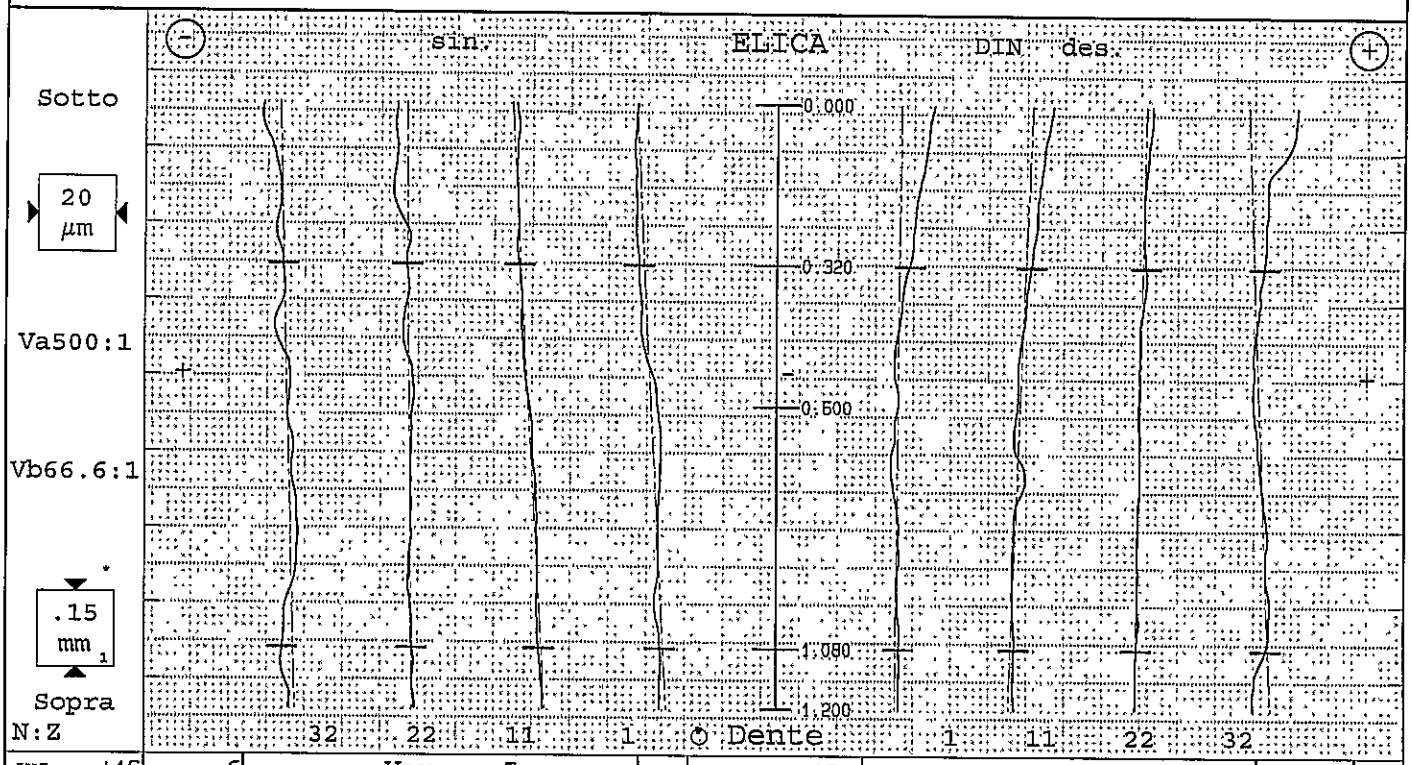


KLINGELNBERG

# GETRAG B7590

## Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 P26 B7590 | Controllore: | TURNO c | Data: | 21.05.2014 15:18 |
| Denominazione: | CA SR3 di pezzo | Numero denti z | 42 | Largh.fasc.dent. b | 1.2mm |
| Numero disegno.: | 250.1.5169.75-KK H | Modulo m | 2mm | Tratto evolv. La | 2.29mm |
| Commessa/serie nr.: | 2 | Angolo pressione | 30°00'00" | Tratto elica Lß | .76mm |
| Masch.Nr.: | | Angolo elica | 04°30'00"/-04°30'00" | Inizio elab. M1 | 21.91mm |
| Untersuchungszweck: | | Ø Base db | 72.7461mm | Palpatore Ø | (#2C) 1mm |
| Werkzeug: | Charge: | Ang. Base | 00°00'00" | Fat.scor.pr. x | .2 |




| | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| fHßm | ±16 | -6 | Var | 7 | | | ±16 | Var | 12 | | 1 |
| fHß | | -6 | -4 | -2 | -9 | -8 | | 1 | 6 | 3 | -6 | 1 |
| Fß | | 5 | 6 | 3 | 5 | 6 | | 5 | 5 | 3 | 4 | 4 |
| ffß | | 4 | 5 | 3 | 2 | 4 | | 4 | 3 | 1 | 4 | 3 |
| Cß | | -2 | -3 | -1 | -1 | -4 | | -2 | -1 | -1 | -2 | -2 |

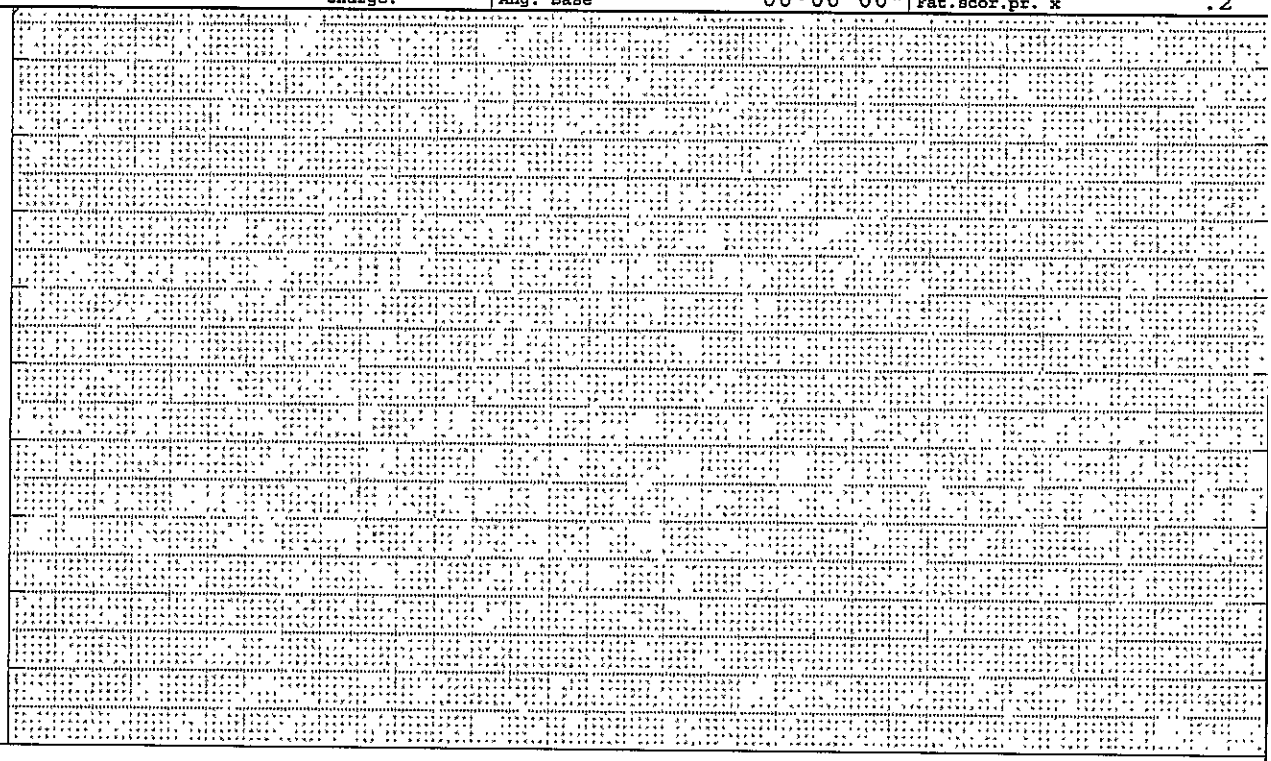


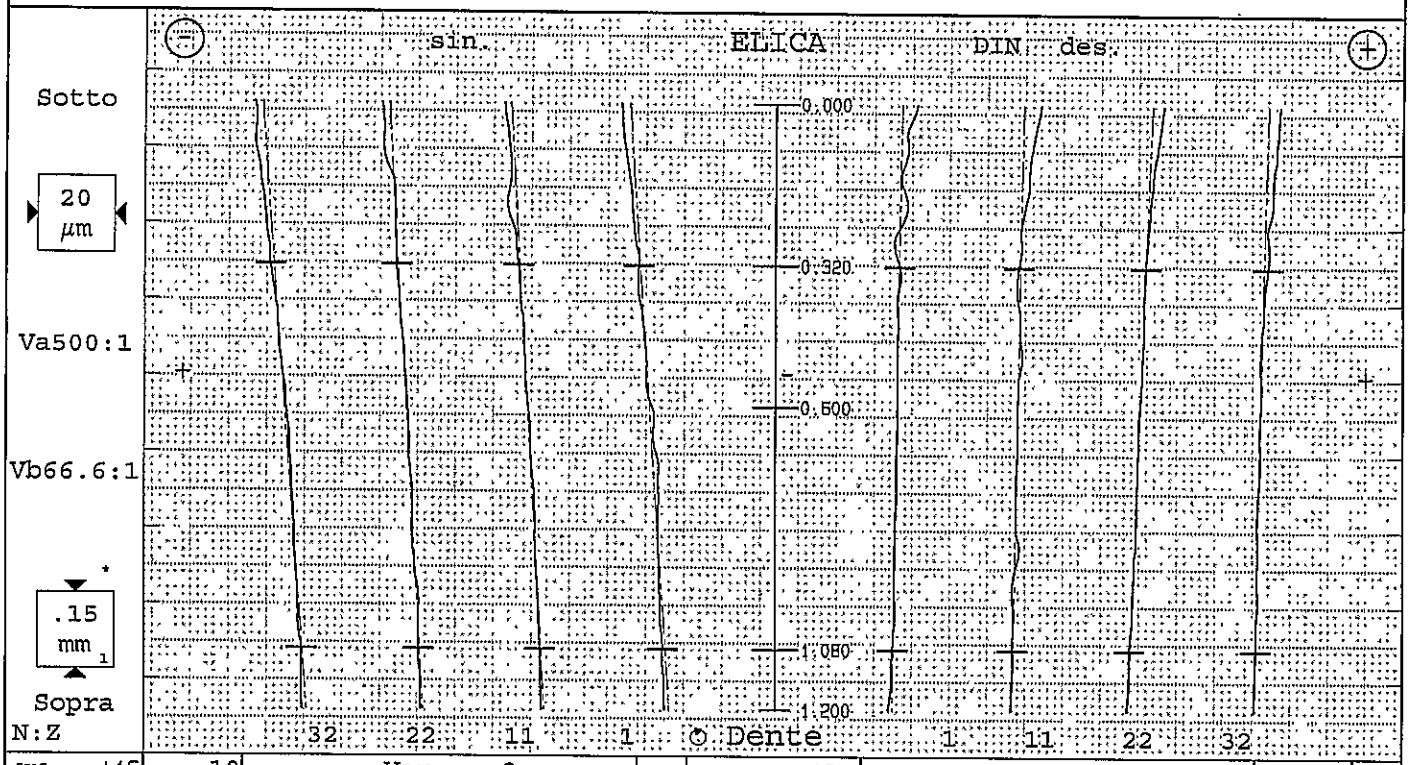
KLINGELNBERG

# GETRAG B7590

# Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 P26 B7590 | Controllore: | TURNO c | Data: | 21.05.2014 15:16 |
| Denominazione: | CA SR3 di pezzo | Numero denti z | 42 | Largh.fasc.dent. b | 1.2mm |
| Numero disegno.: | 250.1.5169.75-KK H | Modulo m | 2mm | Tratto evolv. La | 2.29mm |
| Commessa/serie nr.: | 3 | Angolo pressione | 30°00'00" | Tratto elica Lß | .76mm |
| Masch.Nr.: | | Angolo elica | 04°30'00"/-04°30'00" | Inizio elab. M1 | 21.91mm |
| Untersuchungszweck: | | Ø Base db | 72.7461mm | Palpatore ø | (#2C) 1mm |
| Werkzeug: | Charge: | Ang. Base | 00°00'00" | Fat.scor.pr. x | .2 |






N:Z 32 22 11 1 ⊙ Dente 1 11 22 32

| | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| fHßm ±16 | -10 | Var 3 | | | | | ±16 | Var 4 | | | | 4 |
| fHß | -10 | -12 | -9 | -9 | -10 | | | 2 | 3 | 6 | 4 | 4 |
| Fß | 7 | 8 | 6 | 6 | 7 | | | 2 | 3 | 4 | 3 | 3 |
| ffß | 2 | 2 | 1 | 1 | 2 | | | 1 | 2 | 1 | 1 | 1 |
| Cß | -1 | -1 | 0 | -1 | -2 | | | 0 | 1 | 0 | -1 | 0 |

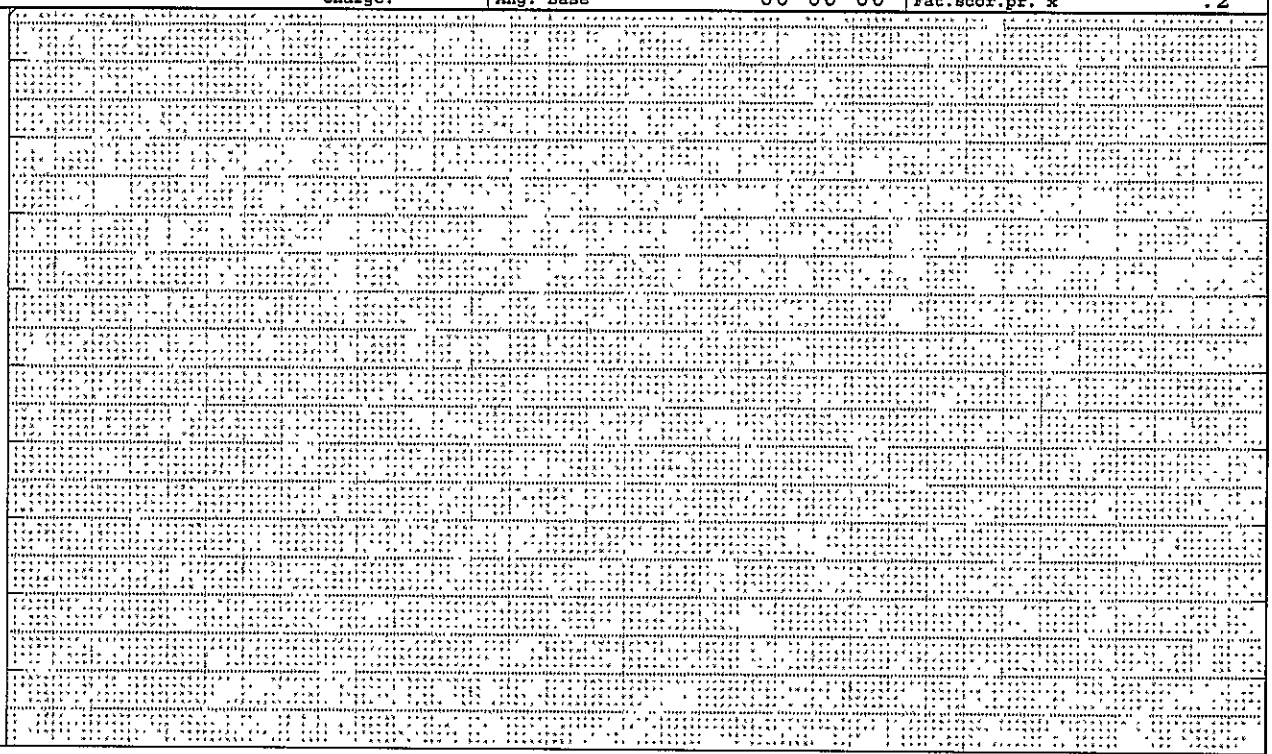


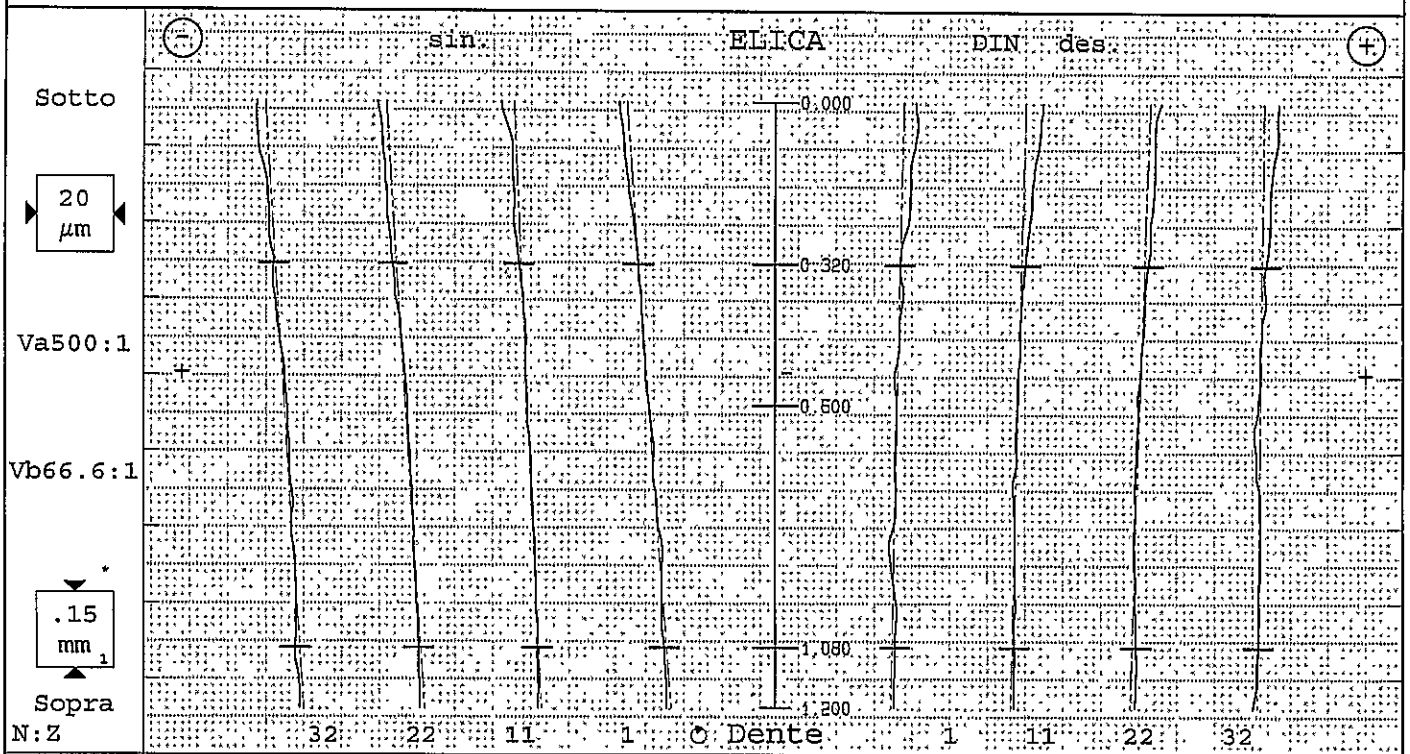
KLINGELNBERG

# GETRAG B7590

# Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 P26 B7590 | Controllore: | TURNO C | Data: | 21.05.2014 15:14 |
| Denominazione: | CA SR3 di pezzo | Numero denti z | 42 | Largh.fasc.dent. b | 1.2mm |
| Numero disegno.: | 250.1.5169.75-KK H | Modulo m | 2mm | Tratto evolv. La | 2.29mm |
| Commessa/serie nr.: | 4 | Angolo pressione | 30°00'00" | Tratto elica Lß | .76mm |
| Masch.Nr.: | | Angolo elica | 04°30'00"/-04°30'00" | Inizio elab. M1 | 21.91mm |
| Untersuchungszweck: | | Ø Base db | 72.7461mm | Palpatore Ø | (#2C) 1mm |
| Werkzeug: | Charge: | Ang. Base | 00°00'00" | Fat.scor.pr. x | .2 |






| | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| fHßm | ±16 | -10 | Var | | 4 | | | ±16 | Var | | 3 | | 4 |
| fHß | | -10 | -10 | -10 | -7 | -11 | | | 3 | 4 | 5 | 2 | 4 |
| Fß | | 6 | 6 | 7 | 5 | 7 | | | 4 | 3 | 4 | 3 | 4 |
| ffß | | 2 | 2 | 2 | 1 | 2 | | | 2 | 2 | 2 | 3 | 2 |
| Cß | | -1 | -2 | -1 | 0 | -1 | | | -1 | -1 | -1 | -1 | -1 |

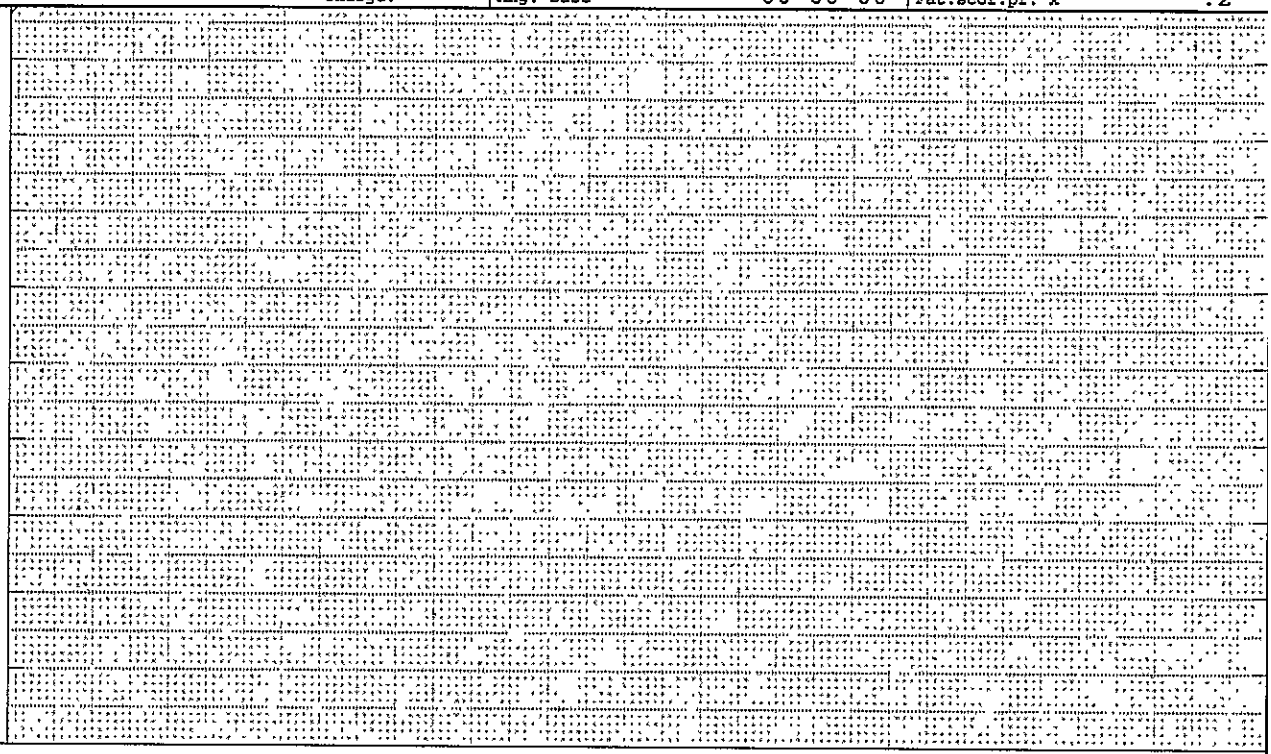


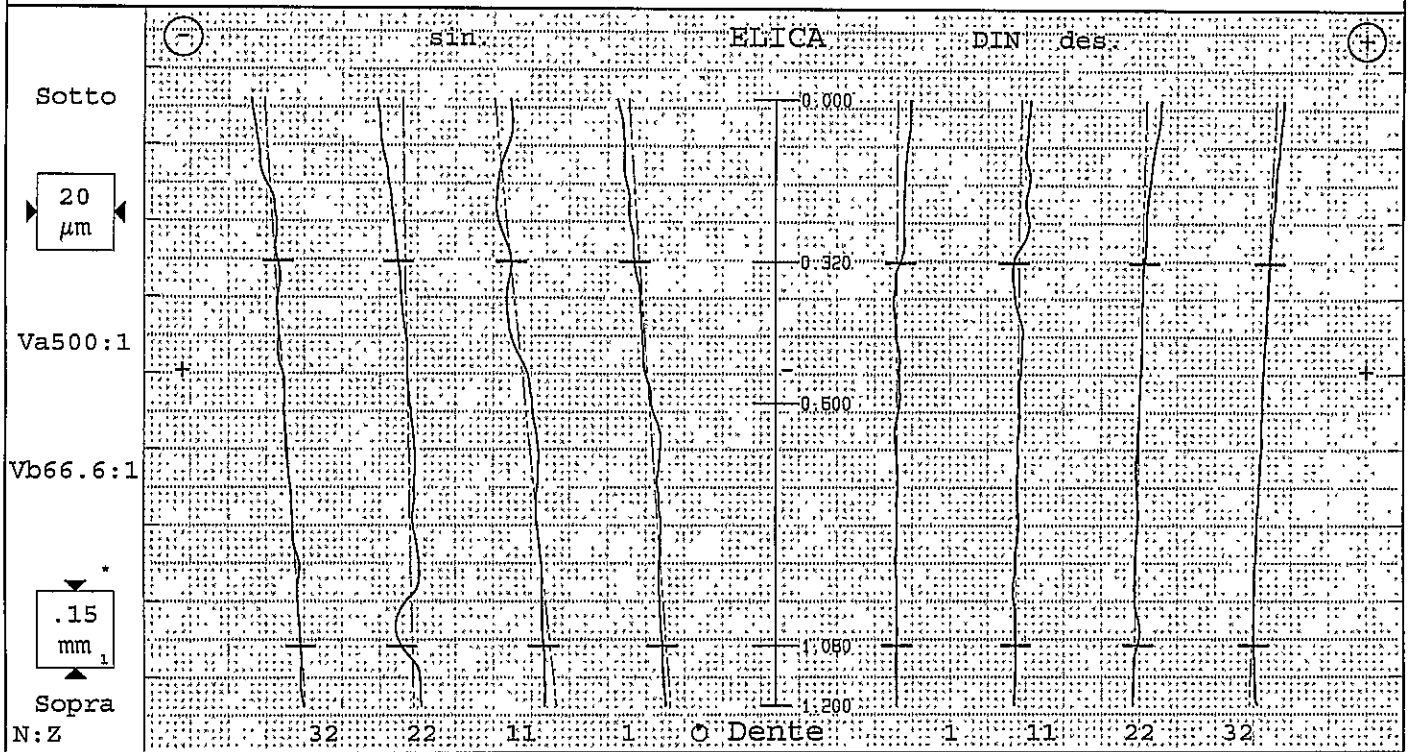
KLINGELNBERG

# GETRAG B7590

# Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 P26 B7590 | Controllore: | TURNO c | Data: | 21.05.2014 15:13 |
| Denominazione: | CA SR3 di pezzo | Numero denti z | 42 | Largh.fasc.dent. b | 1.2mm |
| Numero disegno.: | 250.1.5169.75-KK H | Modulo m | 2mm | Tratto evolv. La | 2.29mm |
| Commessa/serie nr.: | 5 | Angolo pressione | 30°00'00" | Tratto elica Lß | .76mm |
| Masch.Nr.: | | Angolo elica | 04°30'00"/-04°30'00" | Inizio elab. M1 | 21.91mm |
| Untersuchungszweck: | | ø Base db | 72.7461mm | Palpatore ø | (#2C) 1mm |
| Werkzeug: | Charge: | Ang. Base | 00°00'00" | Fat.scor.pr. x | .2 |



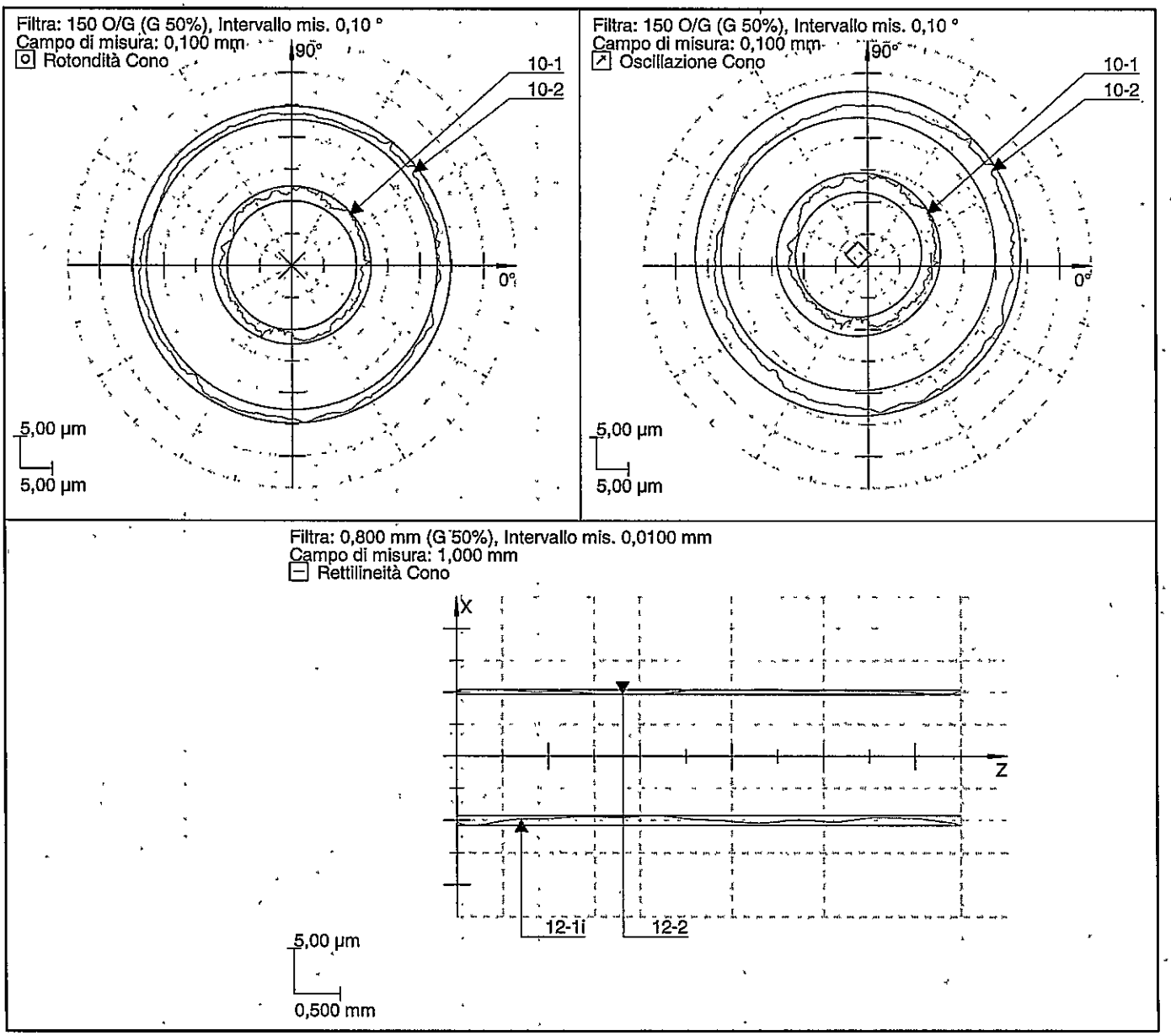



| | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| fHßm ±16 | -10 | Var 13 | | | | | ±16 | Var 7 | | | | 3 |
| fHß | -10 | -11 | -3 | -16 | -11 | | | 0 | 2 | 4 | 7 | 3 |
| Fß | 7 | 6 | 6 | 10 | 7 | | | 2 | 3 | 3 | 4 | 3 |
| ffß | 5 | 2 | 7 | 5 | 4 | | | 2 | 3 | 2 | 1 | 2 |
| Cß | -3 | 1 | -4 | -4 | -3 | | | 0 | 1 | -1 | 0 | 0 |



KLINGELNBERG

| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | GETRAG S.p.a<br>MODUGNO ( BARI )<br>SALA METROLOGICA - M1 | | 24.04.2014<br>08:59:38<br>Operatore<br>**TURNO A**<br>Firma |
| Particolare<br>**SR 3** | N. disegno<br>**250.1.5169.75** | Operazione<br>**FINITO** | |
| **Rapporto delle misure 1** | **Reparto: GPS 5** | | |
| **Formtester: MMQ40** | **N. commessa:** | | **N. lotto: 0** |
| Commento | | | 1_5169_F.FPC |




| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 10-1 | 201,00 | ○ 2,24 | | MZC | | 2,36 | 118,87 |
| 10-2 | 206,00 | ○ 2,08 | | MZC | | 1,53 | 101,65 |
| 10:Compito 10 | | ○ 2,24 | 0,0040 | MZC | | | |
| 10-1 | 201,00 | ↗ 3,01 | | | Asse [A] | 2,29 | 129,58 |
| 10-2 | 206,00 | ↗ 4,00 | | | Asse [A] | 2,34 | 130,75 |
| 11:Compito 11 | | ↗ 4,00 | 0,0200 | | Asse [A] | | |
| 12-1 | 48,9 | ⏤ 1,48 | | MZS | | | -7,644° |
| 12-2 | 228,9 | ⏤ 0,72 | | MZS | | | -7,649° |
| 12:Compito 12 | | ⏤ 1,48 | 0,0030 | MZS | | | |

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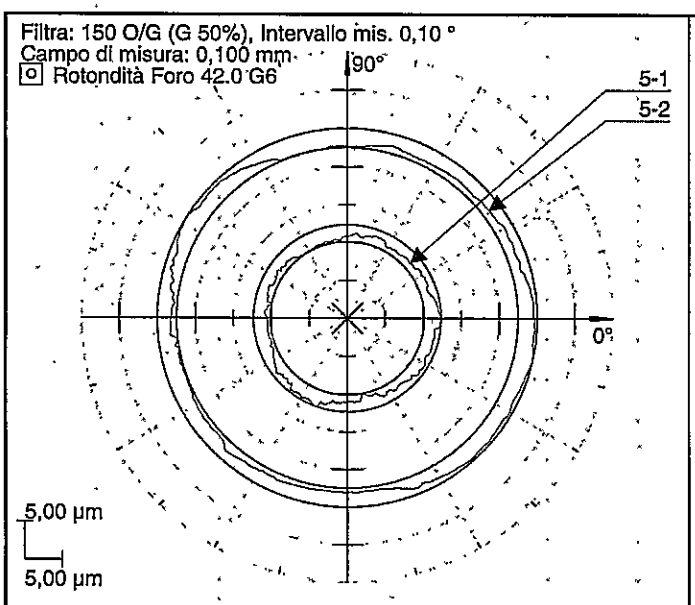
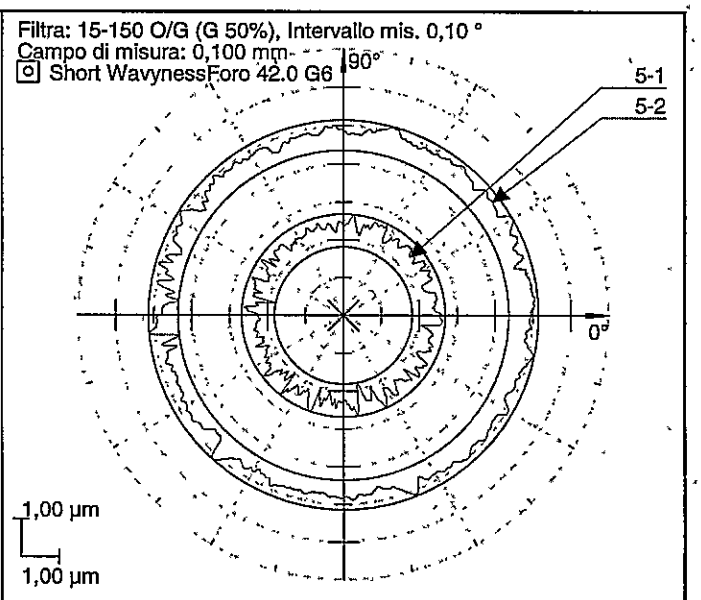
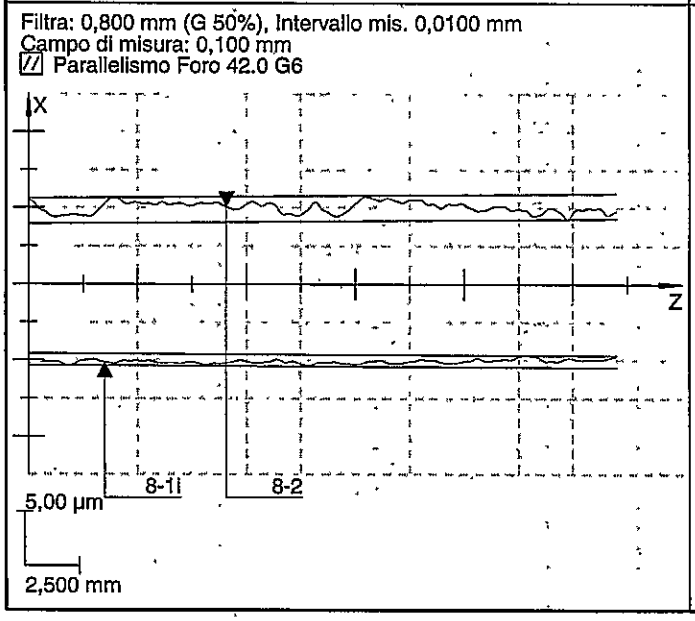
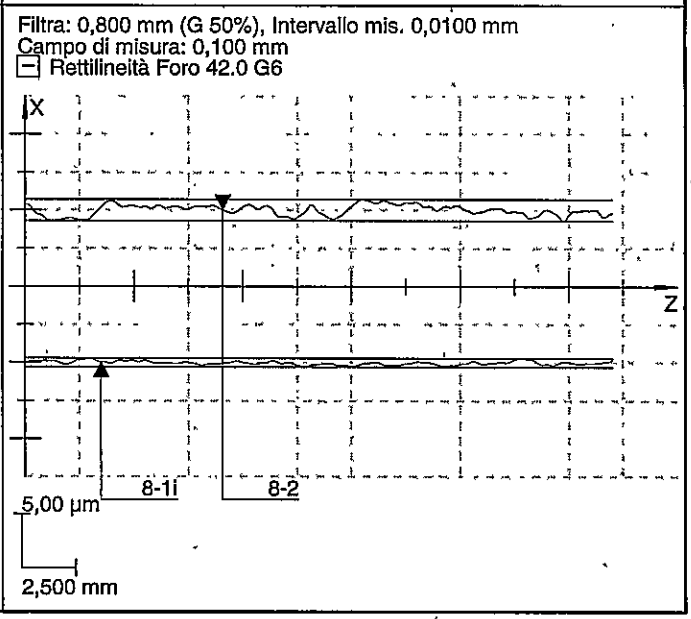
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | GETRAG S.p.a<br>MODUGNO ( BARI )<br>SALA METROLOGICA - M1 | | 24.04.2014<br>08:59:37<br>Operatore<br>TURNO A<br>Firma |
| Particolare<br>SR 3 | N. disegno<br>250.1.5169.75 | Operazione<br>FINITO | |
| Rapporto delle misure 1 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |




| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 5-1 | 199,00 | ○ 2,21 | | MZC | | 2,76 | 130,94 |
| 5-2 | 175,00 | ○ 2,53 | | MZC | | 2,39 | 129,50 |
| 6:Compito 6 | | ○ 2,53 | 0,0060 | MZC | | | |
| 5-1 | 199,00 | ○ 0,87 | | MZC | | 0,07 | 220,82 |
| 5-2 | 175,00 | ○ 0,78 | | MZC | | 0,10 | 207,65 |
| 7:Compito 7 | | ○ 0,87 | 0,0010 | MZC | | | |
| 8-1 | 42,4 | // 1,54 | | MZS | 8-2 | | 28 |
| 8-2 | 222,4 | // 3,31 | | MZS | 8-1 | | 34 |
| 8:Compito 8 | | // 3,31 | 0,0070 | | | | |
| 8-1 | 42,4 | ⏤ 1,11 | | MZS | | | -26 |
| 8-2 | 222,4 | ⏤ 2,82 | | MZS | | | -9 |
| 9:Compito 9 | | ⏤ 2,82 | 0,0040 | MZS | | | |

