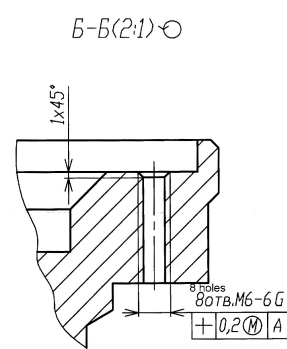
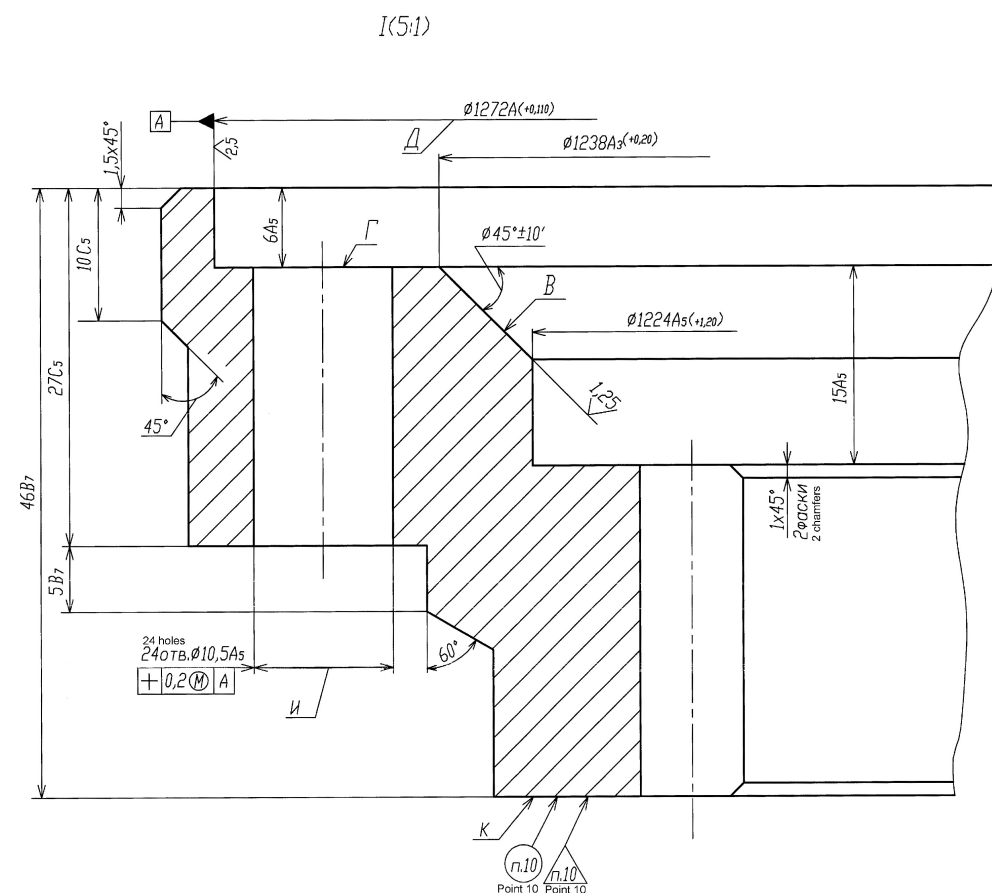
