

# Table of contents

<b>1 Technical Mathematics (TM)</b>	<b>9</b>
<b>1.1 Units of measurement</b>	
SI base quantities and base units . . . . .	10
Derived quantities and their units . . . . .	10
Non-SI units . . . . .	12
<b>1.2 Formulas</b>	
Formula symbols, mathematical symbols . . . . .	13
Formulas, equations, graphs . . . . .	14
Transformation of formulas . . . . .	15
Quantities and units . . . . .	16
Calculation with quantities . . . . .	17
Percentage and interest calculation . . . . .	17
<b>1.3 Angles and triangle</b>	
Types of angles, Pythagoras' theorem . . . . .	18
Functions of triangles . . . . .	19
<b>1.4 Lengths</b>	
Sub-dividing lengths . . . . .	20
Effective lengths . . . . .	21
Rough lengths . . . . .	21
<b>2 Technical Physics (TP)</b>	<b>29</b>
<b>2.1 Motion</b>	
Uniform motion . . . . .	30
Accelerated motion . . . . .	30
Speeds on machines . . . . .	31
<b>2.2 Forces</b>	
Addition and resolution of forces . . . . .	32
Types of forces . . . . .	34
Torque . . . . .	35
<b>2.3 Work, power, efficiency</b>	
Mechanical work . . . . .	35
Simple machines . . . . .	36
Energy . . . . .	36
Power and efficiency . . . . .	37
<b>2.4 Friction</b>	
Friction force, coefficients of friction . . . . .	38
Coefficients of rolling friction . . . . .	38
<b>2.5 Pressure in liquids and gases</b>	
Pressure . . . . .	39
Buoyancy . . . . .	39
Hydraulic power transmission . . . . .	39
Pressure intensification . . . . .	40
Flow velocities . . . . .	40
Changes of state in gases . . . . .	40
<b>2.6 Strength of materials</b>	
Load cases, stress limits . . . . .	41
<b>3 Technical Drawing (TD)</b>	<b>57</b>
<b>3.1 Graphs</b>	
Cartesian coordinate system . . . . .	58
Polar coordinate system . . . . .	59
Area graphs . . . . .	59
<b>3.2 Basic geometrical constructions</b>	
Line segments, perpendiculars, angles . . . . .	60

Tangents, circles . . . . .	61	Retaining rings, springs . . . . .	88
Inscribed circle, ellipse, spiral . . . . .	62	<b>3.7 Object elements</b>	
Cycloid, involute curve, hyperbola . . . . .	63	Bosses, object edges . . . . .	89
<b>3.3 Elements of drawing</b>		Thread runouts, thread undercuts . . .	90
Fonts . . . . .	64	Threads, screw joints . . . . .	91
Preferred numbers, radii, scales . . . . .	65	Centre holes, knurls . . . . .	92
Drawing layouts . . . . .	66	Undercuts . . . . .	93
Bills of materials, item numbers . . . . .	67	<b>3.8 Welding and soldering</b>	
Line types . . . . .	68	Graphical symbols . . . . .	94
<b>3.4 Representation</b>		Dimensioning examples . . . . .	96
Projection methods . . . . .	70	<b>3.9 Surfaces</b>	
Views . . . . .	72	Hardness specifications in drawings . .	98
Sectional views . . . . .	74	Form deviations, roughness . . . . .	99
Hatching . . . . .	76	Surface testing, surface indications .	100
<b>3.5 Dimensioning drawings</b>		Achievable roughness . . . . .	102
Dimension lines, dimension numbers . . . . .	77	Tooth forming quality . . . . .	103
Dimensioning rules . . . . .	78	<b>3.10 Tolerances, fits</b>	
Elements of drawing . . . . .	79	Fundamentals . . . . .	104
Tolerance specifications . . . . .	81	ISO fits . . . . .	106
Types of dimensioning . . . . .	82	General tolerances . . . . .	112
Simplified presentation in drawings . . . . .	84	Antifriction bearing fits . . . . .	112
<b>3.6 Machine elements</b>		Fit recommendations, possible fits . .	113
Gear types . . . . .	85	Geometrical product specification . .	114
Antrifiction bearings . . . . .	86	Geometrical tolerances . . . . .	116
Seals . . . . .	87		