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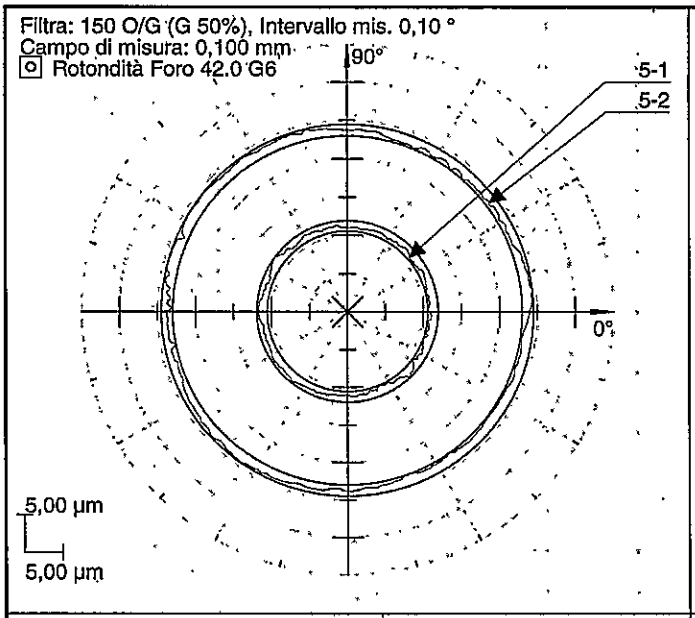
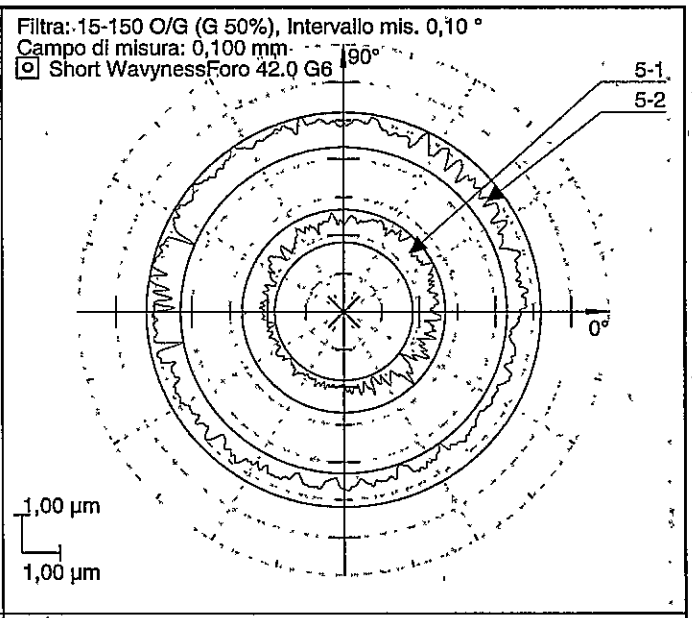
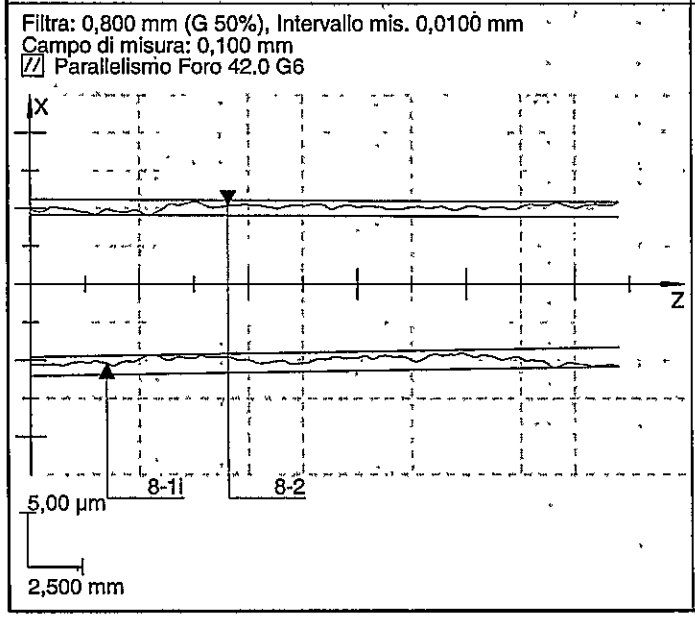
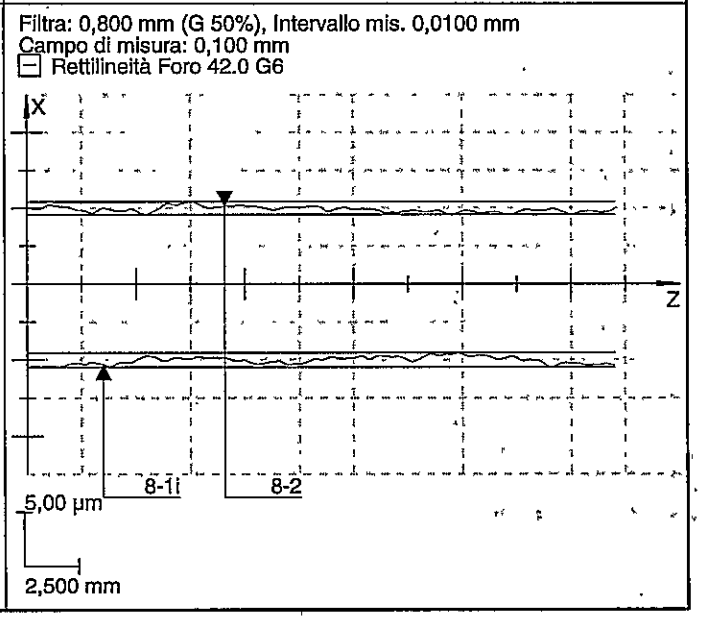
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | GETRAG S.p.a<br>MODUGNO ( BARI )<br>SALA METROLOGICA - M1 | | 24.04.2014<br>09:12:19<br>Operatore<br>**TURNO A**<br>Firma |
| Particolare<br>**SR 3** | N. disegno<br>**250.1.5169.75** | Operazione<br>**FINITO** | |
| **Rapporto delle misure 2** | **Reparto: GPS 5** | | |
| **Formtester: MMQ40** | **N. commessa:** | | **N. lotto: 0** |
| Commento | | | 1_5169_F.FPC |




| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 5-1 | 199,00 | ○ 1,37 | | MZC | | 1,90 | 334,54 |
| 5-2 | 175,00 | ○ 1,50 | | MZC | | 1,59 | 336,32 |
| 6:Compito 6 | | ○ 1,50 | 0,0060 | MZC | | | |
| 5-1 | 199,00 | ○ 0,86 | | MZC | | 0,26 | 229,90 |
| 5-2 | 175,00 | ○ 0,90 | | MZC | | 0,24 | 309,97 |
| 7:Compito 7 | | ○ 0,90 | 0,0010 | MZC | | | |
| 8-1 | 42,8 | // 2,54 | | MZS | 8-2 | | -42 |
| 8-2 | 222,8 | // 2,01 | | MZS | 8-1 | | -33 |
| 8:Compito 8 | | // 2,54 | 0,0070 | | | | |
| 8-1 | 42,8 | — 1,88 | | MZS | | | 12 |
| 8-2 | 222,8 | — 1,69 | | MZS | | | 46 |
| 9:Compito 9 | | — 1,88 | 0,0040 | MZS | | | |

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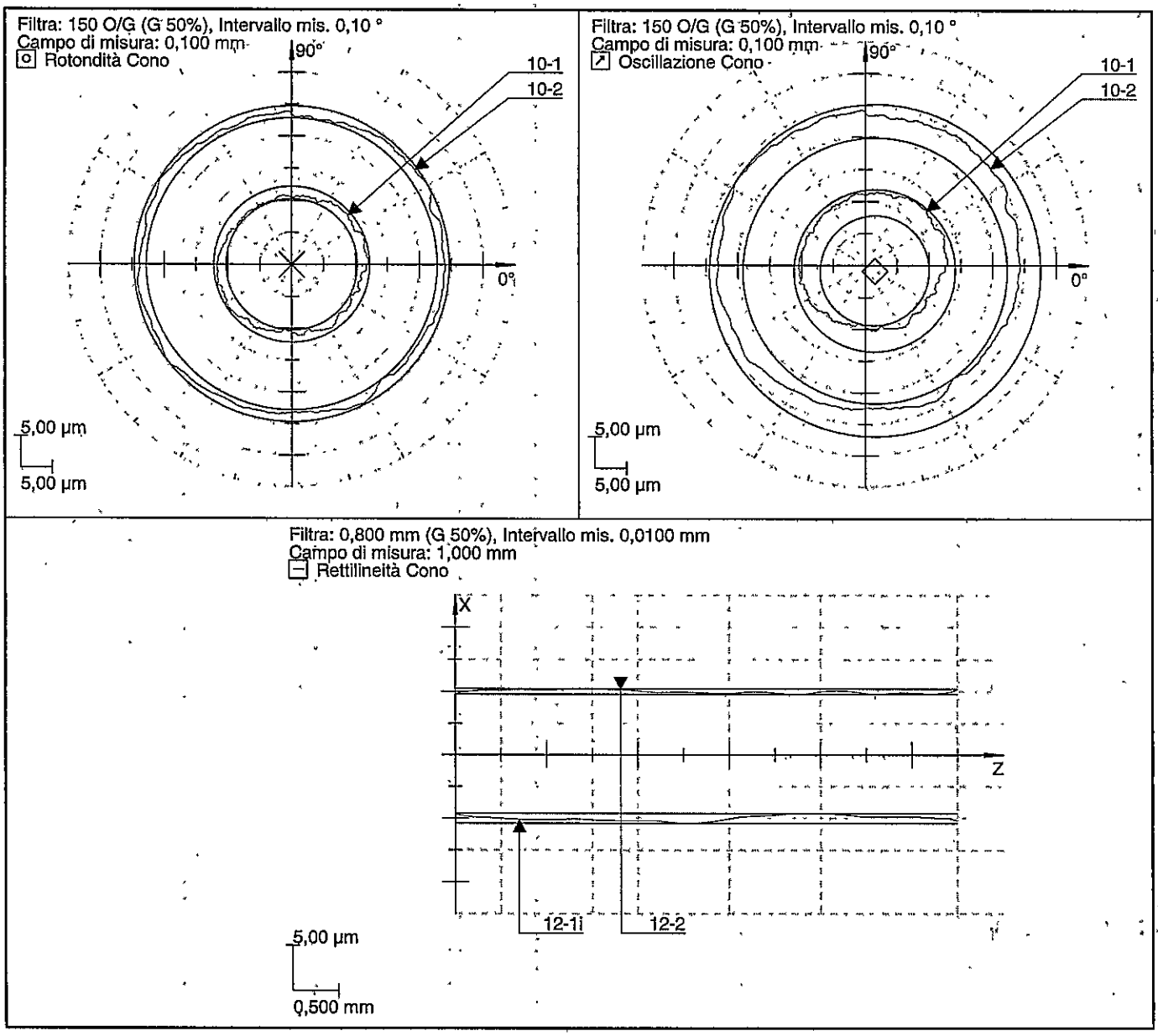
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | [redacted] GETRAG S.p.a MODUGNO ( BARI ) SALA METROLOGICA - M1 | | 24.04.2014 09:12:19 Operatore TURNO A Firma |
| Particolare SR 3 | N. disegno 250.1.5169.75 | Operazione FINITO | |
| Rapporto delle misure 2 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |




| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 10-1 | 201,00 | ○ 1,93 | | MZC | | 1,30 | 36,20 |
| 10-2 | 206,00 | ○ 1,89 | | MZC | | 0,77 | 50,17 |
| 10:Compito 10 | | ○ 1,93 | 0,0040 | MZC | | | |
| 10-1 | 201,00 | ↗ 4,12 | | | Asse [A] | 1,71 | 329,69 |
| 10-2 | 206,00 | ↗ 5,25 | | | Asse [A] | 1,80 | 328,93 |
| 11:Compito 11 | | ↗ 5,25 | 0,0200 | | Asse [A] | | |
| 12-1 | 48,8 | ⏤ 1,57 | | MZS | | | -7,646° |
| 12-2 | 228,8 | ⏤ 0,83 | | MZS | | | -7,648° |
| 12:Compito 12 | | ⏤ 1,57 | 0,0030 | MZS | | | |

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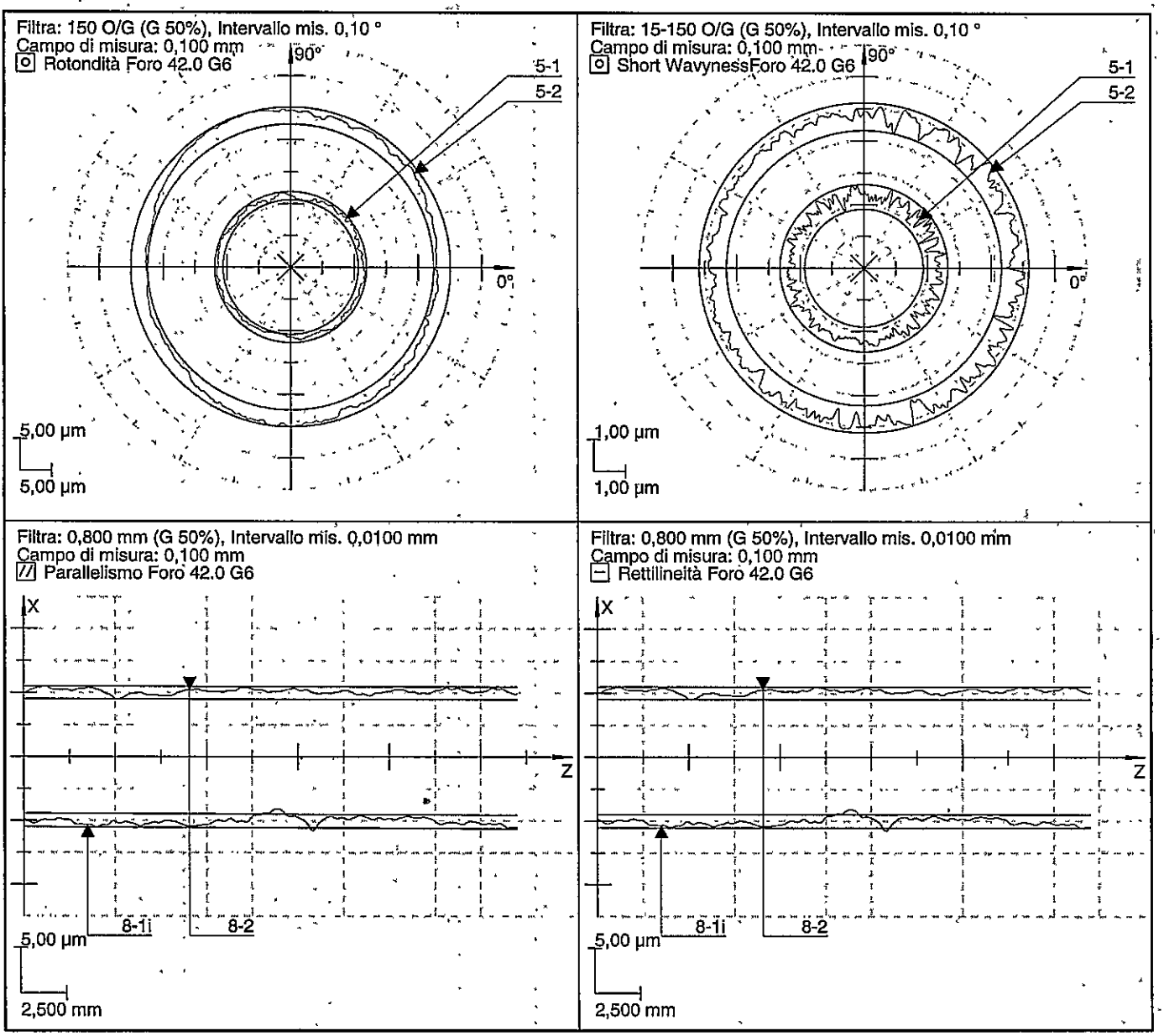
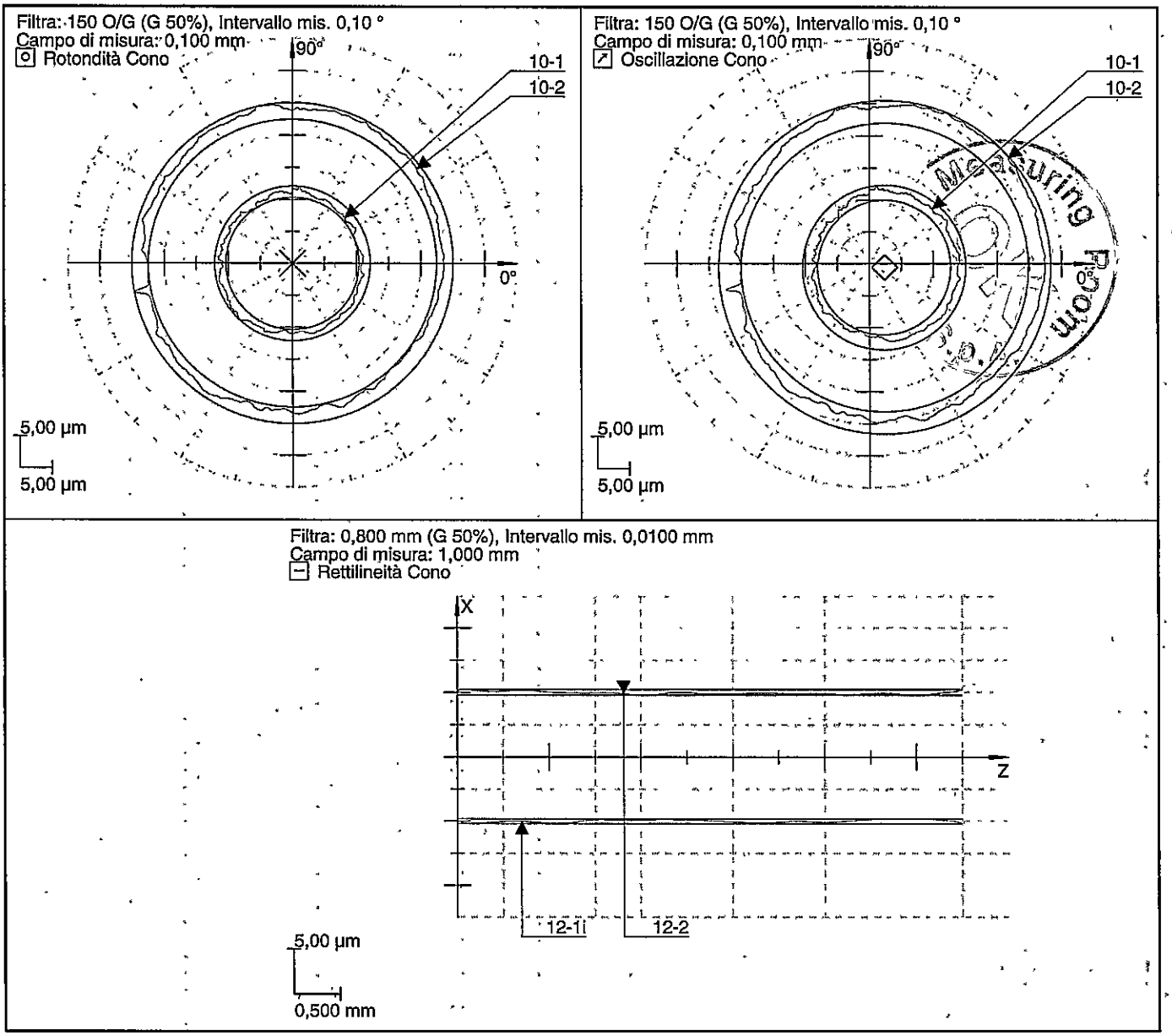
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | [redacted] GETRAG S.p.a MODUGNO ( BARI ) SALA METROLOGICA - M1 | | 24.04.2014 09:25:32 Operatore TURNO A Firma |
| Particolare SR 3 | N. disegno 250.1.5169.75 | Operazione FINITO | |
| Rapporto delle misure 3 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |



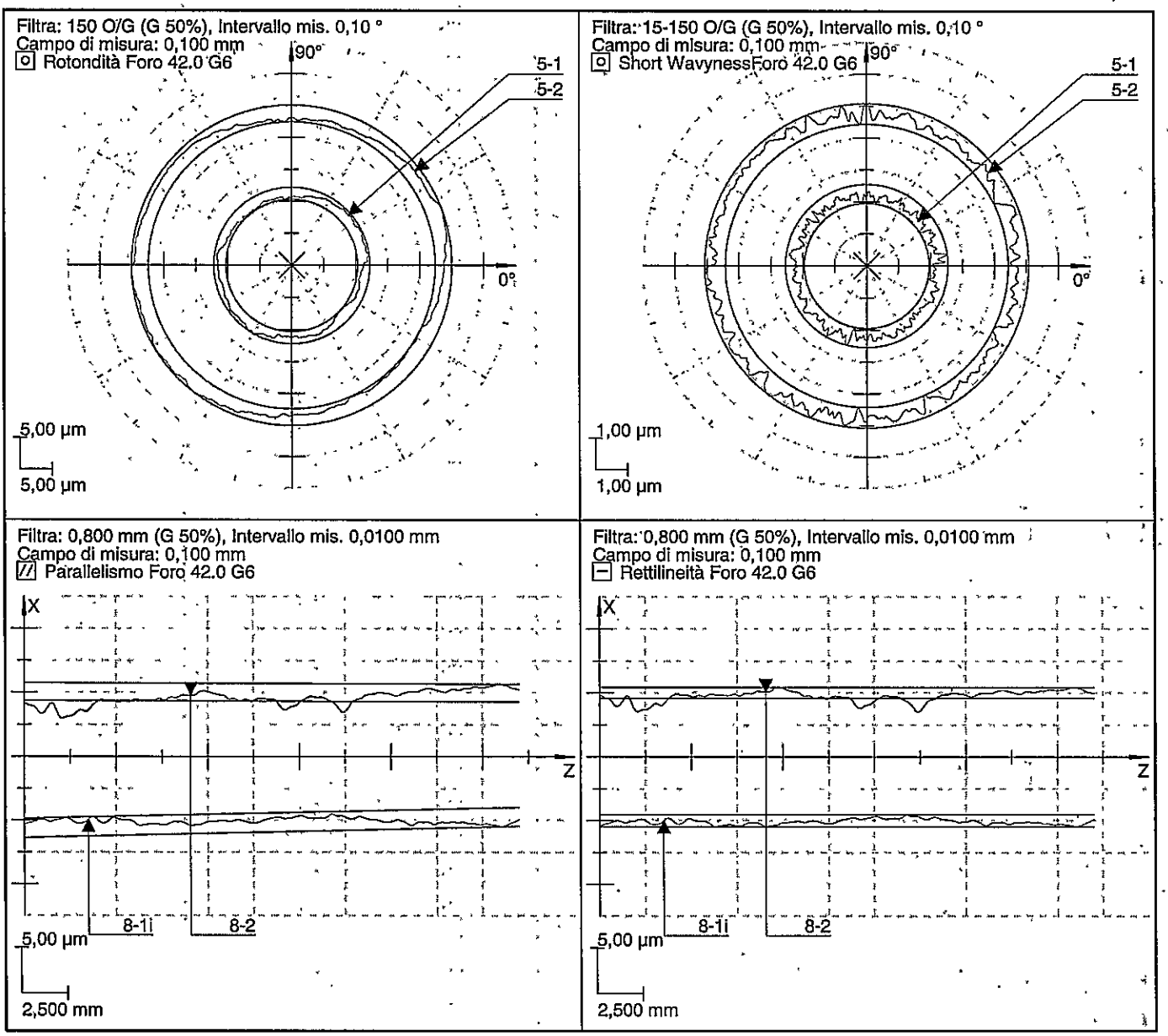

| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 5-1 | 199,00 | ○ 1,30 | | MZC | | 2,35 | 344,33 |
| 5-2 | 175,00 | ○ 2,64 | | MZC | | 1,96 | 338,12 |
| 6:Compito 6 | | ○ 2,64 | 0,0060 | MZC | | | |
| 5-1 | 199,00 | ○ 0,78 | | MZC | | 0,00 | 16,41 |
| 5-2 | 175,00 | ○ 0,86 | | MZC | | 0,01 | 40,69 |
| 7:Compito 7 | | ○ 0,86 | 0,0010 | MZC | | | |
| 8-1 | 42,8 | // 2,12 | | MZS | 8-2 | | 16 |
| 8-2 | 222,8 | // 1,97 | | MZS | 8-1 | | -3 |
| 8:Compito 8 | | // 2,12 | 0,0070 | | | | |
| 8-1 | 42,8 | ⏤ 2,04 | | MZS | | | 2 |
| 8-2 | 222,8 | ⏤ 1,93 | | MZS | | | -10 |
| 9:Compito 9 | | ⏤ 2,04 | 0,0040 | MZS | | | |

| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | | GETRAG S.p.a<br>MODUGNO ( BARI )<br>SALA METROLOGICA - M1 | 24.04.2014<br>09:25:32<br>Operatore<br>TURNO A<br>Firma |
| Particolare<br>SR 3 | N. disegno<br>250.1.5169.75 | Operazione<br>FINITO | |
| Rapporto delle misure 3 | | Reparto: GPS 5 | |
| Formtester: MMQ40 | | N. commessa: | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |



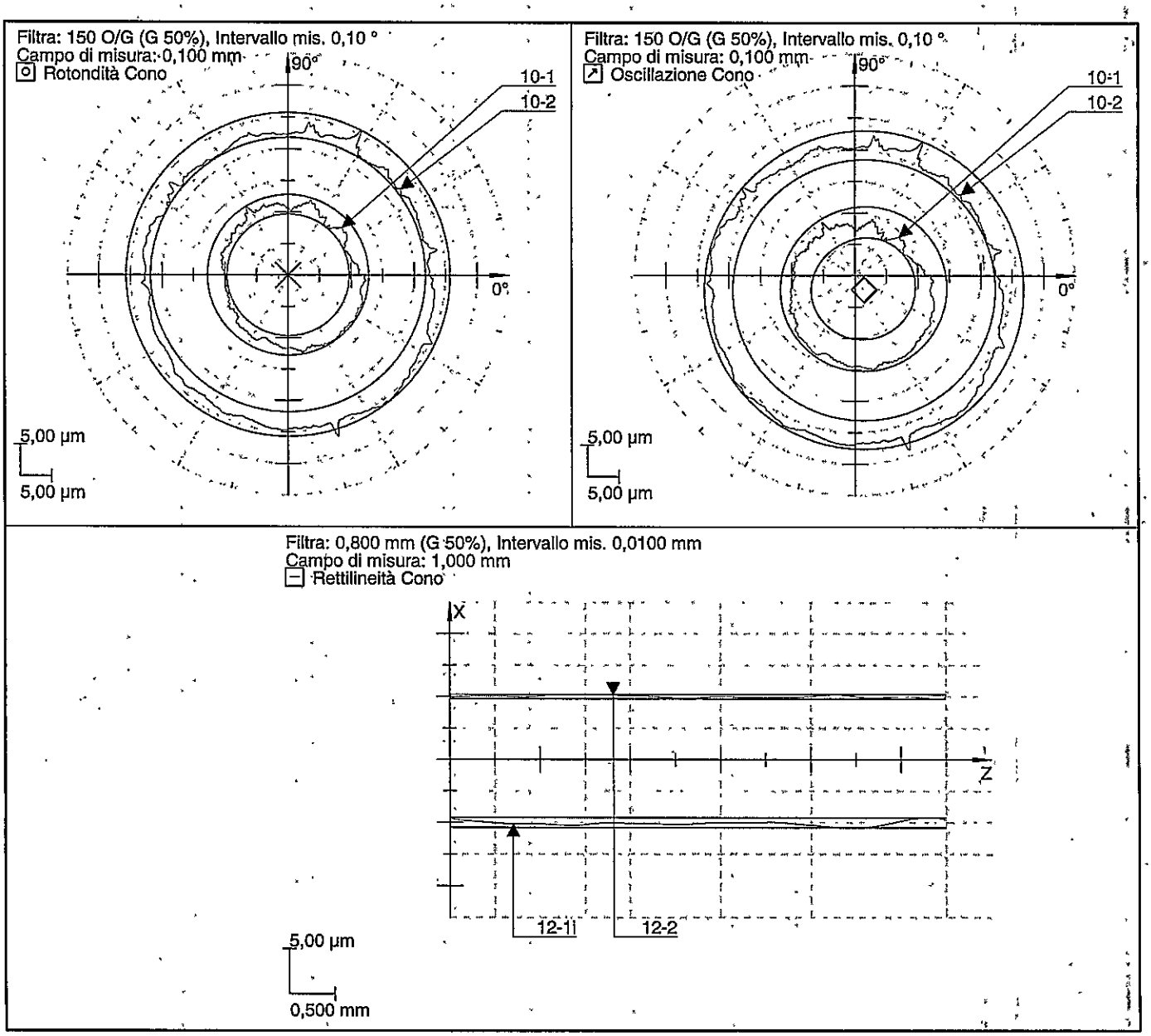

| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 10-1 | 201,00 | ○ 1,74 | | MZC | | 2,87 | 355,17 |
| 10-2 | 206,00 | ○ 2,58 | | MZC | | 3,18 | 351,81 |
| 10:Compito 10 | | ○ 2,58 | 0,0040 | MZC | | | |
| 10-1 | 201,00 | ↗ 2,37 | | | Asse [A] | 2,40 | 346,00 |
| 10-2 | 206,00 | ↗ 3,50 | | | Asse [A] | 2,47 | 346,39 |
| 11:Compito 11 | | ↗ 3,50 | 0,0200 | | Asse [A] | | |
| 12-1 | 49,2 | ⊢ 0,73 | | MZS | | | -7,640° |
| 12-2 | 229,2 | ⊢ 0,82 | | MZS | | | -7,642° |
| 12:Compito 12 | | ⊢ 0,82 | 0,0030 | MZS | | | |

| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | [redacted] GETRAG S.p.a MODUGNO ( BARI ) SALA METROLOGICA - M1 | | 24.04.2014 09:36:43 Operatore TURNO A Firma |
| Particolare SR 3 | N. disegno 250.1.5169.75 | Operazione FINITO | |
| Rapporto delle misure.4 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |



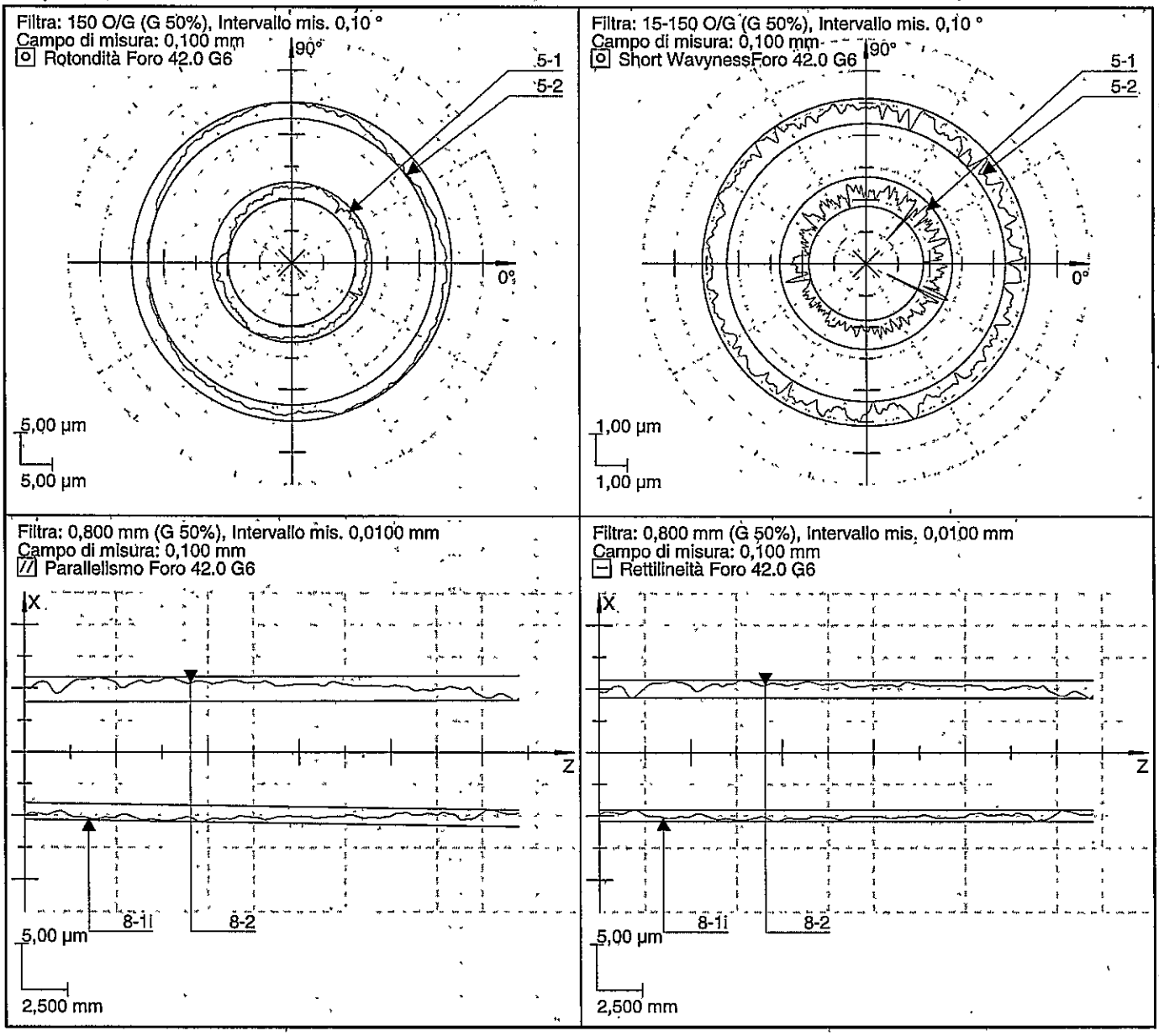

| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 5-1 | 199,00 | ○ 1,90 | | MZC | | 2,34 | 304,99 |
| 5-2 | 175,00 | ○ 2,62 | | MZC | | 2,08 | 325,29 |
| 6:Compito 6 | | ○ 2,62 | 0,0060 | MZC | | | |
| 5-1 | 199,00 | ○ 0,59 | | MZC | | 0,05 | 52,30 |
| 5-2 | 175,00 | ○ 0,64 | | MZC | | 0,10 | 358,57 |
| 7:Compito 7 | | ○ 0,64 | 0,0010 | MZC | | | |
| 8-1 | 42,7 | // 2,97 | | MZS | 8-2 | | -73 |
| 8-2 | 222,7 | // 2,76 | | MZS | 8-1 | | -95 |
| 8:Compito 8 | | // 2,97 | 0,0070 | | | | |
| 8-1 | 42,7 | − 1,89 | | MZS | | | 8 |
| 8-2 | 222,7 | − 1,67 | | MZS | | | 67 |
| 9:Compito 9 | | − 1,89 | 0,0040 | MZS | | | |

| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | | GETRAG S.p.a<br>MODUGNO ( BARI )<br>SALA METROLOGICA - M1 | 24.04.2014<br>09:36:44<br>Operatore<br>TURNO A<br>Firma |
| Particolare<br>SR 3 | N. disegno<br>250.1.5169.75 | Operazione<br>FINITO | |
| Rapporto delle misure 4 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |



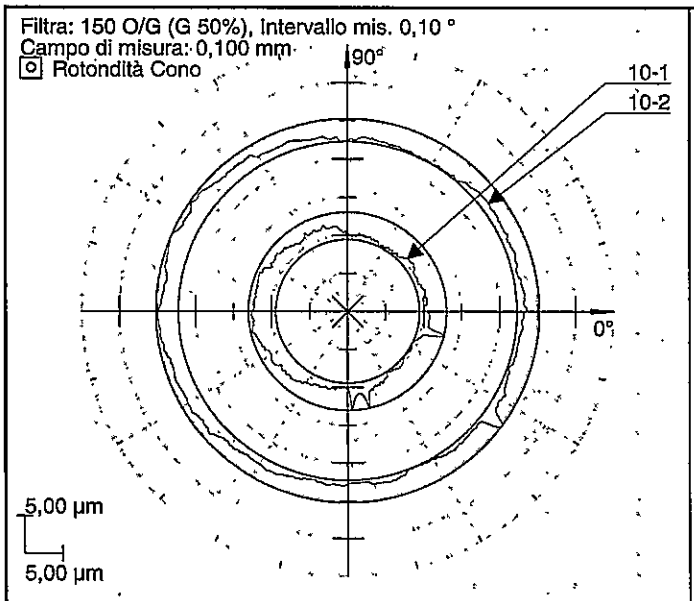

| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 10-1 | 201,00 | 3,09 | | MZC | | 2,98 | 272,36 |
| 10-2 | 206,00 | 3,90 | | MZC | | 2,18 | 267,48 |
| 10:Compito 10 | | 3,90 | 0,0040 | MZC | | | |
| 10-1 | 201,00 | 5,05 | | | Asse [A] | 2,58 | 303,19 |
| 10-2 | 206,00 | 4,54 | | | Asse [A] | 2,76 | 302,07 |
| 11:Compito 11 | | 5,05 | 0,0200 | | Asse [A] | | |
| 12-1 | 48,7 | 1,54 | | MZS | | | -7,669° |
| 12-2 | 228,7 | 0,71 | | MZS | | | -7,657° |
| 12:Compito 12 | | 1,54 | 0,0030 | MZS | | | |

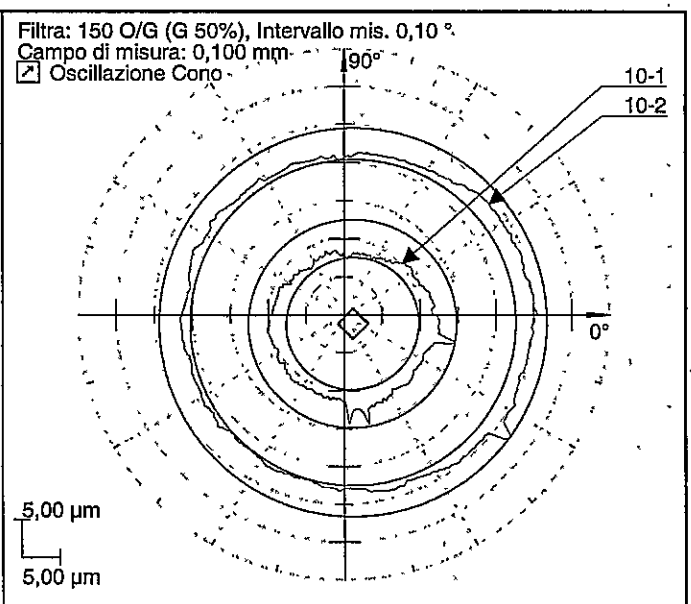
| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | [redacted] GETRAG S.p.a MODUGNO ( BARI ) SALA METROLOGICA - M1 | | 24.04.2014 09:46:19 Operatore TURNO A Firma |
| Particolare SR 3 | N. disegno 250.1.5169.75 | Operazione FINITO | |
| Rapporto delle misure 5 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |

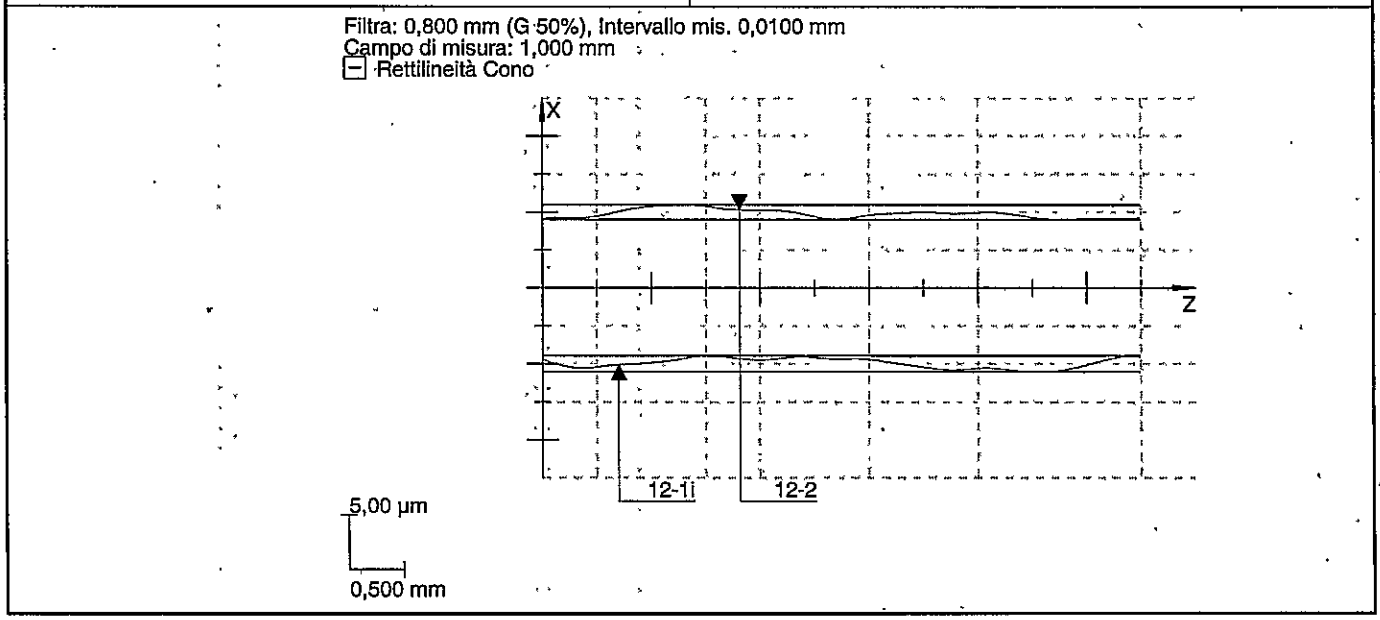



| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 5-1 | 199,00 | ○ 2,61 | | MZC | | 1,37 | 305,12 |
| 5-2 | 175,00 | ○ 2,54 | | MZC | | 1,86 | 280,37 |
| 6:Compito 6 | | ○ 2,61 | 0,0060 | MZC | | | |
| 5-1 | 199,00 | ○ 0,91 | | MZC | | 0,12 | 216,42 |
| 5-2 | 175,00 | ○ 0,77 | | MZC | | 0,13 | 339,69 |
| 7:Compito 7 | | ○ 0,91 | 0,0010 | MZC | | | |
| 8-1 | 43,0 | // 2,59 | | MZS | 8-2 | | 56 |
| 8-2 | 223,0 | // 3,85 | | MZS | 8-1 | | 72 |
| 8:Compito 8 | | // 3,85 | 0,0070 | | | | |
| 8-1 | 43,0 | ⏤ 1,78 | | MZS | | | -13 |
| 8-2 | 223,0 | ⏤ 2,76 | | MZS | | | -38 |
| 9:Compito 9 | | ⏤ 2,76 | 0,0040 | MZS | | | |

| | | | |
|---|---|---|---|
| Mahr FORM-PC V4.28.7 SP15 | [redacted] GETRAG S.p.a MODUGNO ( BARI ) SALA METROLOGICA - M1 | | 24.04.2014 09:46:19 Operatore TURNO A Firma |
| Particolare SR 3 | N. disegno 250.1.5169.75 | Operazione FINITO | |
| Rapporto delle misure 5 | Reparto: GPS 5 | | |
| Formtester: MMQ40 | N. commessa: | | N. lotto: 0 |
| Commento | | | 1_5169_F.FPC |




| Profilo o Compito | Posizion [mm, °] | Risultato [µm] ⌀:[mm] | Tolleranza [mm] | Rif. | Rifer. | Eccentricità [µm] | Fase [°] Inc [µm/m] |
|---|---|---|---|---|---|---|---|
| 10-1 | 201,00 | ○ 3,58 | | MZC | | 2,89 | 319,84 |
| 10-2 | 206,00 | ○ 2,95 | | MZC | | 2,79 | 339,27 |
| 10:Compito 10 | | ○ 3,58 | 0,0040 | MZC | | | |
| 10-1 | 201,00 | ↗ 5,02 | | | Asse [A] | 1,63 | 313,07 |
| 10-2 | 206,00 | ↗ 4,10 | | | Asse [A] | 1,59 | 317,64 |
| 11:Compito 11 | | ↗ 5,02 | 0,0200 | | Asse [A] | | |
| 12-1 | 49,2 | ⏤ 2,11 | | MZS | | | -7,661° |
| 12-2 | 229,2 | ⏤ 1,92 | | MZS | | | -7,667° |
| 12:Compito 12 | | ⏤ 2,11 | 0,0030 | MZS | | | |

PROTOCOLLO DI MISURA ZEISS UMESS

SR3G 080_803472 CICLO CNC

| DISEGNO No. | MACCHINA DI MIS. | FORNITORE/CLIENTE | LAVORAZ. | OPERAZIONE |
|---|---|---|---|---|
| 2501364175 | PRISMO SACC | GETRAG | T. SOFT | - |

| OPERATORE | DATA | NUMERO PART. | COD. MACCH. | EDIZ.DISEG. | FIN. |
|---|---|---|---|---|---|
| | 7. 5.2014 | 1 | | - | |

| IND | NOMI / IDF | SY | VAL ATT | VAL NOM | TOL.S | TOL.I | DEV | MAG |
|---|---|---|---|---|---|---|---|---|
| 7. 5.2014 17 ora 14 min 12. 0sec | | | | | | | | |
| 17 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.SUP | t | 0.004 | 0.050 | | | | + |
| 20 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.C.A | t | 0.095 | 0.100 | | | | ++++ |
| 26 | GDT LINEARITA' | | | | | | | |
| | CONO | tx | 0.001 | 0.003 | | | | + |
| 32 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.INF | t | 0.010 | 0.050 | | | | + |
| 300 | CERCHIO I | | | | | | | |
| | DIAM.I.SUP | D | 42.021 | 42.000 | 0.025 | 0.009 | 0.021 | ++ |
| 303 | CERCHIO I | | | | | | | |
| | DIAM.I.INF | D | 42.020 | 42.000 | 0.025 | 0.009 | 0.020 | + |
| 309 | SUPERFICIE | | | | | | | |
| | SUPERF.INF | Z | -5.320 | 5.340 | 0.050 | 0.050 | -0.020 | - |
| 311 | GDT OSCILL. ASSIALE | | | | | | | |
| | OSC.BATTUT | t | 0.077 | | | | | |
| 312 | SUPERFICIE RICHIAMO (316) CON TRASFORMAZIONE | | | | | | | |
| | ALT.TOTALE | Z | 36.076 | 36.070 | 0.030 | 0.030 | 0.006 | + |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| 316 | DIAMETRO CONO | | | | | | | |
| | DIAM.CONO | D | 70.600 | 70.600 | 0.010 | 0.010 | 0.000 | +- |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| 317 | COORDINATE CONO | | | | | | | |
| | ALT.CONO | Z | 31.050 | 31.050 | 0.040 | 0.040 | 0.000 | |
| 318 | FORMULA: AC(315)/2 | | | | | | | |
| | ANGOL.CONO | AC | 6.975 | 7.000 | 0.030 | 0.030 | -0.025 | ---- |
| 320 | GDT OSCILL. RADIALE | | | | | | | |
| | CONO.2 | t | 0.003 | 0.020 | | | | + |

QPS

QUINTO VICENT GRADINO CONO 12

DATA : 7. 5.2014 NOMEPz:SR3G 080_803472 PARTNO:1 - 2 -

| IND | NOMI / IDF | SY | VAL ATT | VAL NOM | TOL.S | TOL.I | DEV | MAG |
|---|---|---|---|---|---|---|---|---|
| 323 | | GDT OSCILL. RADIALE | | | | | | |
| | CONO.4 | t | 0.003 | 0.020 | | | | + |
| 324 | | SUPERFICIE RICHIAMO ( 19) CON TRASFORMAZIONE | | | | | | |
| | ALT. C.A. | Z | 28.778 | 28.750 | 0.100 | -0.100 | 0.028 | ++ |
| 325 | | SUPERFICIE RICHIAMO ( 23) CON TRASFORMAZIONE | | | | | | |
| | ALT. 38.35 | Z | 38.362 | 38.350 | 0.100 | -0.100 | 0.012 | + |
| 341 | | GDT LINEARITA' | | | | | | |
| | ML-180 | tx | 0.001 | 0.010 | | | | + |
| 343 | | GDT LINEARITA' | | | | | | |
| | ML-0 | tx | 0.001 | 0.010 | | | | + |
| 346 | | GDT PARALLELISMO | | | | | | |
| | PARALL-ML | tx | 0.001 | 0.007 | | | | + |

0 ora 4 min 45.68sec

------ Trasferimento dati SAM concluso --------

CNC - TERM.