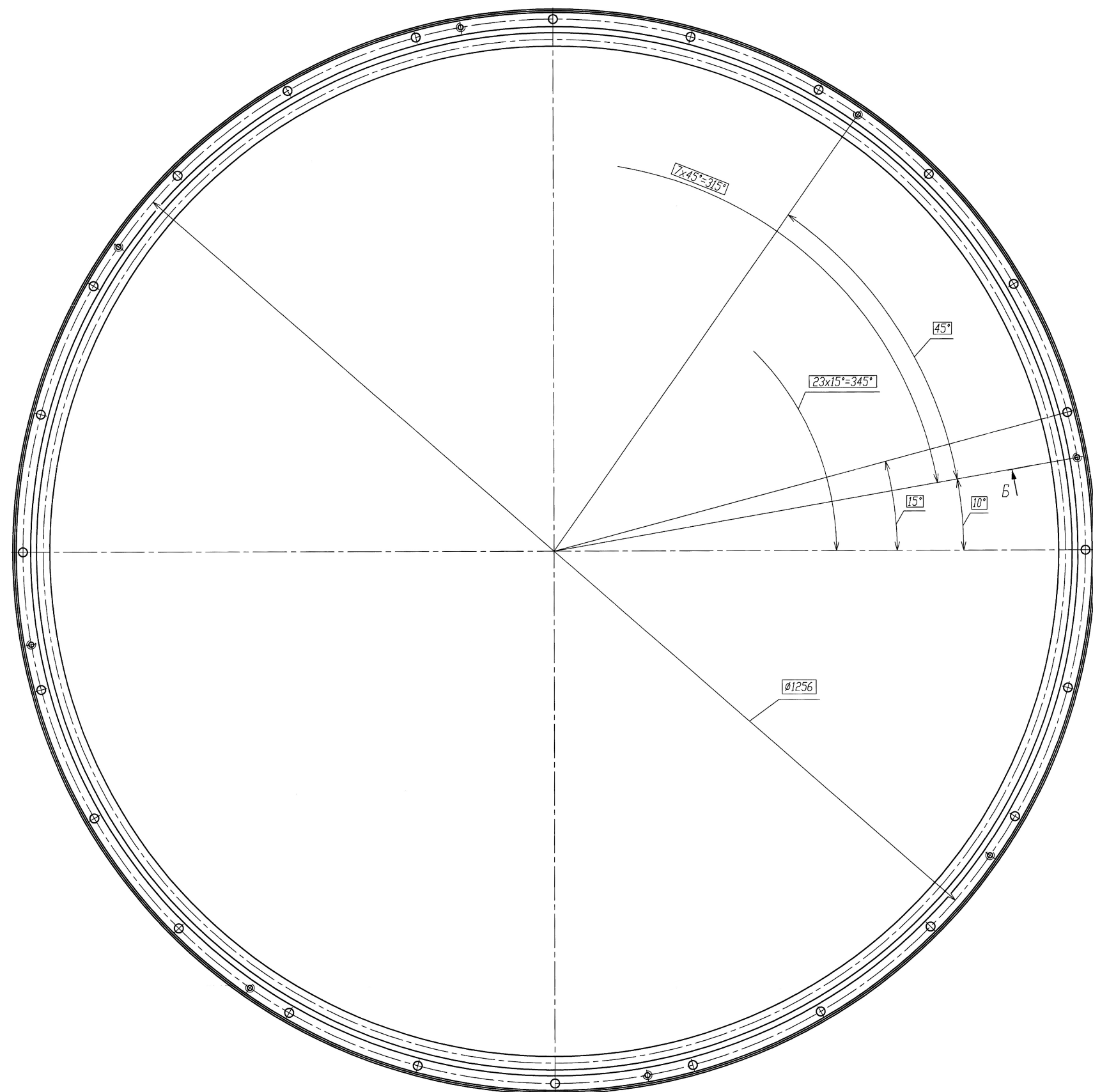


