

ISO 4156-3:2021 (E)

Straight cylindrical involute splines — Metric module, side fit — Part 3: Inspection

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Symbols and abbreviated terms
5	Reference conditions
6	Quality features
6.1	General
6.2	Size
6.2.1	Actual size
6.2.2	Effective size
6.3	Location
6.4	Form
7	Methods of inspection
7.1	Size
7.1.1	General methods
7.1.2	Choice of measuring instrument
7.1.3	Actual size
7.1.3.1	Dimensions over and between balls
7.1.3.2	Dimensions over and between pins
7.1.3.3	NO GO sector gauge
7.1.3.4	Span size over k teeth
7.1.3.5	Variable sector gauge
7.1.4	Effective size
7.1.4.1	GO composite gauge
7.1.4.2	Variable composite gauge
7.1.4.3	NO GO composite gauge
7.1.4.4	Inspection of diameter at tooth tip (Dii or Dee)
7.2	Location
7.2.1	General
7.2.2	Choice of the method of inspection of location
7.2.3	Effective axis using mating part
7.2.4	Actual pitch cylinder axis
7.2.5	Calculation with Fourier analysis
7.2.6	Spline clamping system
7.3	Form
8	Measurements with balls or pins
8.1	General
8.2	Selection of balls or pins
8.3	Use and marking of pins
8.4	Statistical actual tolerance limit LSTA
8.4.1	General
8.4.2	Acceptance of parts according to the statistical actual tolerance limit LSTA

- 8.4.3 Examples
- 8.5 Calculation of ball or pin diameter (DRe or DRi)
- 8.5.1 External spline
- 8.5.2 Internal spline
- 8.6 Calculation of dimensions for ball or pin inspection (part and gauge inspection)
- 8.6.1 Exact calculation
- 8.6.1.1 Measurement over two balls or pins — External splines (MRe)
- 8.6.1.2 Measurement between two pins — Internal splines (MRi)
- 8.6.2 Approximation factor
- 8.6.2.1 General
- 8.6.2.2 Calculation of the approximation factor Ke
- 8.6.2.3 Calculation of the approximation factor Ki
- 9 Measurement over k teeth — External splines (W)
 - 9.1 Calculation of W
 - 9.2 Choice of k
- 10 Gauges
 - 10.1 Generalities
 - 10.1.1 Conditions of use of gauges
 - 10.1.1.1 GO gauge
 - 10.1.1.2 NO GO sector gauge
 - 10.1.1.3 NO GO composite gauge
 - 10.1.2 Limiting dimensions of use for gauges
 - 10.1.3 Handles of spline gauges
 - 10.1.4 Number of teeth for sector NO GO gauges
 - 10.2 Length of measuring part of gauges
 - 10.2.1 Influence of the active spline length and of the length of engagement
 - 10.2.2 GO or NO GO gauges
 - 10.2.3 Master plug gauges
 - 10.2.4 Spline gauges of pitch diameters $D > 180$ mm
 - 10.3 Manufacturing tolerances for spline gauges
 - 10.4 Values of deviation allowances of spline gauges
 - 10.5 Inspection of gauges
 - 10.5.1 Damage
 - 10.5.2 Marking
 - 10.5.3 Major diameter of plug gauges and minor diameter of ring gauges
 - 10.5.4 Form diameter
 - 10.5.5 Tooth thickness of plug gauges
 - 10.5.6 Space width of ring gauges
 - 10.5.7 Form deviations
 - 10.5.8 Gauge wear inspection
 - 10.5.9 Inspection certificates
 - 10.6 Dimensions, designation and marking of gauges
 - 10.6.1 Inspection of external splines
 - 10.6.1.1 GO composite ring gauge
 - 10.6.1.2 Tapered tooth master plug gauge for GO composite ring gauge
 - 10.6.1.3 NO GO sector ring gauge
 - 10.6.1.4 Tapered tooth master plug gauge for NO GO sector ring gauge
 - 10.6.1.5 NO GO composite ring gauge
 - 10.6.1.6 Tapered tooth master plug gauge for NO GO composite ring gauge
 - 10.6.2 Inspection of internal splines
 - 10.6.2.1 GO composite plug gauge
 - 10.6.2.2 NO GO sector plug gauge
 - 10.6.2.3 NO GO composite plug gauge
 - 10.6.3 Inspection with plain gauges for internal and external splines
 - 10.6.3.1 General
 - 10.6.3.2 Inspection of minor diameter — Internal spline
 - 10.6.3.3 Inspection of major diameter — External spline
 - 10.6.4 Marking of gauges
- 11 Measurement of spline deviations
 - 11.1 General
 - 11.2 Total profile deviation $F\alpha$

- 11.3 Total pitch deviation F_p
- 11.4 Total helix deviation F_β

Annex A (informative) Influences of eccentricity and pitch deviation as explained in ISO 4156:1981

Page count: 47