PROTOCOLLO DI MISURA ZEISS UMESS

SR3G 080_803472 CICLO CNC

| DISEGNO No. | MACCHINA DI MIS. | FORNITORE/CLIENTE | LAVORAZ. | OPERAZIONE |
|---|---|---|---|---|
| 2501364175 | PRISMO SACC | GETRAG | T. HARD | - |

| OPERATORE | DATA | NUMERO PART. | COD. MACCH. | EDIZ.DISEG.FIN. |
|---|---|---|---|---|
| | 24. 4.2014 | //32.6AC-108 | 2 | - |

| IND | NOMI / IDF | SY | VAL ATT | VAL NOM | TOL.S | TOL.I | DEV | MAG |
|---|---|---|---|---|---|---|---|---|
| 24. 4.2014 7 ora 50 min 19. 0sec | | | | | | | | |
| 17 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.SUP | t | 0.009 | 0.050 | | | | + |
| 20 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.C.A | t | 0.070 | 0.100 | | | | +++ |
| | | R | 40.250 | | | | | |
| 26 | GDT LINEARITA' | | | | | | | |
| | CONO | tx | 0.001 | 0.003 | | | | + |
| 32 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.INF | t | 0.004 | 0.050 | | | | + |
| | | R | 25.392 | | | | | |
| 300 | CERCHIO I | | | | | | | |
| | DIAM.I.SUP | D | 42.025 | 42.000 | 0.025 | 0.009 | 0.025 | ++++ |
| 303 | CERCHIO I | | | | | | | |
| | DIAM.I.INF | D | 42.025 | 42.000 | 0.025 | 0.009 | 0.025 | ++++ |
| 309 | SUPERFICIE | | | | | | | |
| | SUPERF.INF | Z | -5.333 | 5.340 | 0.050 | -0.050 | -0.007 | - |
| 311 | GDT OSCILL. ASSIALE | | | | | | | |
| | OSC.BATTUT | t | 0.079 | | | | | |
| 312 | SUPERFICIE RICHIAMO ( 16) CON TRASFORMAZIONE | | | | | | | |
| | ALT.TOTALE | Z | 36.070 | 36.070 | 0.030 | -0.030 | 0.000 | +- |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| | ALTEZZA INTERSE | | 31.0500 | | | | | |
| 316 | DIAMETRO CONO | | | | | | | |
| | DIAM.CONO | D | 70.601 | 70.600 | 0.010 | -0.010 | 0.001 | + |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| | DIAMETRO D | | 70.6000 | | | | | |
| 317 | COORDINATE CONO | | | | | | | |
| | ALT.CONO | Z | 31.054 | 31.050 | 0.040 | -0.040 | 0.004 | + |
| 318 | FORMULA: AC(315)/2 | | | | | | | |
| | ANGOL.CONO | AC | 6.990 | 7.000 | 0.030 | -0.030 | -0.010 | -- |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 320 | | GDT OSCILL. RADIALE | | | | | |
| | CONO.2 | t | 0.005 | 0.020 | | | ++ |
| 323 | | GDT OSCILL. RADIALE | | | | | |
| | CONO.4 | t | 0.005 | 0.020 | | | + |
| 324 | | SUPERFICIE RICHIAMO ( 19) CON TRASFORMAZIONE | | | | | |
| | ALT. C.A. | Z | 28.783 | 28.750 | 0.100 | -0.100 | 0.033 ++ |
| 325 | | SUPERFICIE RICHIAMO ( 23) CON TRASFORMAZIONE | | | | | |
| | ALT. 38.35 | Z | 38.372 | 38.350 | 0.100 | -0.100 | 0.022 + |
| 341 | | GDT LINEARITA' | | | | | |
| | ML-180 | tx | 0.001 | 0.010 | | | + |
| 343 | | GDT LINEARITA' | | | | | |
| | ML-0 | tx | 0.001 | 0.010 | | | + |
| 346 | | GDT PARALLELISMO | | | | | |
| | PARALL-ML | tx | 0.000 | 0.007 | | | +- |
| | | L | 27.070 | | | | |

0 ora 7 min 12.10sec

PROTOCOLLO DI MISURA ZEISS UMESS

SR3G 080_803472 CICLO CNC

| DISEGNO No. | MACCHINA DI MIS | FORNITORE/CLIENTE | LAVORAZ | OPERAZIONE |
|---|---|---|---|---|
| 2501364175 | PRISMO SACC | GETRAG | T. HARD | |

| OPERATORE | DATA | NUMERO PART | COD. MACCH | EDIZ.DISEG.FIN |
|---|---|---|---|---|
| | 24. 4.2014 | //32.6AC 108 | 2 | |

| IND | NOMI / IDF | SY | VAL. ATT | VAL. NOM | TOL.S | TOL.I | DEV | MAG |
|---|---|---|---|---|---|---|---|---|
| 24.4.2014 7 ora 57 min.48 .0sec | | | | | | | | |
| 17 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.SUP | t | 0.006 | 0.050 | | | | + |
| 20. | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.C.A | t | 0.096 | 0.100 | | | | + |
| 26 | GDT LINEARITA' | | | | | | | |
| | CONO | tx | 0.001 | 0.003 | | | | + |
| 32 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.INF | t | 0.004 | 0.050 | | | | + |
| 300 | CERCHIO 1 | | | | | | | |
| | DIAM.I.SUP | D | 42.019 | 42.000 | 0.025 | 0.009 | 0.019 | + |
| 303 | CERCHIO 1 | | | | | | | |
| | DIAM.I.INF | D | 42.019 | 42.000 | 0.025 | 0.009 | 0.019 | + |
| 309 | SUPERFICIE | | | | | | | |
| | SUPERF.INF | Z | -5.320 | 5.340 | 0.050 | -0.050 | -0.020 | -- |
| 311 | GDT OSCILL. ASSIALE | | | | | | | |
| | OSC.BATTUT | t | 0.081 | | | | | |
| 312 | SUPERFICIE RICHIAMO ( 16) CON TRASFORMAZIONE | | | | | | | |
| | ALT.TOTALE | Z | 36.072 | 36.070 | 0.030 | -0.030 | 0.002 | + |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| 316 | DIAMETRO CONO | | | | | | | |
| | DIAM.CONO | D | 70.598 | 70.600 | 0.010 | -0.010 | -0.002 | - |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| 317 | COORDINATE CONO | | | | | | | |
| | ALT.CONO | Z | 31.041 | 31.050 | 0.040 | -0.040 | -0.009 | - |
| 318 | FORMULA: AC(315)/2 | | | | | | | |
| | ANGOL.CONO | AC | 6.987 | 7.000 | 0.030 | -0.030 | -0.013 | -- |
| 320 | GDT OSCILL. RADIALE | | | | | | | |
| | CONO.2 | t | 0.004 | 0.020 | | | | + |

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DATA:24. 4.2014 NOMEPz:SR3G      080_803472          PARTNO: //32.6AC-108      2
 IND|    NOMI    / IDF    |SY| VAL ATT   | VAL NOM   | TOL S   | TOL I   | DEV     | MAG
=============================================================================================
 323                          GDT OSCILL. RADIALE
     CONO.4                    t      0.002      0.020                                    +

 324                          SUPERFICIE RICHIAMO (  19) CON TRASFORMAZIONE
     ALT. C.A.                 Z     28.769     28.750    0.100    -0.100    0.019      +

 325                          SUPERFICIE RICHIAMO (  23) CON TRASFORMAZIONE
     ALT. 38.35                Z     38.358     38.350    0.100    -0.100    0.008      +

 341                          GDT LINEARITA'
     ML-180                    tx     0.001      0.010                                    +

 343                          GDT LINEARITA'
     ML-0                      tx     0.002      0.010                                    +

 346                          GDT PARALLELISMO
     PARALL-ML                 tx     0.001      0.007                                    +


 0 ora  7 min  4.87sec

-------- Trasferimento dati SAM concluso ---------
=============================================================================================
                                    CNC    TERM
=============================================================================================
```

PROTOCOLLO DI MISURA ZEISS UMESS

[redacted] 080 803472 CICLO CNC

| DISEGNO No. | MACCHINA DI MIS. | FORNITORE/CLIENTE | LAVORAZ. | OPERAZIONE |
|---|---|---|---|---|
| 2501364175 | PRISMO SACC | GETRAG | T. HARD | |

| OPERATORE | DATA | NUMERO PART. | COD. MACCH. | EDIZ. DISEG. FIN. |
|---|---|---|---|---|
| [redacted] | 24.4.2014 | 7/32 6AC-108 | 3 | |

| IND | NOMI / IDF | SY | VAL ATT | VAL NOM | TOL S. | TOL I. | DEV | MAG |
|---|---|---|---|---|---|---|---|---|
| 24.4.2014 8 ora 5 min 10 Osec | | | | | | | | |
| 17 | GDT OSCILL. ASSIALE | | | | | | | |
| [redacted] SUPERF.SUP | | t | 0.004 | 0.050 | | | | + |
| 20 | GDT OSCILL. ASSIALE | | | | | | | |
| SUPERF.C.A | | t | 0.042 | 0.100 | | | | ++ |
| 26 | GDT LINEARITA' | | | | | | | |
| CONO | | tx | 0.001 | 0.003 | | | | + |
| 32 | GDT OSCILL. ASSIALE | | | | | | | |
| [redacted] SUPERF.INF | | t | 0.003 | 0.050 | | | | + |
| 300 | CERCHIO I | | | | | | | |
| DIAM.I.SUP | | D | 42.017 | 42.000 | 0.025 | 0.009 | 0.017 | +- |
| 303 | CERCHIO I | | | | | | | |
| DIAM.I.INF | | D | 42.017 | 42.000 | 0.025 | 0.009 | 0.017 | +- |
| 309 | SUPERFICIE | | | | | | | |
| [redacted] SUPERF.INF | | Z | -5.325 | 5.340 | 0.050 | -0.050 | -0.015 | -- |
| 311 | GDT OSCILL. ASSIALE | | | | | | | |
| OSC.BATTUT | | t | 0.060 | | | | | |
| 312 | SUPERFICIE RICHIAMO (-16) CON TRASFORMAZIONE | | | | | | | |
| ALT.TOTALE | | Z | 36.075 | 36.070 | 0.030 | -0.030 | 0.005 | + |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| 316 | DIAMETRO CONO | | | | | | | |
| [redacted] DIAM.CONO | | D | 70.594 | 70.600 | -0.010 | -0.010 | -0.006 | -- |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| 317 | COORDINATE CONO | | | | | | | |
| ALT.CONO | | Z | 31.027 | 31.050 | 0.040 | -0.040 | -0.023 | -- |
| 318 | FORMULA: AC(315)/2 | | | | | | | |
| ANGOL.CONO | | AC | 6.984 | 7.000 | 0.030 | -0.030 | -0.016 | -- |
| 320 | GDT OSCILL. RADIALE | | | | | | | |
| [redacted] CONO.2 | | t | 0.004 | 0.020 | | | | + |

DATA : 24-4-2014 NOMEPZ:SR3G 080 803472 PARTNO /32 6AC-108 - 2

| IND | NOMI | / IDF | SY | VAL ATT | VAL NOM | TOL S | TOL I | DEV | MAG |
|---|---|---|---|---|---|---|---|---|---|
| 323 | | | GDT OSCILL. RADIALE | | | | | | |
| | CONO 4 | | t | 0.002 | 0.020 | | | | + |
| 324 | | | SUPERFICIE RICHIAMO ( 19) CON TRASFORMAZIONE | | | | | | |
| | ALT. C.A. | | Z | 28.763 | 28.750 | 0.100 | 0.100 | 0.013 | + |
| 325 | | | SUPERFICIE RICHIAMO ( 23) CON TRASFORMAZIONE | | | | | | |
| | ALT. 38.35 | | Z | 38.355 | 38.350 | 0.100 | 0.100 | 0.005 | + |
| 341 | | | GDT LINEARITA' | | | | | | |
| | MI-180 | | tx | 0.001 | 0.010 | | | | + |
| | | | GDT LINEARITA' | | | | | | |
| | M | | tx | 0.001 | 0.010 | | | | + |
| 346 | | | GDT PARALLELISMO | | | | | | |
| | PARALL-MI | | tx | 0.002 | 0.007 | | | | + |

0 ora 7 min 6.34sec

Trasferimento dati SAM concluso

CNC TERM

PROTOCOLLO DI MISURA ZEISS UMESS

SR3C 080 803472 CICLO CNC

| DISEGNO N° | MACCHINA DI MIS | FORNITORE/CLIENTE | LAVORAZ | OPERAZIONE |
|---|---|---|---|---|
| 2501364175 | PRISMO SACC | GETRAG | T HARD | - |

| OPERATORE | DATA | NUMERO PART | COD. MACCH. | EDIZ. DISEG. FIN. |
|---|---|---|---|---|
| | 24 4 2014 | //32 6AC 108 | 4 | |

| IND | NOMI / IDF | SY | VAL. ATT. | VAL. NOM. | TOL. S | TOL. I | DEV. | MAG. |
|---|---|---|---|---|---|---|---|---|
| 24 4 2014 8 ora 12 min 34 0sec | | | | | | | | |
| 17 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.SUP | t | 0.007 | 0.050 | | | | + |
| 20 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.C.A | t | 0.041 | 0.100 | | | | ++ |
| 26 | GDT LINEARITA | | | | | | | |
| | CONO | tx | 0.000 | 0.003 | | | | + |
| 32 | GDT OSCILL. ASSIALE | | | | | | | |
| | SUPERF.INF | t | 0.004 | 0.050 | | | | + |
| 300 | CERCHIO I | | | | | | | |
| | DIAM.I.SUP | D | 42.021 | 42.000 | 0.025 | 0.009 | 0.021 | +++ |
| 303 | CERCHIO I | | | | | | | |
| | DIAM.I.INF | D | 42.022 | 42.000 | 0.025 | 0.009 | 0.022 | +++ |
| 309 | SUPERFICIE | | | | | | | |
| | SUPERF.INF | Z | -5.324 | 5.340 | 0.050 | -0.050 | -0.016 | - |
| 311 | GDT OSCILL. ASSIALE | | | | | | | |
| | OSC.BATTUT | t | 0.023 | | | | | |
| 312 | SUPERFICIE RICHIAMO ( 16) CON TRASFORMAZIONE | | | | | | | |
| | ALT.TOTALE | Z | 36.069 | 36.070 | 0.030 | -0.030 | -0.001 | - |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| 316 | DIAMETRO CONO | | | | | | | |
| | DIAM.CONO | D | 70.608 | 70.600 | 0.010 | -0.010 | 0.008 | +++ |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| 317 | COORDINATE CONO | | | | | | | |
| | ALT.CONO | Z | 31.082 | 31.050 | 0.040 | -0.040 | 0.032 | +++ |
| 318 | FORMULA: AC(315)/2 | | | | | | | |
| | ANGOL.CONO | AC | 6.993 | 7.000 | 0.030 | -0.030 | -0.007 | - |
| 320 | GDT OSCILL. RADIALE | | | | | | | |
| | CONO.2 | t | 0.003 | 0.020 | | | | + |

```
DATA :24-4-2014 NOMEPz SR3G - 080 803472      PARTNO //32 6AC 108      2
 IND|   NOMI   / IDF   |SY| VAL ATT  | VAL NOM  | TOL S  | TOL I  | DEV    | MAG
323                          GDT OSCILL. RADIALE
    CONC 4                    C        0.002      0.020                      +

324                          SUPERFICIE RICHIAMO (= 19) CON TRASFORMAZIONE
    ALT. C.A                  Z       28.760     28.750    0.100    0.100   0.010  +

325                          SUPERFICIE RICHIAMO (= 23) CON TRASFORMAZIONE
    ALT. 38.35                Z       38.352     38.350    0.100    0.100   0.002  +

341,                         GDT LINEARITA'
    ML-180                    tx       0.001      0.010                      +

343                          GDT LINEARITA'
    ML-0                      tx       0.001      0.010                      +

346                          GDT PARALLELISMO
    PARALL-ML                 tx       0.001      0.007                      +


 0 ora  7 min  6.71sec
 ------ Trasferimento dati SAM concluso ------
                              CNC - TERM
```

PROTOCOLLO DI MISURA ZEISS UMESS

SR3G 080_803472 CICLO CNC

| DISEGNO No. | MACCHINA DI MIS. | FORNITORE/CLIENTE | LAVORAZ. | OPERAZIONE |
|---|---|---|---|---|
| 250136417[illegible] | PRISMO SACC | GETRAG | T. HARD | |

| OPERATORE | DATA | NUMERO PART. | COD. MACCH. | EDIZ. DISEG. FIN. |
|---|---|---|---|---|
| | 24. 4.2014 | 7732 6AC-108 | 5 | |

| IND | NOMI / IDE | SY | VAL. ATT. | VAL. NOM. | TOL. S. | TOL. I. | DEV. | MAC. |
|---|---|---|---|---|---|---|---|---|
| 24. 4.2014 8 ora 20 min 45 sec | | | | | | | | |
| 17 | | GDT OSCILL. ASSIALE | | | | | | |
| | SUPERF.SUP | t | 0.005 | 0.050 | | | | + |
| 2[illegible] | | GDT OSCILL. ASSIALE | | | | | | |
| | SUPERF.C.A | t | 0.021 | 0.100 | | | | + |
| 26 | | GDT LINEARITA' | | | | | | |
| | CONO | tx | 0.001 | 0.003 | | | | ++ |
| 32 | | GDT OSCILL. ASSIALE | | | | | | |
| | SUPERF.INF | t | 0.005 | 0.050 | | | | + |
| 300 | | CERCHIO I | | | | | | |
| | DIAM.I.SUP | D | 42.022 | 42.000 | 0.025 | 0.009 | 0.022 | +++ |
| 303 | | CERCHIO I | | | | | | |
| | DIAM.I.INF | D | 42.020 | 42.000 | 0.025 | 0.009 | 0.020 | ++ |
| 309 | | SUPERFICIE | | | | | | |
| | SUPERF.INF | Z | 5.351 | 5.340 | 0.050 | -0.050 | 0.011 | + |
| 311 | | GDT OSCILL. ASSIALE | | | | | | |
| [illegible] | OSC.BATTUT | t | 0.010 | | | | | |
| 312 | | SUPERFICIE RICHIAMO ( 16) CON TRASFORMAZIONE | | | | | | |
| | ALT.TOTALE | Z | 36.078 | 36.070 | 0.030 | -0.030 | 0.008 | ++ |
| ALTEZZA INT. 31.05mm | | | | | | | | |
| 316 | | DIAMETRO CONO | | | | | | |
| | DIAM.CONO | D | 70.607 | 70.600 | 0.010 | -0.010 | 0.007 | +++ |
| DIAMETRO INT. 70.6mm | | | | | | | | |
| 317 | | COORDINATE CONO | | | | | | |
| | ALT.CONO | Z | 31.077 | 31.050 | 0.040 | -0.040 | 0.027 | ++ |
| 315 | | FORMULA: AC(315)/2 | | | | | | |
| | ANGOL.CONO | AC | 6.998 | 7.000 | 0.030 | -0.030 | -0.002 | |
| 320 | | GDT OSCILL. RADIALE | | | | | | |
| | CONO.2 | t | 0.005 | 0.020 | | | | |
| [illegible] | | | | | | | | |

```
DATA :24 4 2014 NOMEPz:SR3G    080 803472          PARINO /732 6AC-108      2
 IND|   NOMI    / IDE   |SY| VAL ATT  | VAL NOM  | TOL S  | TOL I  | DEV    | MAG
-------------------------------------------------------------------------------
3                        GDT OSCILL  RADIALE
   CONO 4                t     0.003     0.020                                +
324                      SUPERFICIE RICHIAMO (  19) CON TRASFORMAZIONE
   ALT  C.A.             Z    28.781    28.750   0.100   -0.100   0.031    +
325                      SUPERFICIE RICHIAMO (  23) CON TRASFORMAZIONE
   ALT  38.35            Z    38.371    38.350   0.100   -0.100   0.021    +
344                      GDT LINEARITA'
   ML-180                tx    0.001     0.010                              +
343                      GDT LINEARITA'
   ML-0                  tx    0.002     0.010                              +
346                      GDT PARALLELISMO
   PARALL-ML             tx    0.001     0.007                              +