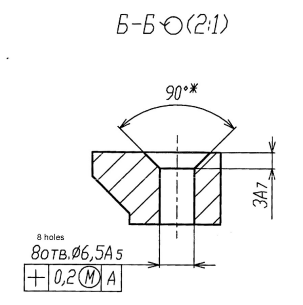
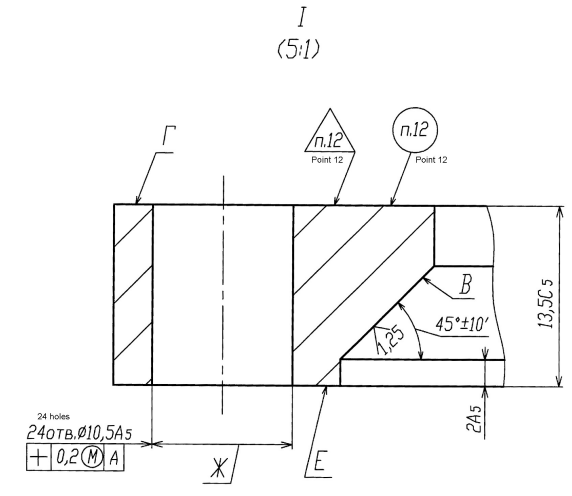
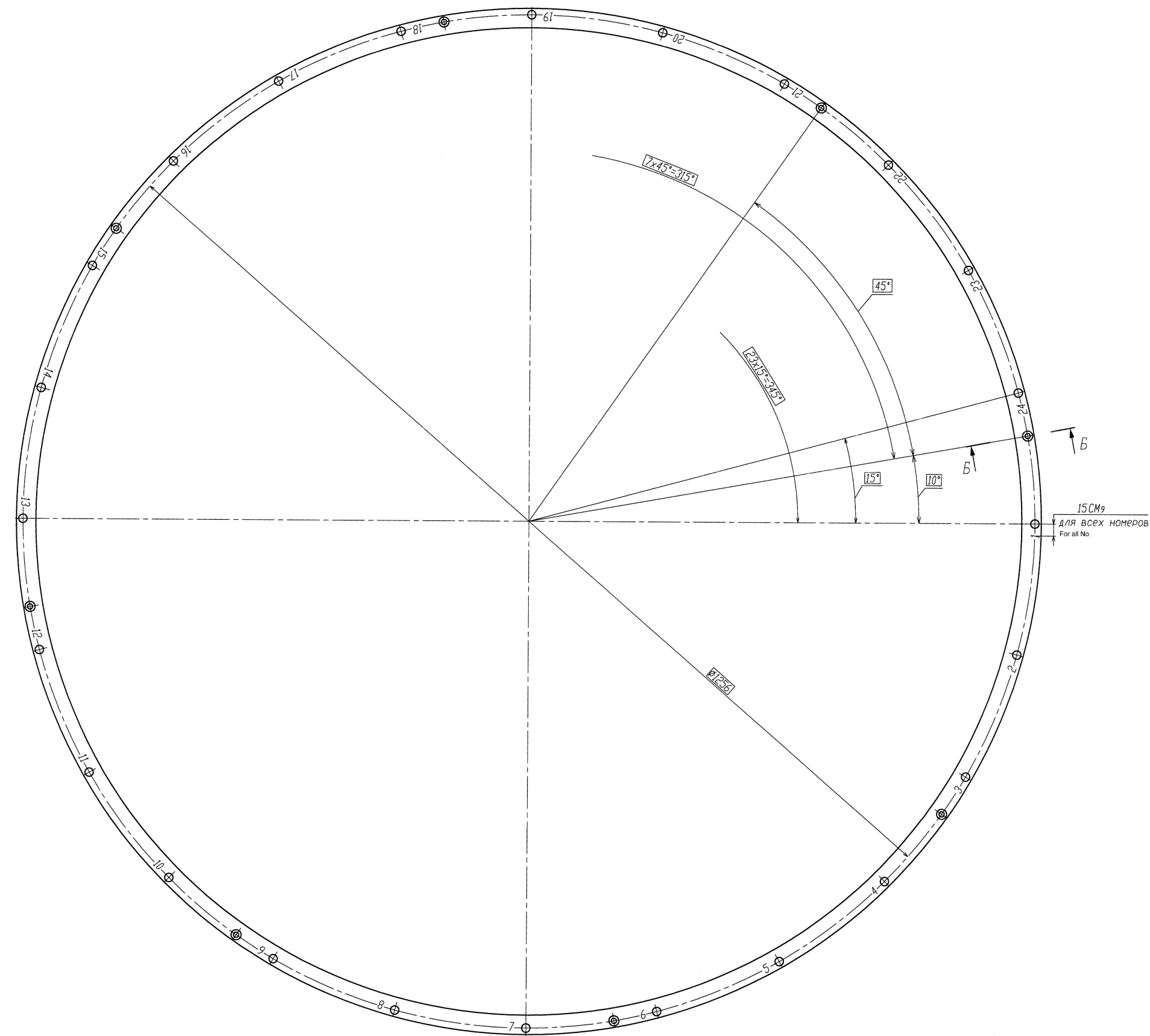
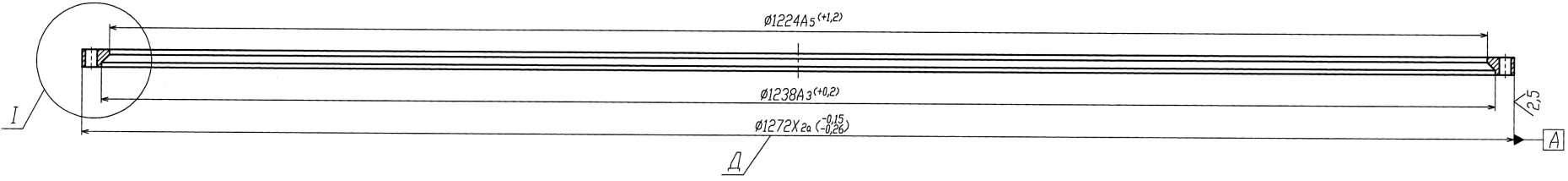
Module	<i>m</i>	4
No. of teeth	<i>Z</i>	300
Standard reference contour		ГОСТ 13755-81
Shafting coefficient	<i>X</i>	0
Accuracy grade as per GOST 1643-81		8-100C
Data for checking of relative positions of unlike profiles of teeth	<i>W</i>	$412,38^{+0,185}_{+0,080}$
Dividing diameter	<i>d</i>	1200
Drawing designation of adjoining wheels		AK-630 104-19



