

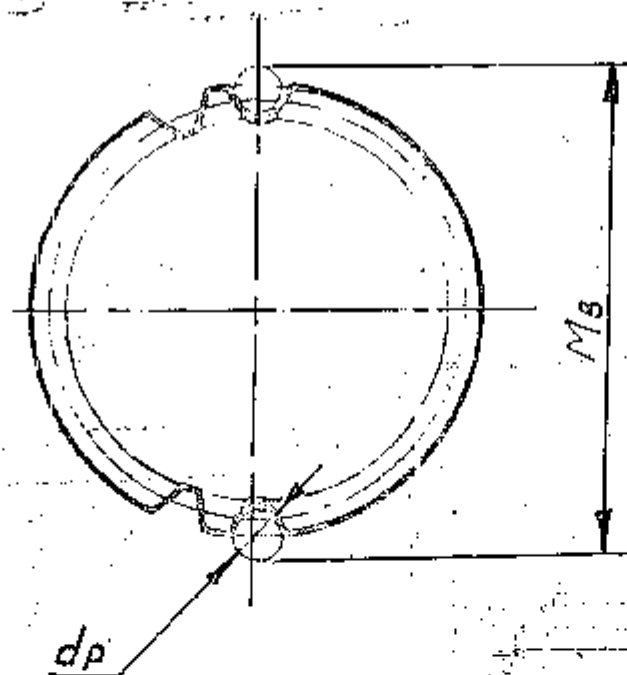
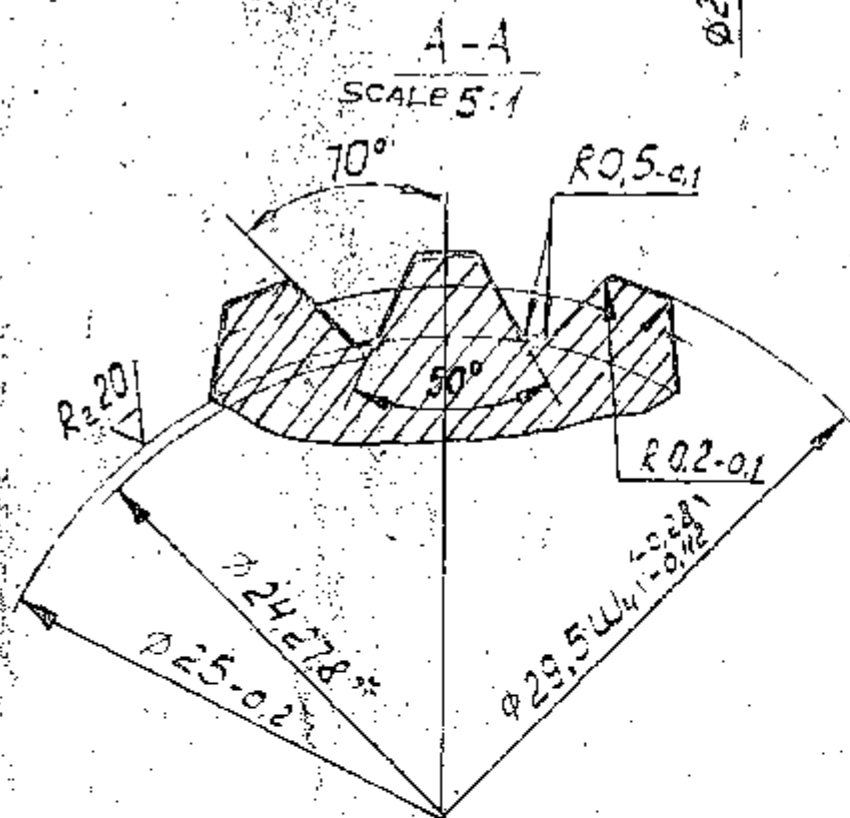
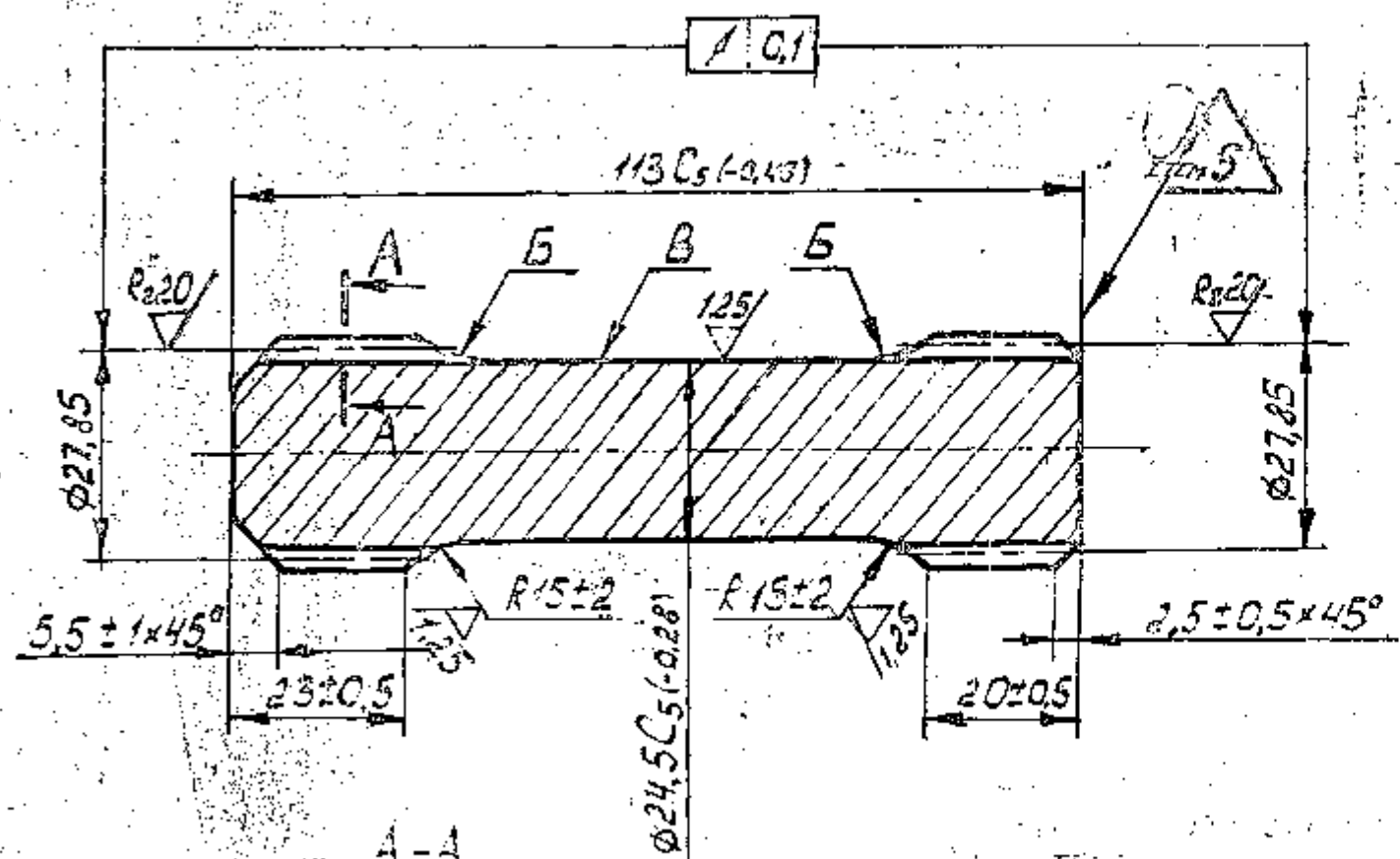