   0 ora  7 min 10.74sec

          ------- Trasferimento dati SAM concluso -------
-------------------------------------------------------------------------------
                                CNC  TERM
-------------------------------------------------------------------------------
```

# GETRAG Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. Prog.: | STI0410o05 0 PNC35 B4784 | Controllore: | 0TURNO a | Data: | 24.05.2014 08:23 |
| Denominazione: | SR3 | Numero denti z | 56 | Largh.fasc.dent. b | 13mm |
| Numero disegnb.: | 250.1.5169.75-IF | Modulo m | 1.75mm | Tratto evolv. La | 12.03/8.97mm |
| Commessa/serie nr.: | 1 | Angolo pressione | 17.5° | Tratto elica Lß | 10.4mm |
| Masch.Nr.: | M001 Spindel: Formmast | Angolo elica | -30° | Inizio elab. M1 | 12.47mm |
| Untersuchungszweck: | Laufende Messung | Ø Base db | 106.3326mm | Palpatore Ø | (#1) 1mm |
| Werkzeug: | Charge: | Ang. Base | -28.48° | Fat.scor.pr. x | -.091 |

RILASCIO

TIRO

Piede-Ø: 106.477mm [106.2/106.65]

Testa-Ø: 117.931mm [117.74/118]

VDI



KLINGELNBERG

# GETRAG Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 PNC35 B4784 | Controllore: | 0TURNO a | Data: | '24.05.2014 08:25 |
| Denominazione: | SR3 | Numero denti z | 56 | Largh.fasc.dent. b | 13mm |
| Numero disegno: | 250.1.5169.75-IF | Modulo m | 1.75mm | Tratto evolv. La | 12.03/8.97mm |
| Commessa/serie nr.: | 2 | Angolo pressione | 17.5° | Tratto elica Lß | 10.4mm |
| Lavoro Nr.: | M001 Spindel: Formmaster | Angolo elica | -30° | Inizio elab. M1 | 12.47mm |
| Untersuchungszweck: | Laufende Messung | Ø Base db | 106.3326mm | Palpatore Ø | (#1) 1mm |
| Werkzeug: | Charge: | Ang. Base | -28.48° | Fat.scor.pr. x | -.091 |

RILASCIO

TIRO

Piede-Ø: 106.467mm [106.2/106.65]

Testa-Ø: 117.927mm [117.74/118]

VDI

# GETRAG — Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 PNC35 B4784 | Controllore: | 0TURNO a | Data: | 24.05.2014 08:27 |
| Denominazione: | SR3 | Numero denti z | 56 | Largh.fasc.dent. b | 13mm |
| Numero disegno.: | 250.1.5169.75-IF | Modulo m | 1.75mm | Tratto evolv. La | 12.03/8.97mm |
| Commessa/serie nr.: | 3 | Angolo pressione | 17.5° | Tratto elica Lß | 10.4mm |
| Masch.Nr.: | M001 Spindel: Formmessl | Angolo elica | -30° | Inizio elab. M1 | 12.47mm |
| Untersuchungszweck: | Laufende Messung | ø Base db | 106.3326mm | Palpatore ø | (#1) 1mm |
| Werkzeug: | Charge: | Ang. Base | -28.48° | Fat.scor.pr. x | -.091 |

RILASCIO

TIRO

Piede-Ø: 106.473mm [106.2/106.65]

Testa-Ø: 117.932mm [117.74/118]

VDI



KLINGELNBERG

# GETRAG — Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog.: | STI0410o05 0 PNC35 B4784 | Controllore: | 0TURNO a | Data: | 24.05.2014 08:29 |
| Denominazione: | SR3 | Numero denti z | 56 | Largh.fasc.dent. b | 13mm |
| Numero disegno.: | 250.1.5169.75-IF | Modulo m | 1.75mm | Tratto evolv. La | 12.03/8.97mm |
| Commessa/serie nr.: | 4 | Angolo pressione | 17.5° | Tratto elica Lß | 10.4mm |
| Mason.Nr.: | M001 Spindel: Formmaster | Angolo elica | -30° | Inizio elab. M1 | 12.47mm |
| Untersuchungszweck: | Laufende Messung | Ø Base db | 106.3326mm | Palpatore Ø | (#1)1mm |
| Werkzeug: | Charge: | Ang. Base | -28.48° | Fat.scor.pr. x | -.091 |

RILASCIO

Piede-Ø: 106.467mm [106.2/106.65]

Testa-Ø: 117.928mm [117.74/118]

TIRO

VDI



KLINGELNBERG

GETRAG

# Ruota cilindrica Evolvente/Elica

| | | | | | |
|---|---|---|---|---|---|
| Nr. prog : | STI0410o05 0 PNC35 B4784 | Controllore: | 0TURNO a | Data: | 24.05.2014 08:31 |
| Denominazione: | SR3 | Numero denti z | 56 | Largh.fasc.dent. b | 13mm |
| Numero disegno.: | 250.1.5169.75-IF | Modulo m | 1.75mm | Tratto evolv. La | 12.03/8.97mm |
| Conduzione/serie nr.: | 5 | Angolo pressione | 17.5° | Tratto elica Lß | 10.4mm |
| Mandr.Nr.: | M001 Spindel: Formmessplatz | Angolo elica | -30° | Inizio elab. M1 | 12.47mm |
