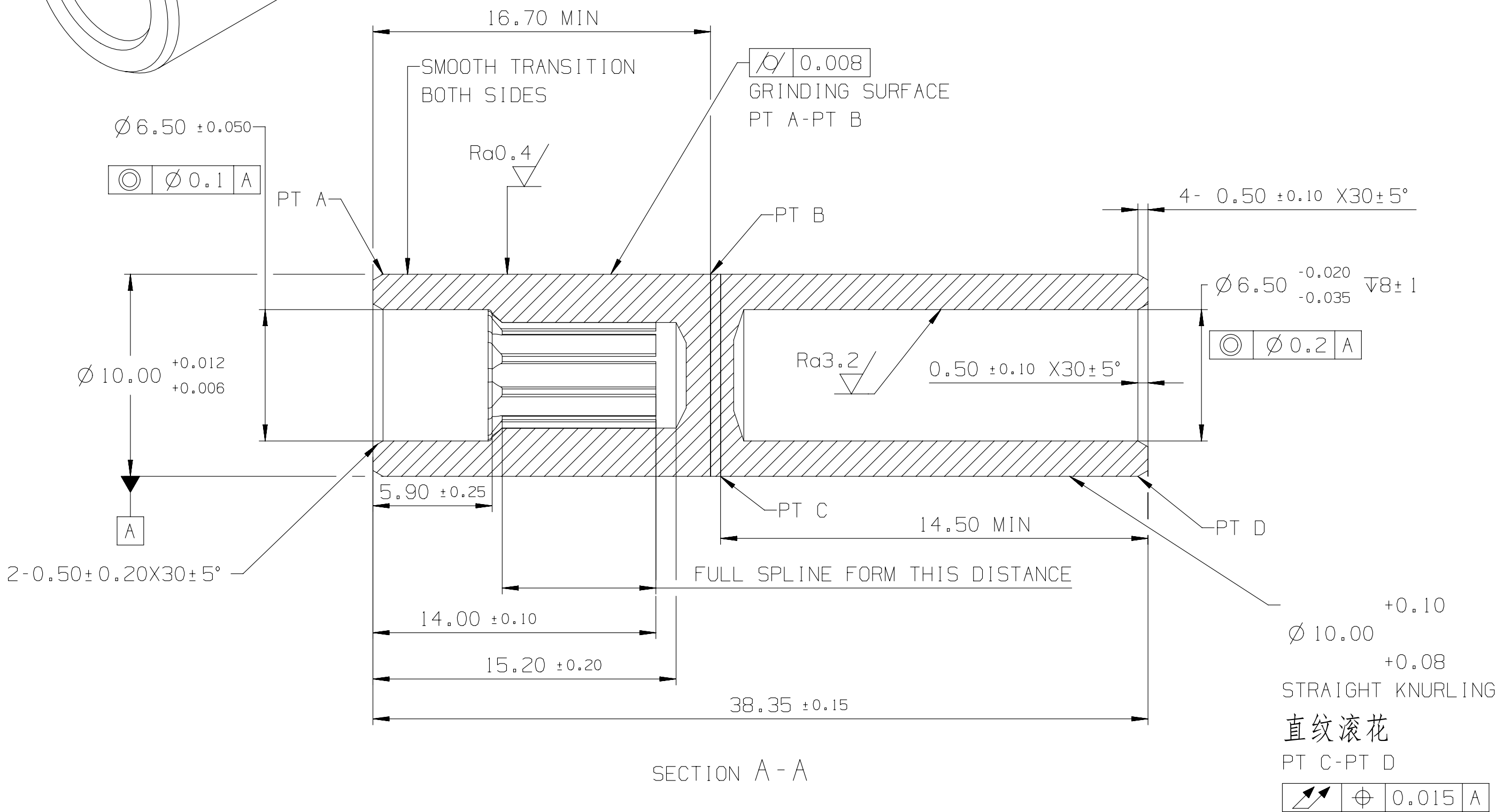
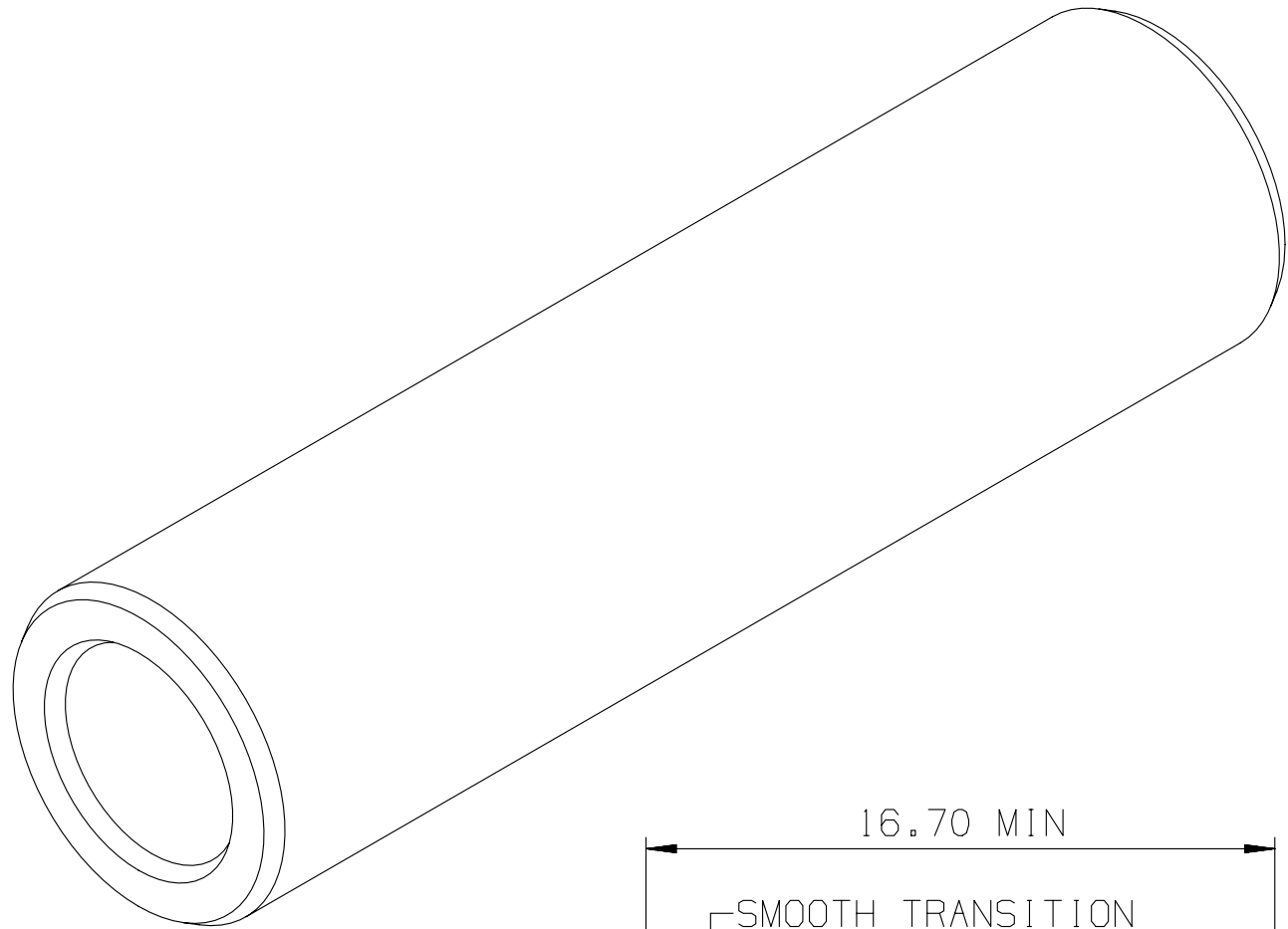