DIAGRAM FOR  
CHECKING TEETH THICKNESS

|                                                       |                |                               |
|-------------------------------------------------------|----------------|-------------------------------|
| NUMBER OF TEETH                                       | Z              | 18                            |
| THICKNESS OF TOOTH ALONG THE CHORD<br>OF PITCH CIRCLE | Sa *           | 2,427 $\pm 0,095$<br>$-0,194$ |
| DISTANCE OVER PINS                                    | M <sub>B</sub> | 32,2 $\pm 0,30$               |
| DIAMETER OF PINS                                      | d <sub>p</sub> | 2,886                         |
| DIAMETER OF PITCH CIRCLE                              | da             | 27,85                         |

- 1 INSPECTION GROUP III AS PER TECHNICAL REQUIREMENTS TT-11.
  - 2 CARBURIZE SPLINES h 0,3 TO 0,9: CARBURIZE SURFACE B h 0,3 TO 0,9 HRA  $\geq 78$ .
  - 3 AFTER <sup>FINISH</sup> MACHINING, POLISH SURFACE B AND FILLETS b. CHECK THE PART USING A MAGNETIC FLAW DETECTOR AS PER INSTRUCTIONS M B 20-17
  - 4 HAIRCRACKS, CRACKS, NOTCHES, NICKS, TRACES OF ROUGH MACHINING ARE NOT PERMITTED.
  - 5 ACCEPT SURFACE B AND FILLETS b AS PER STANDARD.
  - 6 STAMP BY ELECTROCHEMICAL METHOD.
- ⑥ \* DIMENSIONS ARE GIVEN FOR REFERENCE.

18X2H4MA ( 18X2H4BA )  
TY 14-1-381-72

PILOT SAMPLE SHOULD BE APPROVED BY AITOP BEFORE BULK PRODUCTION

|                              |                                       |                                                       |
|------------------------------|---------------------------------------|-------------------------------------------------------|
| EST. MASS                    | 0,38 Kg                               | TO BE STAMPED OR MARKED WHERE INDICATED THUS: LETTERS |
| B                            | 5,9,90                                | DO CORRECTION                                         |
| A                            | 71289                                 | SET CORRECTION                                        |
| ISSUE                        | DATE                                  | NATURE OF AMENDMENTS                                  |
| OWN                          | SCALE                                 | 1:1                                                   |
| CH                           | DIMENSIONS                            | IN mm                                                 |
| YCD                          | TOLERANCE ON DIMS                     | UNLESS OTHERWISE STATED                               |
| APP                          | ALL THREADS                           | UNIFORM TO                                            |
| DATE                         | 26/1/87                               |                                                       |
| 29T, MASS                    | 0,38 Kg                               | TO BE STAMPED OR MARKED WHERE INDICATED THUS: LETTERS |
| ALL SHARP EDGES AND CORNERS  | TO BE REMOVED UNLESS OTHERWISE STATED | MACHINED CORNERS TO HAVE R OUTSIDE                    |
| 4 VISUAL EQUIVALENT CHAMFERS | ARE PERMISSIBLE                       |                                                       |
| MATERIAL                     | ** SEE ABOVE                          | USED ON: C6 20-63-00-5                                |
| CONTROL RATE OF INSPECTION   | (HEAVY VEHICLES) AVADI                |                                                       |
| TORSION BAR                  | ④                                     |                                                       |
| 1 * CAT NUMBER               |                                       | DRAWING NUMBER                                        |
|                              |                                       | 20-63-11-1                                            |