| Untersuchungszweck: | Laufende Messung | ø Base db | 106.3326mm | Palpatore ø | (#1) 1mm |
| Werkzeug: | Charge: | Ang. Base | -28.48° | Fat.scor.pr. x | -.091 |

RILASCIO

TIRO

Piede-Ø: 106.476mm [106.2/106.65]

Testa-Ø: 117.916mm [117.74/118]

VDI

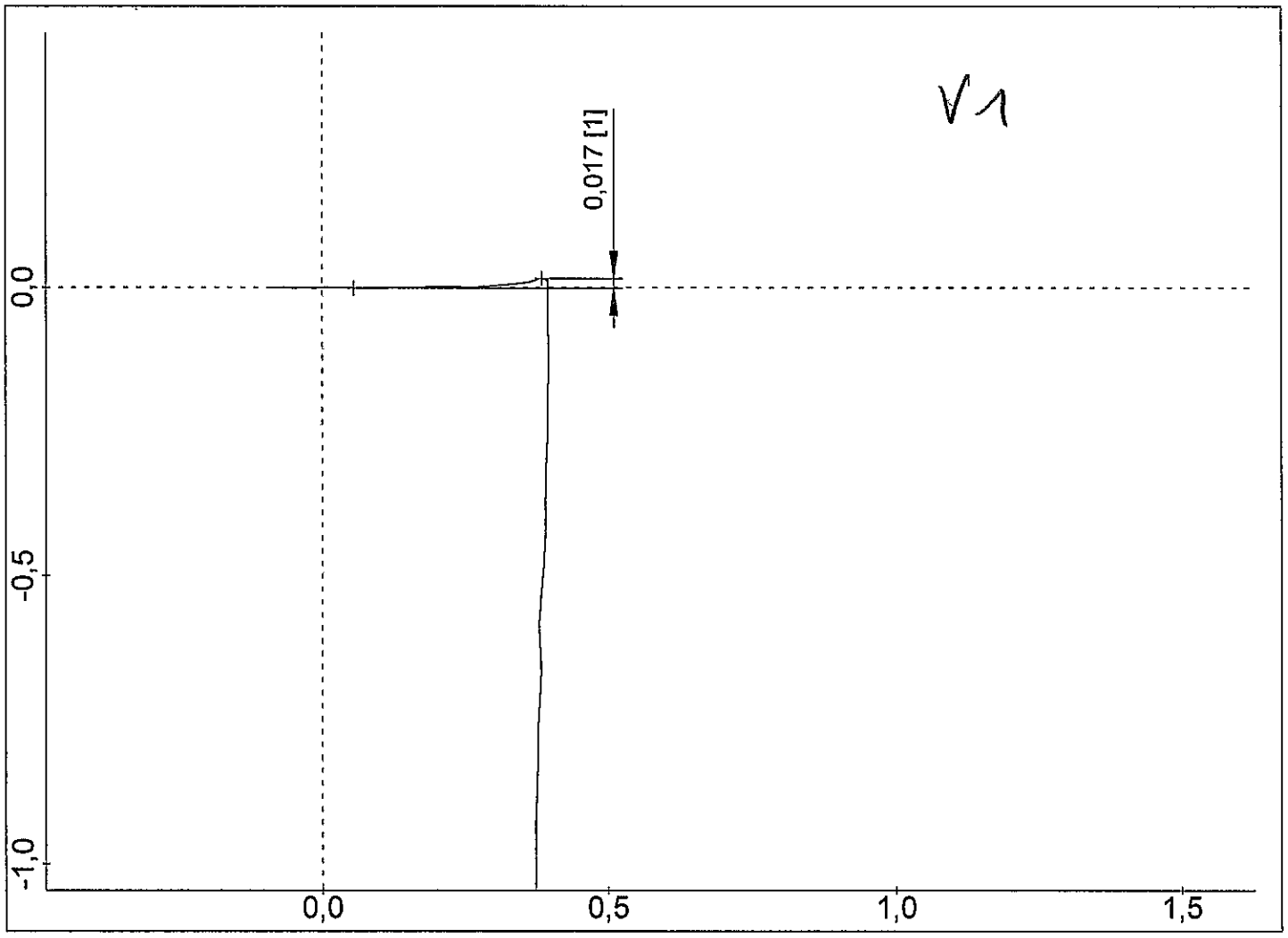


KLINGELNBERG

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.1 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:03 |
| Nota: | V 1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

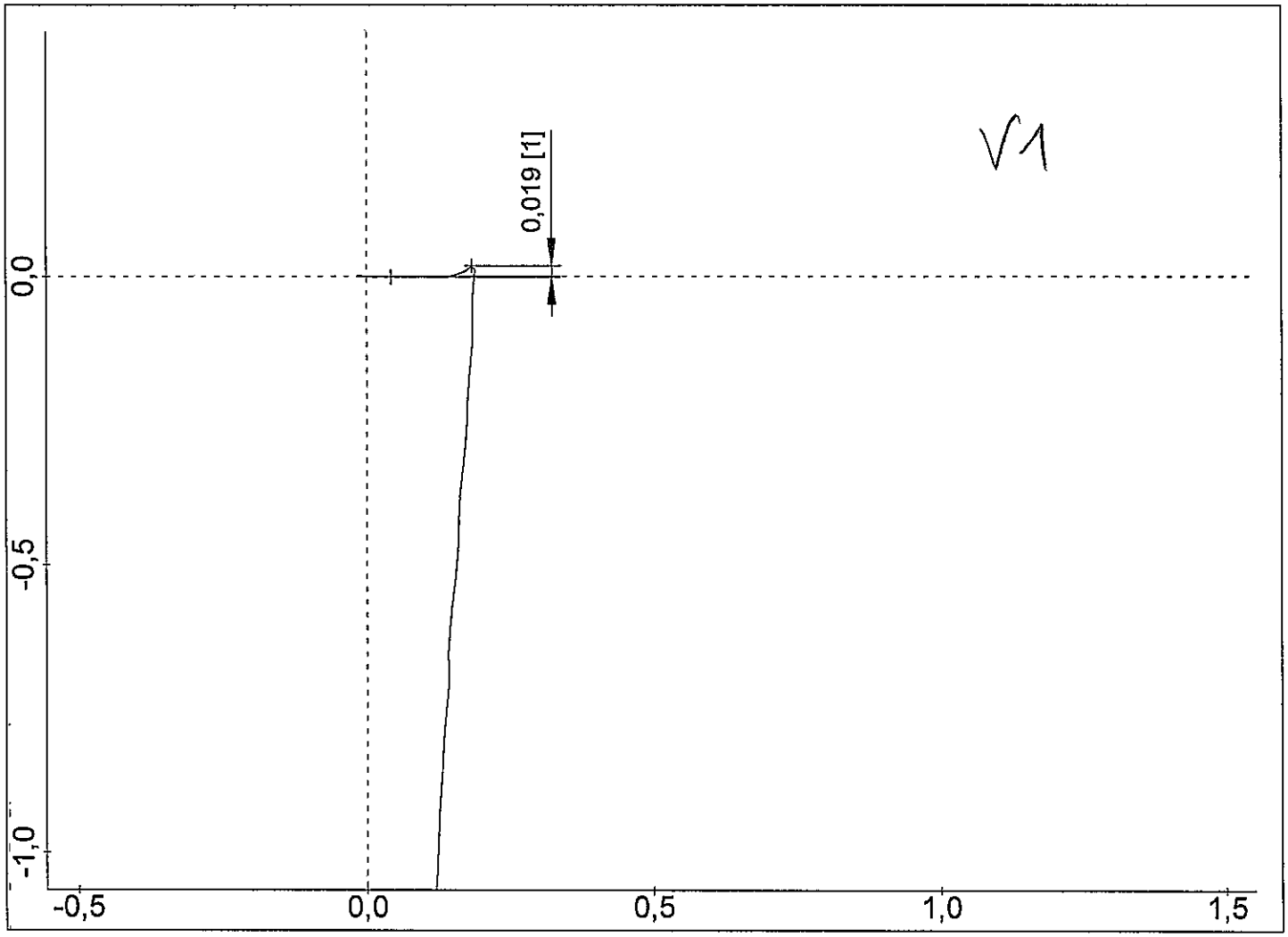



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.2 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:04 |
| Nota: | V 1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

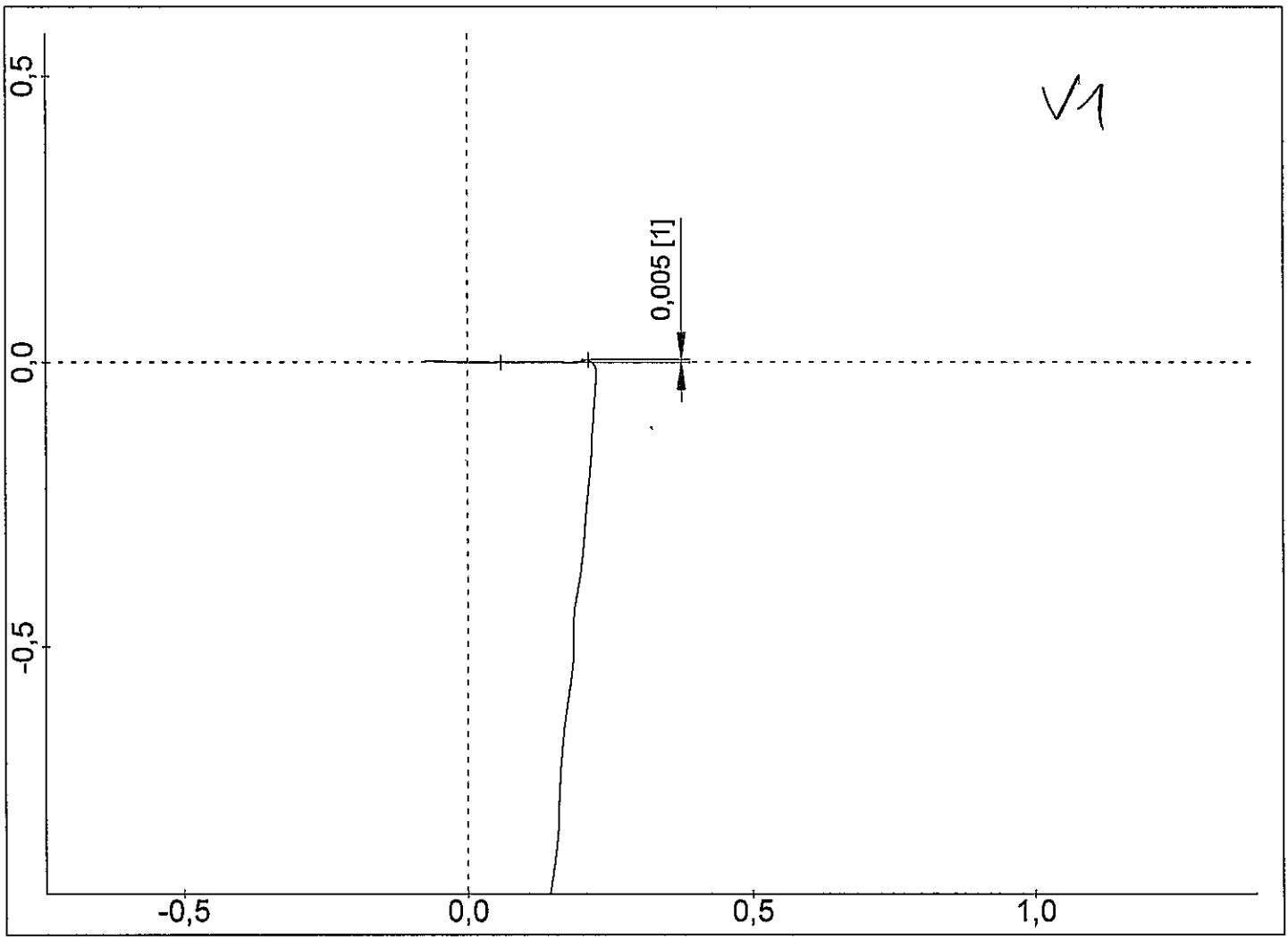



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.3 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:05 |
| Nota: | V 1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

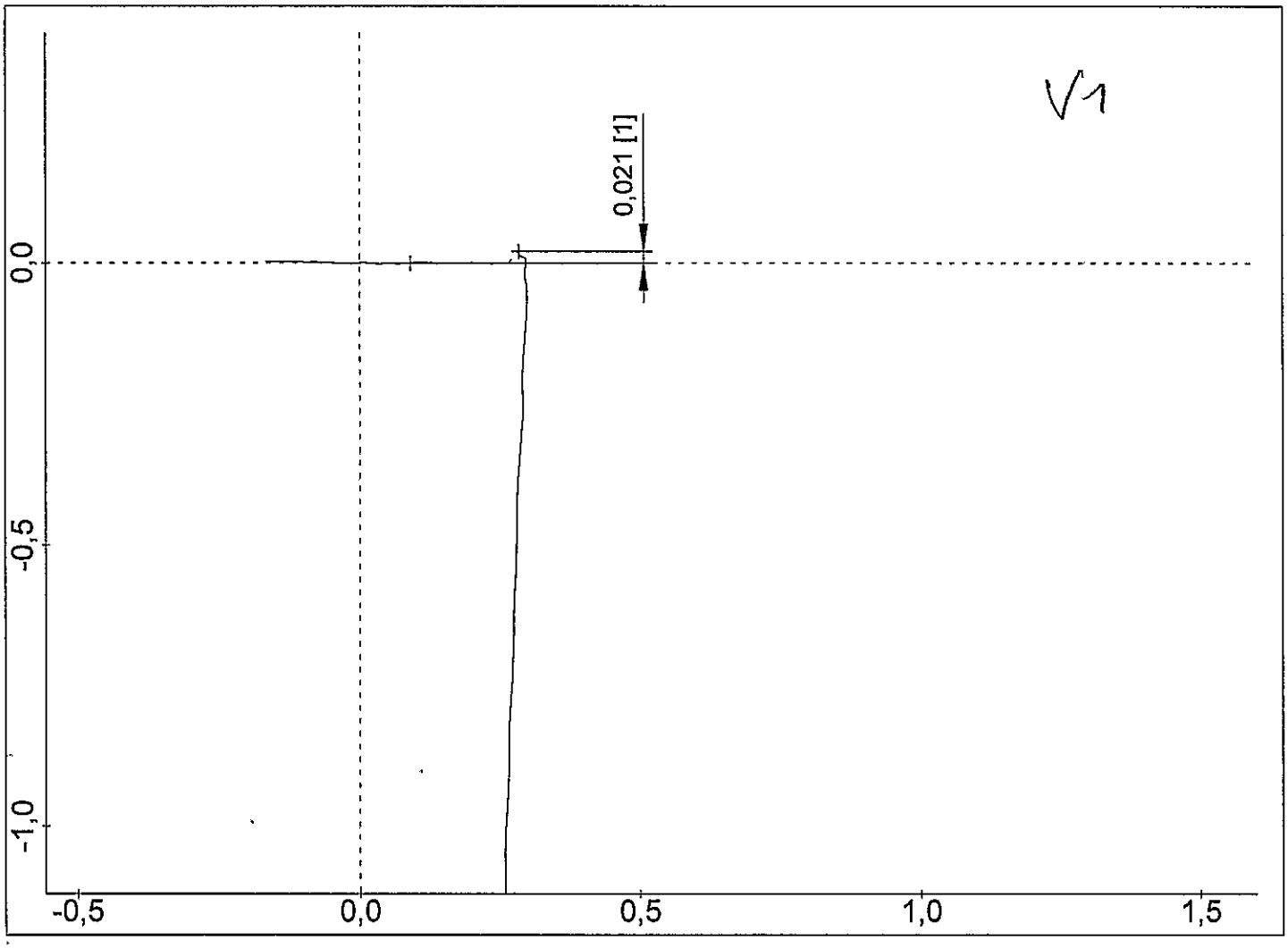



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.4 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:06 |
| Nota: | V 1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

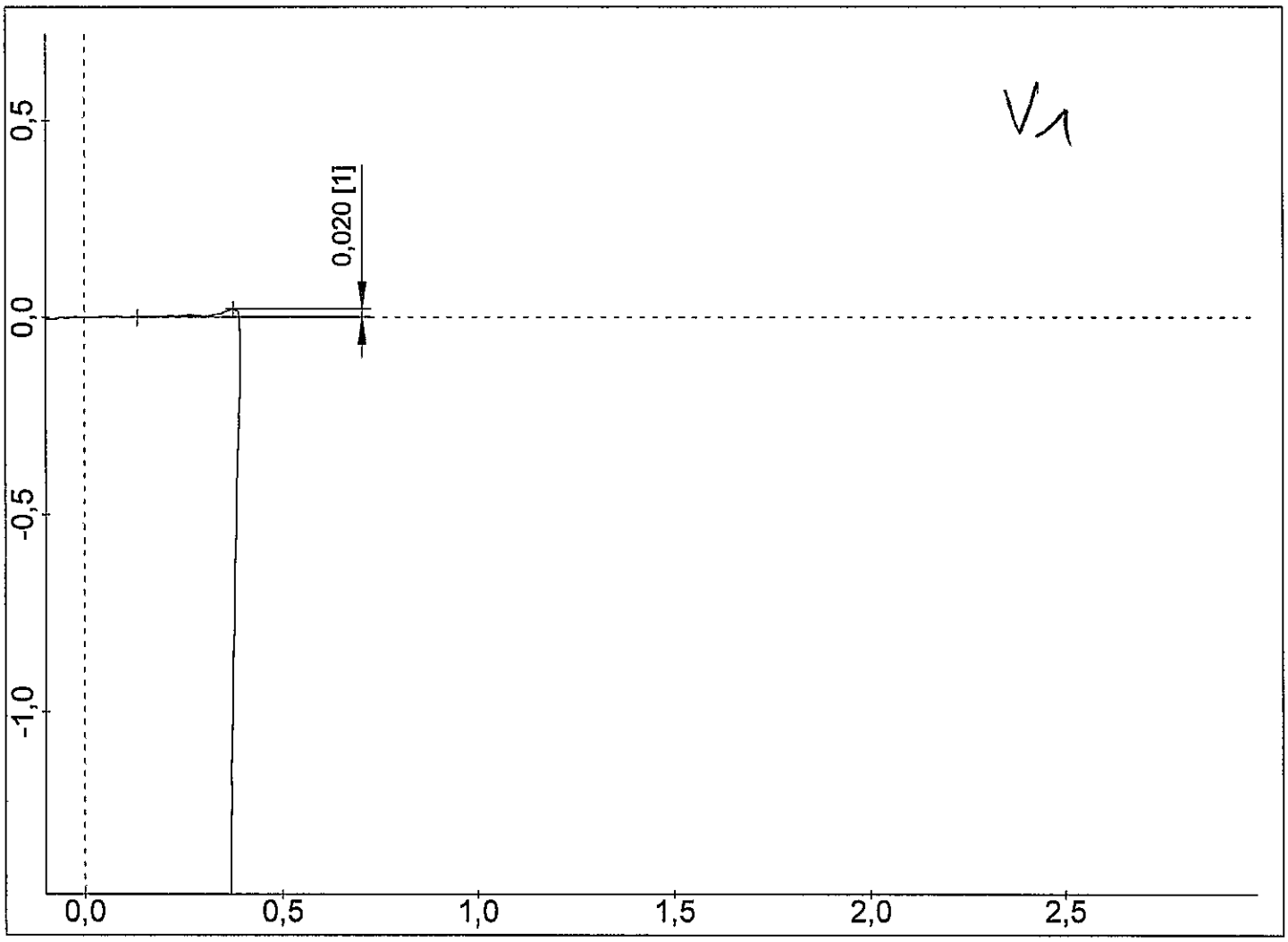



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.5 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:06 |
| Nota: | V 1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

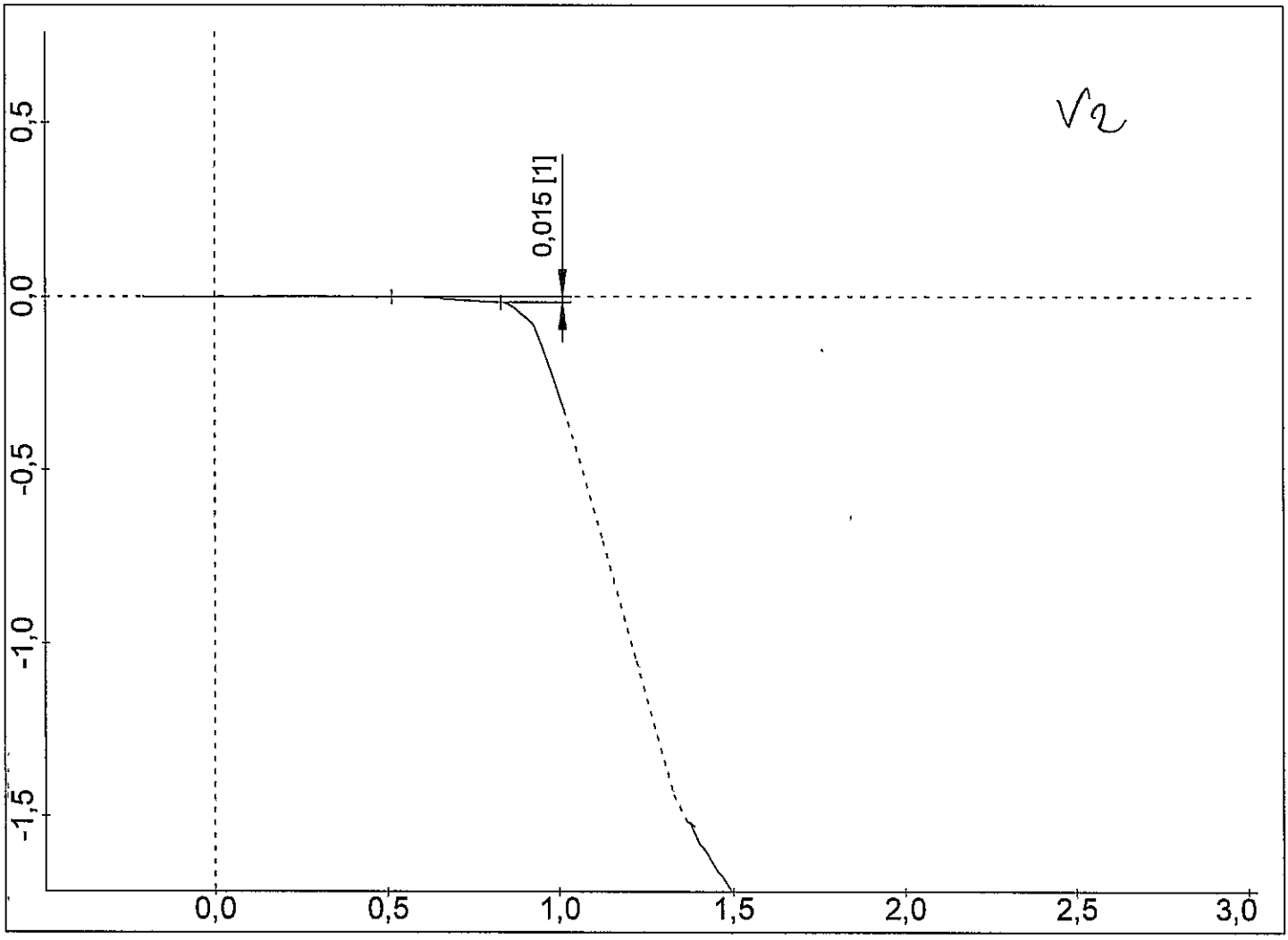



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.1 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:08 |
| Nota: | V 2 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

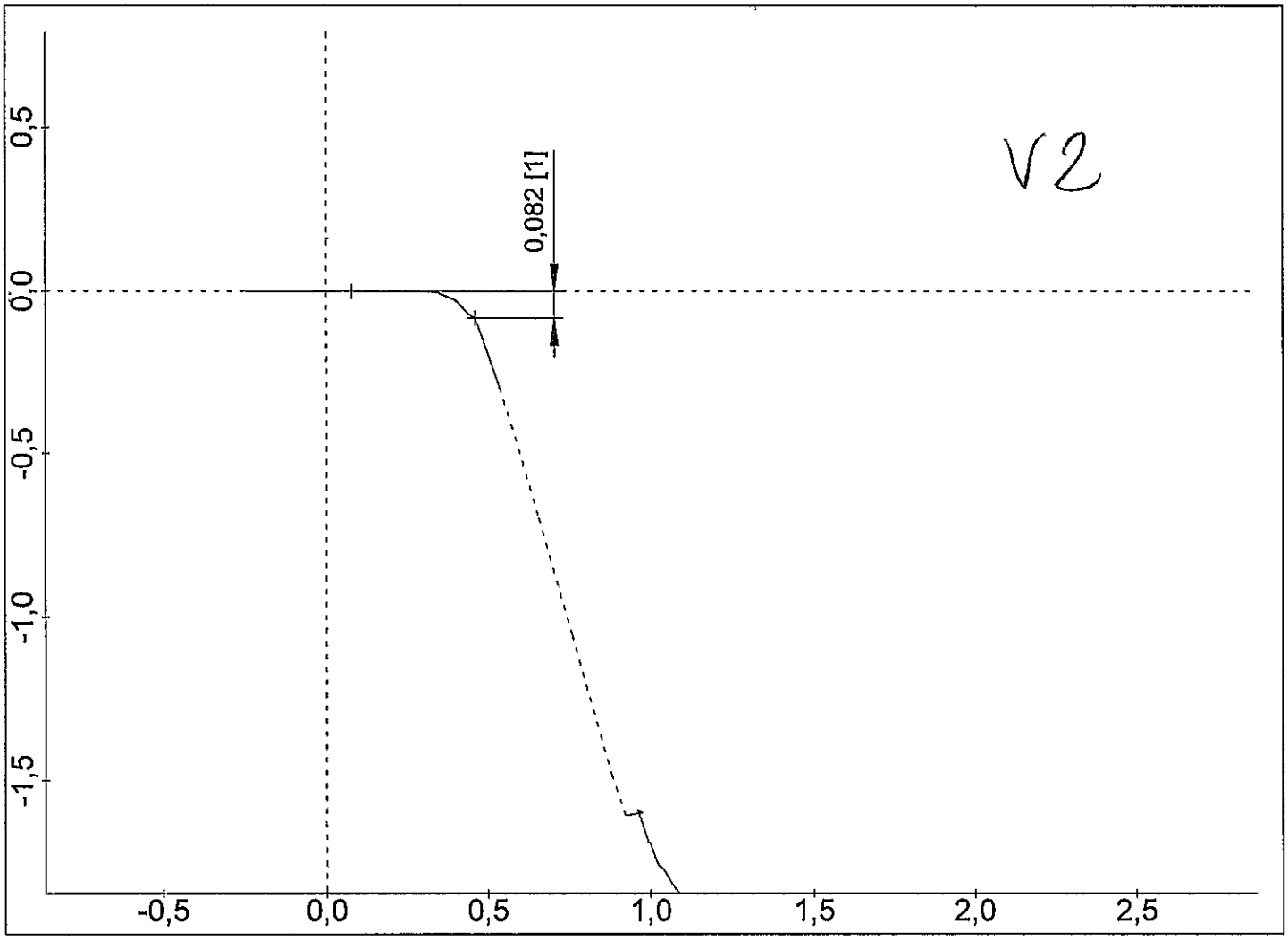



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.2 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:09 |
| Nota: | V 2 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

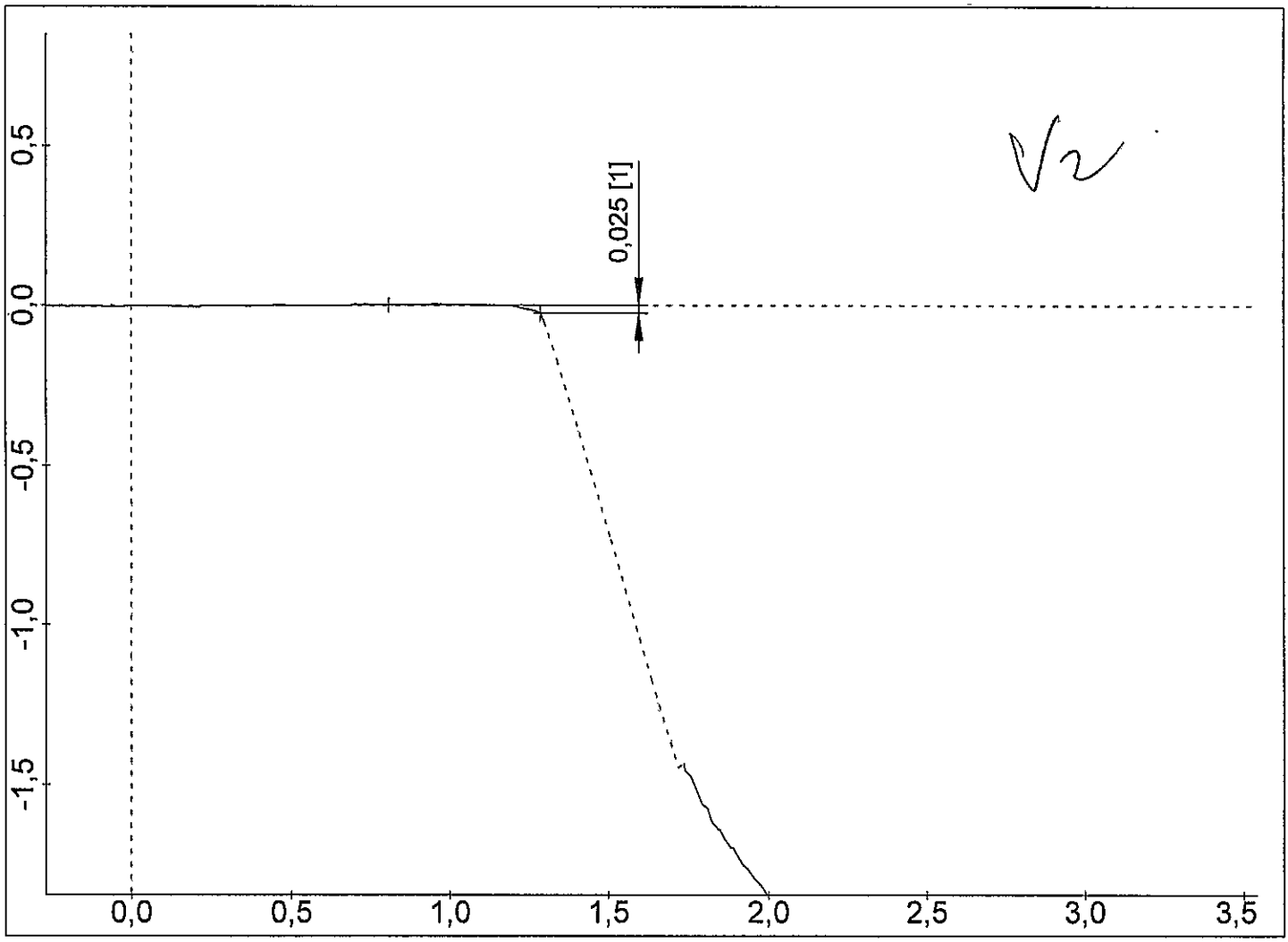



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.3 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:09 |
| Nota: | V 2 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

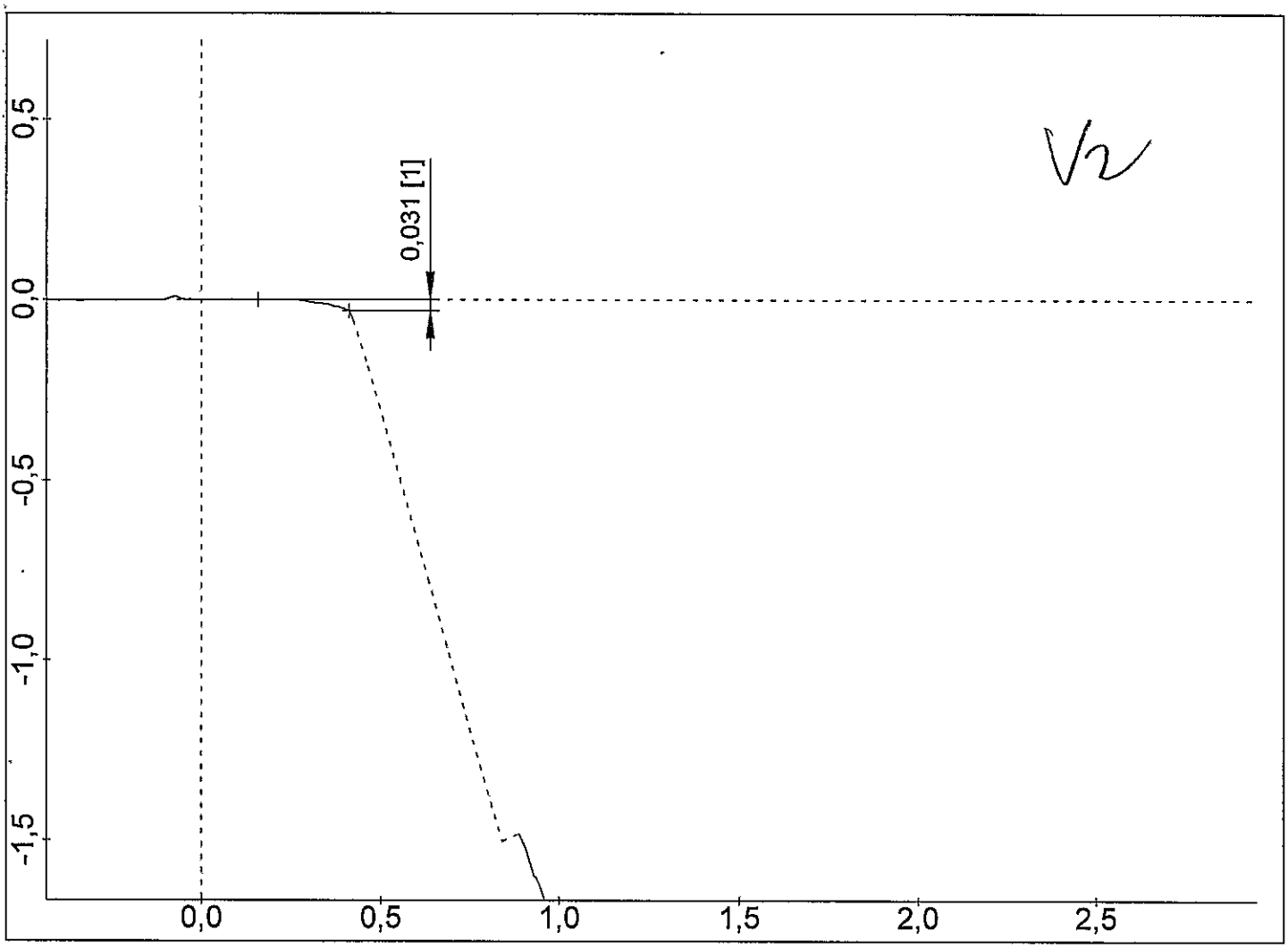



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.4 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:10 |
| Nota: | V 2 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

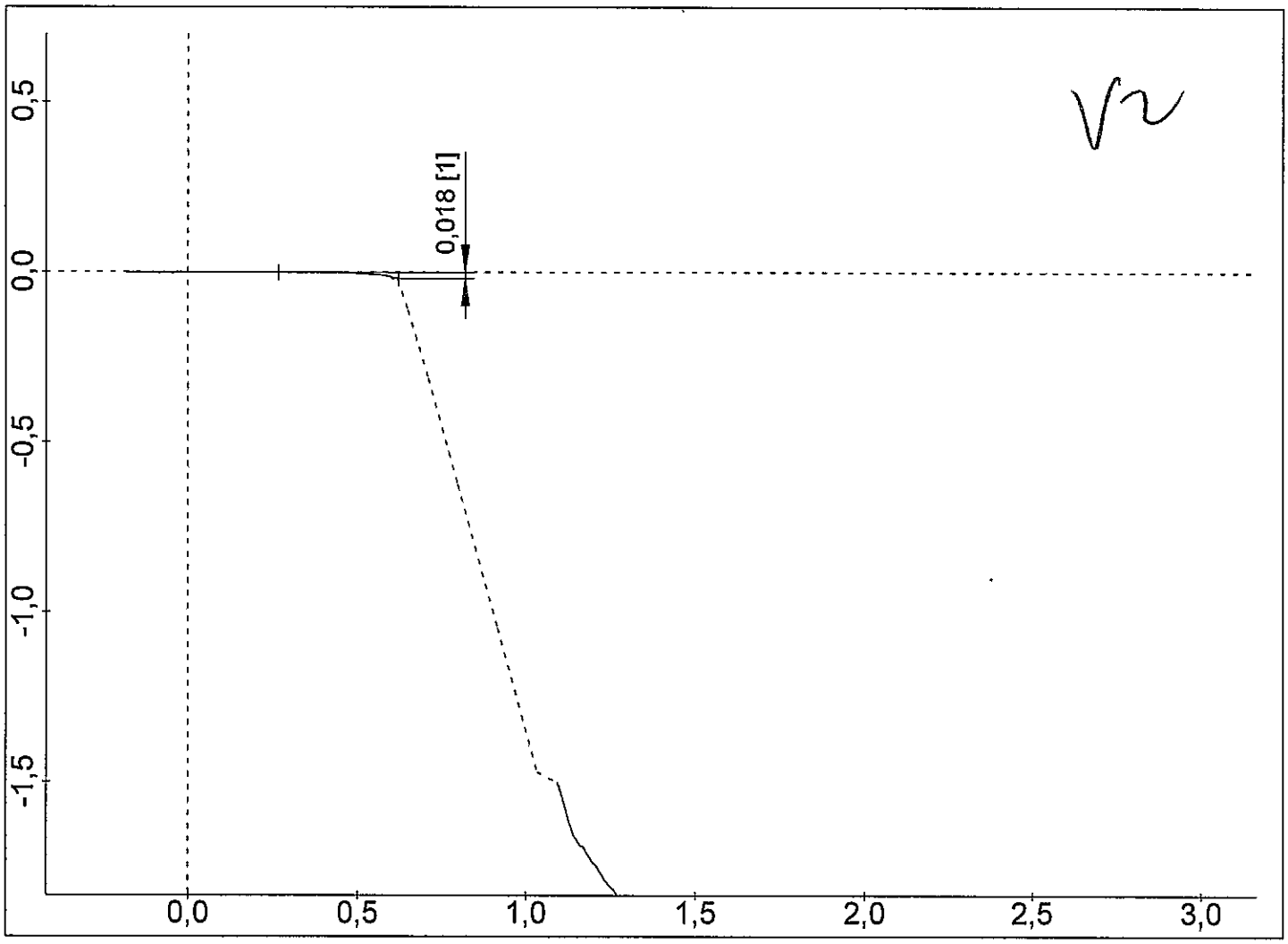



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.5 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:11 |
| Nota: | V 2 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |



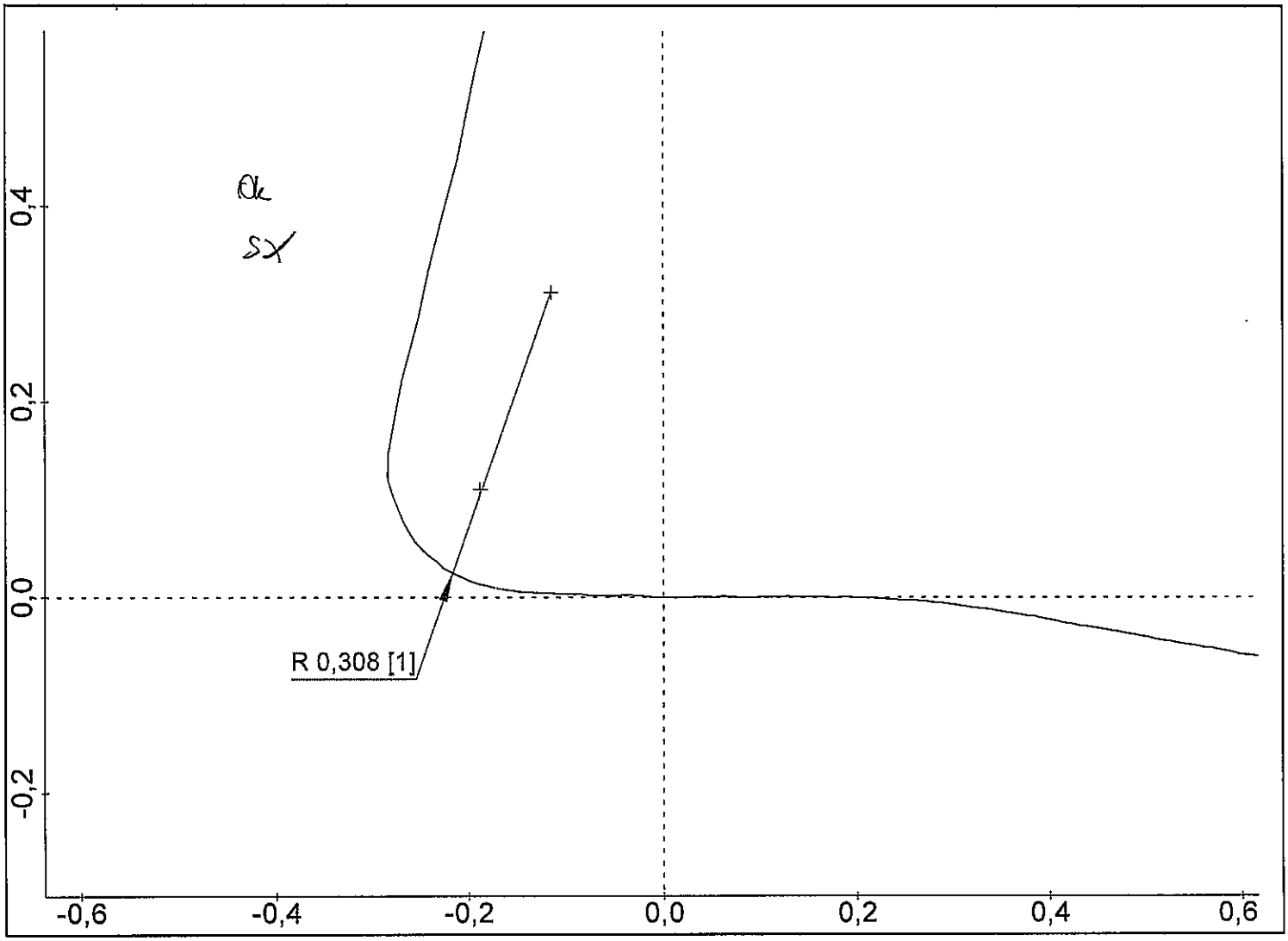

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 10:11 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



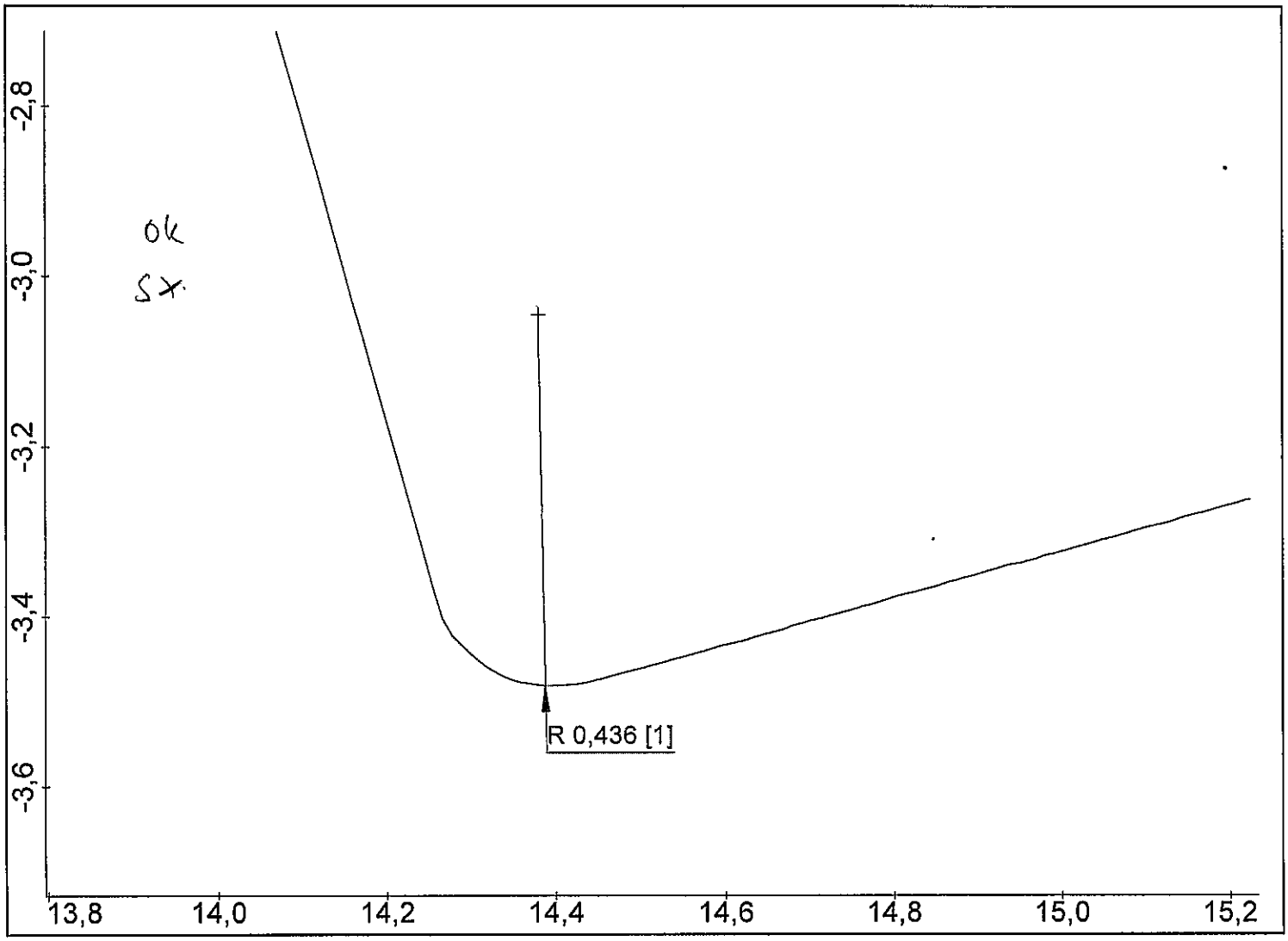

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 10:23 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



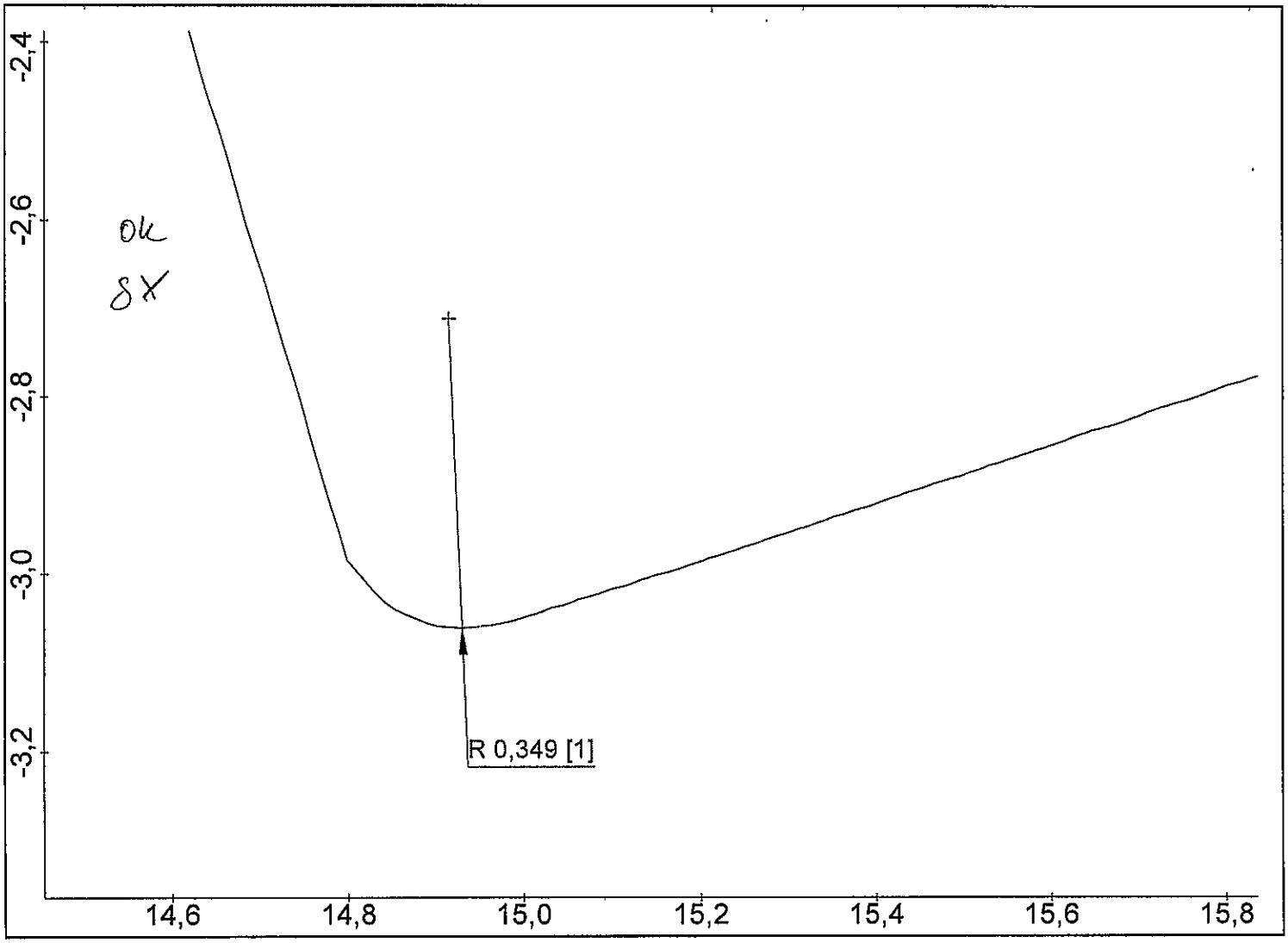

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:38 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



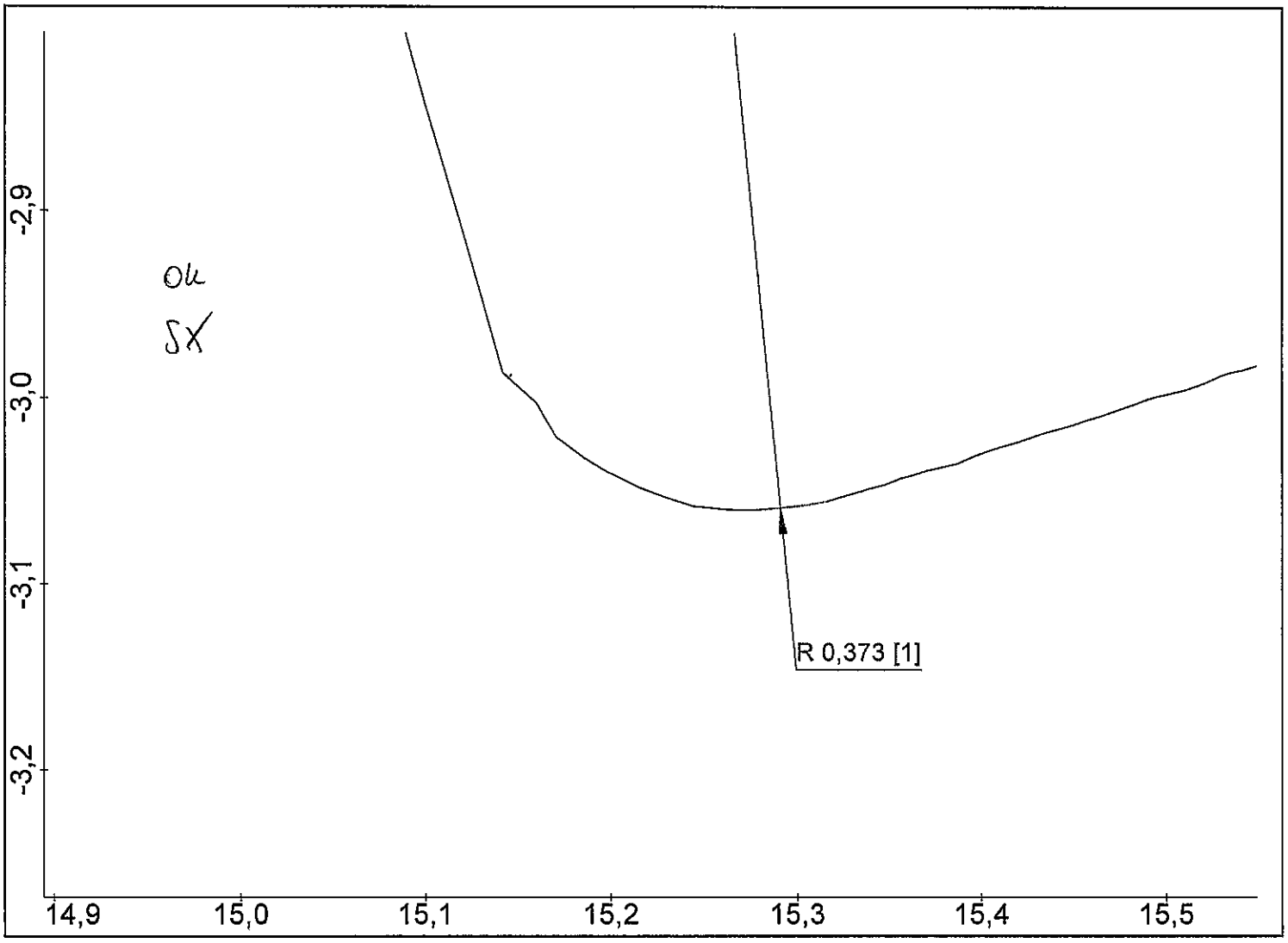

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:44 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



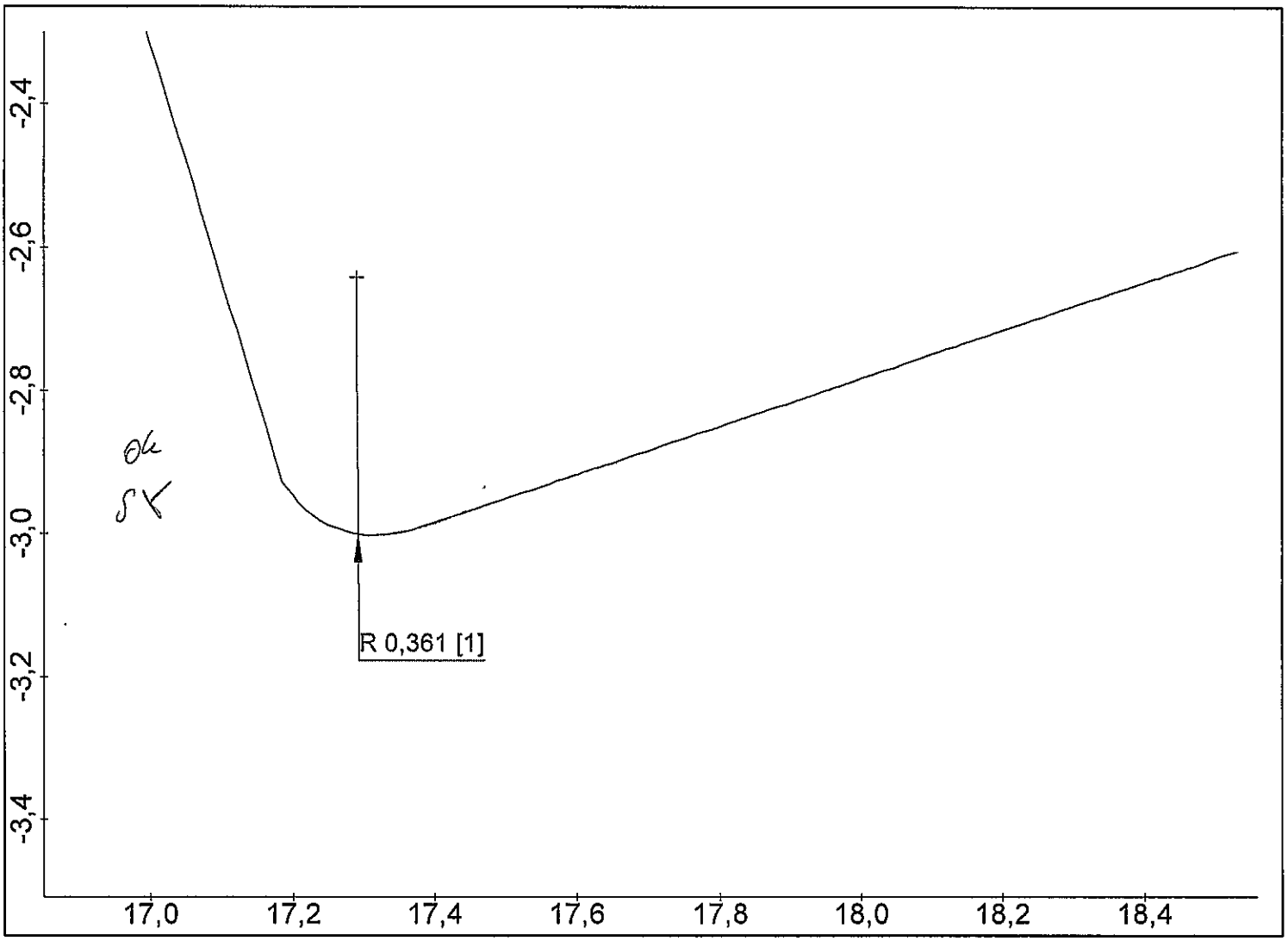

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:46 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



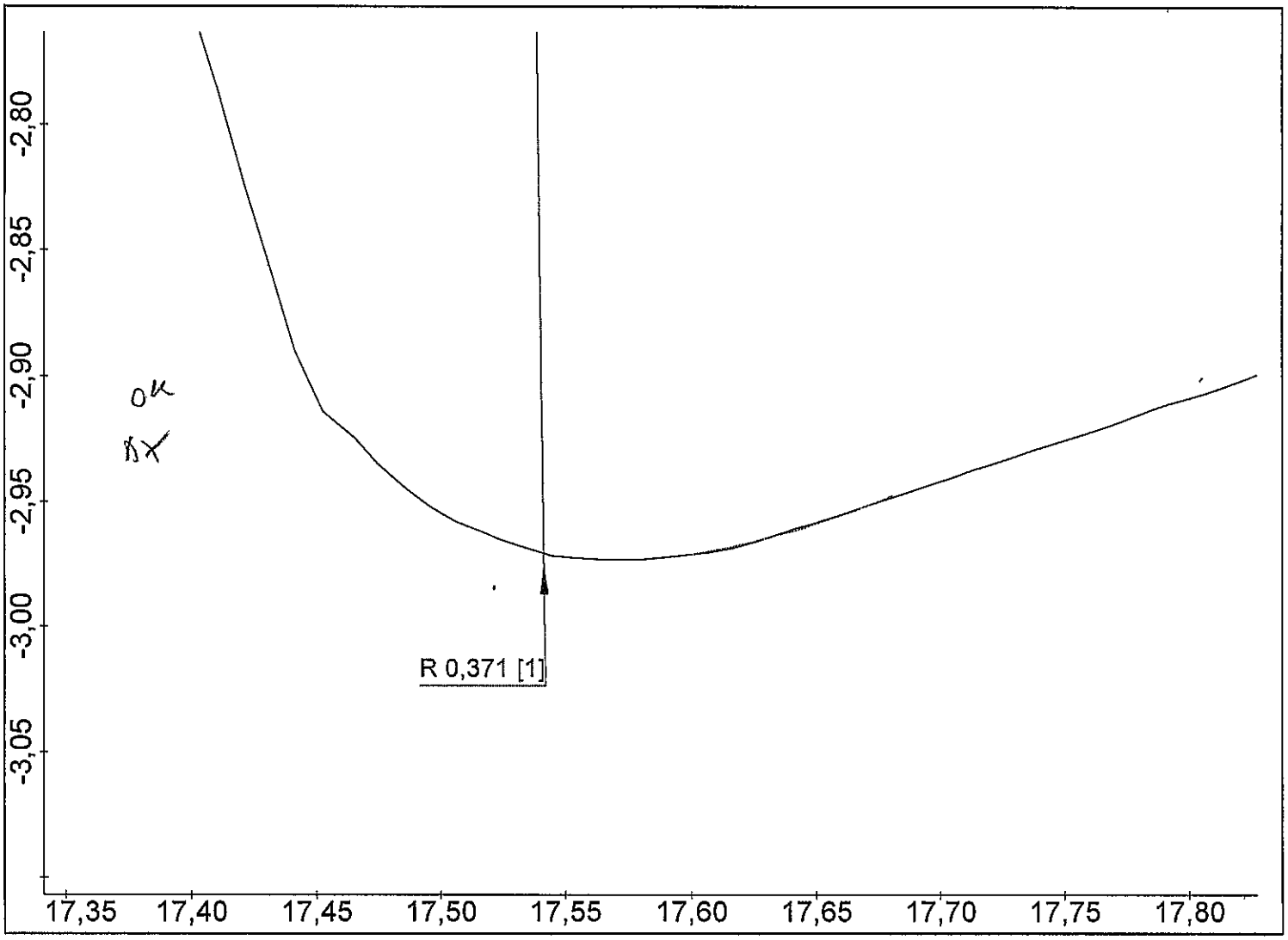

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:55 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



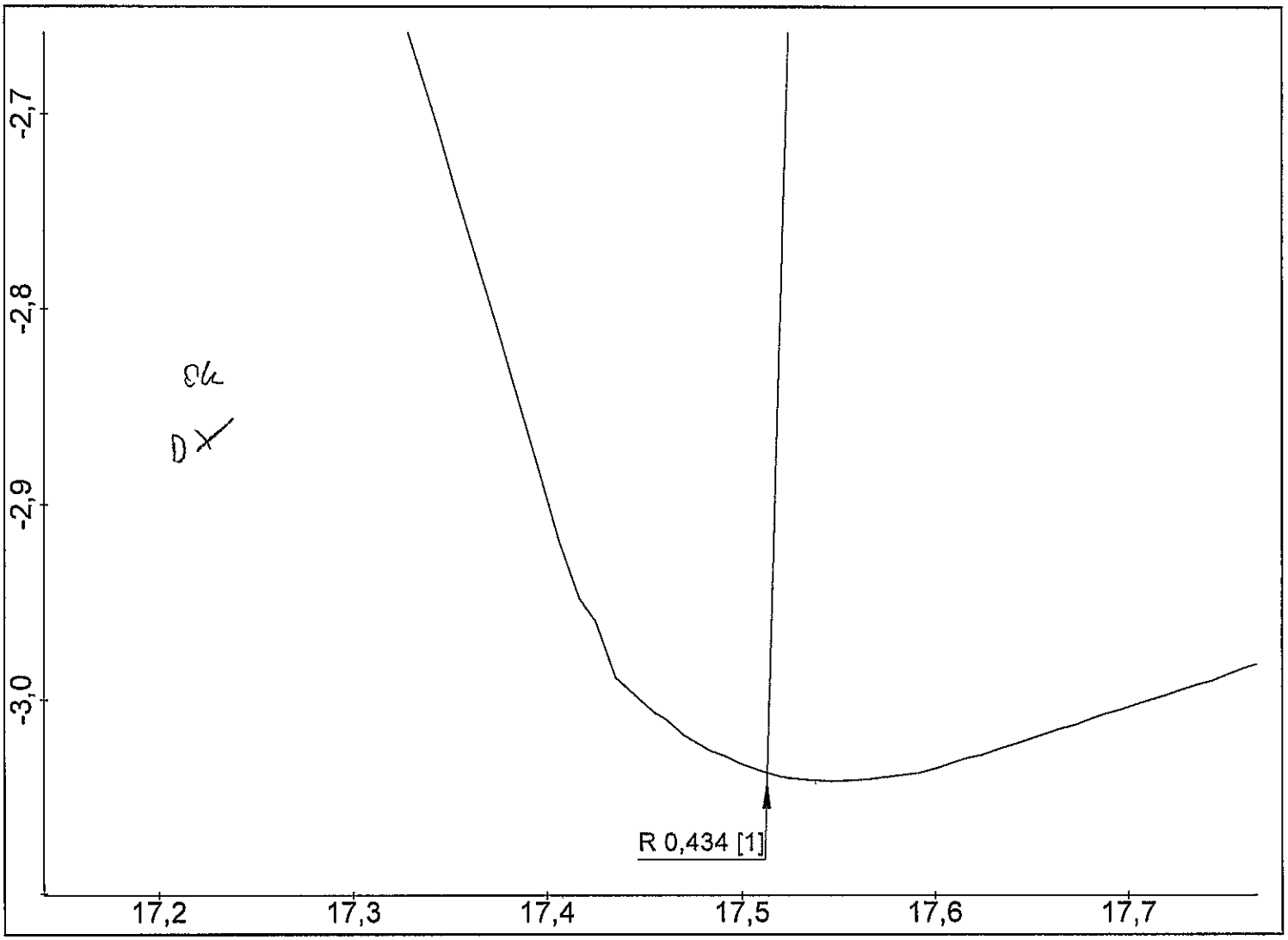

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:58 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



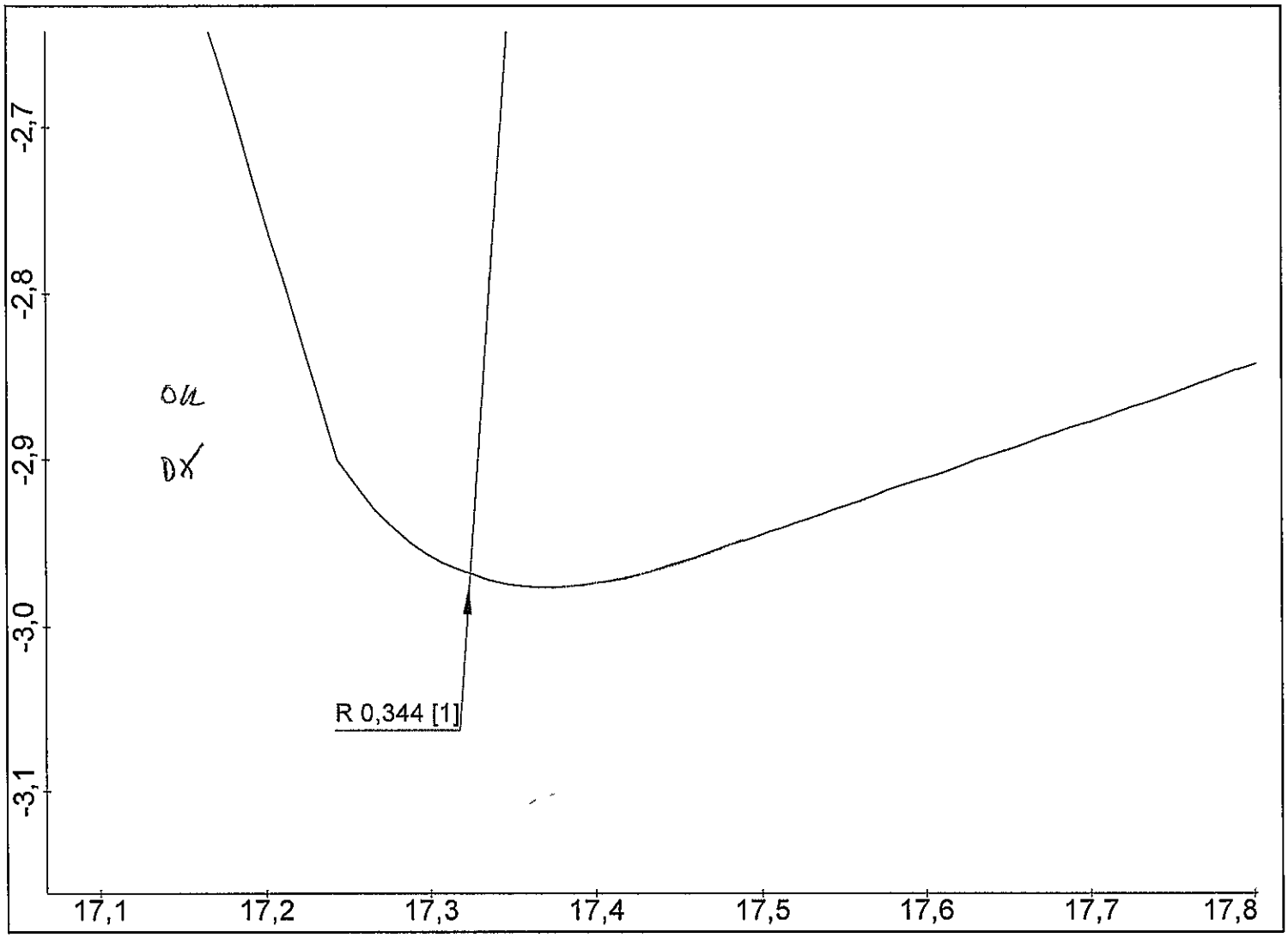

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 10:59 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



