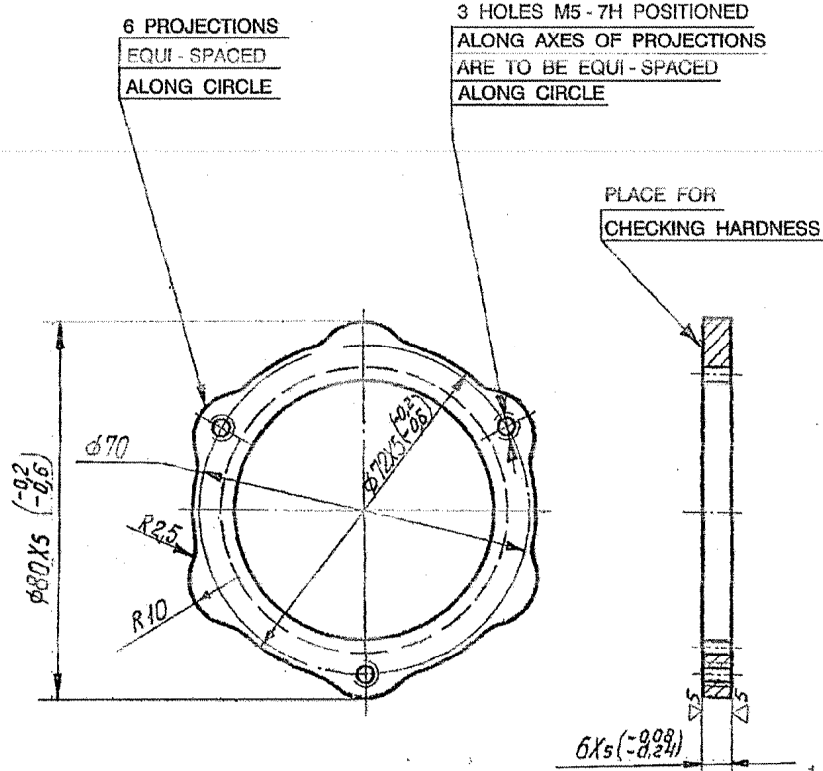


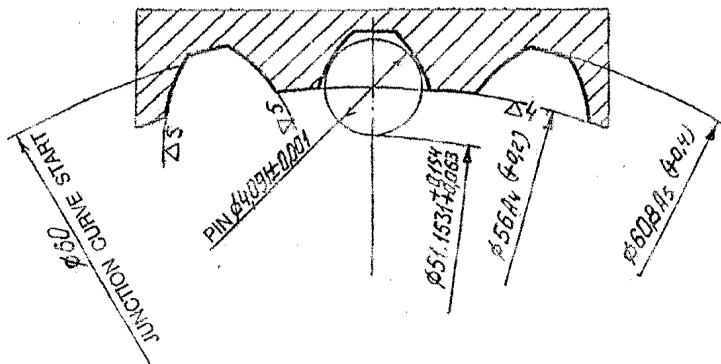
DRAWING NUMBER
175.41.011

SHEET No. 1 OF 1

UNLESS OTHERWISE SPECIFIED Rz 80/√(✓)



PROFILE OF INVOLUTE SPLINES $\phi 60 \times 2 \times 28 \text{ } 3 \alpha$
SCALE 5:1



1. THE COMPONENT MAY BE MANUFACTURED FROM STEEL 38XC GOST 4543 - 71 BHN 341 - 285 (DIA OF INDENTATION 3.3 - 3.6)
2. BHN 321 - 269 (DIA OF INDENTATION 3.4 - 3.7)
3. WARPAGE OF WASHER SURFACE IS 0.2 MM MAXIMUM.
4. THE SPLINES ARE TO BE CHECKED FOR INTERCHANGEABILITY BY SPLINE GAUGE. DIMENSIONS OF SPLINES ARE GIVEN FOR MANUFACTURING TOOLS AND ARE NOT TO BE CHECKED.
5. LOCATION OF SPLINES AND PROJECTIONS R10 OPTIONAL.
6. SHIFT OF HOLES M5 - 7H FROM TRUE POSITION IS 0.3 MM MAXIMUM.
7. SHIFT OF PROJECTIONS AXES FROM TRUE POSITION IS 0.2 MM MAXIMUM.
8. TO BE MARKED ON FACES WITH ACID.
9. COATING : OXIDIZING / PHOSPHATING.

BASIC RACK	MODULE	<i>m</i>	2	FOR CHECK	NOMINAL THICKNESS OF TEETH ALONG REFERENCE CIRCLE ARC OF COMPLEX GAUGE 4.297
	NUMBER OF TEETH	<i>z</i>	28		
PROFILE ANGLE	<i>α</i>	30°	FOR REFERENCE	DIMENSION Ø 60, MINIMUM IS TO BE CHECKED BY COMPLEX GAUGE	
REFERENCE DIAMETER	<i>d_a</i>	56			
ADDENDUM MODIFICATION SHIFT	<i>x</i>	1		DIMENSION Ø 60.8 - BASIC FOR CUTTING TOOL	
TOOTH SPACE WIDTH ALONG REFERENCE CIRCLE ARC	<i>s</i>	4.297 +0.085 +0.035			

EXPLANATORY NOTE :-

THE COMPONENT SHOULD BE MANUFACTURED FROM PLATE AND WIDE STRIP UNIVERSAL ALLOYED HIGH - GRADE SPECIAL STEEL OF GRADE 30XГ CA - 3 (3 - CATEGORY) TO SPECN. GOST 11269 - 76.

ALTERNATIVE :- GRADE FROM 38XC TO GOST 4543 - 71.

CHEMICAL COMPOSITION % :- AS PER GOST 4543 - 71.

GRADE OF STEEL	C	Si	Mn	Cr	S	P	Ni	Cu
30XГ CA - 3	0.28 - 0.34	0.90 - 1.20	0.80 - 1.10	0.80 - 1.10	0.035	0.035	0.30	0.30
30XC	0.34 - 0.42	1.00 - 1.40	0.30 - 0.60	1.30 - 1.60	0.035	0.035	0.30	0.30

MECHANICAL PROPERTIES :-

MECHANICAL PROPERTIES OF GRADE 30XГ CA - 3 TO GOST 11269 - 76.

MECHANICAL PROPERTIES OF GRADE 38XC TO GOST 4543 - 41 ARE AS UNDER

GRADE OF STEEL	UTS Kgf / mm ²	RELATIVE ELONGATION %	YIELD POINT Kgf / mm ²	REDUCTION OF AREA %	IMPACT STRENGTH Kgm / cm ²
30XГ CA - 3	50 - 75	16	—	—	—
30XC	95	12	75	50	7

Ⓟ ALT. MATERIAL :- STEEL 817 M40 (EN - 24) TO BS 970 - PART - 1:1983.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. (Kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.068	

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	Sd / =	MATERIAL :-	USED ON :-
CHD	Sd / =	STEEL 38XГ CA - 3	175.41.008cb-1
APPD	Sd / =	GOST 11269 - 76	172.45.060cbCb
DATE	14 - 06 - 88	188.45.001cb-3Cb ⓅA	
SCALE :-	1 : 1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102 - 69		LOCKING WASHER	
5B 14.1.06 AUTHY L1No.8000V/CQAHV/GEN DI.15.10.05		D S CAT NUMBER	DRAWING NUMBER
5A 25.10.04 N OF A. No. CQA(HV)/T90/45/001			175.41.011
ISSUE DATE NATURE OF AMENDMENTS			

IRRAMANI, JTO
12-01-06

" COMMON TO T - 90 " DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

KVD No. 72563

F - 79
SIZE A2