

ISO 10825-1:2022-05 (E)

Gears - Wear and damage to gear teeth - Part 1: Nomenclature and characteristics

Contents		Page
Foreword		v
Introduction		vi
1 Scope		1
2 Normative references		1
3 Terms and definitions		1
4 Classes and modes of failure		2
5 Tribological damages (non-fatigue)		4
5.1 General information on wear.....		4
5.2 Polishing wear.....		5
5.2.1 General.....		5
5.2.2 Mild polishing wear.....		5
5.2.3 Moderate polishing wear.....		5
5.2.4 Severe polishing wear.....		5
5.3 Scratches.....		6
5.4 Abrasive wear.....		7
5.4.1 General.....		7
5.4.2 Mild abrasive wear.....		9
5.4.3 Moderate abrasive wear.....		10
5.4.4 Severe abrasive wear.....		10
5.5 Scuffing.....		10
5.5.1 General.....		10
5.5.2 Hot scuffing.....		11
5.5.3 Cold scuffing.....		11
5.5.4 Mild scuffing.....		11
5.5.5 Moderate scuffing.....		12
5.5.6 Severe scuffing.....		15
5.6 Adhesive wear.....		18
5.6.1 General.....		18
5.6.2 Mild adhesive wear.....		18
5.6.3 Moderate adhesive wear.....		18
5.7 Fretting corrosion.....		19
5.8 Interference wear.....		19
6 Fatigue damage		20
6.1 Fatigue cracks.....		20
6.2 Contact fatigue.....		20
6.2.1 General.....		20
6.2.2 Micropitting.....		20
6.2.3 Macropitting.....		25
6.2.4 Case crushing (Subcase fatigue).....		32
6.2.5 White layer flaking.....		34
6.2.6 Tooth flank fracture (TFF).....		35
6.2.7 Tooth interior fatigue fracture, TIFF.....		39
6.3 Bending fatigue.....		40
6.3.1 Tooth root fatigue fracture.....		40
6.3.2 Rim, web, and hub cracks.....		45
7 Non-fatigue fracture		47
7.1 General.....		47

	7.1.1	Overview	47
	7.1.2	Brittle fracture	48
	7.1.3	Ductile fracture	49
	7.1.4	Semi-brittle fracture	50
	7.2	Tooth root rupture	50
	7.3	Tooth end rupture	53
	7.4	Tooth shear fracture	54
8		Plastic deformation	54
	8.1	General	54
	8.2	Indentation	54
	8.3	Brinelling	55
	8.4	Cold flow	55
	8.5	Hot flow	55
	8.6	Root fillet yielding	56
	8.7	Fracture after plastic deformation	56
	8.8	Rolling	57
	8.9	Tooth hammer	58
	8.10	Rippling	58
	8.11	Ridging	60
	8.12	Burr	61
	8.13	Interference deformation	62
9		Manufacturing issues	63
	9.1	Forging cracks	63
	9.2	Hardening cracks	63
	9.3	Grinding cracks	64
	9.4	Hydrogen and internal residual stress failures	65
	9.5	Grinding burn (temper due to grinding)	65
	9.6	Grinding notch (not a failure mode)	67
	9.7	Scaling	67
	9.8	Case/core separation	68
10		Other surface damage	69
	10.1	Corrosion	69
	10.2	Cavitation	69
	10.3	Erosion	72
	10.4	Electric discharge	73
	10.5	Overheating	77
		Bibliography	78