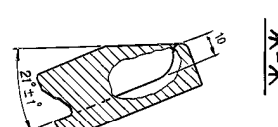
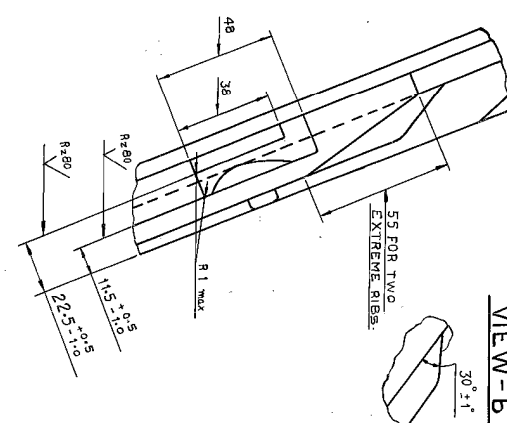


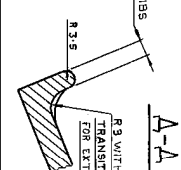
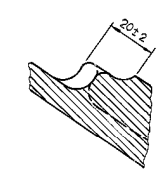
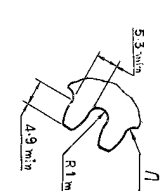
VIEW-B



MODULE	NUMBER OF TEETH	PROFILE ANGLE	ADDENDUM COEFFICIENT	LIMIT HEIGHT COEFFICIENT	CURVATURE RADIUS COEFFICIENT	OF FILLET CURVE	RADIAL BACKLASH FACTOR	TOOTH THICKNESS ALONG REFERENCE STRAIGHT LINE	ADDENDUM MODIFICATION COEFFICIENT	ACCURACY DEGREE TO ROOT 1645-81	BASE TANGENT LENGTH	REFERENCE DIAMETER	ROOT CIRCLE DIAMETER	CURVATURE RADIUS OF TOOTH PROFILE IN CONTACT AT LOWER POINT	NUMBER OF SECTOR TEETH	DEMAGINATION OF MATING GEAR DRAWING
z	w	2.5	1	2.0	2.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
2	2.5	20°	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
4	4.0	20°	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
6	6.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
8	8.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
10	10.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
12	12.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
14	14.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
16	16.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
18	18.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
20	20.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
22	22.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
24	24.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
26	26.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
28	28.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
30	30.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
32	32.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
34	34.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
36	36.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
38	38.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
40	40.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
42	42.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
44	44.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
46	46.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
48	48.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
50	50.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
52	52.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
54	54.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
56	56.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
58	58.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
60	60.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
62	62.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
64	64.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
66	66.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
68	68.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
70	70.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
72	72.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
74	74.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
76	76.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
78	78.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
80	80.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
82	82.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
84	84.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
86	86.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
88	88.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
90	90.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
92	92.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
94	94.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
96	96.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
98	98.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81
100	100.0	2.2	1.0	1.0	1.0	1.0	0.25	0.8	X	8-9	1645-81	1645-81	1645-81	1645-81	1645-81	1645-81

1. TOOTHING ON GEAR TO WITHIN 0.25 mm DEPTH ON GEAR TOOTH SURF.
2. REMAINING SECTION GEAR DEPTH 0.10 mm TO 0.15 mm.
3. SUBSTITUTE FOR MATERIAL - STEEL, ALX FOR 4543-71.
4. UNSPECIFIED RAIL - 6 mm MAXIMUM.
5. UNSPECIFIED LIFT DEVIATIONS OF SLEETS AFTER REMOVAL OF LAYER OF METAL: FOR RIGLES - ACCORDING TO A1, FOR SHAFTS ACCORDING TO B1, OTHERS - ACCORDING TO CMB.
6. DEFECTS UP TO 1 mm DEEP ON UNMACHINED SURFACES ARE TOLERABLE.
7. IT IS ALLOWED TO MANUFACTURE ACCORDING TO THICKENED DASH-AND-DOT LINE.
8. OTHER REQUIREMENTS TO FORGING - ACCORDING TO CLASS II TOCT 7606-74.
9. TEETH WHICH ARE LESS THAN 0.5 OF TOOTH IN SIZE ARE SUBJECT TO REMOVAL.
10. PROTECTION OF SURFACE IF BEYOND TOOTH PROFILE IS NOT TOLERABLE.
11. GEAR SIZE 12 BEYOND THERMAL TREATMENT.
12. SIZES IN BRACKETS - AFTER ASSEMBLY.
13. IT IS ALLOWED TO CHECK RINGOUT OF SECTION TOOTHING WHEN IT IS CLAIMED ON MILLING MACHINE AFTER TOOTH HAS BEEN FINALLY MACHINED.
14. DATA FOR CHECKING - ACCORDING TO ACCURACY SPECIFICATIONS TO TOCT 1643-91, CHECK RELATIVE TO AXIS OF ROTATION AND SURFACE KA.
15. COATING - CH, OX, OILED.
16. TOL. TRACES NOT MORE THAN 0.2 mm DEEP ON SURFACE A¹ ARE TOLERABLE.
17. THE FOLLOWING DETAILS ARE TO BE ENGRAVED/STAMPED WITH LETTER SIZE 6 mm X 0.5 mm WIDE X 0.3 mm DEEP AT (ZONE D-E19) PLACE MARKED XXX AT THE TIME OF FORGING AND MACHINING.
 - a) MANUFACTURER'S INITIAL.
 - b) YEAR OF MANUFACTURE.
 - c) FORGING NUMBER.
 - d) SERIAL NUMBER.
18. IF IT IS DIFFERENT THAN FORGE NUMBER.

OR
BUT MAO, CONDITION 'V' TO BS: 970, T-1-1983



DATE	TIME	LOCATION	ZONE	NATURE	SIG CLASS
0208H	1817A-W			DRG. SELED. CANCELLED	DRG
0208H	1640Z-W			DRG. SELED. PROV.	DRG
0208H	1518Z-W			NOTE NO 16 ADDED.	NOTE
0208H	1505Z-W			RETRACED WITHOUT CHANGE	RETRACED

[illegible]

SECTOR सेक्टर

प्रश्न

675-54-190