MarWin. Lead Testing and Analysis V2
Expansion Package for MarForm Formtester
as per Mercedes Benz Standard MBN31007-7

Mahr
EXACTLY
### Measured value acquisition

The surface structure of the seal face of a shaft influences the flow behaviour of the fluid that is to be sealed and therefore greatly influence the sealing function.

A lead structure on the seal face can interfere with the interplay of shaft surface, fluid and sealing lip support creating leakage due to a conveying effect.

Lead is a surface feature appearing over the entire scope on rotation symmetrical surfaces. The evaluation of the macro lead is conducted with the option lead testing as per the Mercedes Benz Standard 31007-7.

Measurement of n generating lines (72 as per MB Standard, MBN 31007-7)

A probe arm for T7W, equipped with two styli, is used to record measured values:

- **Stylus #1** with HM ball dia. 3 mm for mechanical centering and tilting of the workpiece on the MMQ 400 Formtester
- **Stylus #2** with diamond stylus tip for measuring lead and form parameters

### Scope of application

External measurement on workpiece diameters dia. = 2 - 200 mm

### Form and lead evaluation

- Form/positional evaluation/parallelism parallel to lead evaluation
- Form/positional/lead evaluation of several wavelengths

### Evaluation and recording

After the measurements have been performed, measurement records with the following content are generated:

#### Lead parameters (MBN 31007-7):

The following are measured as parameters for lead evaluation:

- Number of threads DG (upr)
- Period length DP (mm)
- Lead angle Dλ (degree)
- Lead direction
- Lead depth Dt (µm)
- Theoretical supply cross-section DF (µm²)
- Theoretical supply cross-section per turn DFu (µm²)
- Contact length

### Graphic output

The measured profiles are output in the record as a graphic. Various graphic output types are available:

- 3D-cylinder in color, traditional and unwound
- Display of individual generating lines as a straightness profile for individual assessment of form and position parameters
- Amplitude spectra of the linear profiles in a bar graph

or as per MBN 31007-7: 3D cylinder unwinding, color,

- Surface structure
- Lead surface
- Display of surface profile and lead profile
MarWin. Lead Measurement Record

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Carl-Mahr-Str. 1, Göttingen
AWT

Sheet: 3.05-07
Drawing n°: 5
Machining operation:

Comment:
est measurement

Lead parameters 5D° / DIN 31 007-07

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Number of data (DC)</td>
<td>-11</td>
</tr>
<tr>
<td>Lead depth (x)</td>
<td>0.99 μm</td>
</tr>
<tr>
<td>Period length (DF)</td>
<td>0.39 mm</td>
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<tr>
<td>Cross section (DF)</td>
<td>20.80 μm</td>
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<tr>
<td>Drive section per revolution (Dfu)</td>
<td>394.01 μm/J</td>
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<tr>
<td>Bearing length (% of total length)</td>
<td>29.94 %</td>
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<tr>
<td>Lead angle (dy)</td>
<td>-0.371° (-0°-22°-10°)</td>
</tr>
<tr>
<td>Profile orientation</td>
<td>peak</td>
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</tbody>
</table>

Surface roughness parameters

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Evaluation length (Le)</td>
<td>10.00 nm</td>
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<tr>
<td>Cut-off wavelength (λc)</td>
<td>1.00 nm</td>
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<tr>
<td>Mean roughness depth (Rq)</td>
<td>2.00 μm</td>
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<tr>
<td>Maximum roughness depth (Rmax)</td>
<td>3.00 μm</td>
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<tr>
<td>Reduced peak height (Rpk)</td>
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<td>Core roughness depth (Rku)</td>
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<tr>
<td>Reduced valley depth (Rvl)</td>
<td>50.00 μm</td>
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<tr>
<td>Evaluation section lead</td>
<td>2.00 nm</td>
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<tr>
<td>Rev. / post travel</td>
<td>2.06 / 1.88 mm</td>
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<tr>
<td>Potential radius</td>
<td>3.005 mm</td>
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<tr>
<td>Workpiece diameter</td>
<td>47 mm</td>
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</table>

Real surface

Lead surface at the cross section

Lead surface at the measurement scale

Lead profile: Surface profile

Location of profile line: Generating line 36

Measurement m: Z

Amplitude

1.00 μm
0.111 mm
Expansion Package for Formtester: MarForm MMQ 400

Expansion package for lead testing and lead evaluation

Can be used in combination with MarForm MMQ 200, MMQ 400, MFU 100, T7W probe and Mahr evaluation software MarWin comprising:

- Lead evaluation software package based on MarWin evaluation software
- Probe arm for T7W for lead measurement, double-ended, with diamond tip and HM ball dia. 3 mm for alignment (5400234)

Order No.: 5440675