合肥恒信动力科技股份有限公司

Hefei Hengxin Powertrain Technology Co.,Ltd



直纹滚花参数			
模数	m	0.3	mm
节距	P	0.942	mm
圆角	r	0.09	mm
滚花深度	h	0.198	mm
整个滚花齿深		0.3±0.05	mm

内花键参数			
齿数	Z	10	
模数	m	0.5	mm
压力角	α	30	degree
变位系数	x	-0.8	
齿顶圆直径	da	5.200-5.275	mm
齿根圆直径	df	6.149-6.237	mm
实际齿槽宽	E _{min} /E _{max}	1.2723-1.3473	mm
作用齿槽宽	E _{vmin} /E _{max}	1.2473-1.2723	mm
量棒直径	[DM _{eff}]	1.1000	mm
量棒跨距	M _{Re} /M _{ri-pin}	3.9036-4.0288	mm
公法线	W _k .S _{min} /max	4.0553-4.1202	mm
分度圆跳动	F _r	0.03	mm

KEY CHARACTERISTIC (关键特性)						
0	0	0	0	LAST NUMBER USED (最后使用序号)	KPC (KEY PRODUCT CHARACTERISTIC) (关键产品特性)	
0	0	0	0	TOTAL BY COLUMN (总数量)	PQC (PRODUCT QUALITY CHARACTERISTIC) (产品质量特性) AQC (ATTRIBUTE QUALITY CHARACTERISTIC) (属性质量特性) DR (DOCUMENTATION REQUIRED) (特殊记录控制特殊)	
KPC #	PQC #	AQC #	DR #	CHARACTERISTIC (特性描述)	RATIONALE (失效描述)	ZONE (区域)
KPC NO.	PQC NO.	AQC NO.	DR NO.			

1		1	Z16050415	D	01	NA		转子铁芯轴	20CrMnTi
No.编号	ZONE区域	QUANTITY数量	PART NUMBER零件编号	ST阶段	REV LVL版本号	PDI标识	CALC MASS零件重量 (kg)	PART NAME 零件名称	Material 材料

WHERE DIMENSIONS ARE SPECIFIED ON THE DRAWING, THE DRAWING IS THE AUTHORITY FOR DIMENSIONAL VALUES.