- Substitute - material - steel 30X13 GOST 5632-72.
- 363-429 HB, check on surface K four equidistant point.
- Internal angles **** 0.4 mm.
- Blunt sharp edges **** 0.4 mm.
- Run out of surface B relative to surface D and surface F should not be above 0.05 mm. Run out of surface E relative to surface Ж should not be above 0.1 mm.
- Non-roundness of surfaces D,Ж,З should not be above 0.15 mm. It is permissible to check the run out as per points and non-roundness as per point 6 on industrial machine in fastened position.
- Non-level of surface F should not be above 0.5 mm check it on testing plate or ring.
- Machining of hole H together with comp. AK-630 119-2 is permissible.
- Rectification of component is not permissible.
- Mark Ш,Ч,Н with font PO-5 GOST 2930-62 and stamp К,И as per AK-630, AK-630M TU 1.
- Select set of test as per GOST 1643-81 and fix as per the conditions and serviceability of factory.

AK-630 119-1						
Amend	Sheet	Doc. No.	Sign	Date		
Lower ring				Type	Weight	Scale
				A	26	1:2
Head of G.C.D.				Sheet	Sheets 1	
Steel 20X13 GOST 5632-72						

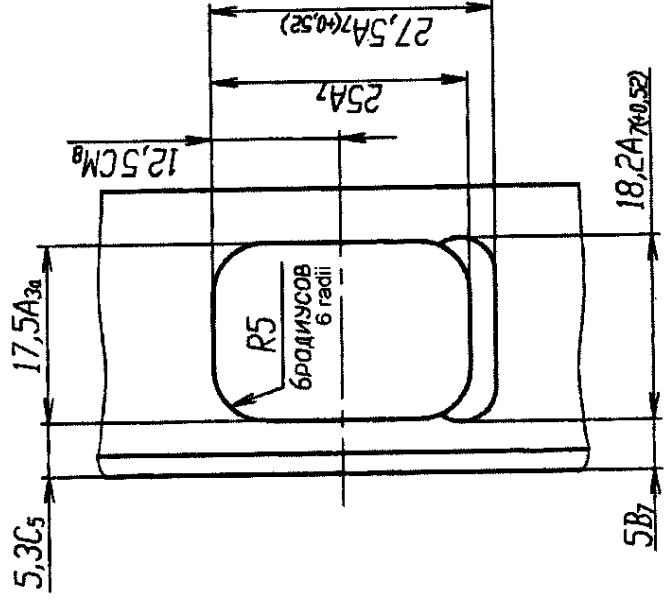
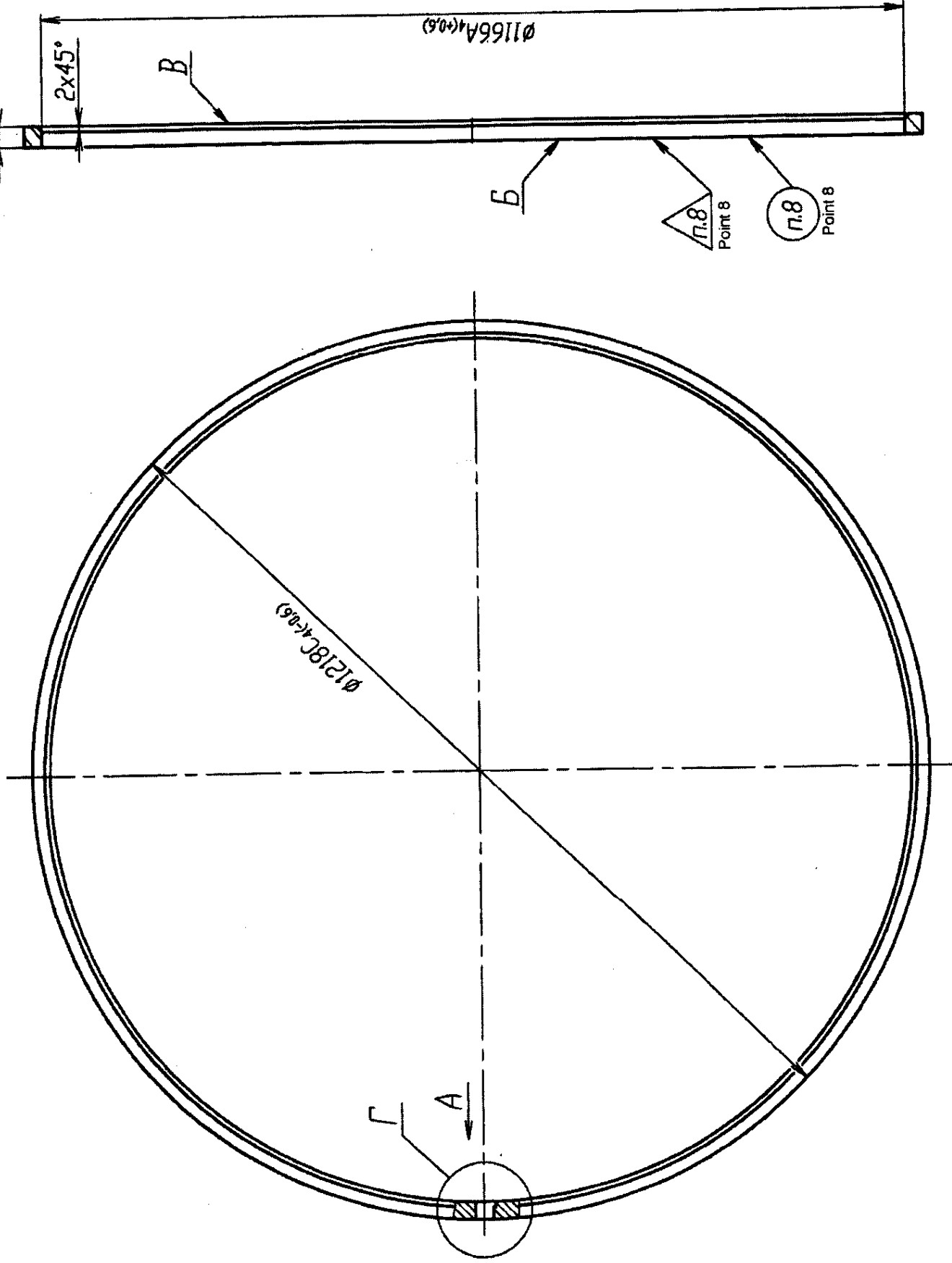
AK-630 119-1