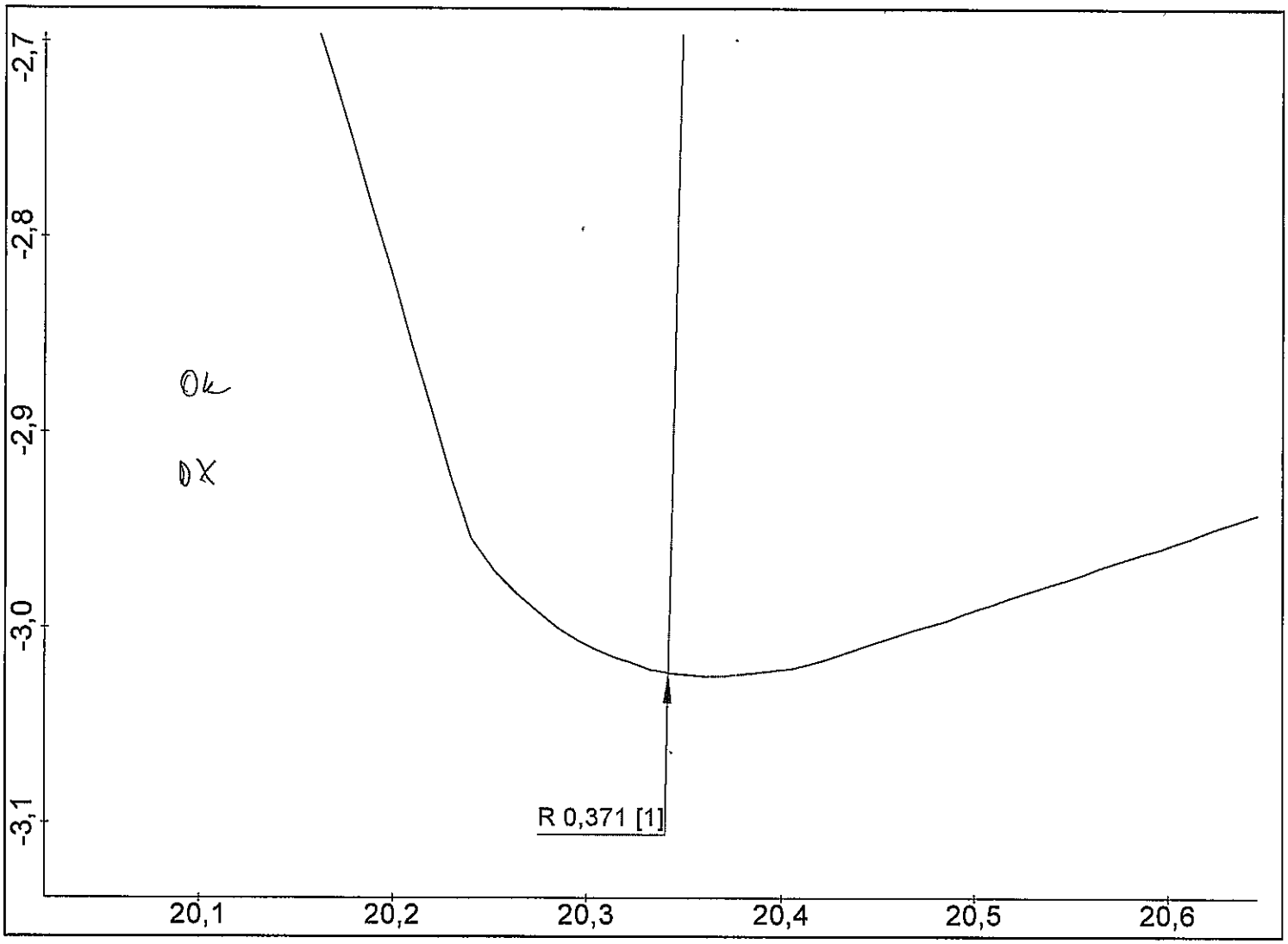

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 11:04 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



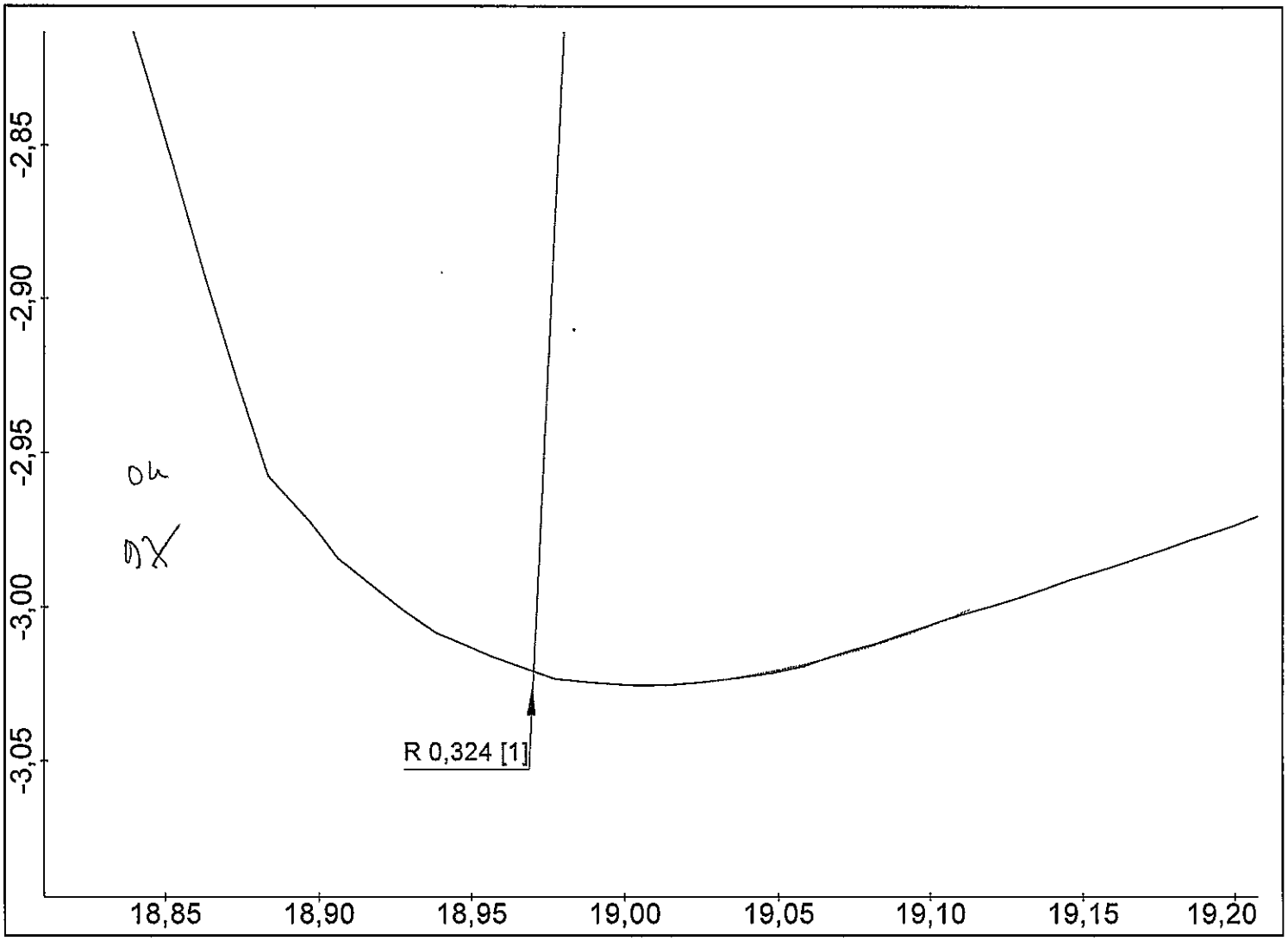

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Data, ora: | 05.06.2014, 11:02 |
| Nota: | PART V |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |



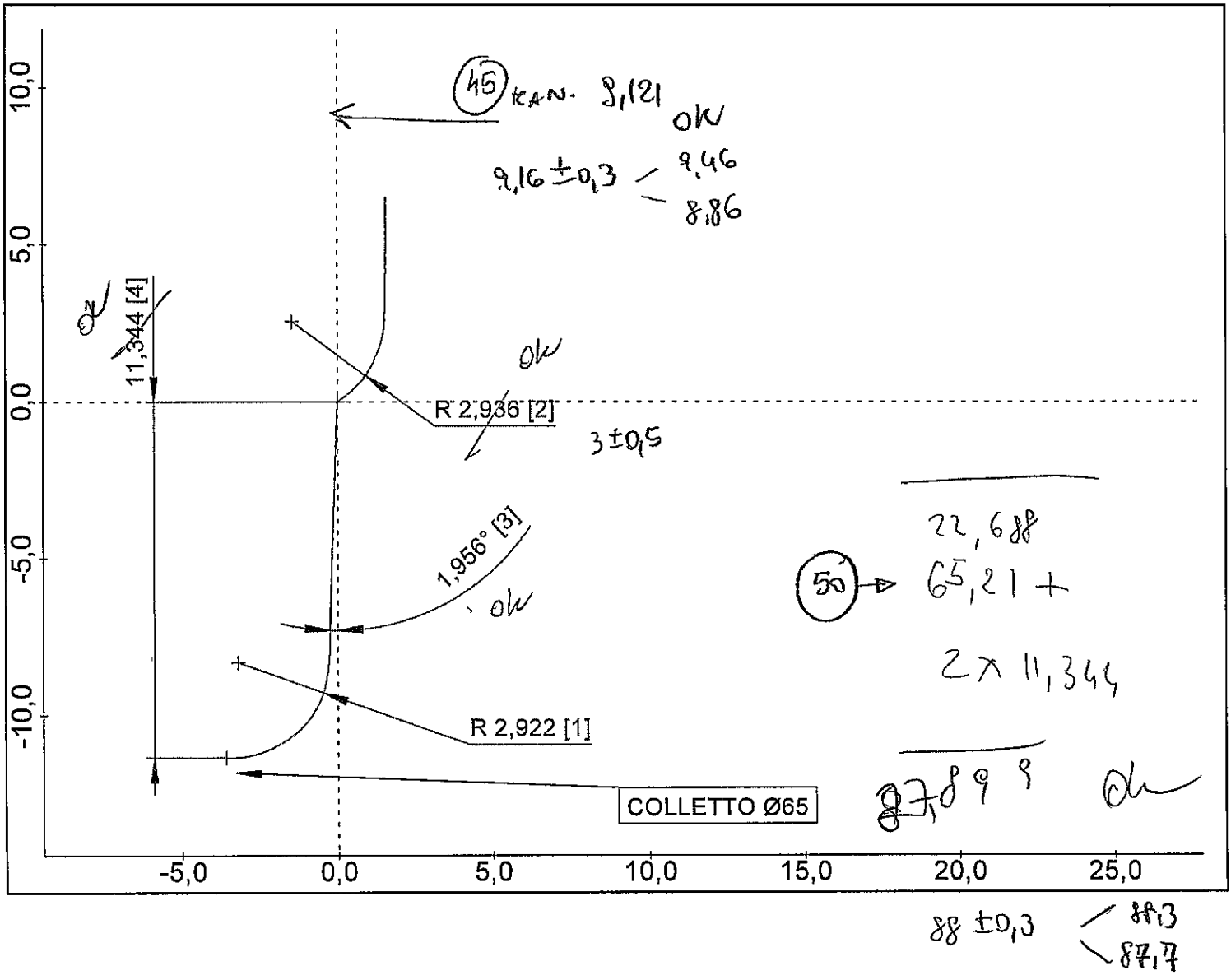

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 13:49 |
| Nota: | RAGGIO/ PART R |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 002 |



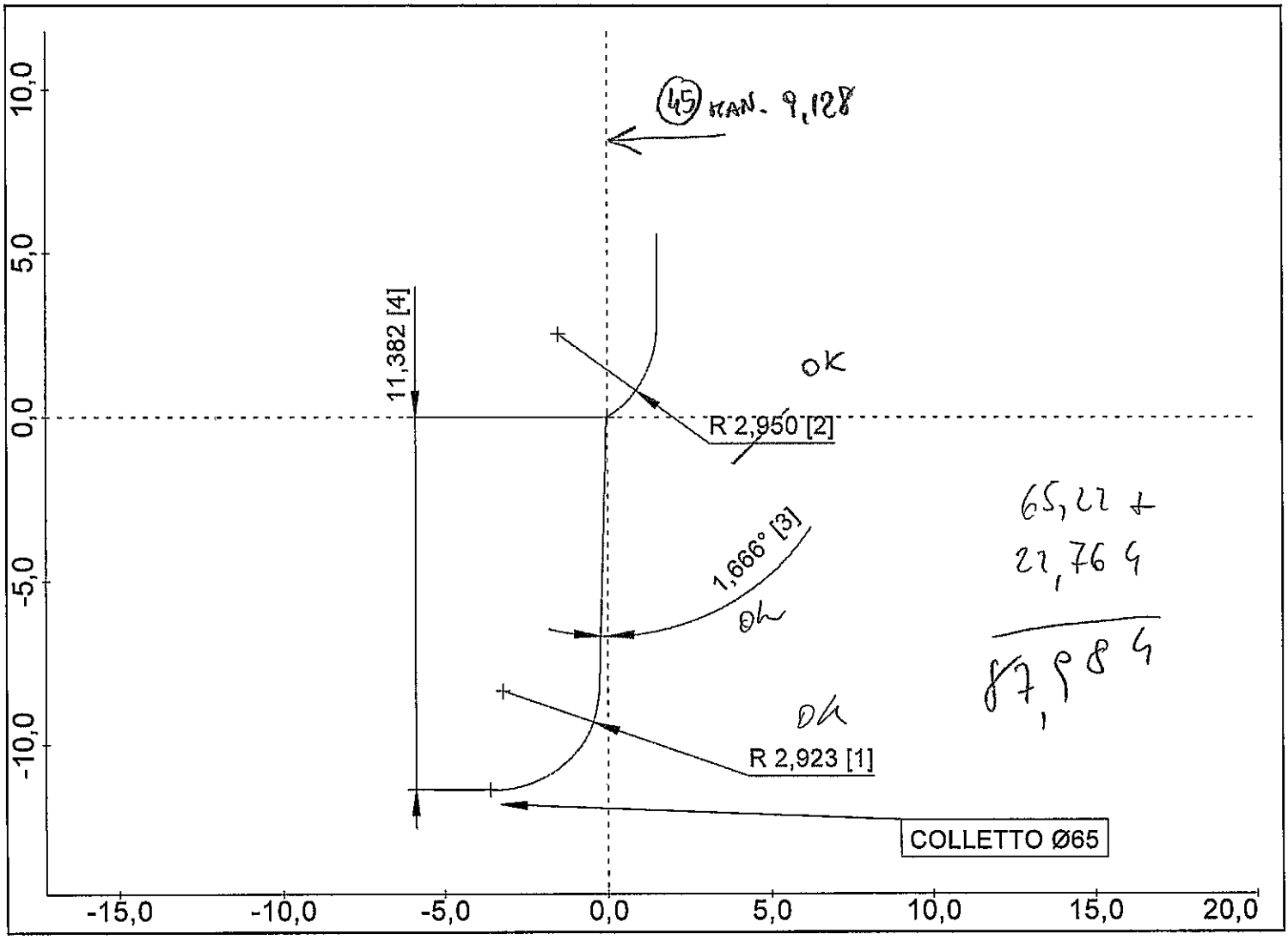

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 14:01 |
| Nota: | RAGGIO/ PART R |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 002 |



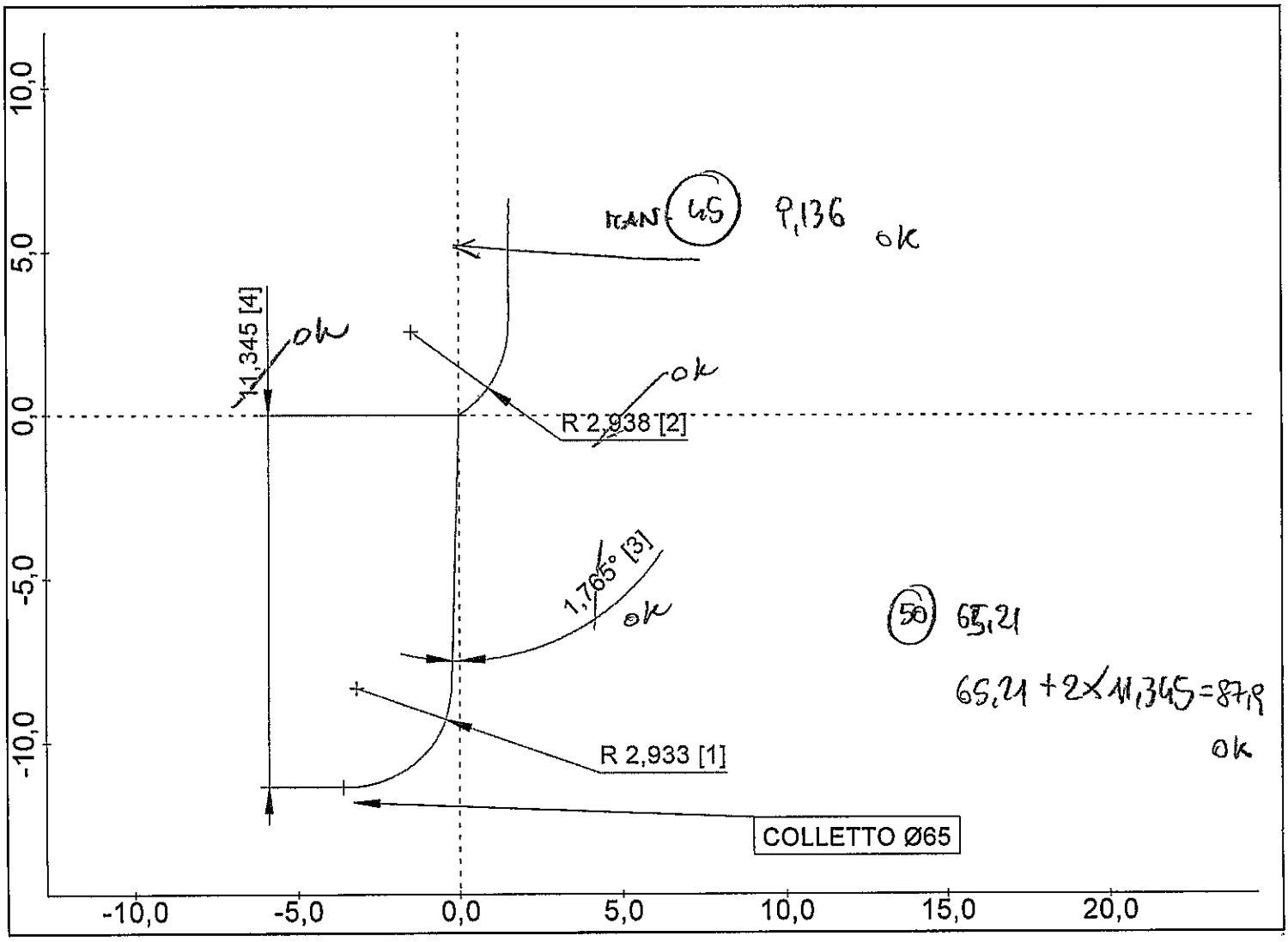

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 14:04 |
| Nota: | RAGGIO/ PART R |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 002 |



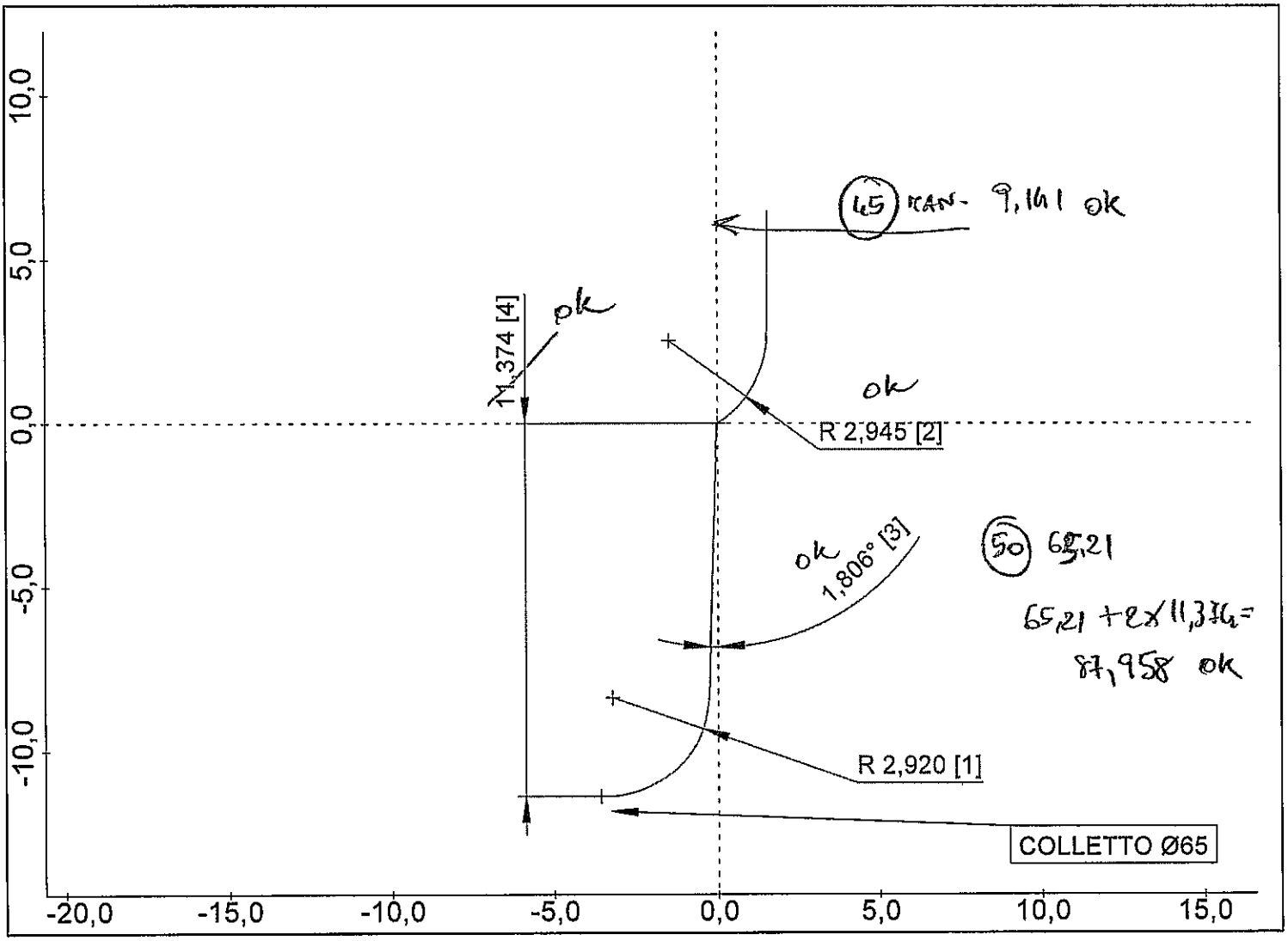

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 14:07 |
| Nota: | RAGGIO/ PART R |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 002 |



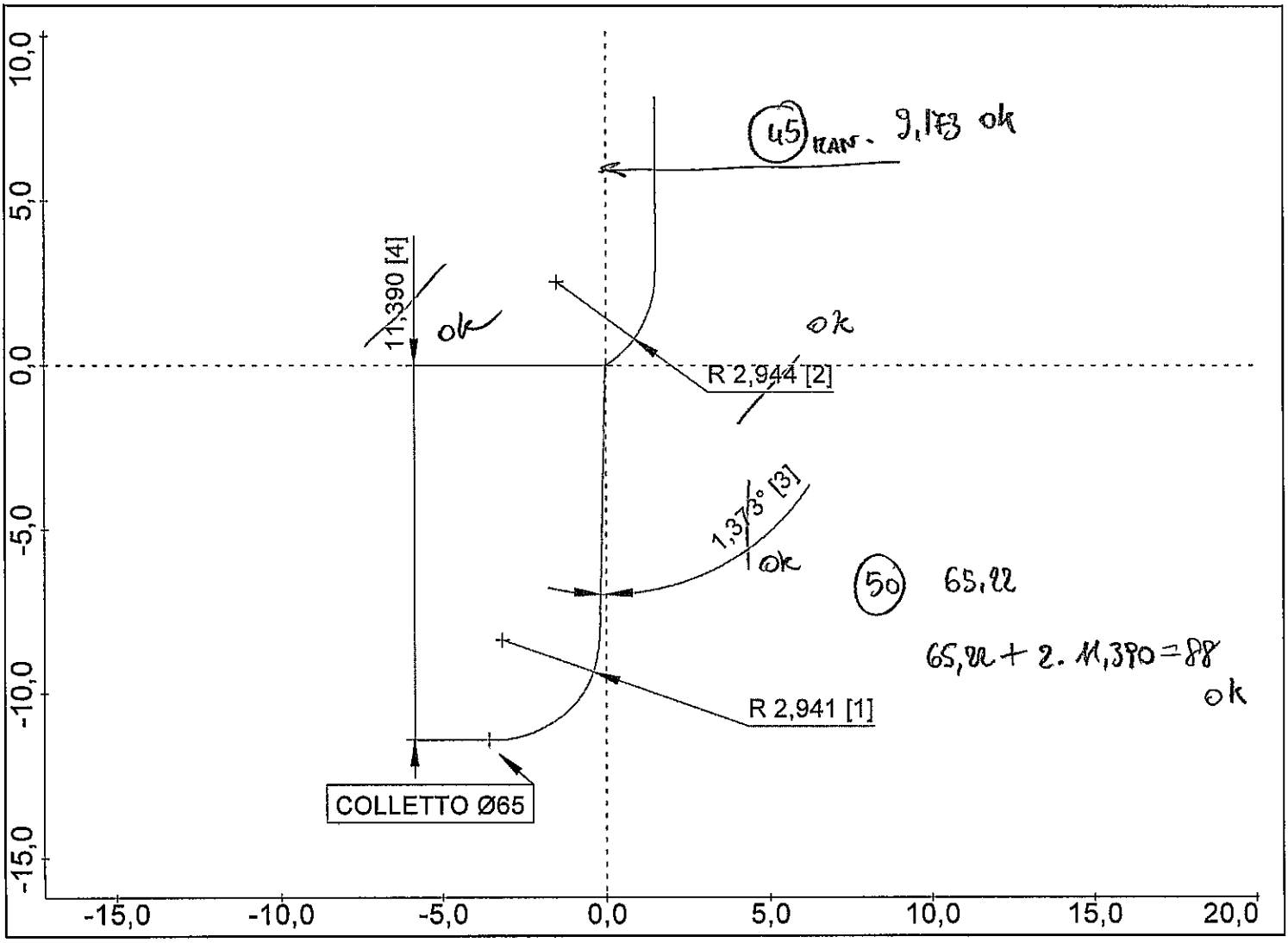

PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 14:12 |
| Nota: | RAGGIO/ PART R |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 002 |

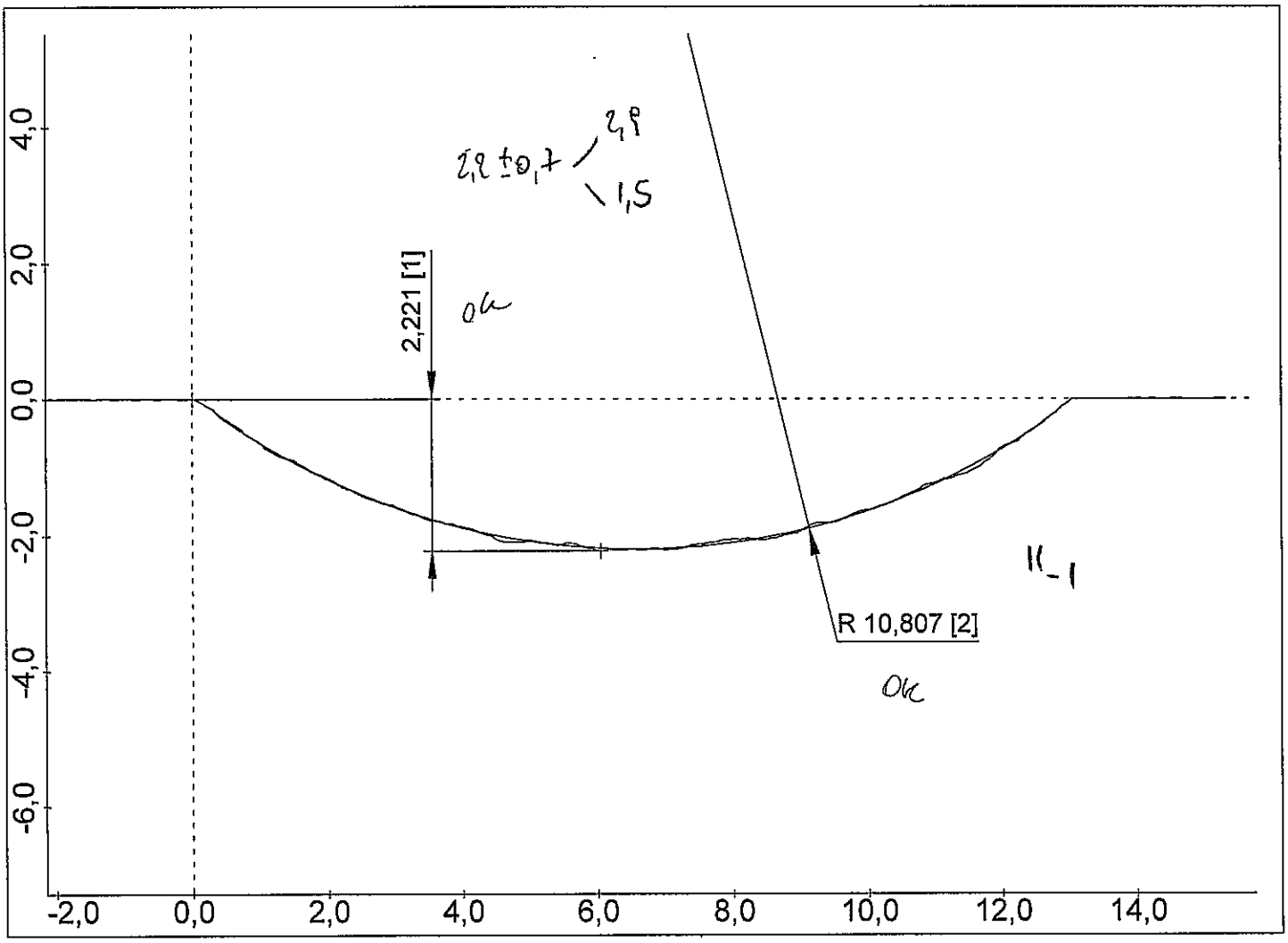



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 1 |
| Operatore: | TURNO D |
| Nota: | PART Z |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 12:53 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

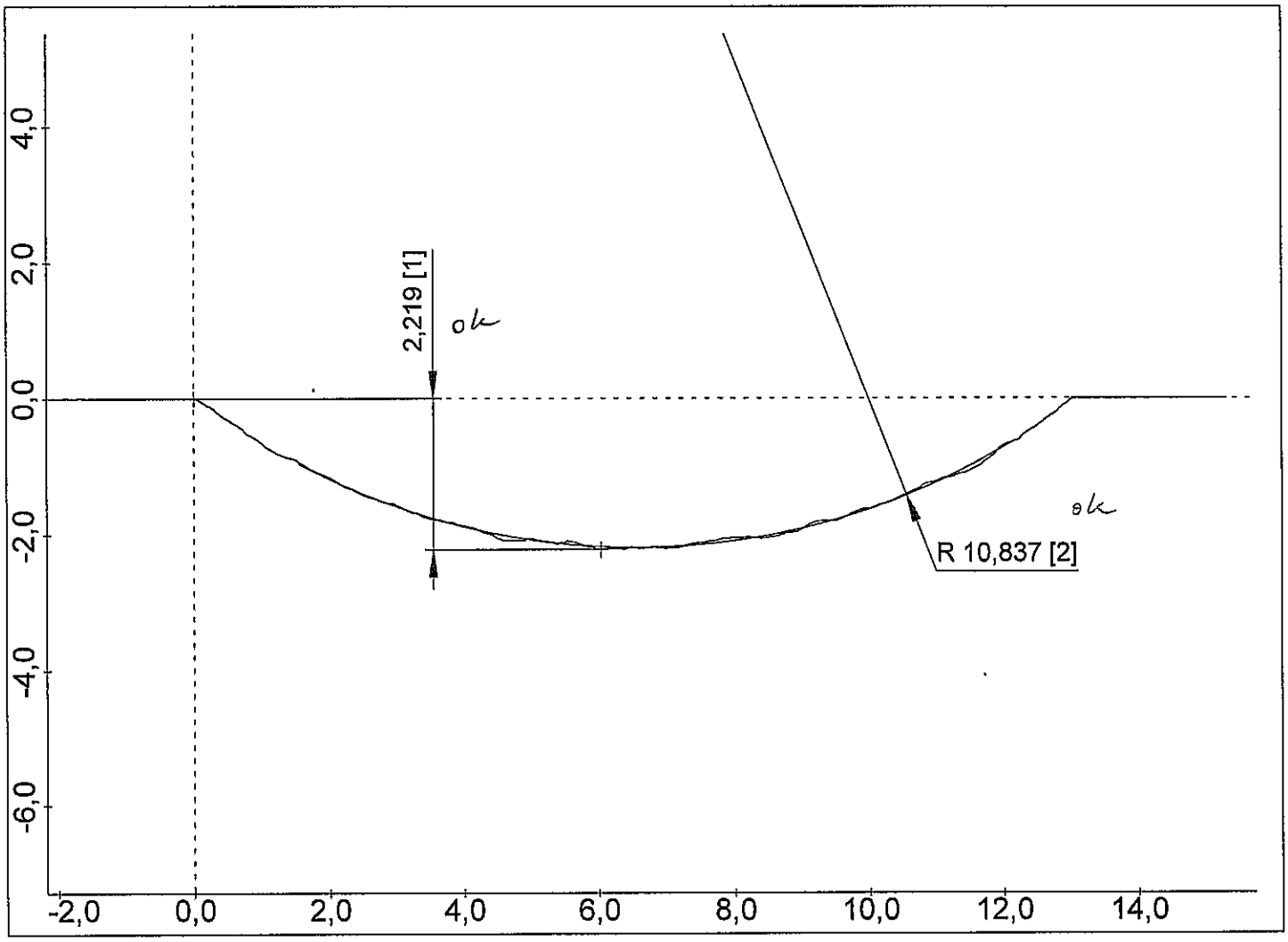

Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 2 |
| Operatore: | TURNO D |
| Nota: | PART Z |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 12:55 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

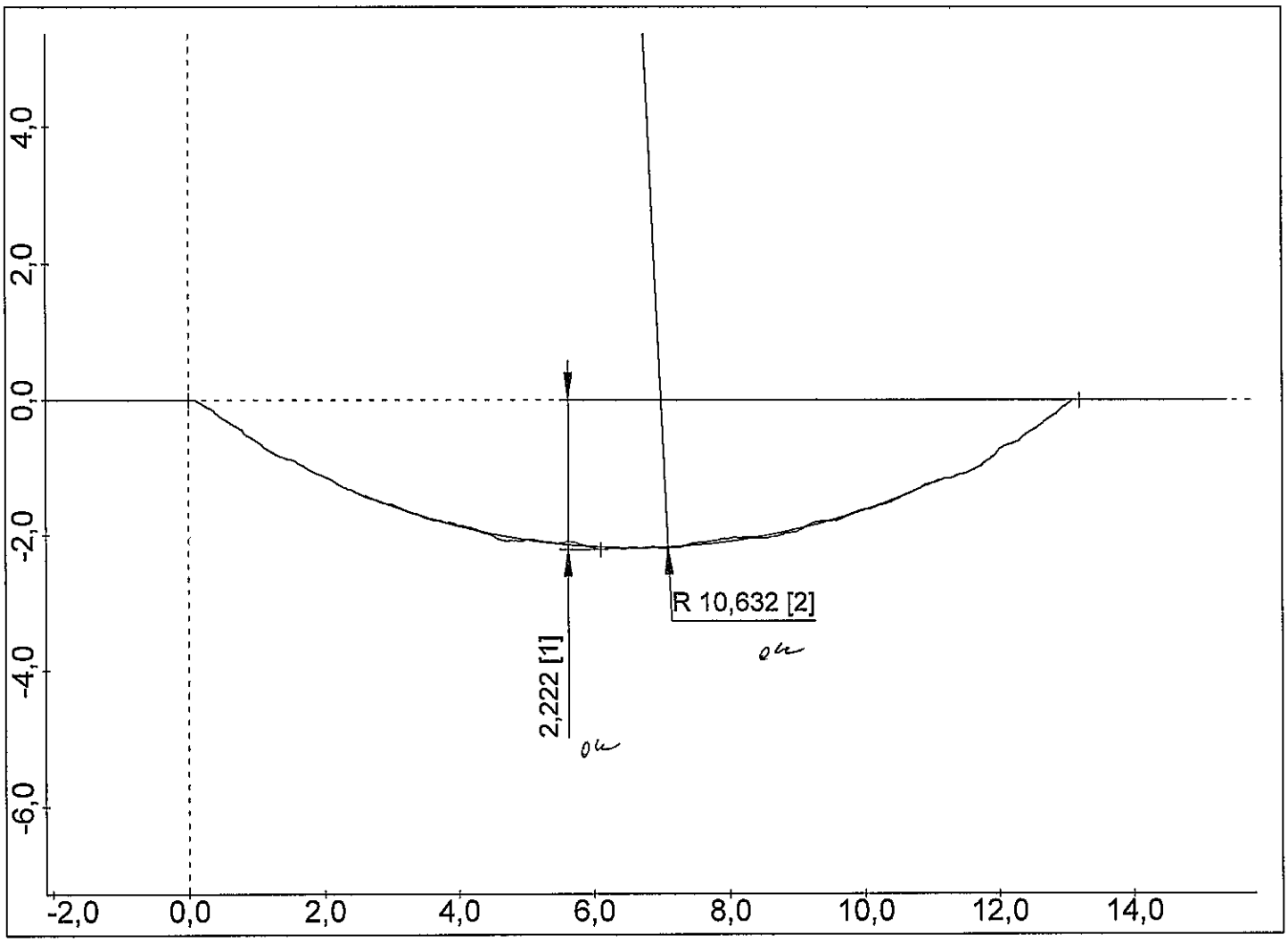
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 3 |
| Operatore: | TURNO D |
| Nota: | PART Z |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:03 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

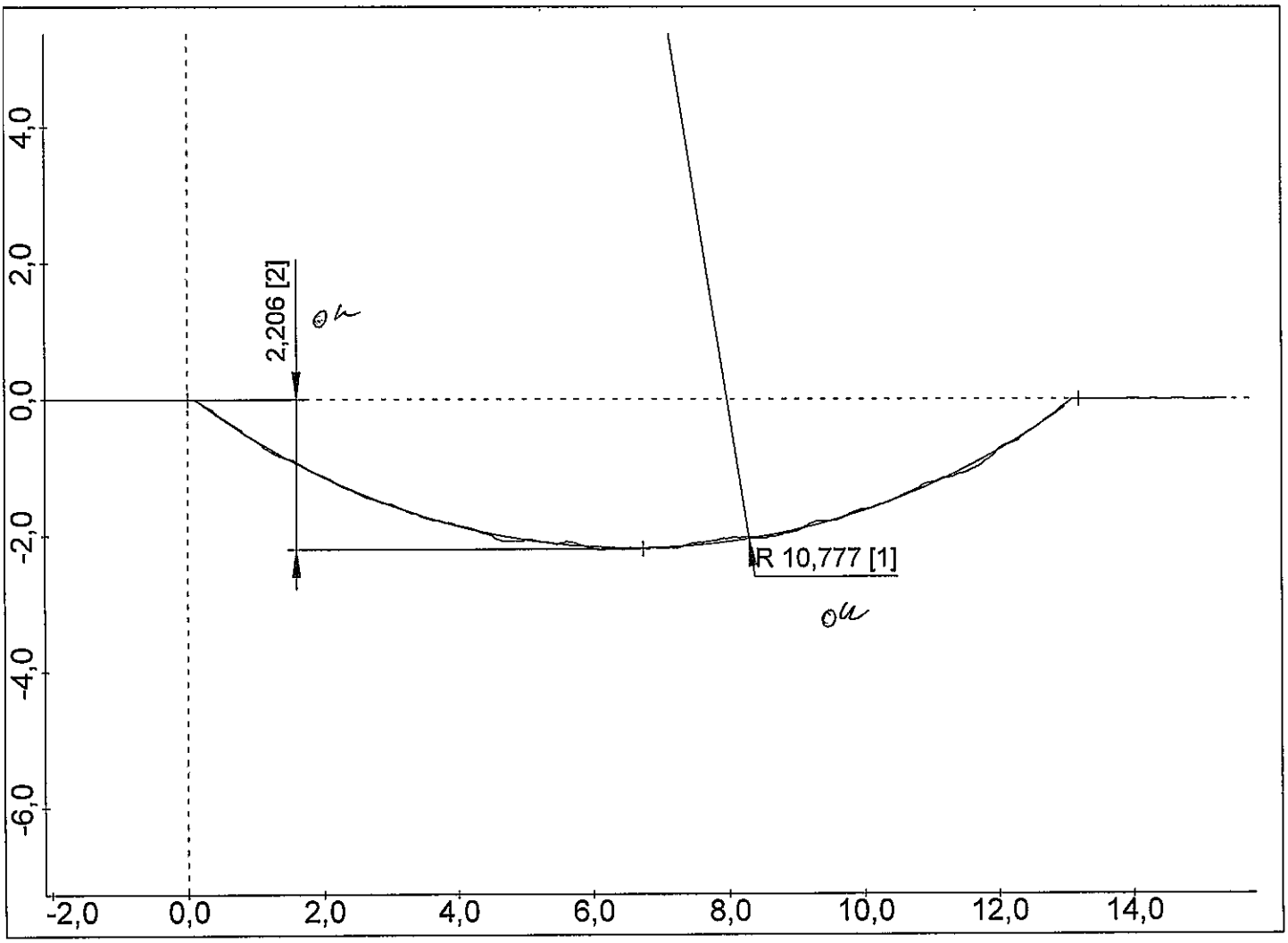

lacchina: MOA 416120 001

lacchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 4 |
| Operatore: | TURNO D |
| Nota: | PART Z |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:06 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

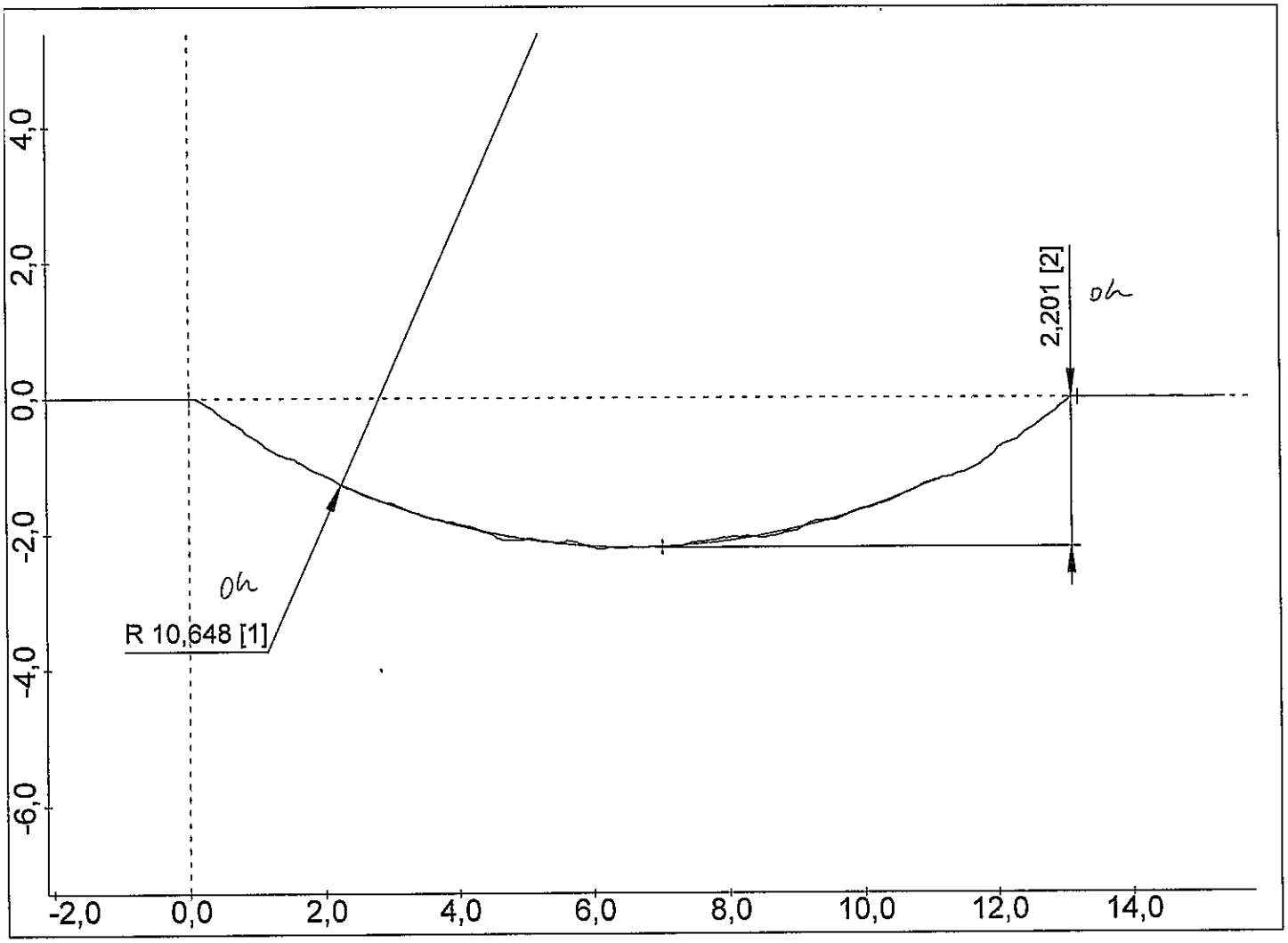
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 5 |
| Operatore: | TURNO D |
| Nota: | PART Z |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:10 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

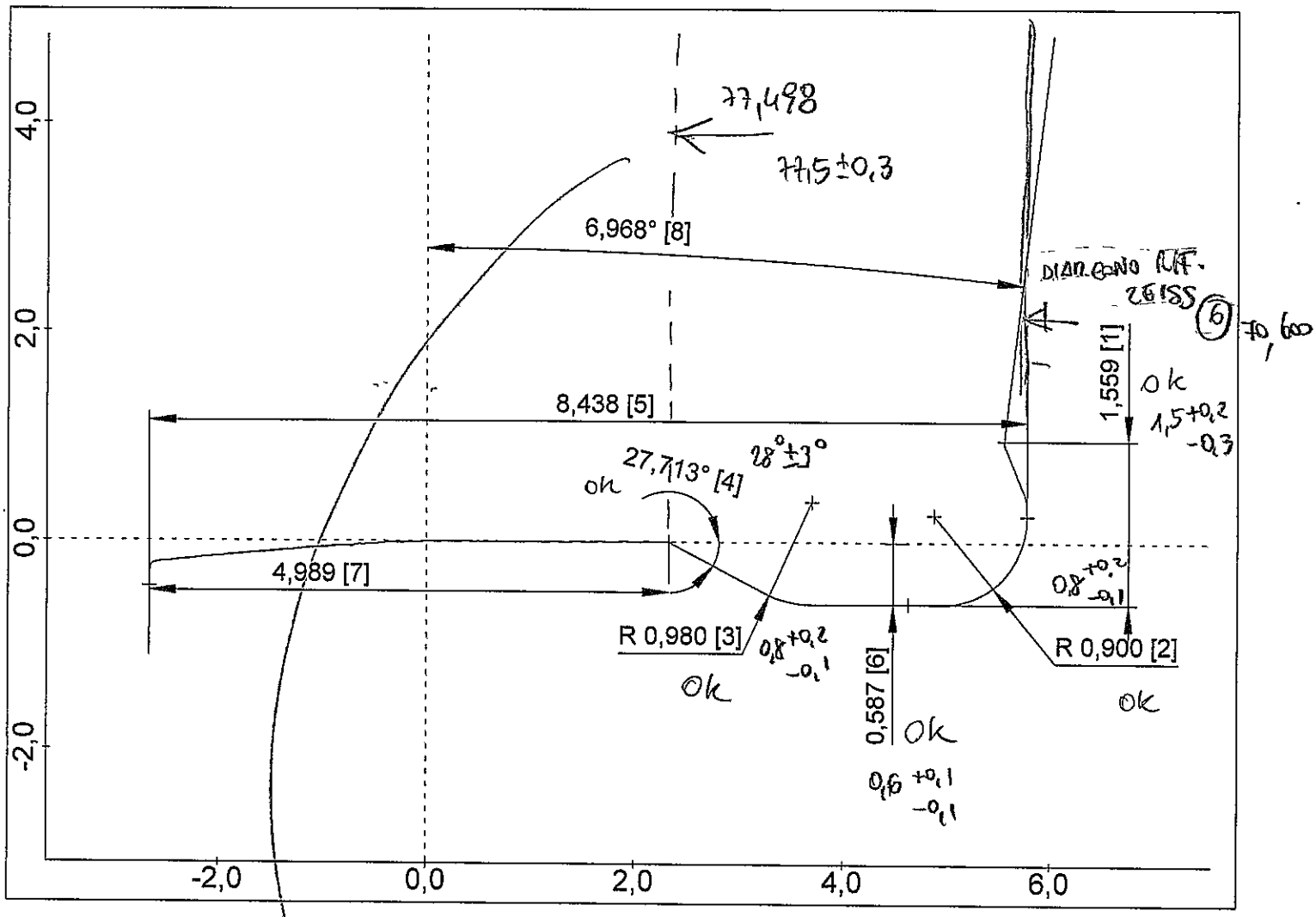
lacchina: MOA 416120 001

lacchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 09:55 |
| Nota: | PART U |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

$\pm 0,1$

RIF. ~~70,6~~

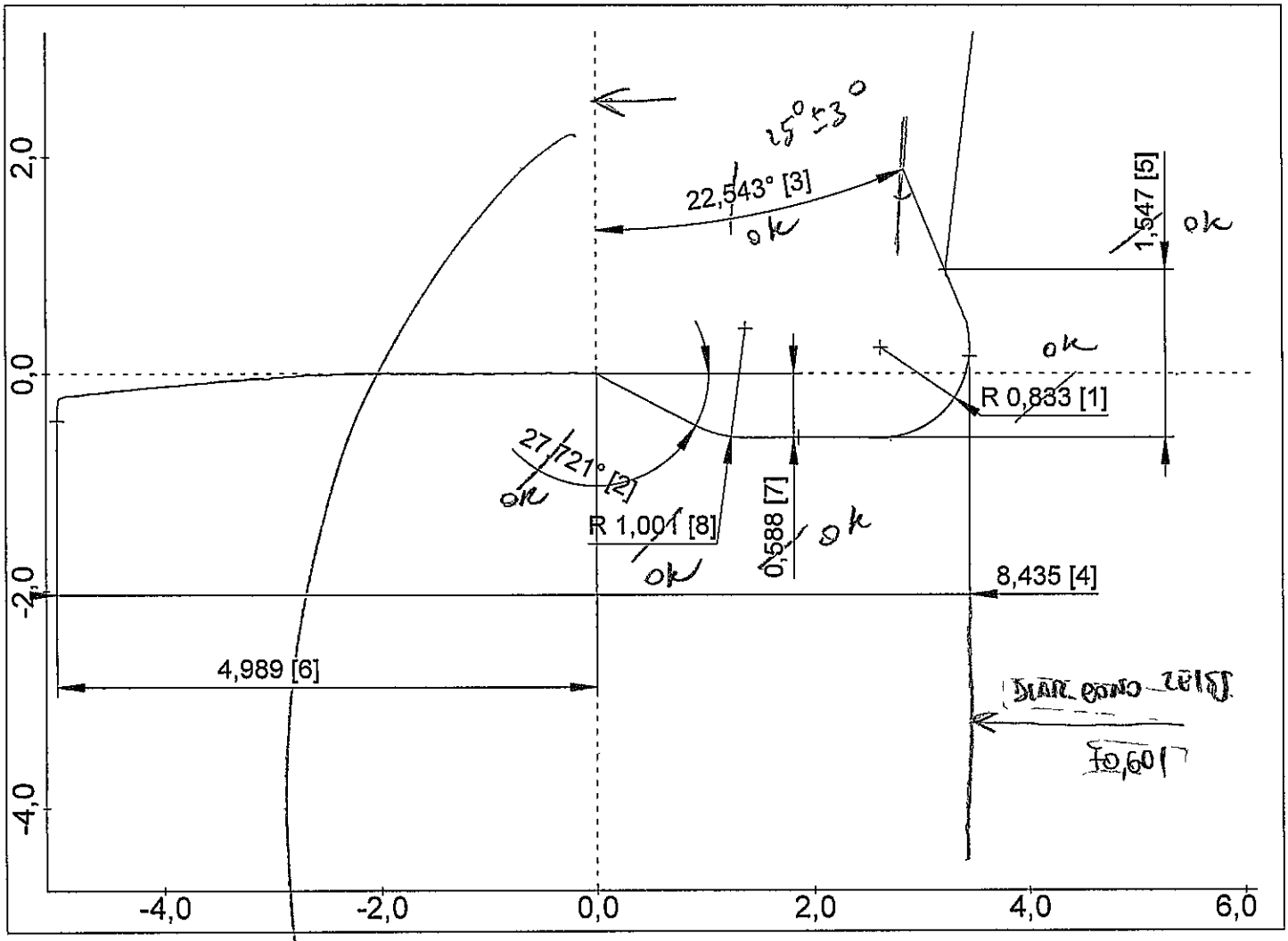
$70,600 + 2\left(8,438 - 4,989\right) = 70,6 + 6,898 = 77,498$ ok

Toll. $77,5 \pm 0,3$ < 77,8 / 77,2

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Nota: | PART U |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 09:35 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

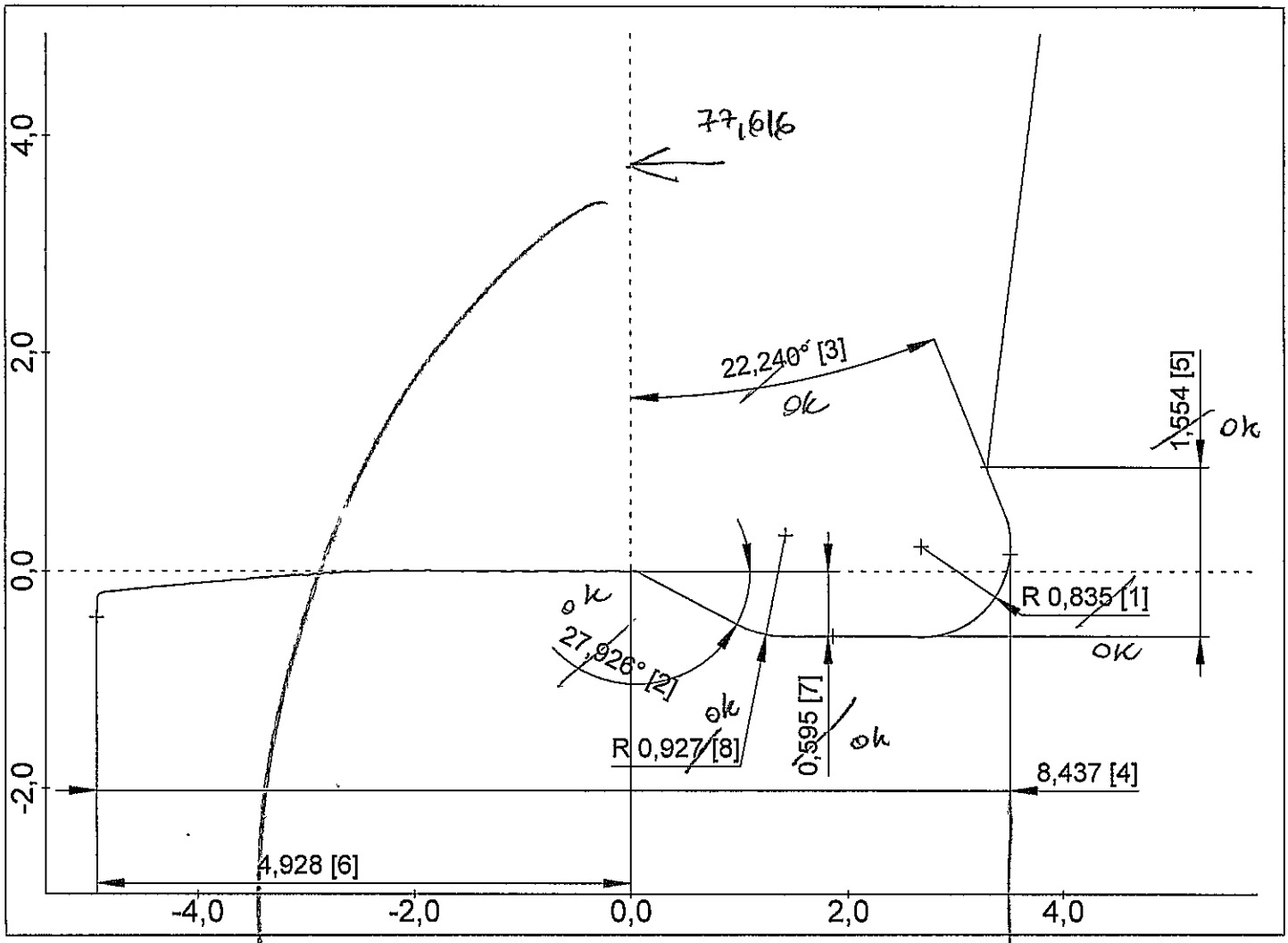
$70,601 + 2\left(8,435 - 4,989\right) = 70,601 + 2 \cdot 3,446 = 77,493$

ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Nota: | PART U |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 09:55 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

DIAM. PERNO MF. 22,85

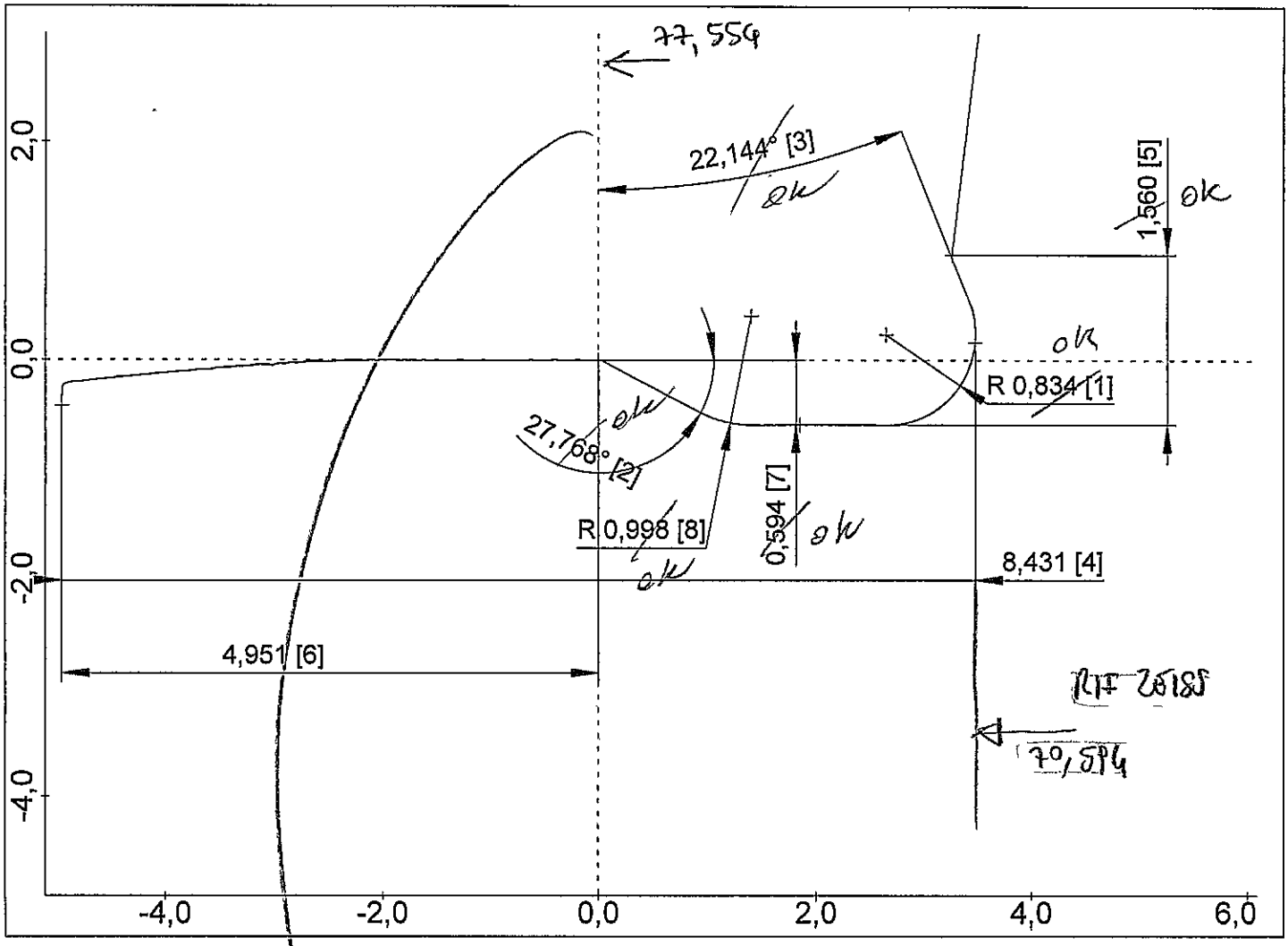
70,598

$70,598 + 2\left(8,437 - 4,928\right) = 77,616$ ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Nota: | PART U |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 10:15 |
| Macchina: | MOA 416120 001 |