## 4 Materials Science (MS)

119

<b>4.1 Materials</b>		Types of cast iron materials . . . . .	168
Material characteristics . . . . .	120	<b>4.7 Foundry technology</b> . . . . .	171
Periodic table of the elements . . . . .	122	<b>4.8 Light alloys</b>	
Chemicals used in metal technology . . . . .	123	Overview of aluminium alloys . . . . .	173
<b>4.2 Steels, designation system</b>		Wrought aluminium alloys . . . . .	175
Definition and classification . . . . .	124	Aluminium casting alloys . . . . .	177
Standardisation of steel products . . . . .	125	Aluminium profiles . . . . .	178
Material numbers . . . . .	126	Magnesium and titanium alloys . . . .	181
Designation system . . . . .	127	<b>4.9 Heavy metals</b>	
<b>4.3 Steel types</b>		Designation system . . . . .	183
Overview of steel products . . . . .	131	Copper alloys . . . . .	184
Overview of steels . . . . .	132	<b>4.10 Other materials</b> . . . . .	186
Structural steels . . . . .	134	<b>4.11 Plastics</b>	
Case hardened steels . . . . .	137	Overview . . . . .	188
Quenched and tempered steels . . . . .	138	Thermosets . . . . .	191
Tool steels . . . . .	140	Thermoplastics . . . . .	192
Stainless steels . . . . .	141	Elastomers, foam materials . . . . .	195
Spring steels . . . . .	143	Plastics processing . . . . .	196
Steels for bright steel products . . . . .	144	Polyblends, laminated materials . . .	197
<b>4.4 Steels, finished products</b>		Testing of plastics . . . . .	198
Sheet and strip metal, tubes . . . . .	146	<b>4.12 Material testing</b>	
Profiles . . . . .	150	Overview . . . . .	199
Linear and area mass density . . . . .	159	Tensile testing . . . . .	201
<b>4.5 Heat treatment</b>		Notched-bar impact test, rotary bending test . . . . .	202
Crystal lattices, alloy systems . . . . .	160	Hardness test . . . . .	203
Iron-carbon phase diagram . . . . .	161	<b>4.13 Corrosion, corrosion protection</b> . .	206
Heat treatment of steels . . . . .	162		
<b>4.6 Cast iron materials</b>			
Designation, material numbers . . . . .	167		

<b>5 Machine Elements (ME)</b>	<b>207</b>
<b>5.1 Threads</b>	
Types of threads, overview . . . . .	208
Thread standards of various countries . . . . .	209
Metric ISO thread . . . . .	210
Other types of threads . . . . .	211
Thread tolerances . . . . .	213
<b>5.2 Bolts and screws</b>	
Types of bolts and screws, overview . . . . .	214
Designation . . . . .	215
Property . . . . .	216
Hexagon head bolts and screws . . . . .	217
Cap screws . . . . .	220
Other bolts and screws . . . . .	221
Calculation of screw joints . . . . .	226
Locking fasteners, overview . . . . .	228
Bolt and screw drive systems . . . . .	229
<b>5.3 Countersinks</b>	
Countersinks for countersunk head screws . . . . .	230
Counterbores for cap screws . . . . .	231
<b>5.4 Nuts</b>	
Nut types, overview . . . . .	232
Designation . . . . .	233
Property . . . . .	234
Hexagon nuts . . . . .	235
Other nuts . . . . .	236
<b>5.5 Washers</b>	
Washers, overview . . . . .	239
<b>6 Production Engineering (PE)</b>	<b>277</b>
<b>6.1 Measurement technology</b>	
Measuring instruments . . . . .	278
Measurement result . . . . .	279
<b>6.2 Quality management</b>	
Standards, terminology . . . . .	280
Quality planning, quality testing . . . . .	282
Statistical analysis . . . . .	283
Quality capability . . . . .	285
Statistical process control . . . . .	286
<b>6.3 EU machinery directive</b>	289
<b>6.4 Production organization</b>	
Product breakdown structure . . . . .	291
Work planning . . . . .	293
Cost accounting . . . . .	297
<b>6.5 Maintenance</b>	
Maintenance, repair service . . . . .	300
Maintenance concepts . . . . .	301
<b>6.6 Machine processes</b>	
Documentation system . . . . .	303
Material removal rate . . . . .	304
Forces while machining . . . . .	305
Speed graph . . . . .	306
Cutting materials . . . . .	308
Indexable inserts . . . . .	310
Tool holding fixtures . . . . .	311
Flat washers . . . . .	240
Other washers . . . . .	241
<b>5.6 Pins and bolts</b>	
Designs, overview . . . . .	242
Dowel and spring pins . . . . .	243
Grooved pins, clevis pins . . . . .	244
<b>5.7 Shaft-hub connections</b>	
Connection, overview . . . . .	245
Keys . . . . .	246
Parallel keys, woodruff keys . . . . .	247
Tool tapers . . . . .	248
<b>5.8 Other machine elements</b>	
Springs . . . . .	249
Grub screws, thrust pads, ball knobs . . . . .	252
Knobs, locating bolts . . . . .	253
Quick-release drilling fixture . . . . .	255
<b>5.9 Drive elements</b>	
Belts . . . . .	257
Spur gears, dimensions . . . . .	260
Bevel gears, worm drive, dimensions . . . . .	262
Gear ratios . . . . .	263
<b>5.10 Bearings</b>	
Plain bearings . . . . .	264
Antifriction bearings . . . . .	266
Lubricating oils and lubricating greases . . . . .	275
Cooling lubrication . . . . .	312
Turning . . . . .	314
Milling . . . . .	326
Drilling, countersinking, reaming . . . . .	337
Grinding . . . . .	343
Honing . . . . .	348
CNC machining, zero and reference point . . . . .	349
Tool offsets, path corrections . . . . .	350
CNC production according to DIN . . . . .	351
CNC turning according to PAL . . . . .	354
CNC milling according to PAL . . . . .	360
<b>6.7 Material removal</b>	
Wire spark eroding, sink EDM . . . . .	369
Parameters . . . . .	370
<b>6.8 Separation by cutting</b>	
Cutting force, presses . . . . .	371
Cutting tool . . . . .	372
Tool and workpiece dimensions . . . . .	374
Strip stock utilization . . . . .	375
<b>6.9 Forming</b>	
Bending: tool, procedure . . . . .	376
Bending radius, blank size . . . . .	378
Deep drawing: tool, procedure . . . . .	380
Blank diameter, drawing gap . . . . .	382