1. Alternate - material - steel 30A13 GOST 5632-72
2. 30A42 HB, check on surface F at 4 equal instant points
3. *Dimensions are given in mm.
4. Internal angles R = 0,4 mm.
5. Chamfered edges R = 0,4 mm.
6. Non-roughness of surface B should not be more than 0,2 mm.
7. Non-roughness of surface D should not be more than 0,2 mm.
8. Non-roughness of surface E should not be more than 0,2 mm. Check on test plate or ring.
9. It is permissible to machine the hole K together with comp. AK-630 114-1.
10. Rectification of component is not permissible.
11. Engage letter on PCS GOST 2304-62.
12. Mark U11 with engraving letter PC-G GOST 2005-62 and stamp K.M as per AK-630, AK-630M T2. 1

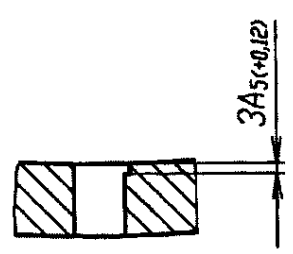
Item	Doc. No.	Sign	Date	Type	Weight	Count
Checked by				Upper ring	0,8	1,2
Designed by						
Material						
Heat treatment						
Heat of stamp						
Heat of QC						
Approved by						

Inv. No. | Sign & Date | Alterations Inv. No. | Duplicate Inv. No. | Spec. & Date | Refer. No. | Firm remarks



1. Alternate internal - steel 30X13 GOST 5632-72.
2. 363-429 HB, to be checked on surface B at 4 equidistant points.
3. Internal angles $R \approx 0.4$ mm.
4. Blunt sharp edges ≈ 0.4 mm.
5. In case of receiving of ready made preconditioned ring, non-roundness may be allowed up to 1 mm.
6. Non- flatness of surface B should not be more than 0.5 mm. Carry out test on test plate or ring.
7. Straightening of parts is not permitted.
8. Mark Ш, Ч, Н with letter PO-5 GOST 2930-62 and stamp К, И as per AK-630, AK-630M TU 1.

Г (1:2)



Inv. No.	Sign and Date	Alternate Inv. No.	Duplicate Inv. No.	Refer. No.	First remarks
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AK-630 119-25		Internal ring		Type	Weight	Scale
Steel 20X13 GOST 5632-72		Internal ring		A	16.61	1:5
Approved by		Checked by		Sheet		Sheets 1
Head of OCD		Technician		Sheet		Sheets 1
Sign		Date		Sheet		Sheets 1
Doc. No.		Sign		Sheet		Sheets 1
Date		Date		Sheet		Sheets 1