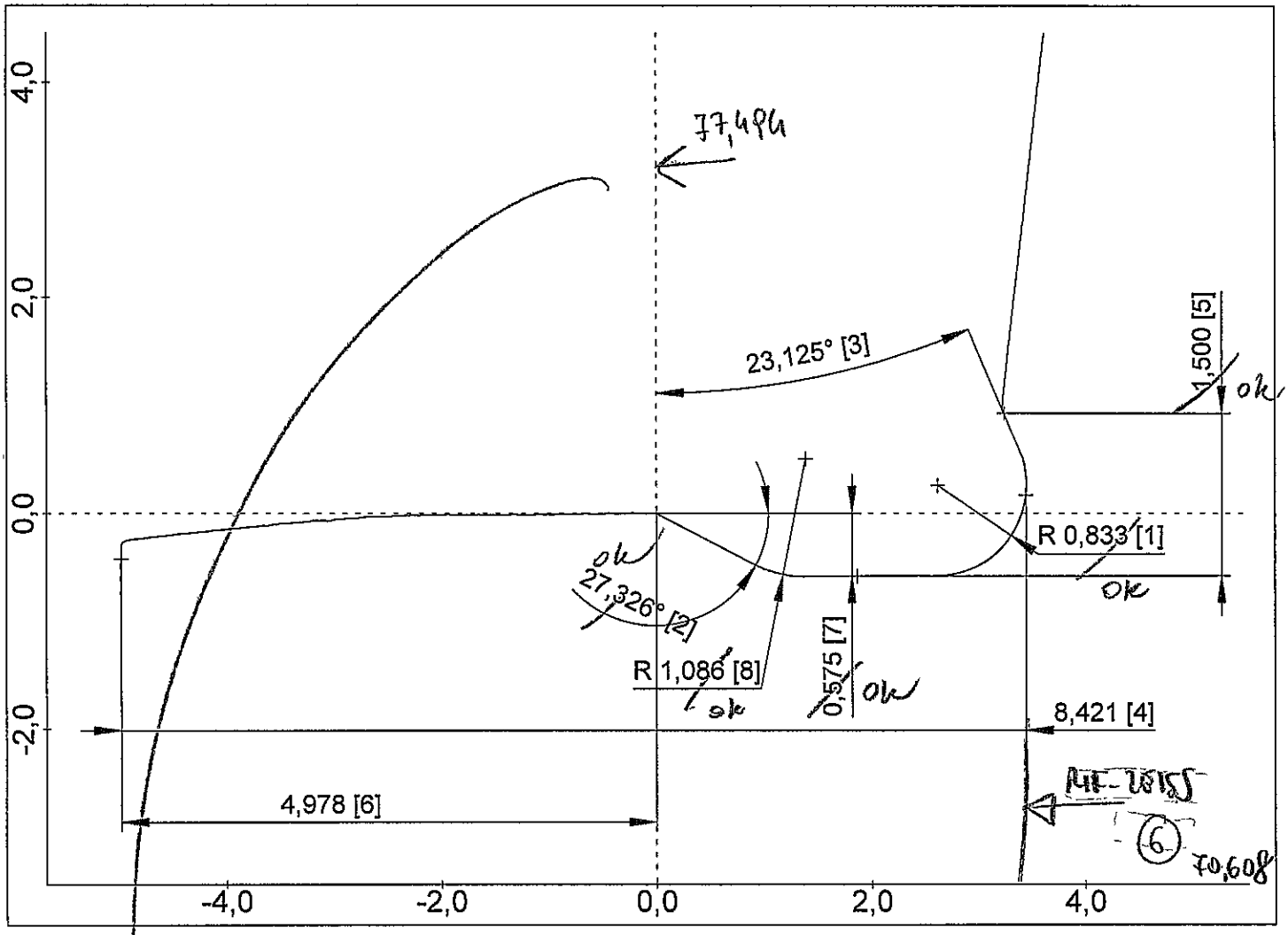

PERTHOMETER CONCEPT

$70{,}594 + 2\left(8{,}431 - 4{,}951\right) = 77{,}554$ ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Nota: | PART U |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 10:43 |
| Macchina: | MOA 416120 001 |



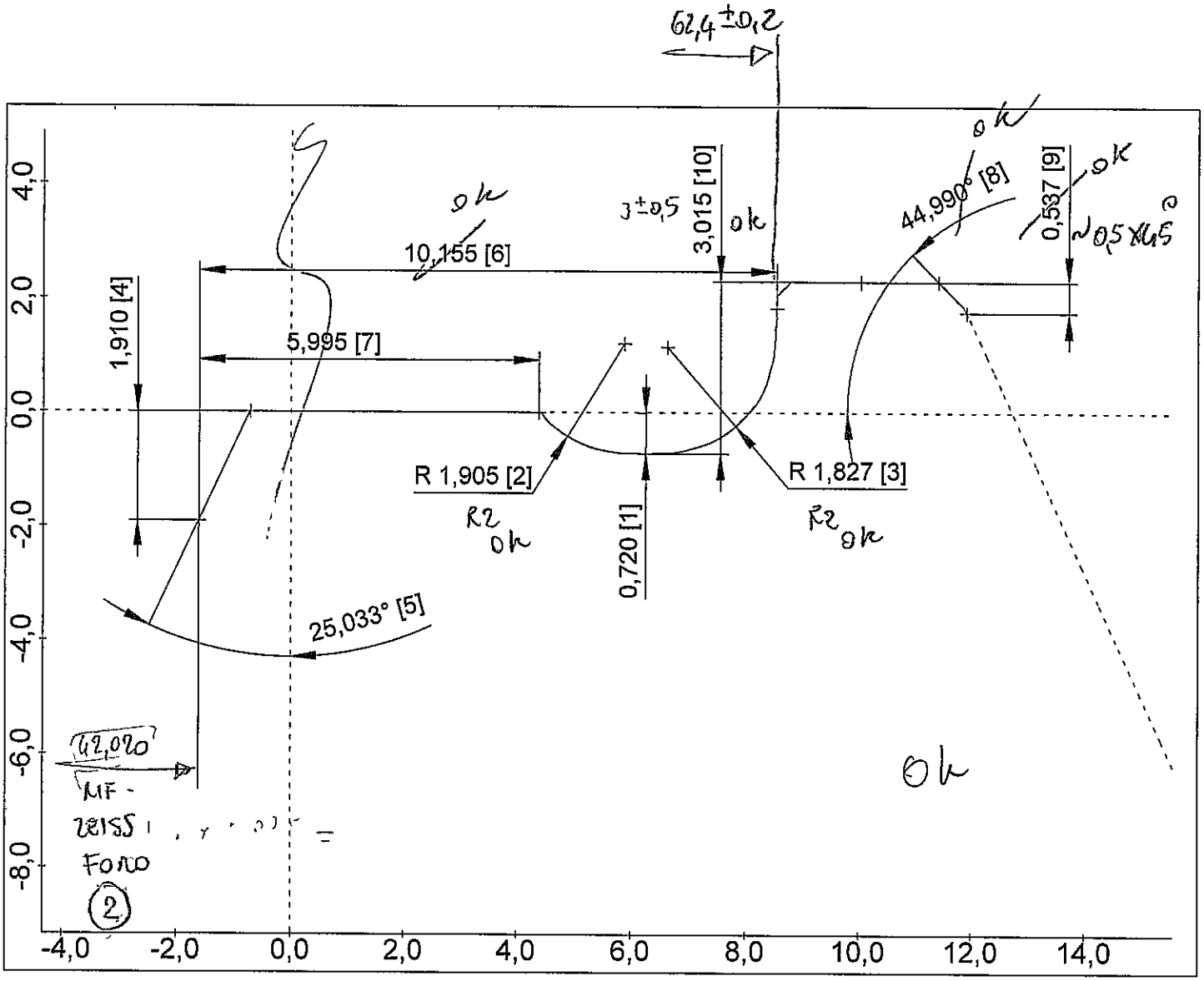

PERTHOMETER CONCEPT

$70{,}608 + 2 \cdot (8{,}421 - 4{,}978) = 77{,}494$ ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 10:18 |
| Nota: | PART X/1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |



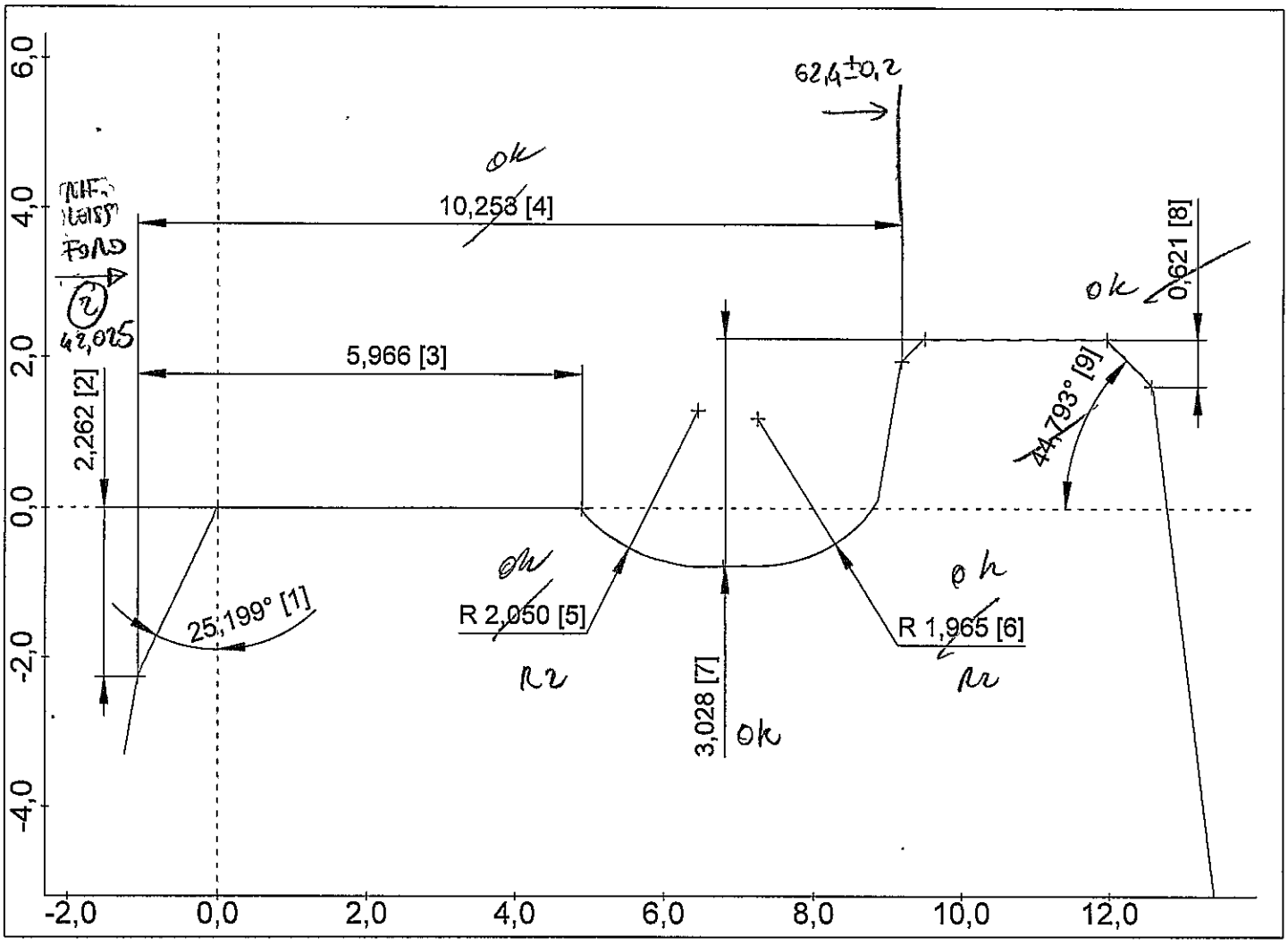

PERTHOMETER CONCEPT

62,4 ±0,2 : 62,020 + 2 x 10,155 = 62,33 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 17:02 |
| Nota: | PART X/1 |
| Tastatore: | PCV 350 / 21 mm |
| Macchina: | MOA 416120 001 |



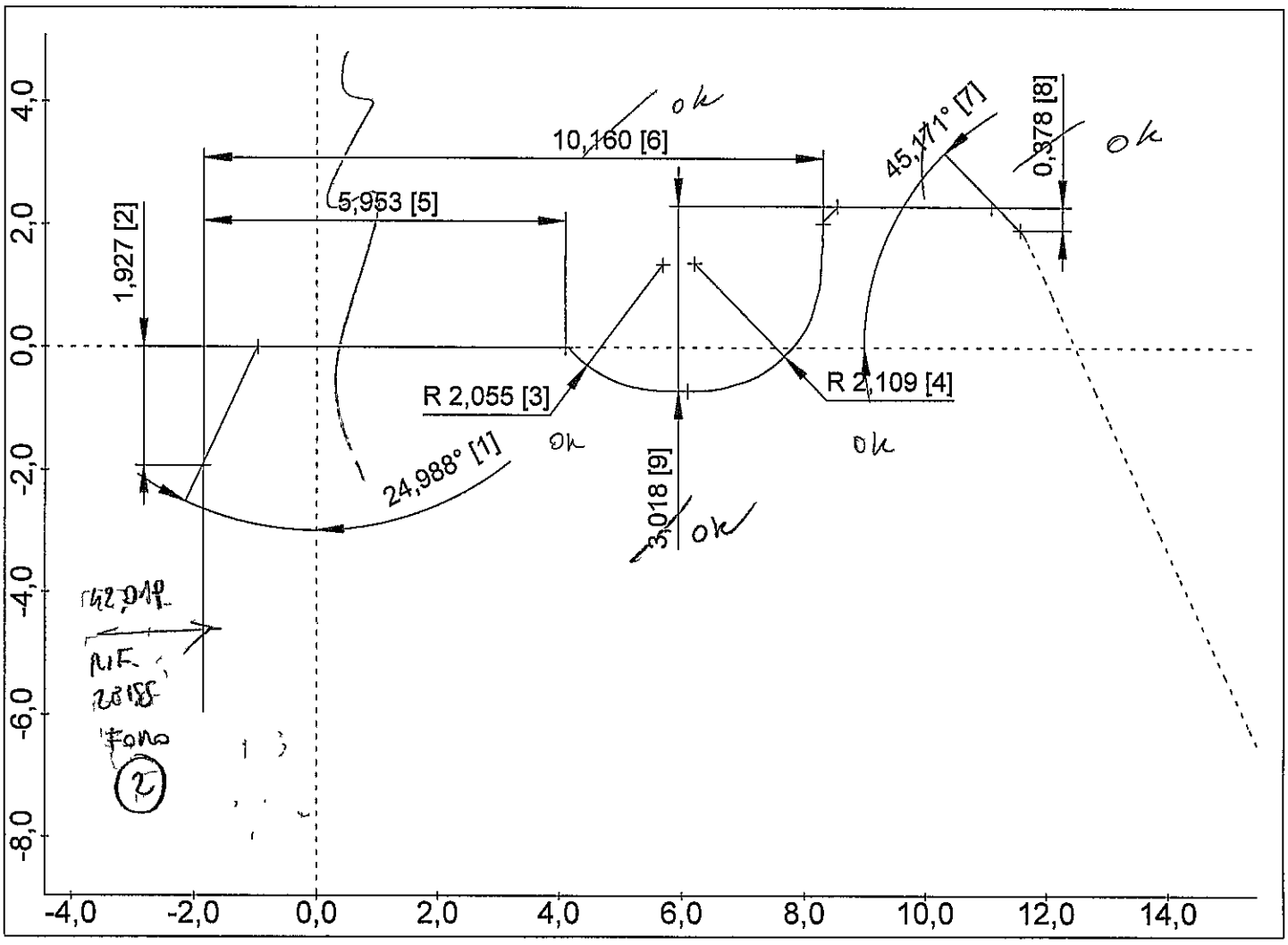

PERTHOMETER CONCEPT

62,6 ±0,2 : 42,025 + 2 × 10,253 = 62,531 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 10:26 |
| Nota: | PART X/1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |



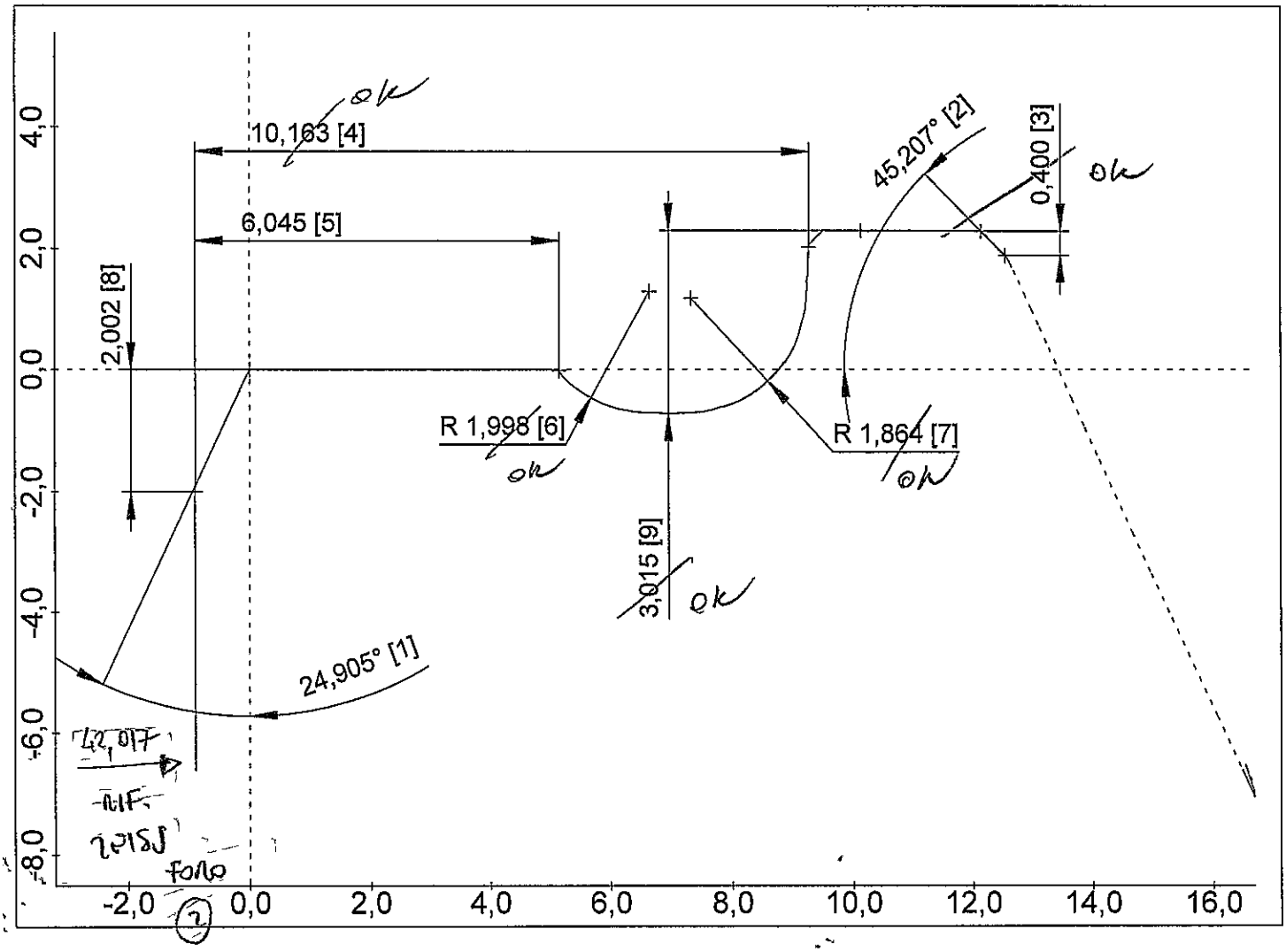

PERTHOMETER CONCEPT

62,4±0,2 : 42,019 + 2x 10,160 = 62,339 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Nota: | PART X/1 |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 10:53 |
| Macchina: | MOA 416120 001 |



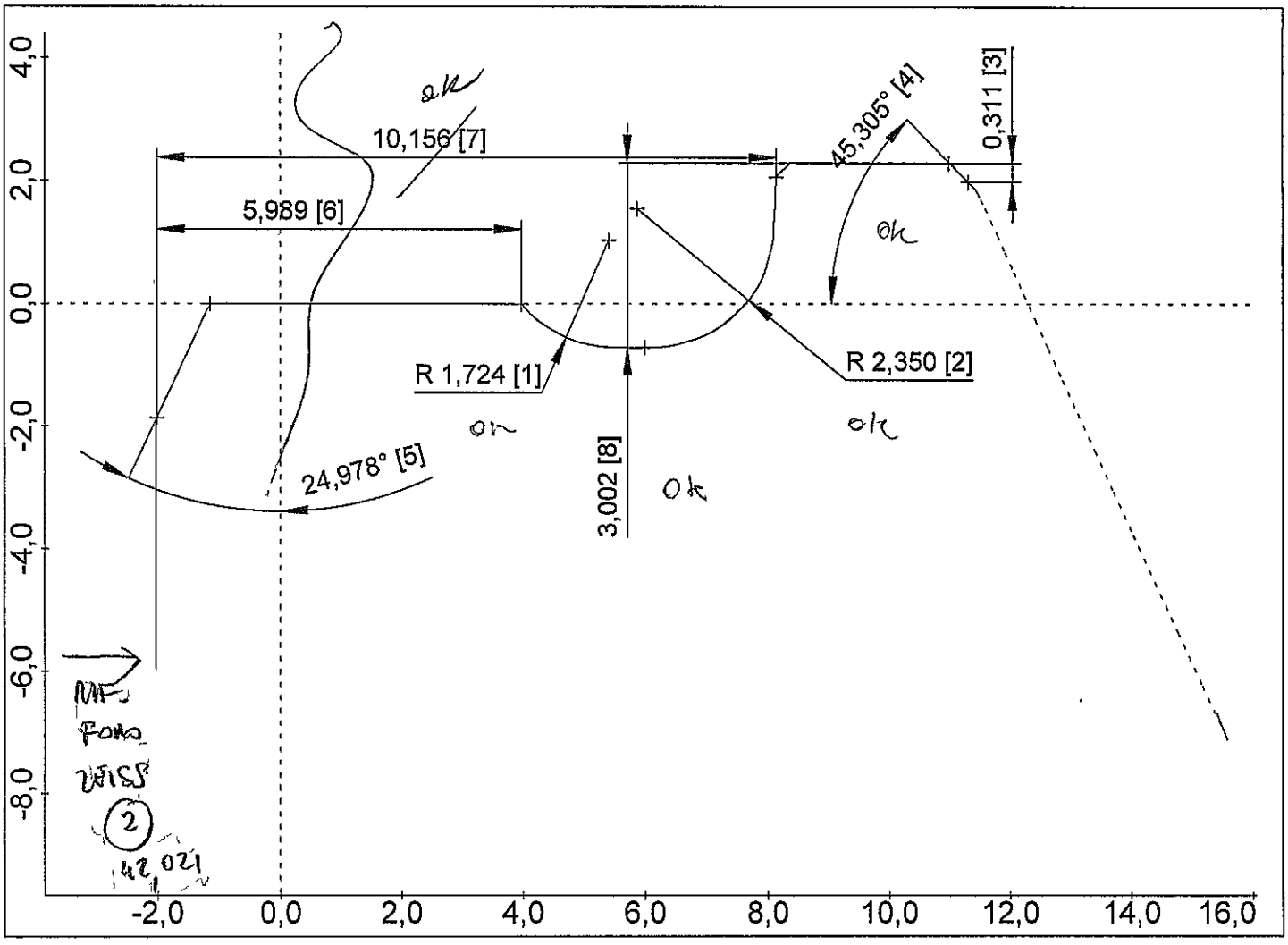

PERTHOMETER CONCEPT

62,4±0,2 : 42,017 + 2 x 10,163 = 62,343 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 45 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 10:26 |
| Nota: | PART X/1 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

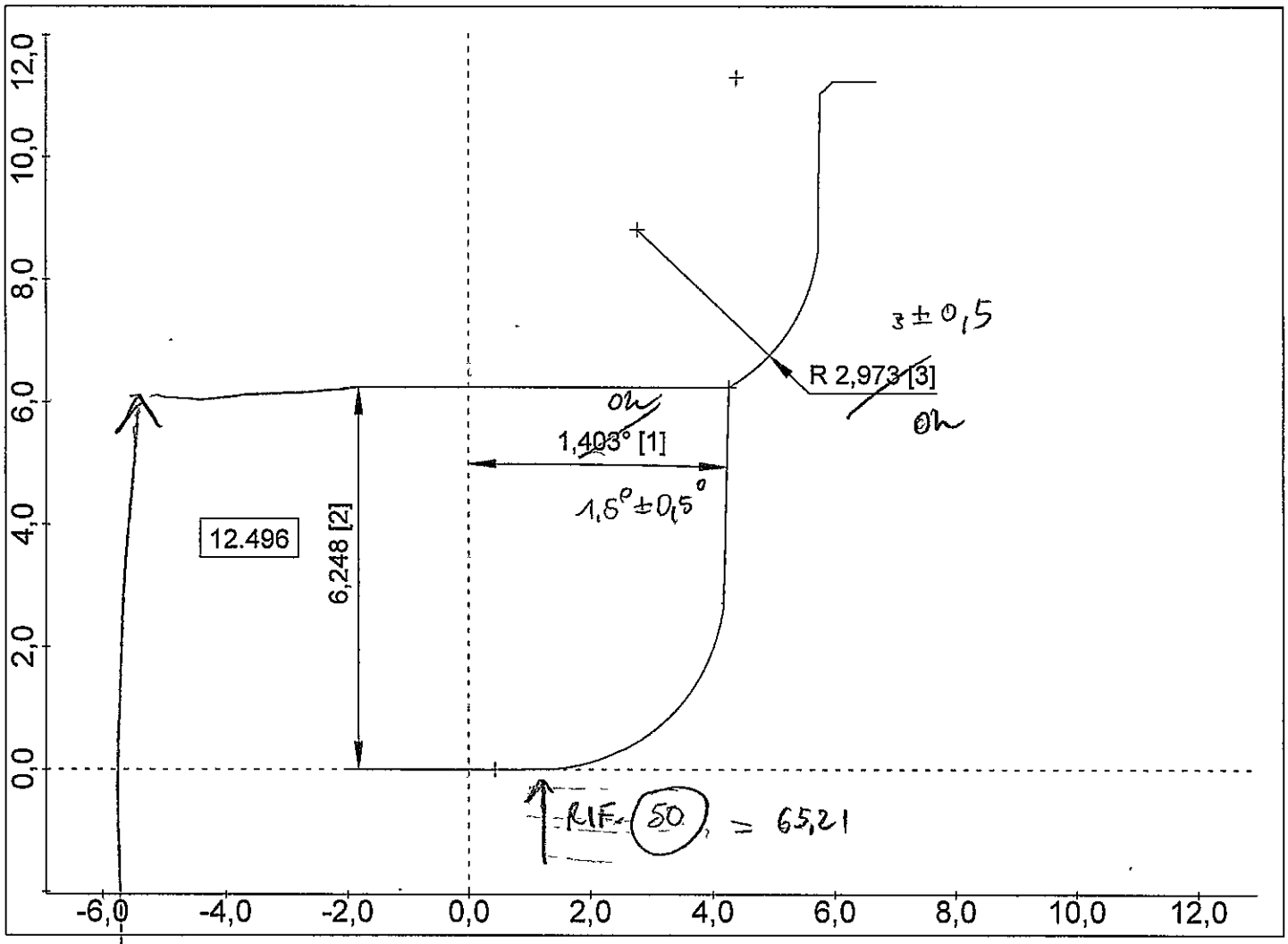
62,4 ±0,2 : 42,021 + 2x 10,156 = 62,333 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.1 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 12:49 |
| Nota: | X |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

X RIGHT




PERTHOMETER CONCEPT

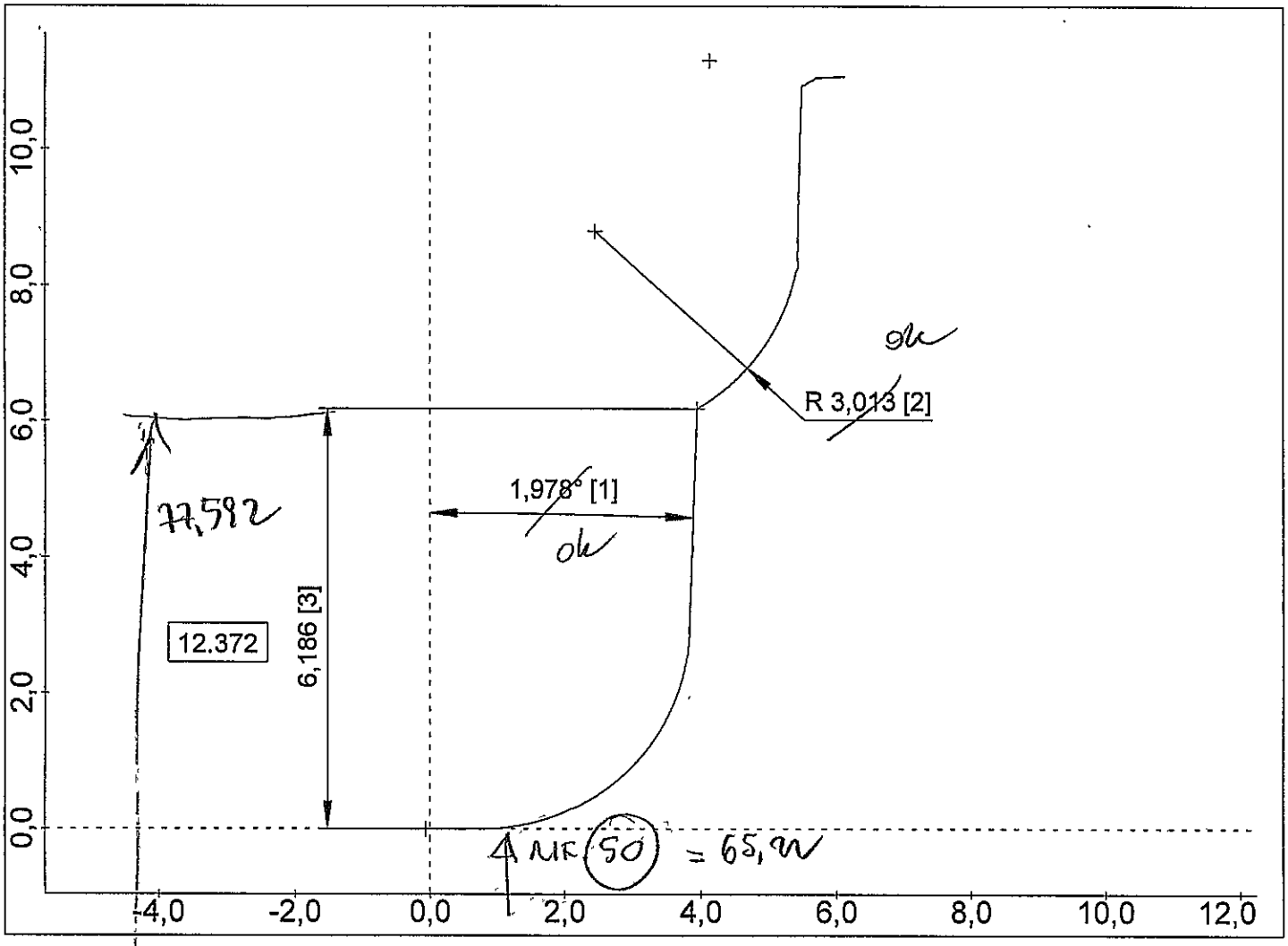
77,5±0,3: 65,21 + 2 × 6,248 = 77,706 ok

GETRAG

Via dei Ciclamini 4; Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.2 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 12:54 |
| Nota: | X |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

X RIGHT




PERTHOMETER CONCEPT

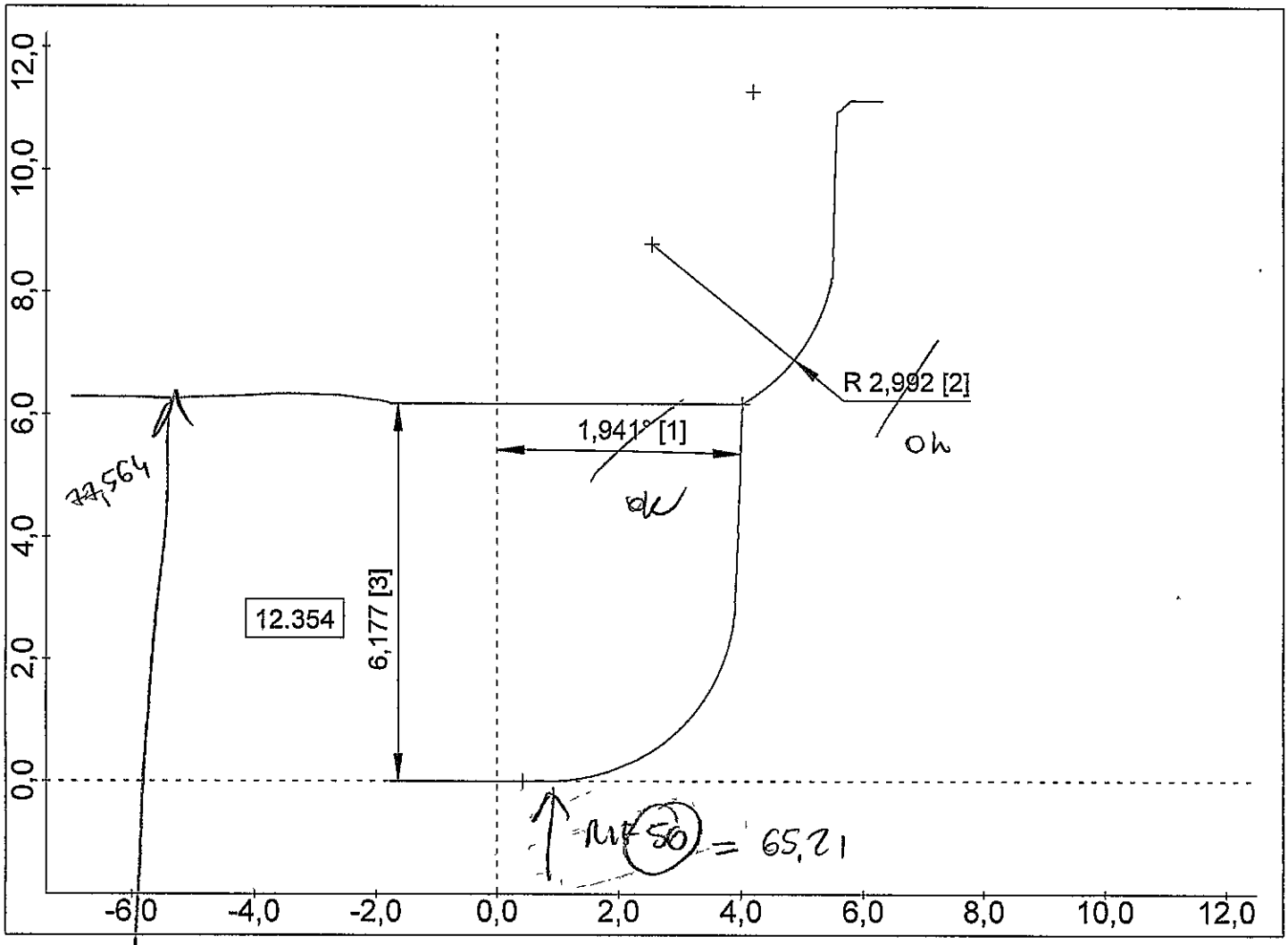
77,5 ±0,3 ; 65,92 + 2 x 6,186 = 77,592 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.3 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 12:58 |
| Nota: | X |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

X RIGHT




PERTHOMETER CONCEPT

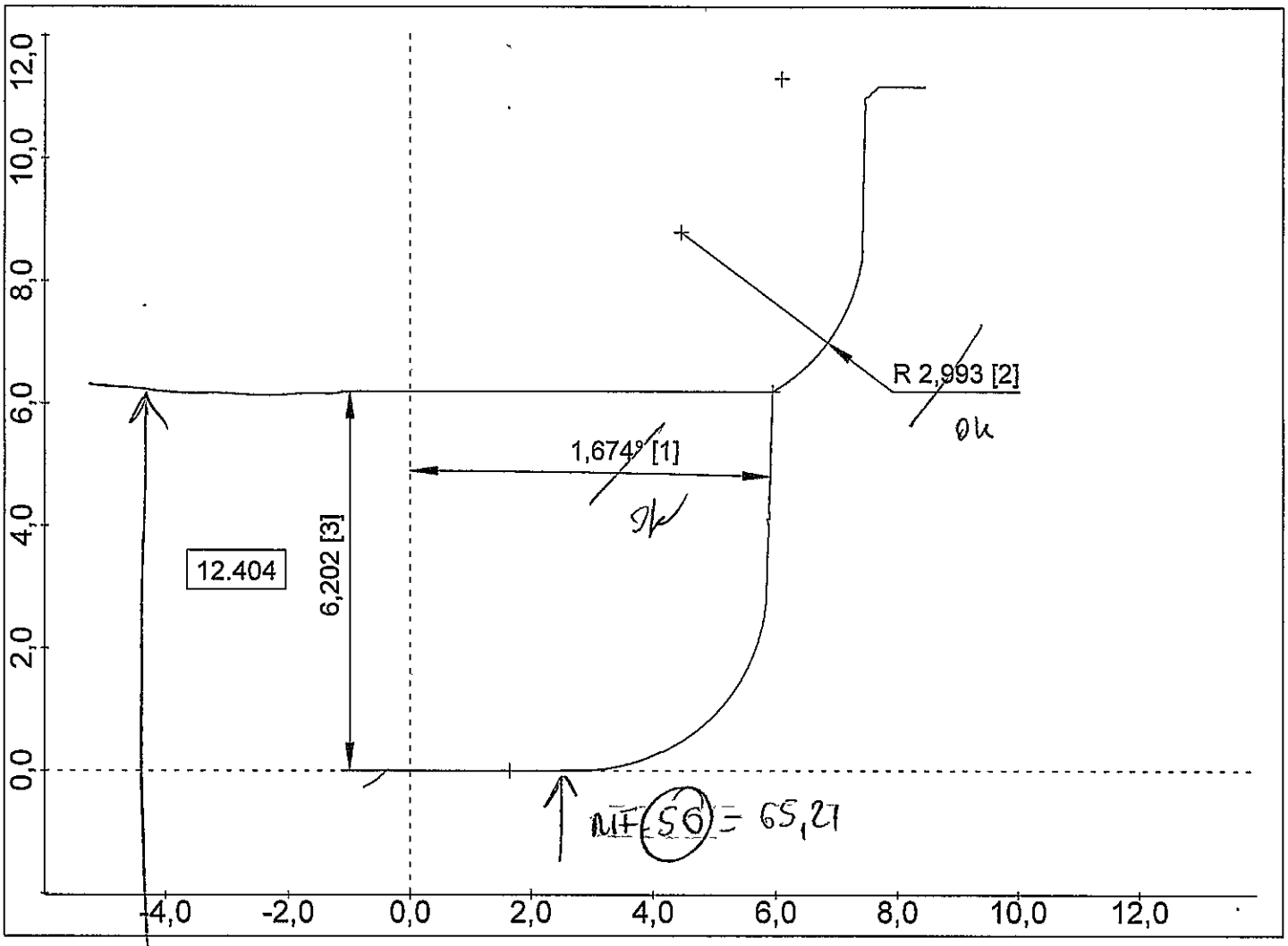
77,5 ± 0,3 : 65,21 + 2x 6,177 = 77,564 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.4 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:00 |
| Nota: | X |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

X RUOTI




PERTHOMETER CONCEPT

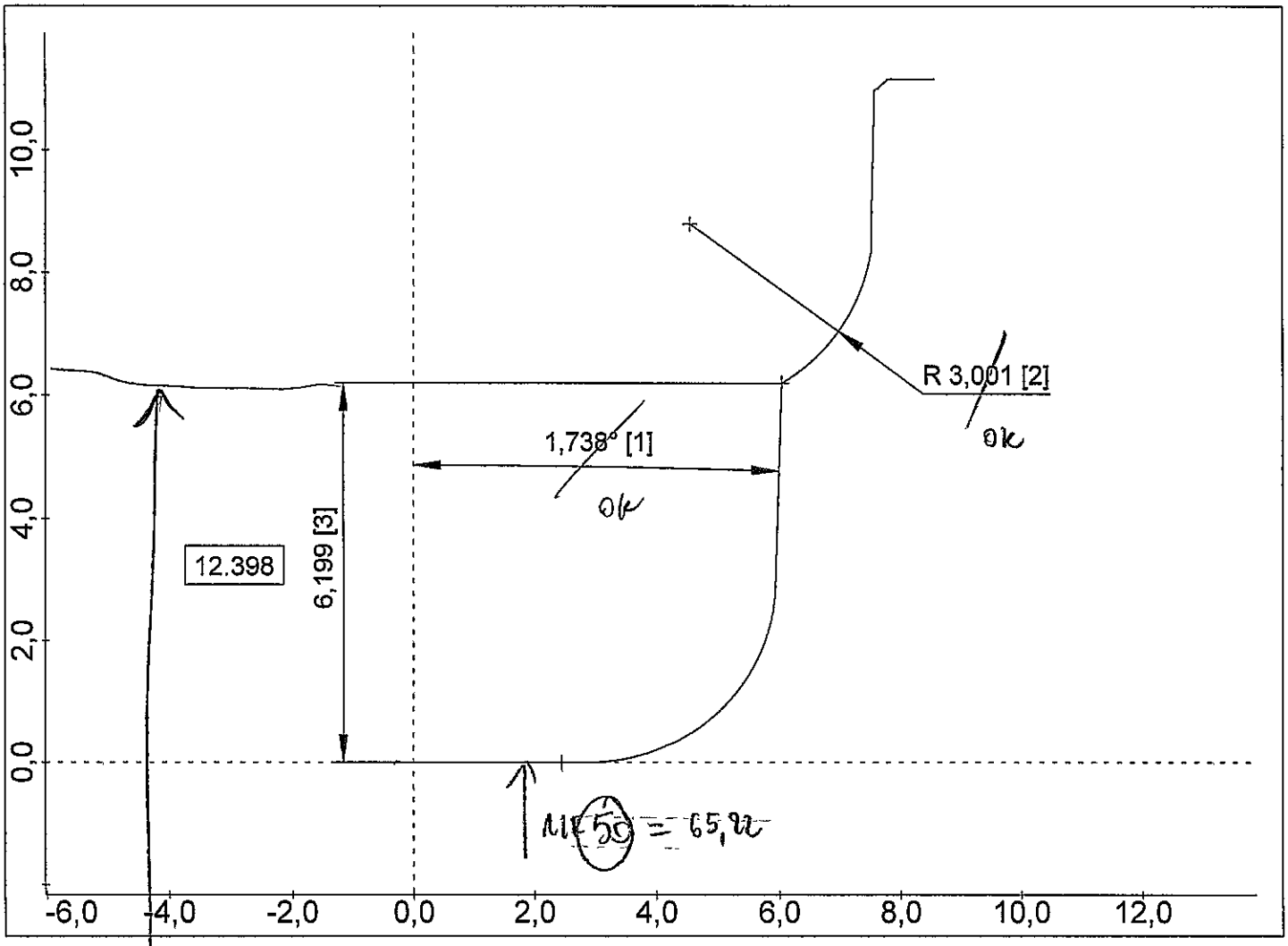
77,5 ± 0,3 : 65,21 + 2x 6,202 = 77,614 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 |
| Numero: | 5169 PPAP PZ.5 |
| Operatore: | TURNO B |
| Data, ora: | 04.06.2014, 13:01 |
| Nota: | X |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |

X M6HT



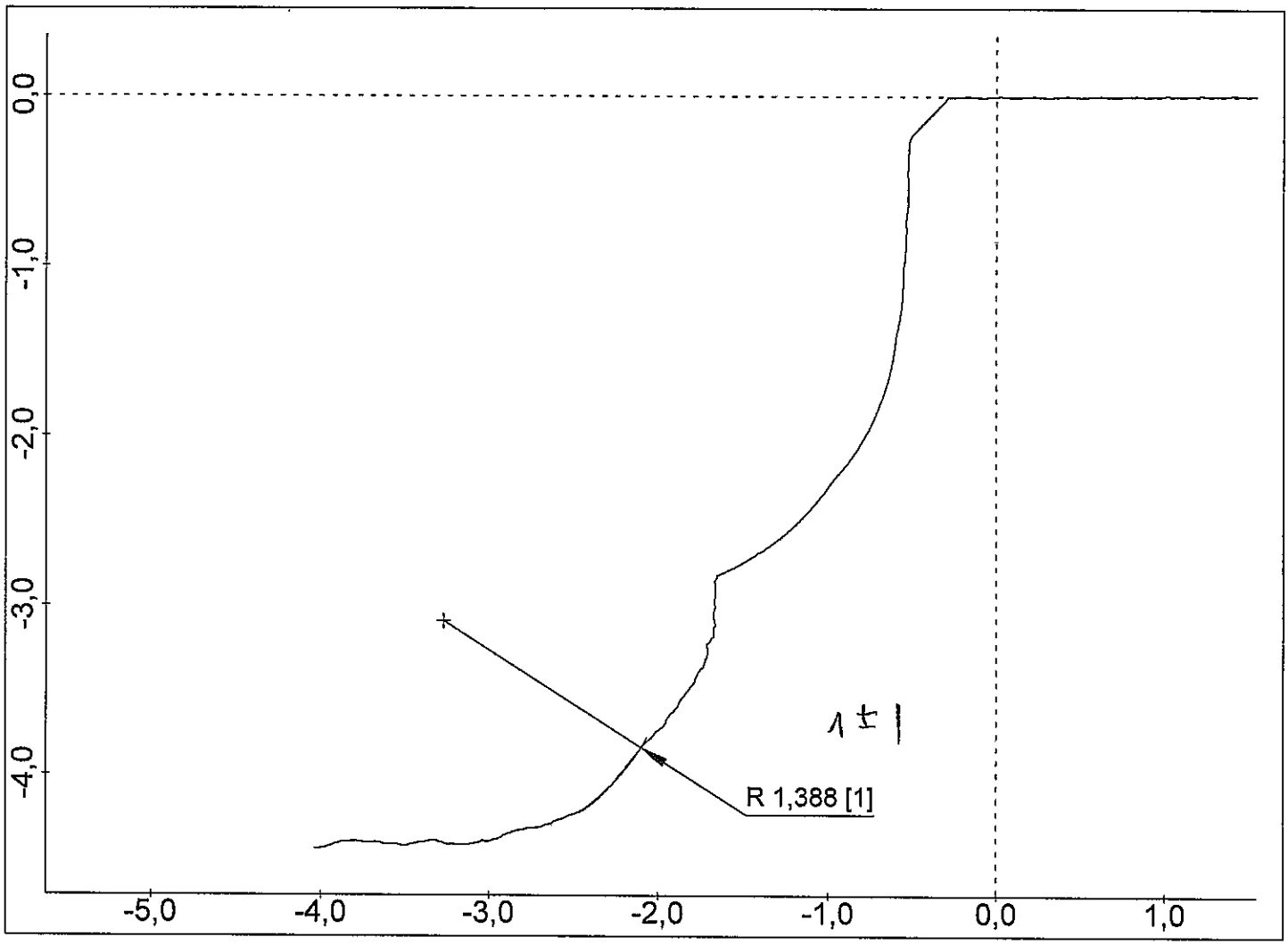

PERTHOMETER CONCEPT

77,5±0,3 : 65,22 + 2 × 6,199 = 77,618 ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 10:31 |
| Nota: | PART D-D |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |



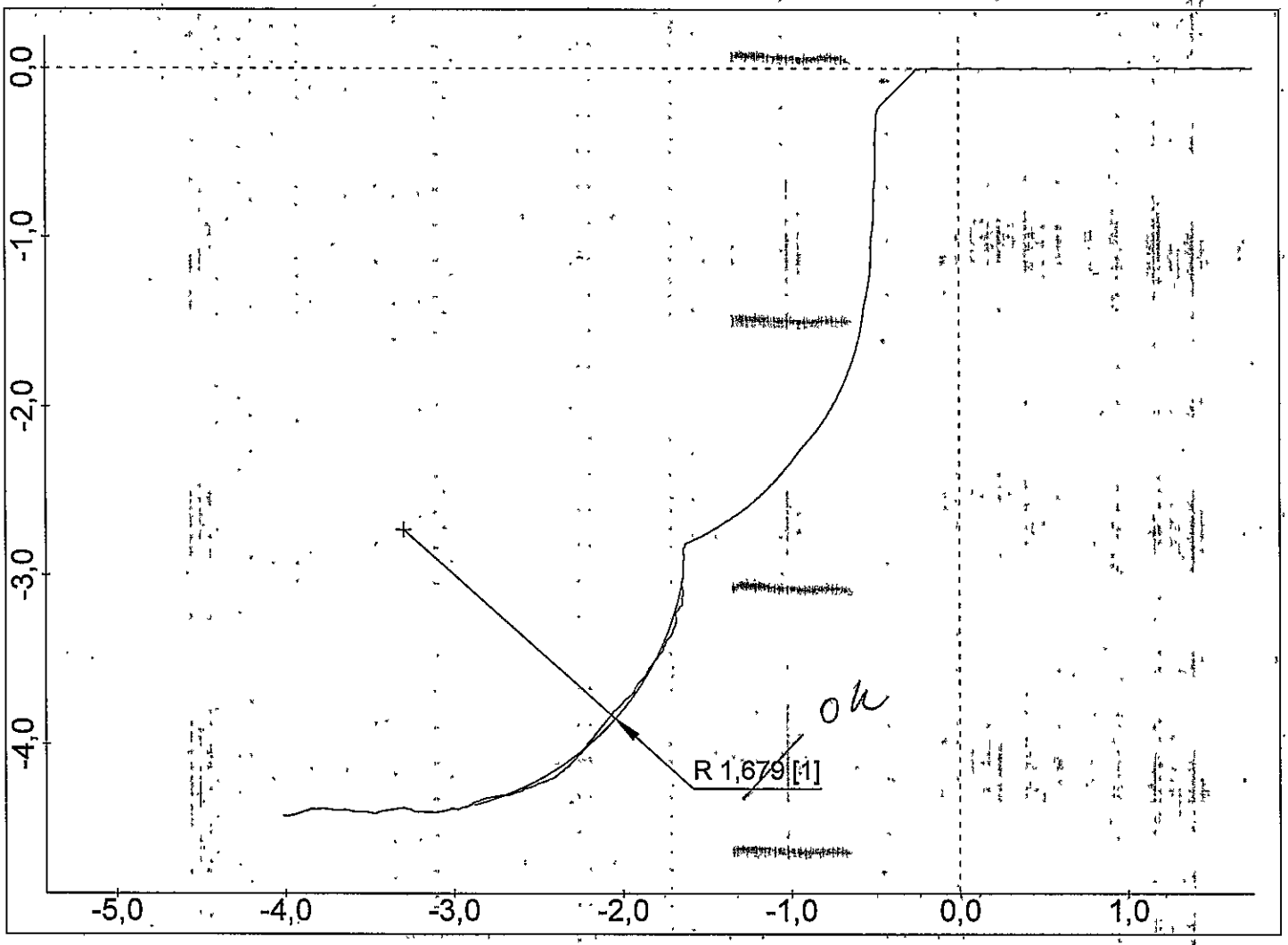

PERTHOMETER CONCEPT

ok

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 03.06.2014, 10:31 |
| Nota: | PART D-D |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |



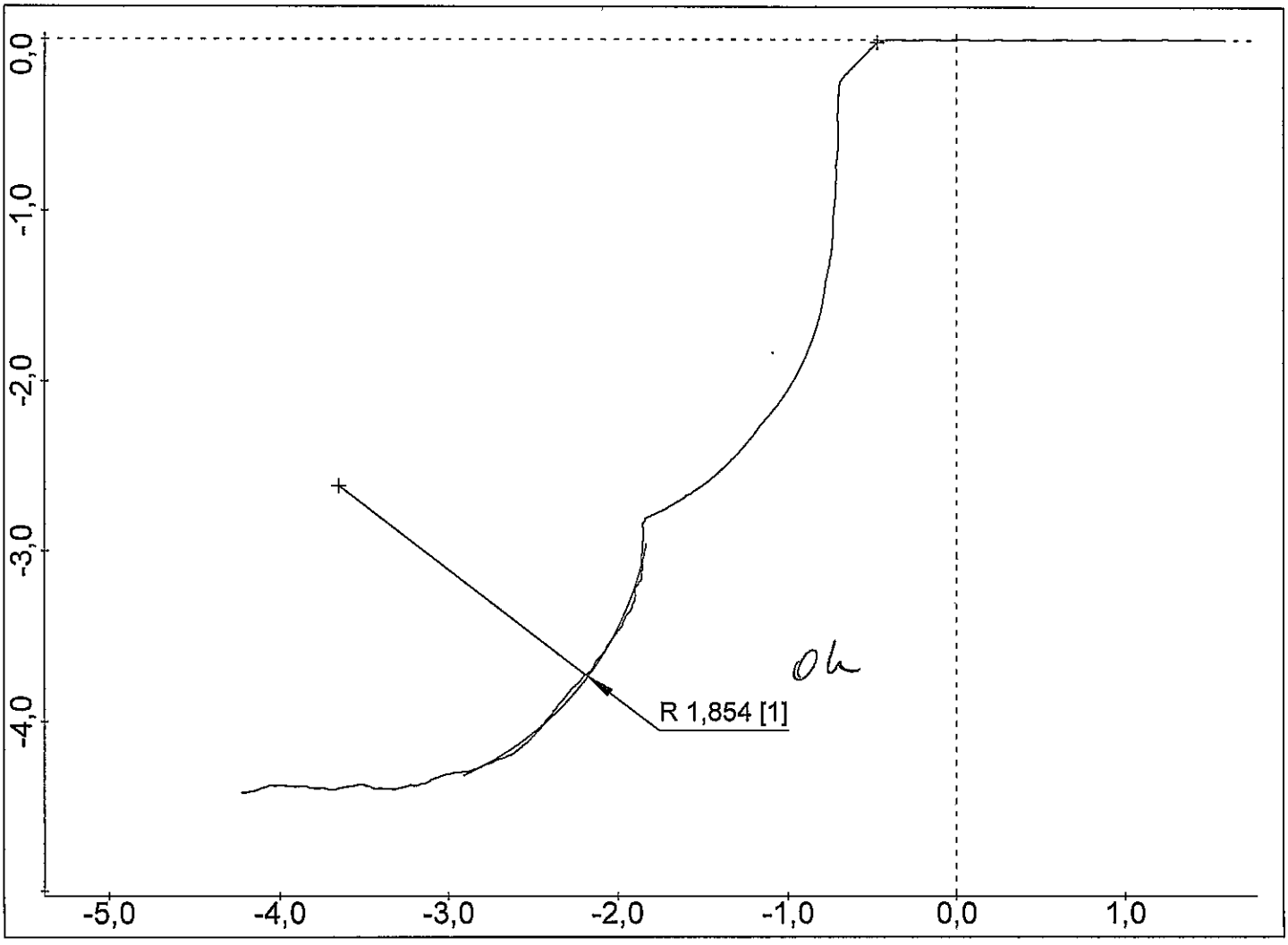

PERTHOMETER CONCEPT

OK

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Nota: | PART D-D |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 08:50 |
| Macchina: | MOA 416120 001 |

