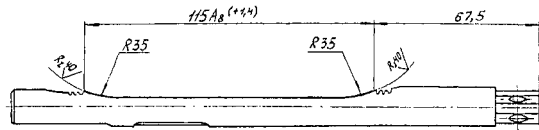


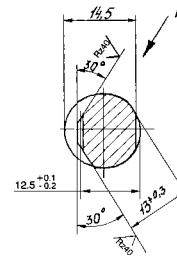
DRAWING NUMBER  
20.27.75.4

SHEET No. 1 OF 1

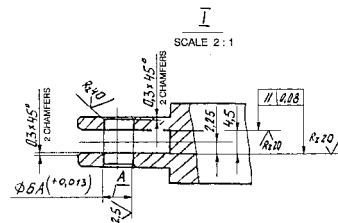
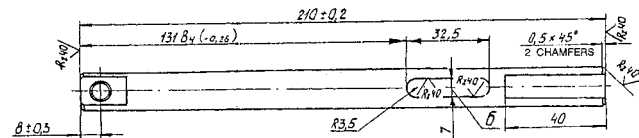
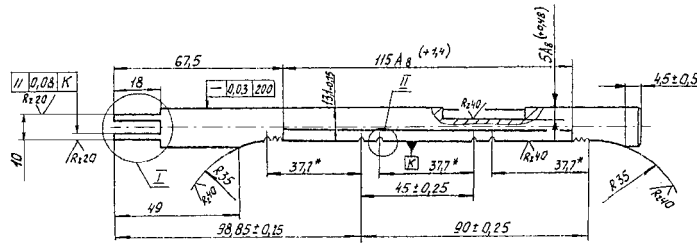
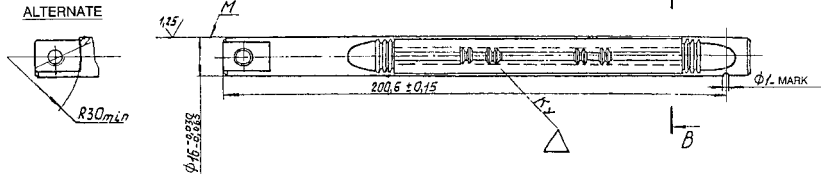
VIEW - I' ALTERNATE REVOLVED



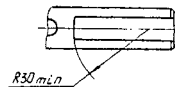
B - B  
SCALE 2:1



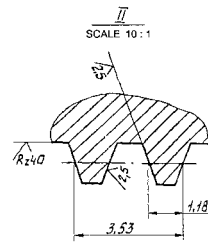
ALTERNATE



ALTERNATE



II  
SCALE 10:1



MODULE	m	0.75
PITCH	t	2.356
MEASUREMENT		
HEIGHT	h	0.75
PRESSURE ANGLE	L	20°
TOOTH THICKNESS	S	1.18
BASIC RACK		GOST 9537-68
NUMBER OF TEETH OVER	Z	16
LENGTH L =		37.7
TOOTH HEIGHT	PH	1.625

- INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11
- HB 241 TO 285: d = 3.6 TO 3.9
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:  
FOR HOLES - AS PER A7  
FOR SHAFTS - AS PER B7  
FOR OTHERS - AS PER CM7
- SHIFT AND ANGULAR DISPLACEMENT OF THE AXIS OF SPLINE B FROM CENTRE PLANE, WHICH IS PERPENDICULAR TO PLANE K SHOULD BE NOT MORE THAN 0.2 mm.
- NON-SQUARENESS OF THE GENERATRIX OF THE TOOTH CONTACT SIDE, MEASURED IN THE PITCH LINE, WITH THE AXIS OF SURFACE M SHOULD NOT EXCEED 0.04 mm OVER THE TOOTH WIDTH.
- NON-SQUARENESS OF THE AXIS OF HOLE A WITH PLANE WHICH GOES THROUGH THE GENERATRIX OF THE TOOTH CONTACT SIDES ALONG THE PITCH LINE SHOULD BE NOT MORE THAN 0.05 mm OVER THE LENGTH OF 12 mm.
- COATING: ZINC-CHROMATISED, 6 MICRONS THICK, OILED CHECK DIMENSIONS, EXCEPT FOR HOLE A, BEFORE APPLYING COATING.
- \* DIMENSIONS ARE GIVEN FOR REFERENCE.

9. EXPLANATORY NOTE :-

MATERIAL QUOTED :- 45 GOST 1050-74  
HOT ROLLED CARBON STRUCTURAL STEEL.

CHEMICAL COMPOSITION :- %

CARBON	= 0.42 - 0.50
SILICON	= 0.17 - 0.37
MANGANESE	= 0.50 - 0.80
CHROMIUM	= 0.25 (MAX)
SULPHUR	= 0.040 (MAX)
PHOSPHORUS	= 0.035 (MAX)
COPPER	= 0.25 (MAX)
NICKEL	= 0.25 (MAX)

MECHANICAL PROPERTIES :-

YIELD POINT	= 36 Kg/mm <sup>2</sup> (MIN)
ULTIMATE TENSILE STRENGTH	= 81 Kg/mm <sup>2</sup> (MIN)
PERCENTAGE OF ELONGATION	= 18 % (MIN)
REDUCTION OF AREA	= 40% (MIN)
IMPACT STRENGTH	= 5 Kgmm <sup>2</sup> (MIN)

DRN	Sd/=	MATERIAL :-	USED ON :-
CHD	Sd/=	45 GOST 1050-74	Cb 20.27.00.4
APFD	Sd/=	CONTROLLER/ATY OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	08.03.87	AVADI	
SCALE :- 1:1		TITLE :-	
DIMENSIONS IN mm		CONTROL RACK	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
EST. WT. (kg)	0.245	ISSUE	DATE
TO BE STAMPED OR MARKED WHERE INDICATED THIS # ( LETTERS)		NATURE OF AMENDMENTS	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			

DRAWING RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 20 (G. JAYAVELU), (TODI), 17-10-2007.

SIZE A1