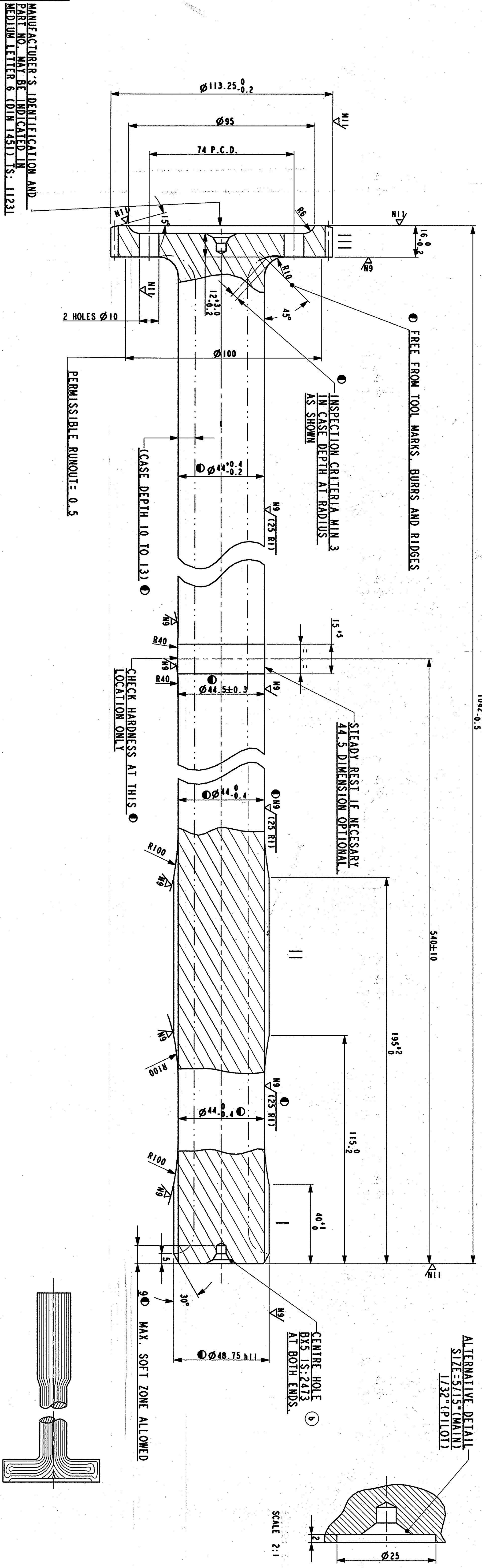




MANUFACTURER'S IDENTIFICATION AND PART NO. MAY BE INDICATED IN MEDIUM LETTER 6 (DIN 1451) TS. 11231

INVOLUTE SPLINE DATA

NO. OF TEETH	38	35
MODULE	1.25	3.15
PRESSURE ANGLE	30°	25°
BASE CIRCLE DIAMETER	41.13643 99.92068	
FLANK CLEARANCE TO THE TOOTH FLANK	0.05±0.02 0.04±0.03	
CUTTER ADDENDUM	-	2.2
SPAN MEASUREMENT OVER 6 TEETH	-	52.280 52.180
BALL OR ROLLER DIA.	2.3	
MEASUREMENT OVER BALLS/ROLLERS	ACTUAL 30.72 30.82 30.88	THEORETICAL 30.88

INVOLUTE SPLINE DATA

MAX. PITCH ERROR FROM TOOTH TO TOOTH	0.010
TOTAL PITCH ERROR	0.030
MAX. RUNOUT ON PITCH CIRCLE Ø	0.080
MAX. RUNOUT ON OUTSIDE Ø	0.150
TOTAL LEAD ERROR OVER 25 mm	0.020
TOTAL DEVIATION OF INVOLUTE	0.025
MAX. BASE CIRCLE DEVELOPMENT	0.005

TESTING NOTES:-

- 1) 100% HARDNESS AND CRACK TESTING TO BE DONE.
- 2) 1 IN EVERY 200 SHAFTS TO BE SECTIONED AND CHECKED FOR FLOW LINES, DECARBURISATION & MICROSTRUCTURE.
- 3) MAX. DEPTH OF DECARBURISATION - 0.05mm
- 4) RUNOUT NEAR NECK, CENTRE OF SHAFT & NEAR SPLINE SHOULD NOT EXCEED 0.7, 0.7, 0.15 T.I.R. RESPECTIVELY.

CRITICAL DIMENSIONS/PARAMETERS

MATERIAL	TEMPERED CASE HARDENED & TEMPERED (T14) Kg/mm ² Ⓢ	CASE DEPTH mm Ⓢ
40Cr-4Mn-3-Si-40Cr-27	70-85	10-12
40Cr-41Cr-1H	80-95	10-12
SS-4027	100-110	10-12

MATERIAL AND HEAT TREATMENT:-

PART NO.	REMARKS	WEIGHT
2614 3570 79.02 N	WITH SPLINES II	13.5
2614 3570 79.03 N	WITHOUT SPLINES II	13.3

SPLINE DETAIL - II

SPLINE DETAIL - III

FLANGE END TO BE FORMED BY UPSETTING OR SIMILAR OPERATION TO PRODUCE A UNIFORM RADIAL GRAIN FLOW.