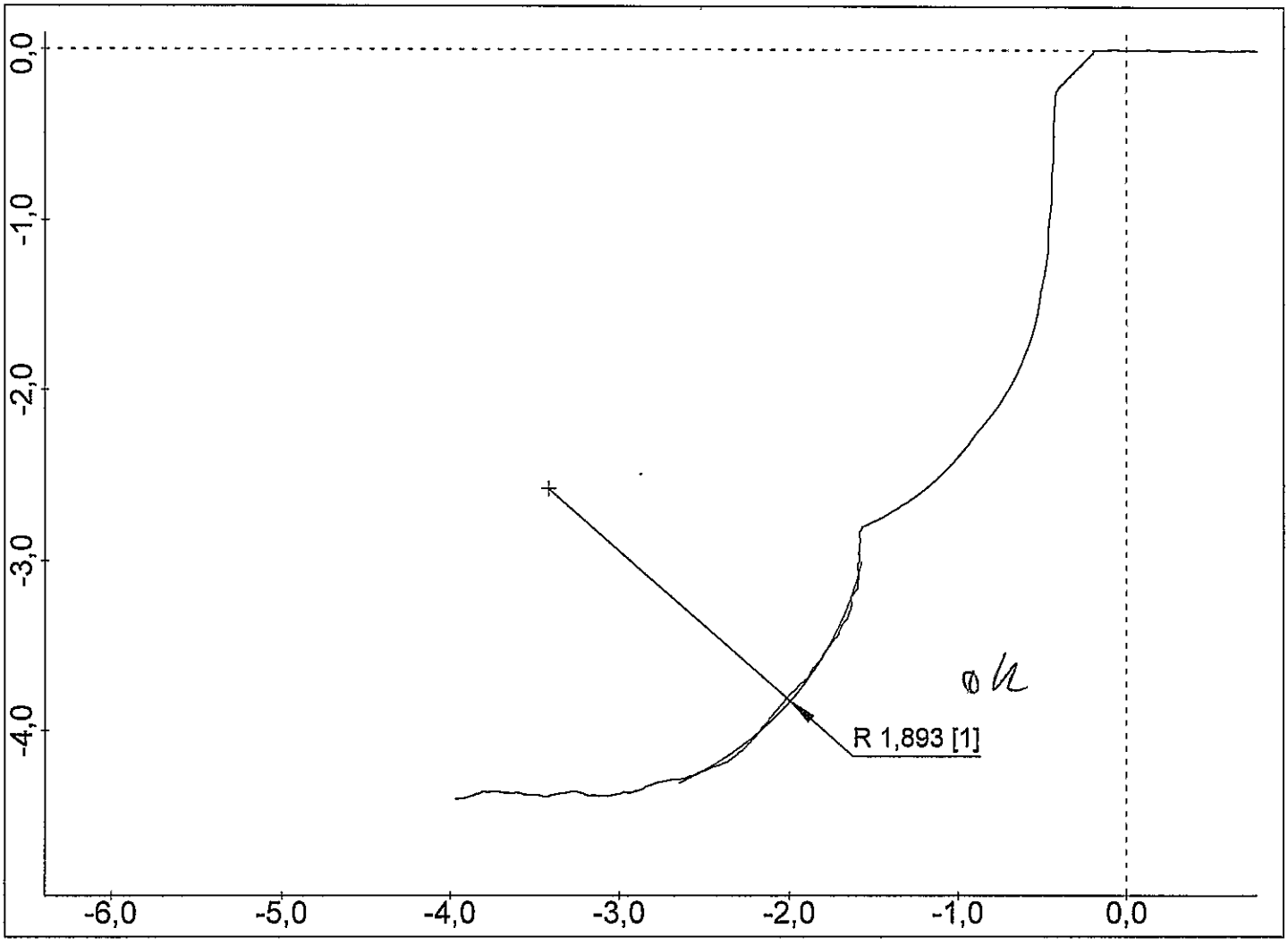



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Nota: | PART D-D |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 08:58 |
| Macchina: | MOA 416120 001 |

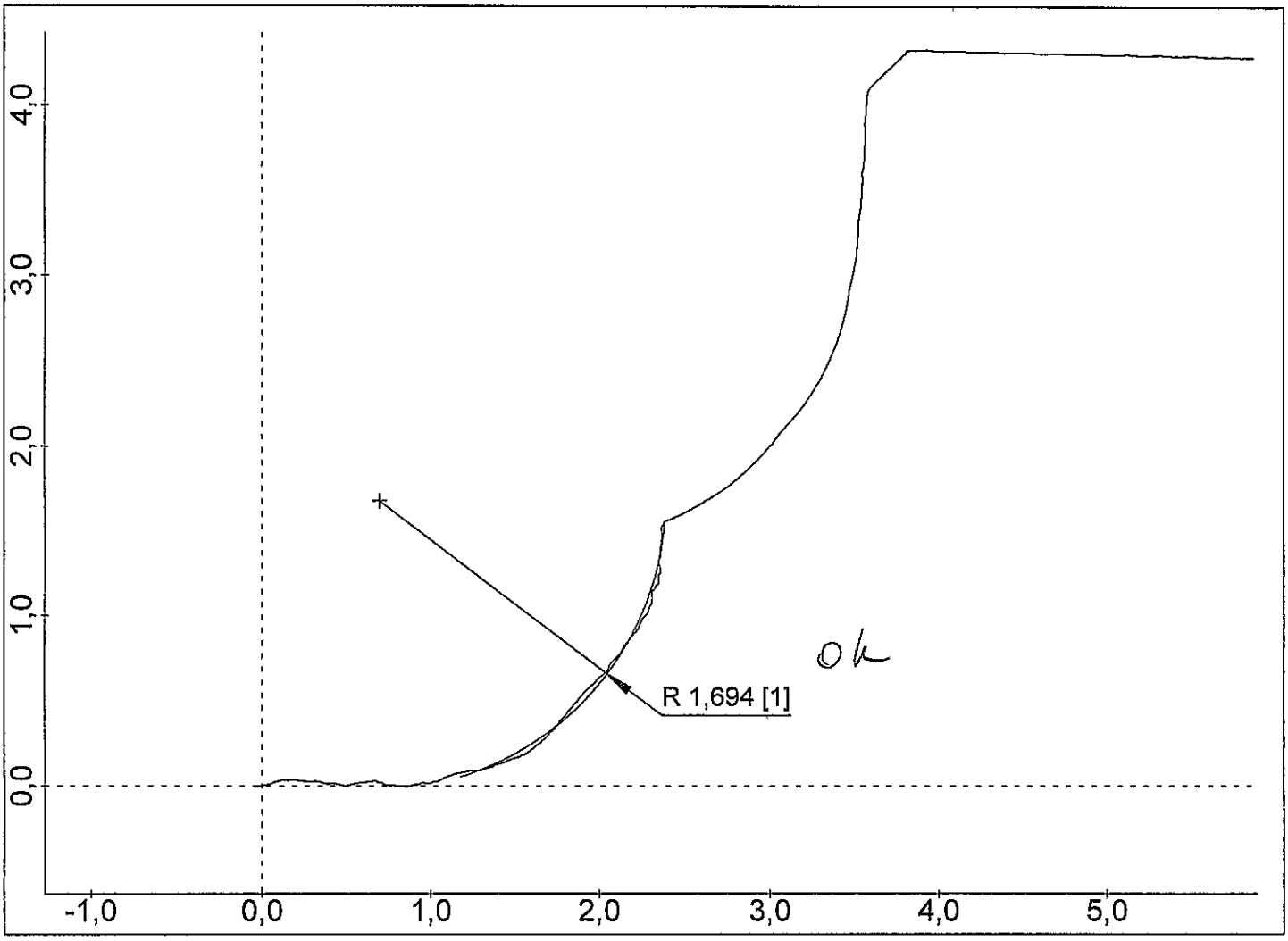



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Nota: | PART D-D |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 09:05 |
| Macchina: | MOA 416120 001 |

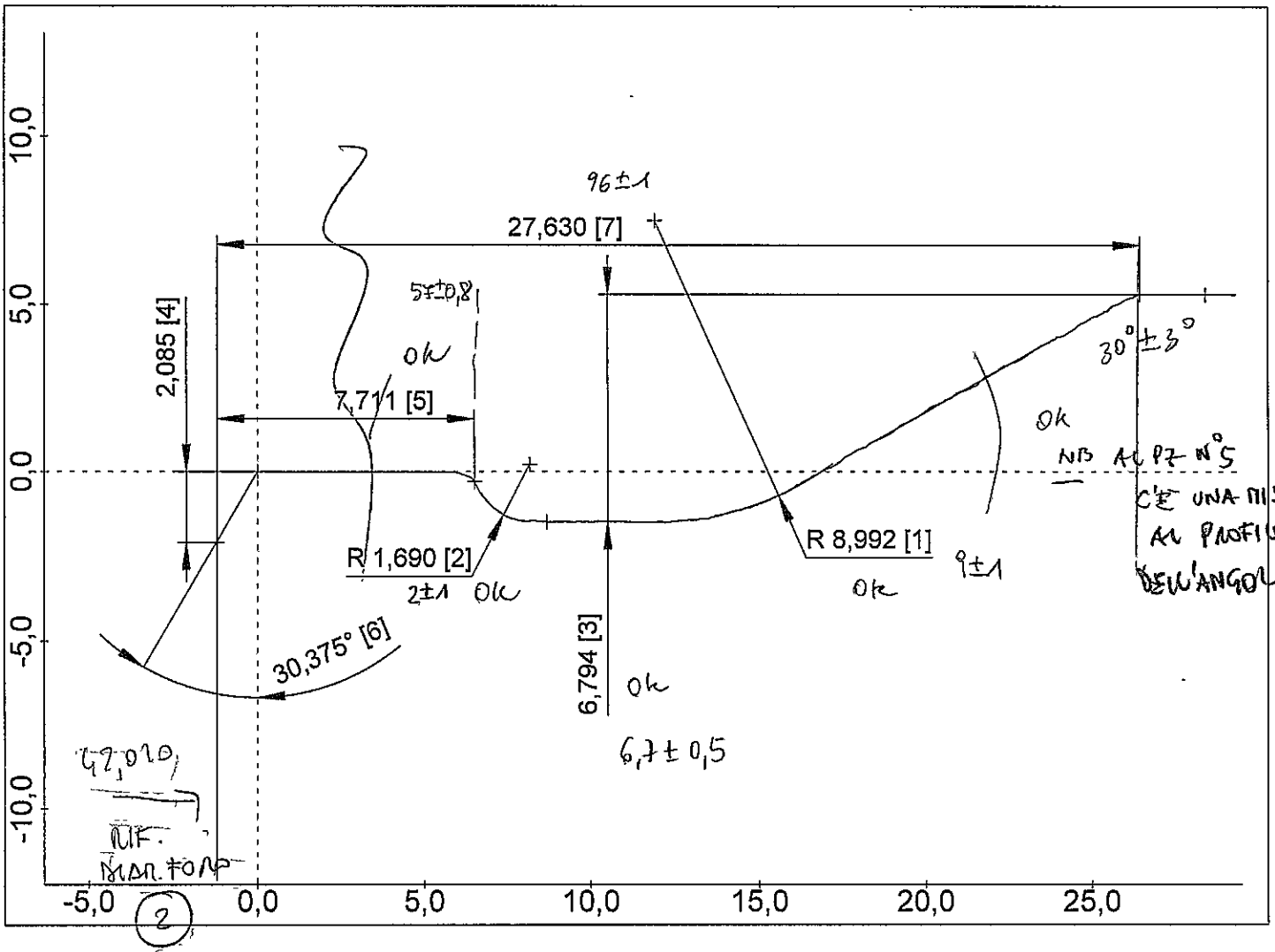



PERTHOMETER CONCEPT

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 1 |
| Operatore: | TURNO D |
| Nota: | PART Y |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:45 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

$57 \pm 0{,}8$: $42{,}020 + 2 \times 7{,}711 = 57{,}442$

$96 \pm 1$ : $42{,}020 + 2 \times 27{,}630 = 97{,}28 \sim 97$

$57 \pm 0{,}8$

$\arctg \frac{2{,}6}{4{,}7} = 30°$

56,2

57,8

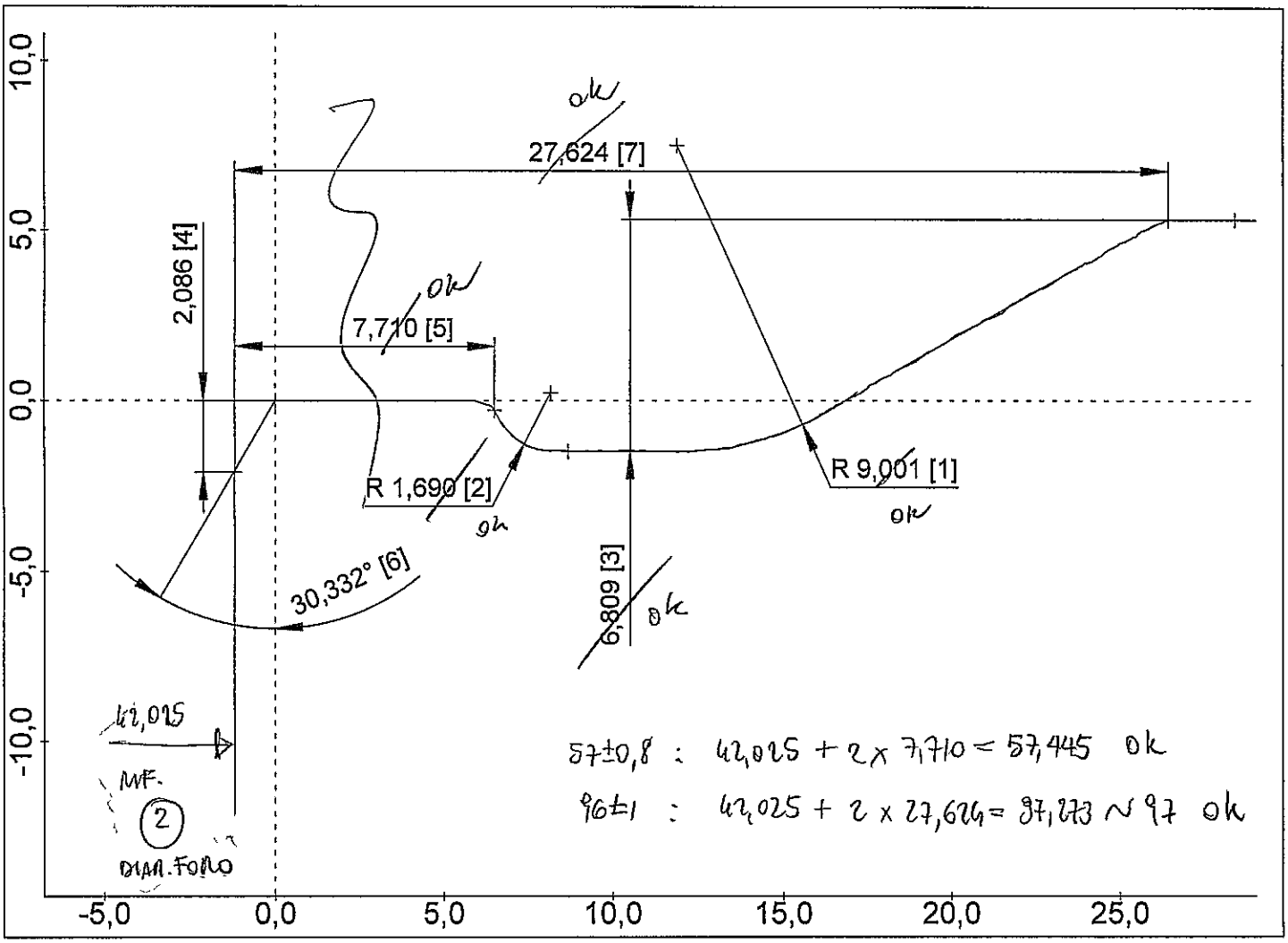
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 2 |
| Operatore: | TURNO D |
| Nota: | PART Y |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:55 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

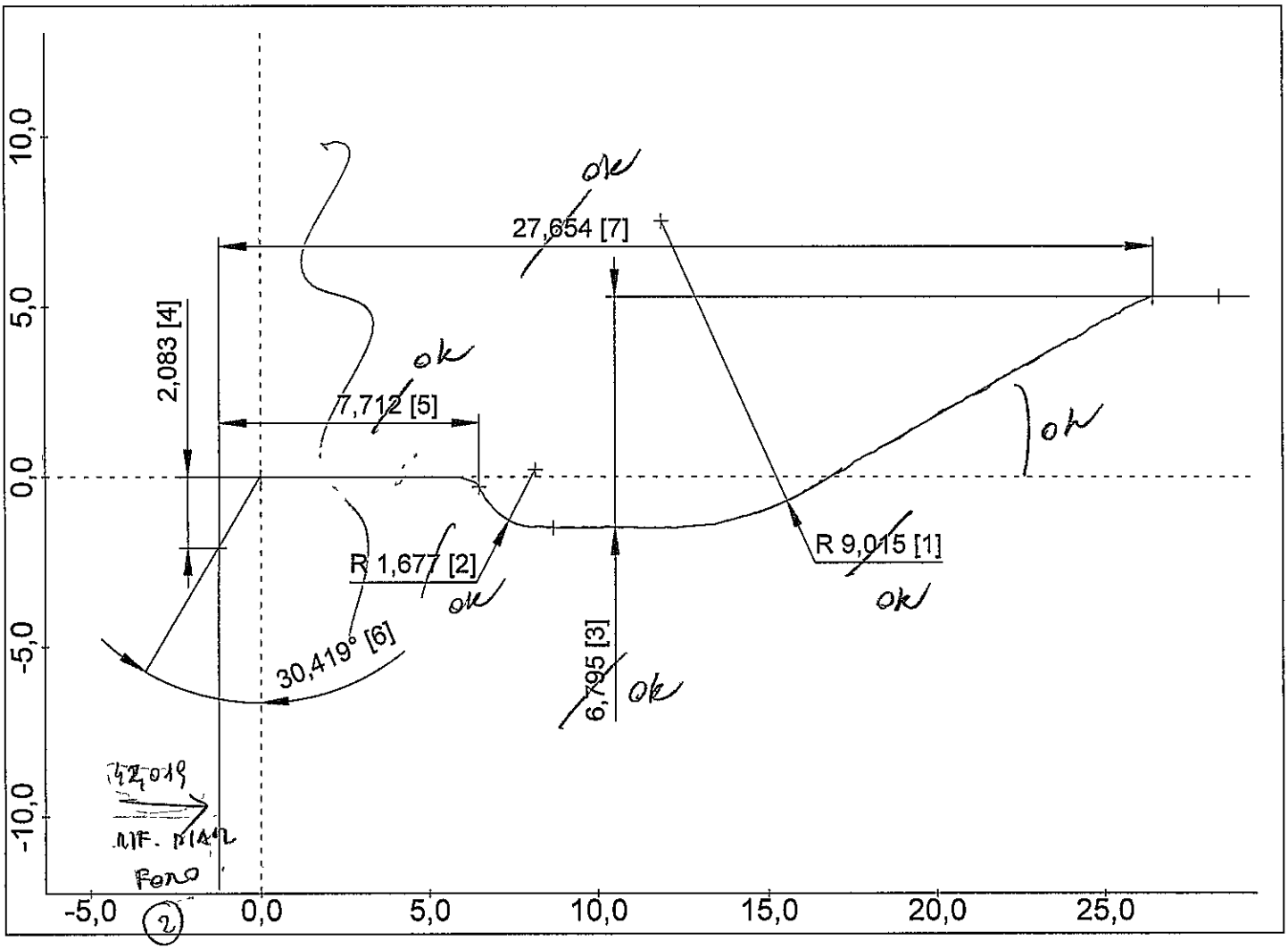
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 3 |
| Operatore: | TURNO D |
| Nota: | PART Y |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 13:59 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

$57 \pm 0{,}8$ : $42{,}019 + 2 \times 7{,}712 = 57{,}443$ ok

$96 \pm 1$ : $42{,}019 + 2 \times 27{,}654 = 97{,}327$ ok

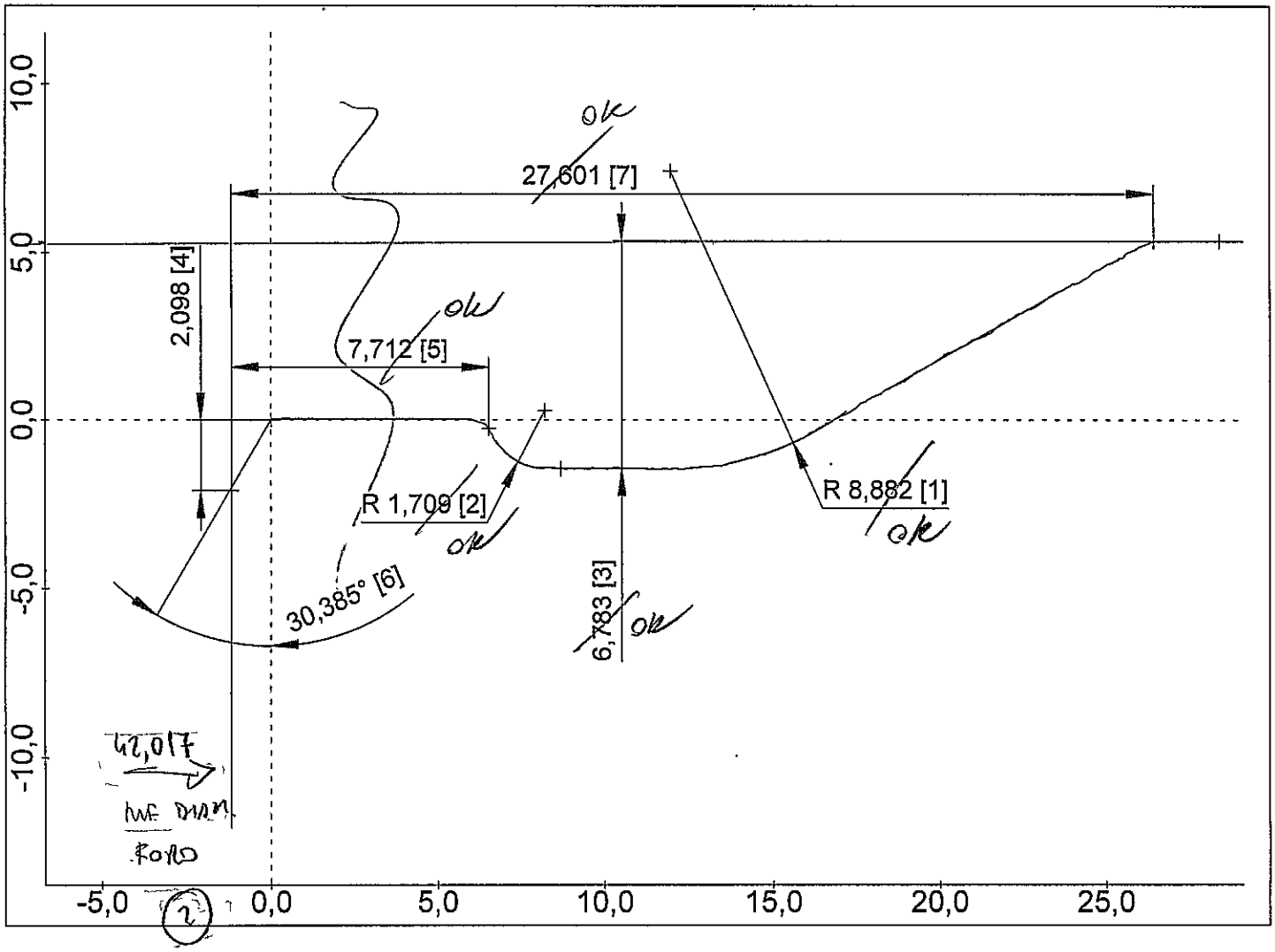
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 4 |
| Operatore: | TURNO D |
| Nota: | PART Y |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 14:15 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

$57 \pm 0{,}8$ : 42,017 + 2x 7,712 = 57,441 ok

$96 \pm 1$ : 42,017 + 2x 27,601 = 97,219 ~ 97 ok

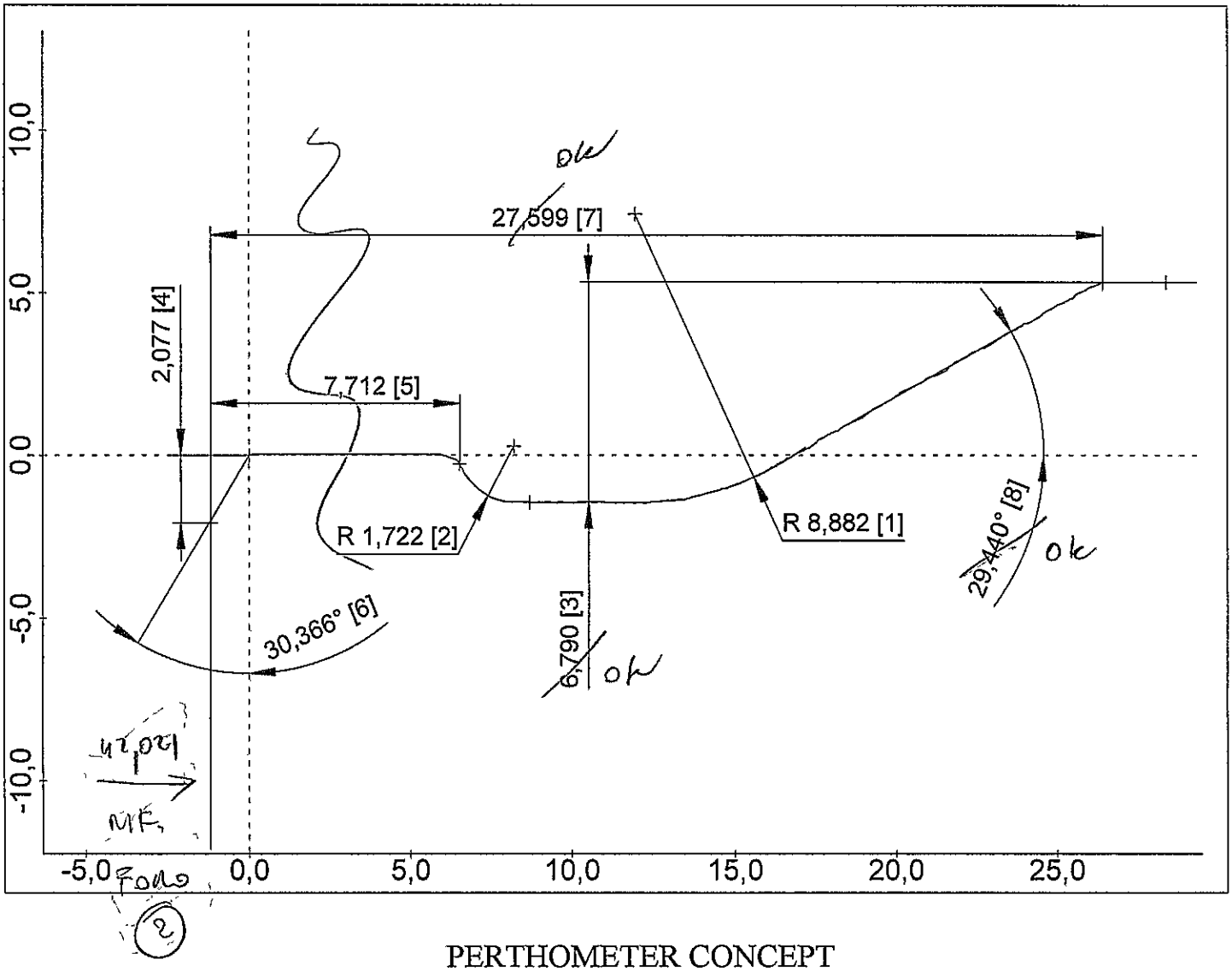
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP PEZZO 5 |
| Operatore: | TURNO D |
| Nota: | PART Y |
| Tastatore: | PCV 350 / 33 mm |
| Data, ora: | 04.06.2014, 14:37 |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

57±0,8 : 42,021 + 2 · 7,712 · = 57,445 ok

96±1 : 42,021 + 2 × 27,599 = 97,219 N 97

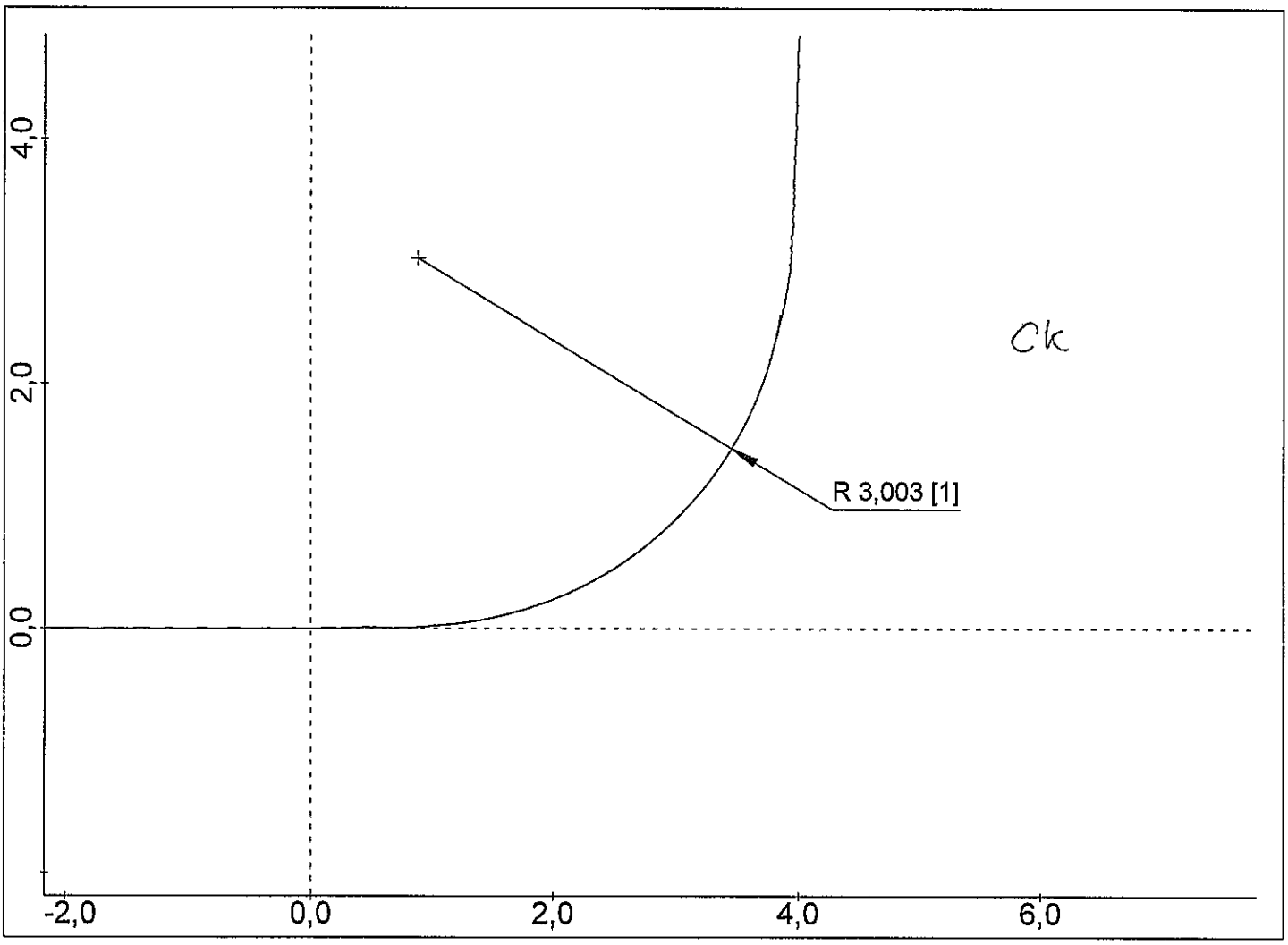
Macchina: MOA 416120 001

Macchina: MOA 416120 001

GETRAG

Via dei Ciclamini 4, Modugno ( BA )

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 1 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 18:40 |
| Nota: | PART 59 |
| Tastatore: | PCV 350 / 33 mm |
| Macchina: | MOA 416120 001 |




PERTHOMETER CONCEPT

GETRAG

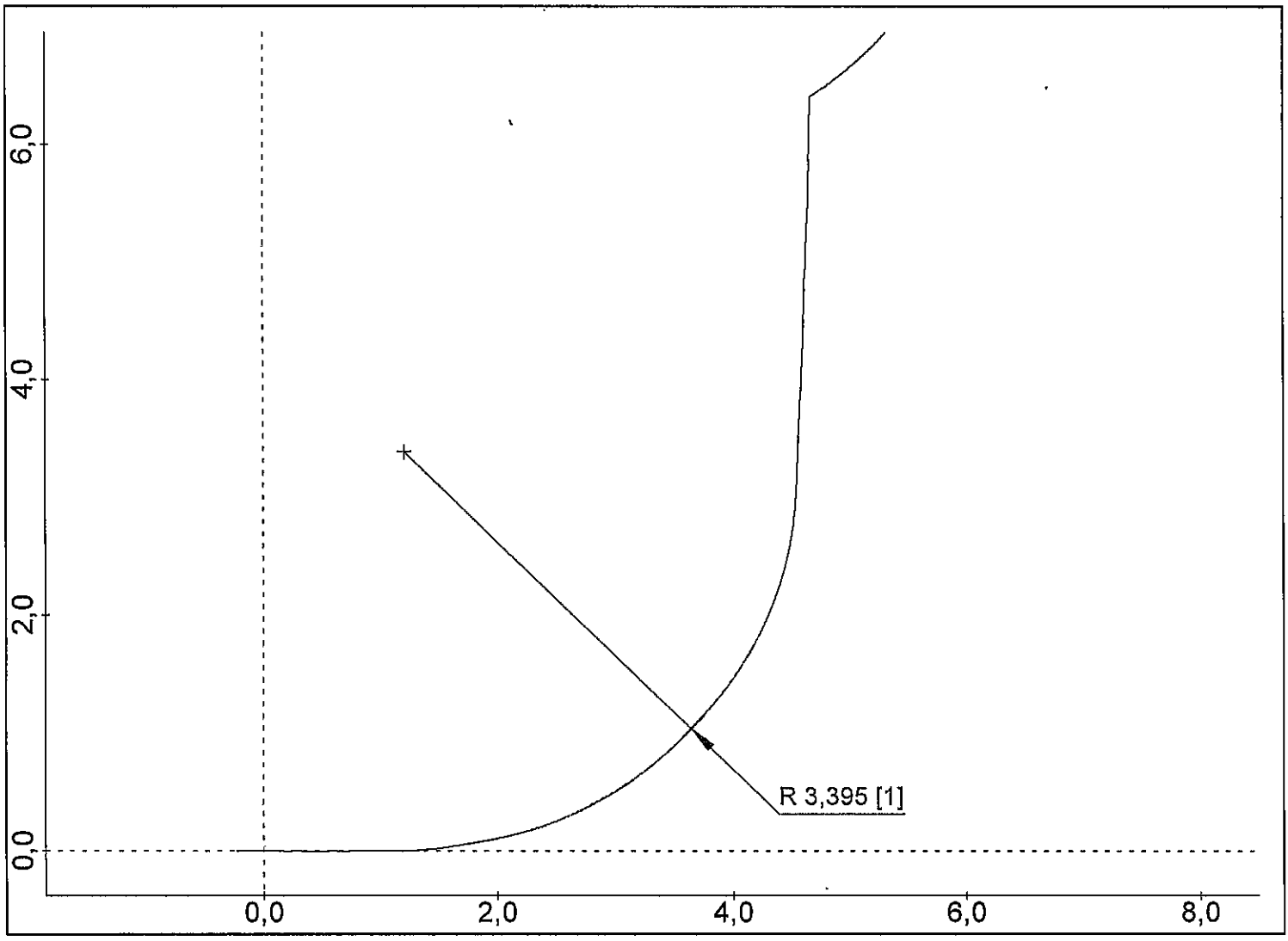
Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 2 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 13:36 |
| Nota: | RAGGIO SOTTO KK |
| Tastatore: | PCV 175-M / 9032212 |

59

Macchina: MOA 416120 002




PERTHOMETER CONCEPT

GETRAG

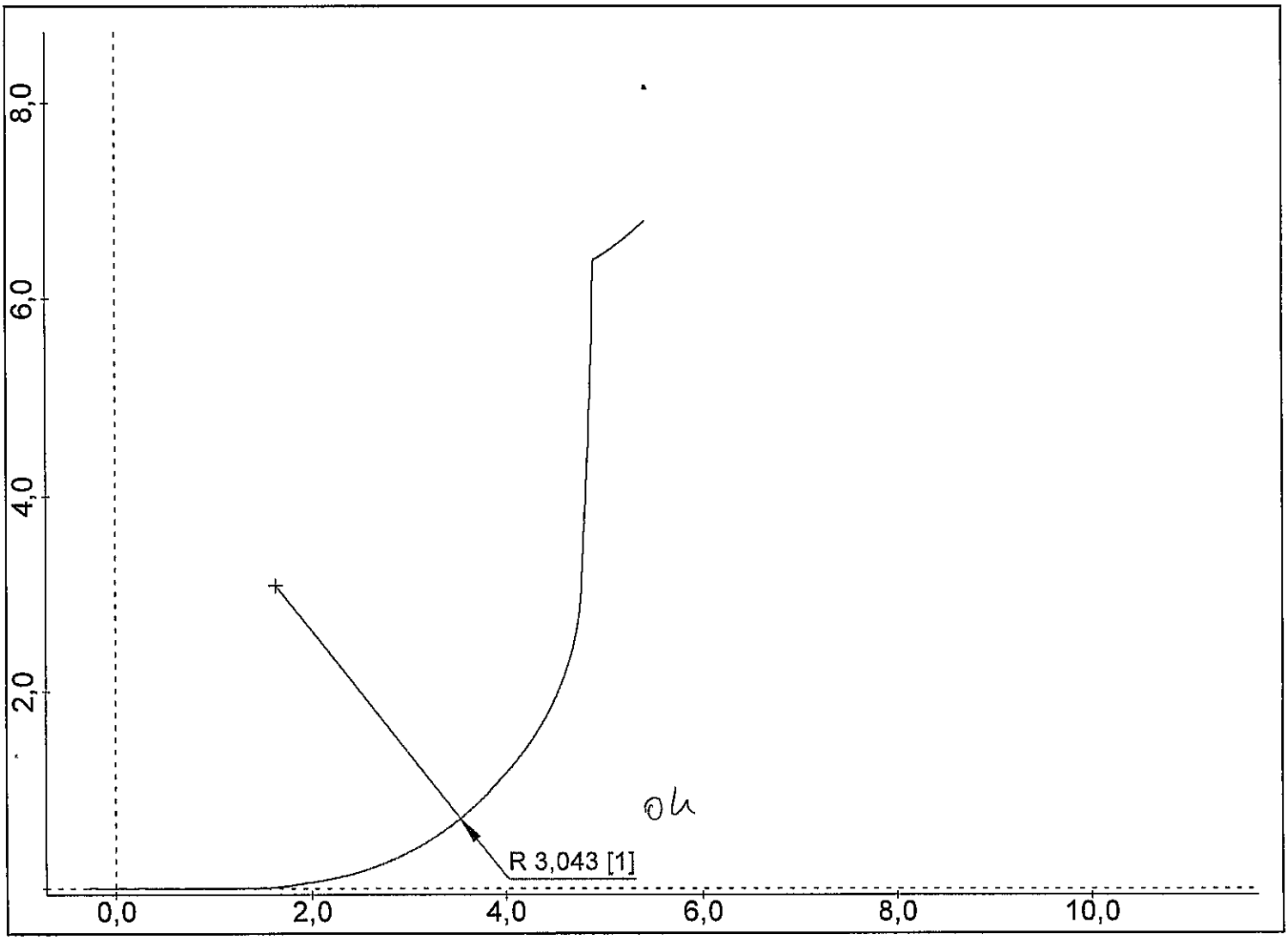
Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 3 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 13:40 |
| Nota: | RAGGIO SOTTO KK |
| Tastatore: | PCV 175-M / 9032212 |

59

Macchina: MOA 416120 002




PERTHOMETER CONCEPT

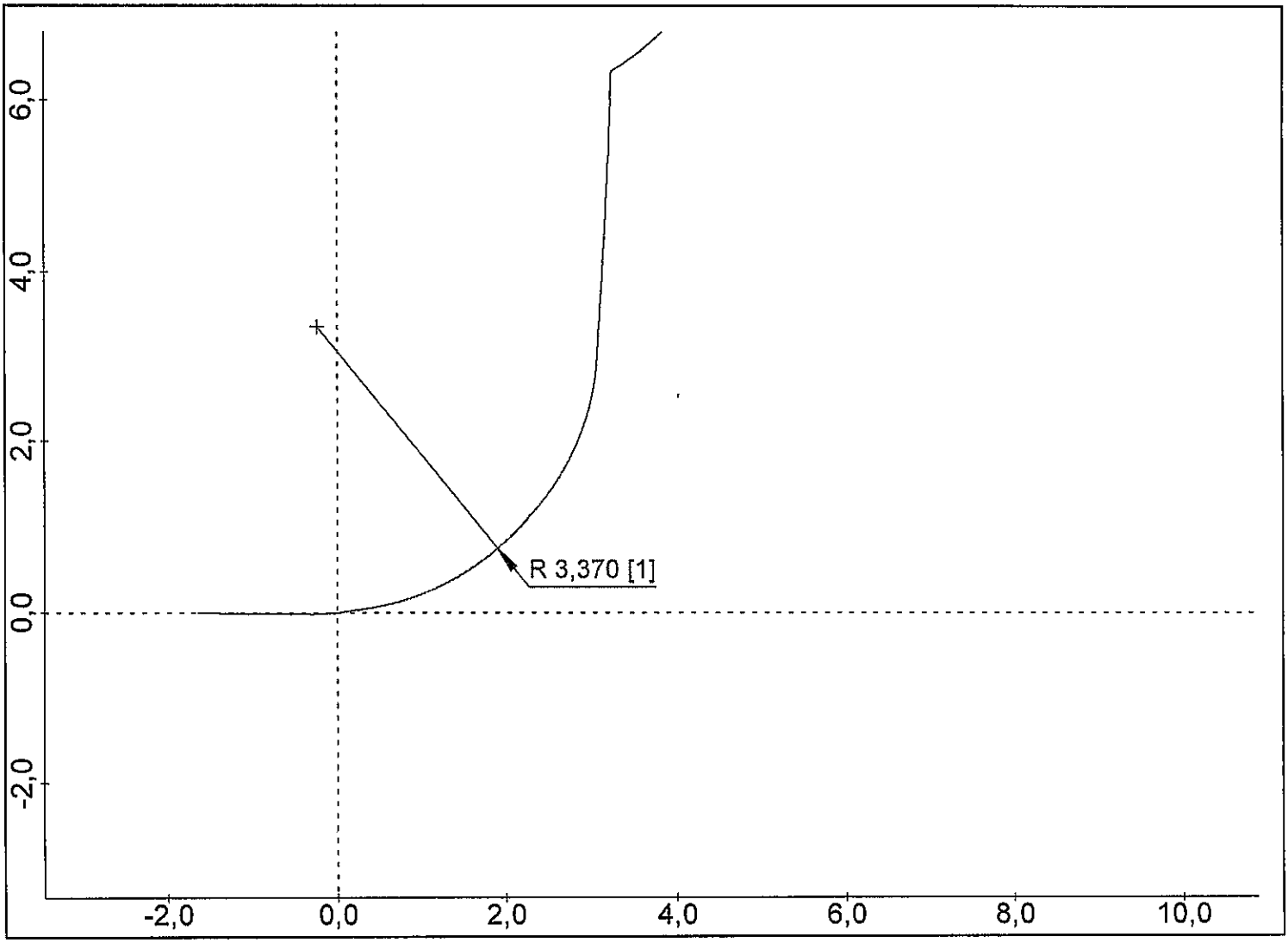
GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 4 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 13:37 |
| Nota: | RAGGIO SOTTO KK |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |

59




PERTHOMETER CONCEPT

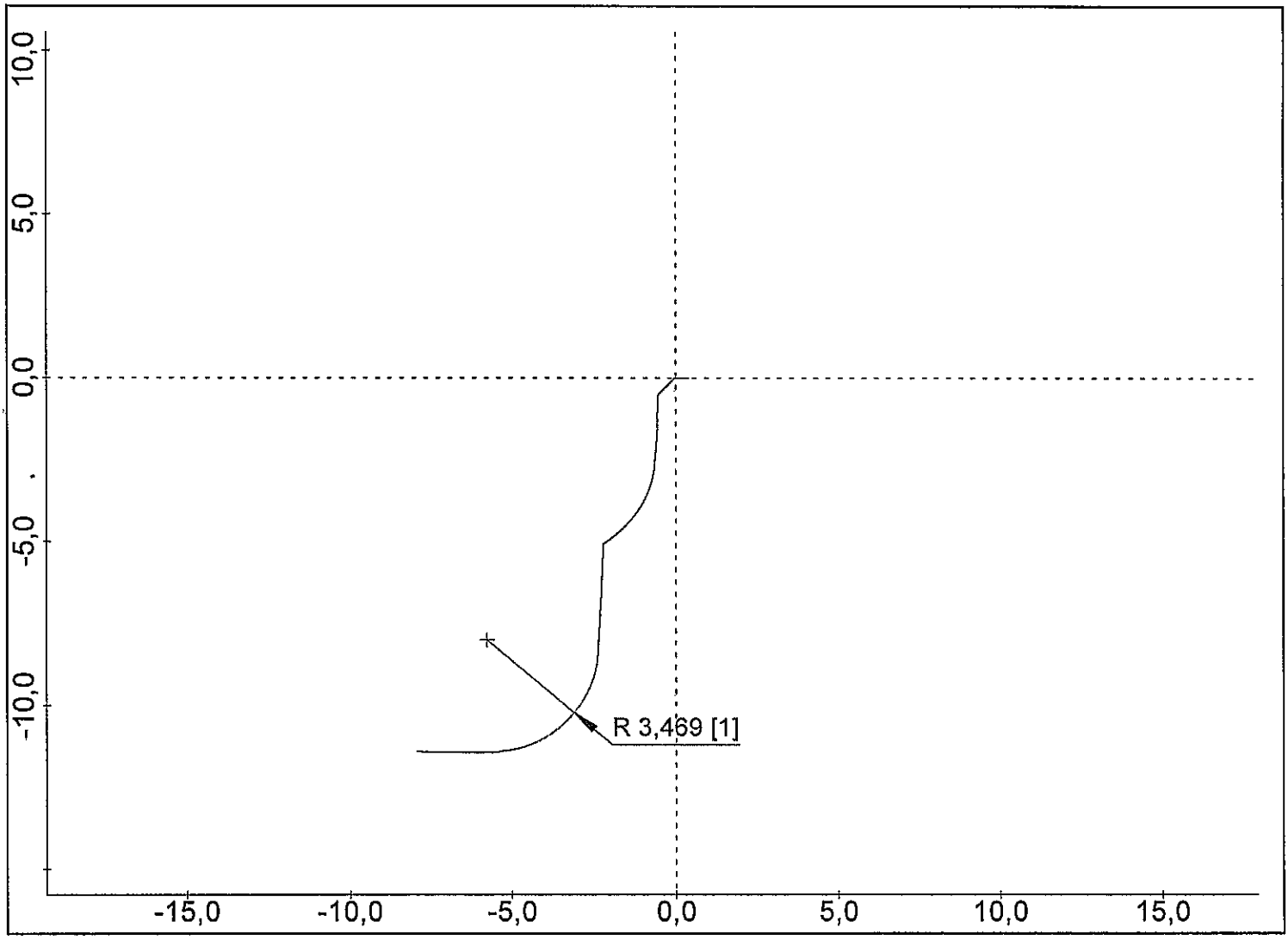
GETRAG

Via dei Ciclamini 4, Modugno (BA)

Sala Metrologica GPS5

| | |
|---|---|
| Oggetto: | SR3 5169 |
| Numero: | PPAP 5 |
| Operatore: | TURNO C |
| Data, ora: | 04.06.2014, 13:42 |
| Nota: | RAGGIO SOTTO KK |
| Tastatore: | PCV 175-M / 9032212 |
| Macchina: | MOA 416120 002 |

59




PERTHOMETER CONCEPT