

DIN ISO 4156-3:2026-01 (E)

Straight cylindrical involute splines - Metric module, side fit - Part 3: Inspection (ISO 4156-3:2021)

Contents		Page
Foreword		v
Introduction		vi
1 Scope		1
2 Normative references		1
3 Terms and definitions		1
4 Symbols and abbreviated terms		1
5 Reference conditions		4
6 Quality features		4
6.1 General.....		4
6.2 Size.....		4
6.2.1 Actual size.....		4
6.2.2 Effective size.....		4
6.3 Location.....		5
6.4 Form.....		5
7 Methods of inspection		5
7.1 Size.....		5
7.1.1 General methods.....		5
7.1.2 Choice of measuring instrument.....		5
7.1.3 Actual size.....		5
7.1.4 Effective size.....		8
7.2 Location.....		8
7.2.1 General.....		8
7.2.2 Choice of the method of inspection of location.....		8
7.2.3 Effective axis using mating part.....		9
7.2.4 Actual pitch cylinder axis.....		9
7.2.5 Calculation with Fourier analysis.....		9
7.2.6 Spline clamping system.....		10
7.3 Form.....		10
8 Measurements with balls or pins		10
8.1 General.....		10
8.2 Selection of balls or pins.....		11
8.3 Use and marking of pins.....		11
8.4 Statistical actual tolerance limit L_{STA}		11
8.4.1 General.....		11
8.4.2 Acceptance of parts according to the statistical actual tolerance limit L_{STA}		12
8.4.3 Examples.....		13
8.5 Calculation of ball or pin diameter (D_{Re} or D_{Ri}).....		13
8.5.1 External spline.....		13
8.5.2 Internal spline.....		14
8.6 Calculation of dimensions for ball or pin inspection (part and gauge inspection).....		15
8.6.1 Exact calculation.....		15
8.6.2 Approximation factor.....		18
9 Measurement over k teeth — External splines (W)		21
9.1 Calculation of W		21

9.2	Choice of k	21
10	Gauges	23
10.1	Generalities.....	23
10.1.1	Conditions of use of gauges.....	23
10.1.2	Limiting dimensions of use for gauges.....	23
10.1.3	Handles of spline gauges.....	23
10.1.4	Number of teeth for sector NO GO gauges.....	23
10.2	Length of measuring part of gauges.....	24
10.2.1	Influence of the active spline length and of the length of engagement.....	24
10.2.2	GO or NO GO gauges.....	24
10.2.3	Master plug gauges.....	25
10.2.4	Spline gauges of pitch diameters $D > 180$ mm.....	25
10.3	Manufacturing tolerances for spline gauges.....	25
10.4	Values of deviation allowances of spline gauges.....	28
10.5	Inspection of gauges.....	28
10.5.1	Damage.....	28
10.5.2	Marking.....	28
10.5.3	Major diameter of plug gauges and minor diameter of ring gauges.....	28
10.5.4	Form diameter.....	29
10.5.5	Tooth thickness of plug gauges.....	29
10.5.6	Space width of ring gauges.....	29
10.5.7	Form deviations.....	30
10.5.8	Gauge wear inspection.....	30
10.5.9	Inspection certificates.....	30
10.6	Dimensions, designation and marking of gauges.....	30
10.6.1	Inspection of external splines.....	30
10.6.2	Inspection of internal splines.....	37
10.6.3	Inspection with plain gauges for internal and external splines.....	39
10.6.4	Marking of gauges.....	40
11	Measurement of spline deviations	40
11.1	General.....	40
11.2	Total profile deviation F_α	40
11.3	Total pitch deviation F_p	41
11.4	Total helix deviation F_β	41
Annex A (informative) Influences of eccentricity and pitch deviation as explained in ISO 4156:1981		42
Bibliography		47