
**Calculation of load capacity of spur
and helical gears —**

**Part 5:
Strength and quality of materials**

*Calcul de la capacité de charge des engrenages cylindriques à
dentures droite et hélicoïdale —*

Partie 5: Résistance et qualité des matériaux



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 60, *Gears*, Subcommittee SC 2, *Gear capacity calculation*.

This third edition cancels and replaces the second edition (ISO 6336-5:2003), which has been technically revised to reflect current practices throughout the industry.

A list of all parts in the ISO 6336 series can be found on the ISO website.

Introduction

This document, together with ISO 6336-1, ISO 6336-2, ISO 6336-3 and ISO 6336-6, provides the principles for a coherent system of procedures for the calculation of the load capacity of cylindrical involute gears with external or internal teeth. ISO 6336 is designed to facilitate the application of future knowledge and developments, as well as the exchange of information gained from experience.

Allowable stress numbers, as covered by this document, may vary widely. Such variation is attributable to defects and variations of chemical composition (charge), structure, the type and extent of hot working (e.g. bar stock, forging, reduction ratio), heat treatment, residual stress levels, etc.

Tables summarize the most important influencing variables and the requirements for the different materials and quality grades. The effects of these influences on surface durability and tooth bending strength are illustrated by graphs.

This document covers the most widely used ferrous gear materials and related heat treatment processes. Recommendations on the choice of specific materials, heat treatment processes or manufacturing processes are not included. Furthermore, no comments are made concerning the suitability or otherwise of any materials for specific manufacturing or heat treatment processes.

Calculation of load capacity of spur and helical gears —

Part 5: Strength and quality of materials

1 Scope

This document describes contact and tooth-root stresses and gives numerical values for both limit stress numbers. It specifies requirements for material quality and heat treatment and comments on their influences on both limit stress numbers.

Values in accordance with this document are suitable for use with the calculation procedures provided in ISO 6336-2, ISO 6336-3 and ISO 6336-6 and in the application standards for industrial, high-speed and marine gears. They are applicable to the calculation procedures given in ISO 10300 for rating the load capacity of bevel gears. This document is applicable to all gearing, basic rack profiles, profile dimensions, design, etc., covered by those standards. The results are in good agreement with other methods for the range indicated in the scope of ISO 6336-1 and ISO 10300-1.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 53, *Cylindrical gears for general and heavy engineering — Standard basic rack tooth profile*

ISO 642, *Steel — Hardenability test by end quenching (Jominy test)*

ISO 643:2012, *Steels — Micrographic determination of the apparent grain size*

ISO 683-1, *Heat-treatable steels, alloy steels and free-cutting steels — Part 1: Non-alloy steels for quenching and tempering*

ISO 683-2, *Heat-treatable steels, alloy steels and free-cutting steels — Part 2: Alloy steels for quenching and tempering*

ISO 683-3, *Heat-treatable steels, alloy steels and free-cutting steels — Part 3: Case-hardening steels*

ISO 683-4, *Heat-treatable steels, alloy steels and free-cutting steels — Part 4: Free-cutting steels*

ISO 683-5, *Heat-treatable steels, alloy steels and free-cutting steels — Part 5: Nitriding steels*

ISO 1328-1, *Cylindrical gears — ISO system of flank tolerance classification — Part 1: Definitions and allowable values of deviations relevant to flanks of gear teeth*

ISO 2639, *Steels — Determination and verification of the depth of carburized and hardened cases*

ISO 3754, *Steel — Determination of effective depth of hardening after flame or induction hardening*

ISO 4948-2, *Steels — Classification — Part 2: Classification of unalloyed and alloy steels according to main quality classes and main property or application characteristics*

ISO 4967, *Steel — Determination of content of non-metallic inclusions — Micrographic method using standard diagrams*

ISO 6336-1, *Calculation of load capacity of spur and helical gears — Part 1: Basic principles, introduction and general influence factors*

ISO 6336-2, *Calculation of load capacity of spur and helical gears — Part 2: Calculation of surface durability (pitting)*

ISO 6336-3:2006, *Calculation of load capacity of spur and helical gears — Part 3: Calculation of tooth bending strength*

ISO 9443, *Heat-treatable and alloy steels — Surface quality classes for hot-rolled round bars and wire rods — Technical delivery conditions*

ISO 10474, *Steel and steel products — Inspection documents*

ISO 14104, *Gears — Surface temper etch inspection after grinding, chemical method*

ISO 18265, *Metallic materials — Conversion of hardness values*

EN 10204, *Metallic products — Types of inspection documents*

EN 10228-1, *Non-destructive testing of steel forgings — Magnetic particle inspection*

EN 10228-3, *Non-destructive testing of steel forgings — Ultrasonic testing of ferritic or martensitic steel forgings*

EN 10308, *Non-destructive testing — Ultrasonic testing of steel bars*

ASTM¹⁾ A388-01, *Standard practice for ultrasonic examination of heavy steel forgings*

ASTM A609-91, *Standard practice for castings, carbon, low alloy and martensitic stainless steel, ultrasonic examination thereof*

ASTM E428-00, *Standard Practice for Fabrication and Control of Steel Reference Blocks Used in Ultrasonic Examination*

ASTM E1444-01, *Standard practice for magnetic particle examination*

3 Terms, definitions and symbols

For the purposes of this document, the terms and definitions given in ISO 1122-1 and the symbols and units given in ISO 6336-1 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Methods for the determination of allowable stress numbers

4.1 General

Allowable stress numbers should be determined for each material and material condition, preferably by means of gear running tests. Test conditions and component dimensions should equate, as nearly as is practicable, to the operating conditions and dimensions of the gears to be rated.

When evaluating test results or data derived from field service, it is always necessary to ascertain whether or not specific influences on permissible stresses are already included with the evaluated data, e.g. in the case of surface durability, the effects of lubricants, surface roughness and gear geometry; in

1) American Society for Testing and Materials