WHERE DIMENSIONS ARE NOT SPECIFIED ON THE DRAWING, THE DIGITAL MODEL IS THE AUTHORITY FOR DIMENSIONAL VALUES.

DIMENSIONS OBTAINED FROM THE DIGITAL MODEL ARE BASIC:

- FOR RELATIONSHIPS BETWEEN FEATURES WHEN ESTABLISHED BY GEOMETRIC TOLERANCES.
- FOR THE FORM OF A FEATURE WHEN CONTROLLED BY A PROFILE TOLERANCE.
- FOR THE SIZE, FORM, AND/OR RELATIONSHIP BETWEEN FIXED DATUM TARGETS.

DIMENSIONS OBTAINED FROM THE DIGITAL MODEL ARE ROUNDED TO TWO DECIMAL PLACES (PER IEEE/ASTM SI 10-2002).

THE DIGITAL MODEL MUST CORRESPOND WITH THE RELEASE LEVEL

DWG STATUS 图样状态					REVISION 更改描述		EWO编号	ENG 工程师
DATA 日期	ST 审核	REV 版本	PDI 验证	PDI 验证	INITIAL RELEASE			
24JUL20	PB2	001						
08SEP20	PB2	002		D7	滚花大径 Ø 10(+0.045/+0.015);滚花参数增加			
12NOV20	PB2	003		A10	WAS e max=1.081 e min=1.059 ev min=1.045			
12NOV20	PB2	003		D7	[0.01] A ADDED			
24NOV20	PB2	004		A10	e max was 1.095; e min was 1.063; ev min was 1.045			
11JUN21	B	01		NA	RELEASE FOR BETA1			
20JUN21	B	01		001	1)变更前内花键参数: 齿顶圆直径Ø5.000-5.075, 齿根圆直径Ø6.073-6.151、量棒跨距3.8286-3.8784; ;压力角30° 公法线要求新增; 2)16.7(+0.5/0);15.0±0.5;32.2±0.1			
14DEC21	C	01		NA	1) 总长度由32.2变更为40.8 2) PRE-GAMMA释放			
01MAR22	C	01		001	1) 总长度由40.8变更为39.35 2) GAMMA释放			
16APR22	C	01		002	1) 10(+0.045/+0.015)更改为10(+0.1/+0.08) 2) 增加齿顶厚0.13°0.20mm			
09JUN22	C	01		003	1) 39.35(+0.15/-0.15)更改为38.35(+0.15/-0.15) E2: 表面硬度标准由HRC57-61改为700 HV1 MIN E2: 由HRC30-43改为HRC40-50 轴的中心不再是通孔 材料由20CrMnTi旧更换为20CrMnTi		EWO-0476	LJ.Hu
2024.1.2	C	02		NA				
2024.4.16	D	01		NA	E10:内花键的深度, 6.4改为5.9 (尺寸标注位置更新)		EWO-543	LJ.Hu

MATERIAL : 20CrMnTi GB/T 3077-2015

HEAT TREATMENT: CARBURIZE, QUENCH, TEMPER
EFFECTIVE CASE DEPTH 0.3-0.5mm
TOOTH SURF ACE HARDNESS : 700 HV1 MIN
CORE HARDNESS HRC 40-50

SCALE: 5X

MAX MAGNETIC FIELD ALLOWABLE: 5 GAUSS

CLEANLINESS MUST CONFORM TO GMW16037 0.05mg MAX
PER PC 10 MICRON FILTER PAPER

RESTRICTED & REPORTABLE SUBSTANCES PER GMW 3059

PARTS AS DELIVERED TO ASSEMBLY
SHALL BE CLEAN AND FREE OF DEBRIS, RESIDUAL
ABRASIVE MATERIAL AND CORROSION PRODUCTS
ADVERSELY AFFECTING FUNCTION OR APPEARANCE.

UNDEFINED DIMENSIONS [0.4] A [B-C]

TOLERANCES ON ANGULAR DIMENSIONS TO BE ±2°

PART MUST BE FREE OF BURRS AND SHARP EDGES

MACHINING RADIUS: R0.8±0.3

PARTS MUST WITHSTAND 100° F & 100% RH FOR 60
DAYS SHIPPING&INVENTORY
WITH NO RUST.

KEYSION		上海启盛汽车技术中心 Shanghai Keysion Automotive Technical Center			
SCALE 比例	REFERENCE 参考			DATA 日期	
5:1	16050415			设计	胡刘佳 2024/4/16
MATERIAL 材料牌号				校对	秦亮亮 2024/4/16
20CrMnTi				会签	王千禧、张栋 2024/4/16
MATERIAL SPEC材料标准				审核	徐晓锋 2024/4/16
GB/T 3077-2015				批准	俞黎明 2024/4/16
		DRAWING NAME 零件名			
		Rotor Stack Shaft			
SIZE 图幅	DRAWING NUMBER 图号			SHREET NUMBER 页码	
A1	Z16050415			DWG STATUS 图样状态	
				ST 审核	
				REV 版本	
				PDI 验证	
				D	01
				NA	
				1	OF 1