<b>6.10</b>	<b>Injection moulding</b>		
	Injection moulding tools .....	384	
	Shrinkage, cooling, batching .....	387	
<b>6.11</b>	<b>Joining</b>		
	Welding processes, overview .....	389	
	Weld preparation .....	391	
	Gas-shielded welding .....	392	
	Arc welding .....	394	
	Beam cutting .....	396	
<b>6.12</b>	<b>Workplace and environmental protection</b>		
	Gas cylinders labelling .....	398	
	Soldering .....	400	
	Bonding .....	403	
<b>7</b>	<b>Automation and Information Technology (AT)</b>	<b>419</b>	
<b>7.1</b>	<b>Pneumatics, hydraulics</b>		
	Circuit symbols, directional control valves .....	420	
	Proportional valves .....	422	
	Circuit diagrams, designation systems .....	425	
	Pneumatic control .....	427	
	Pneumatic cylinders .....	428	
	Hydraulic and pneumatic cylinders, hydraulic pumps .....	429	
	Pipes .....	431	
<b>7.2</b>	<b>Grafset</b>		
	Basic structure .....	432	
	Steps, transitions .....	433	
	Actions .....	434	
	Branching .....	436	
<b>7.3</b>	<b>Electropneumatics, electrohydraulics</b>		
	Circuit symbols .....	438	
	Circuit diagrams designation .....	439	
	Sensors .....	441	
	Electro-pneumatic control .....	442	
	<b>7.4</b>	<b>PLC controls</b>	
	PLC programming languages .....	443	
	Binary logic .....	447	
	Sequence controls .....	448	
	<b>7.5</b>	<b>Control technology</b>	
	Basic terminology, code letters .....	450	
	Symbols .....	451	
	Controllers .....	452	
	<b>7.6</b>	<b>Handling and robot systems</b>	
	Coordinate systems, axes .....	454	
	Robot designs .....	455	
	Grippers, job safety .....	456	
	<b>7.7</b>	<b>Motors and drives</b>	
	Safety precautions, protection types .....	457	
	Electric motors, connections, calculations .....	459	
<b>International standards</b>		<b>461 ... 465</b>	
<b>List of standards</b>		<b>466 ... 470</b>	
<b>Subject index</b>		<b>471 ... 482</b>	