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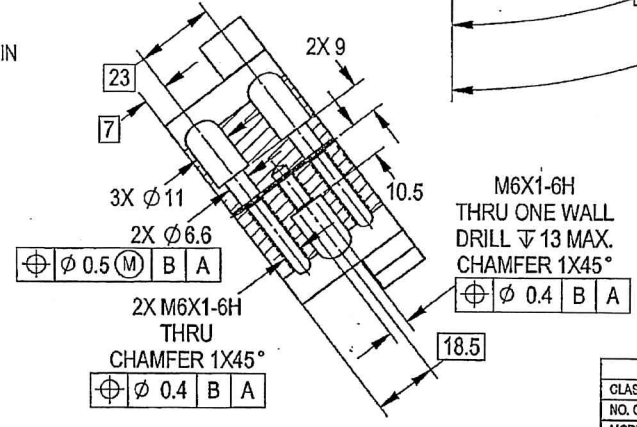
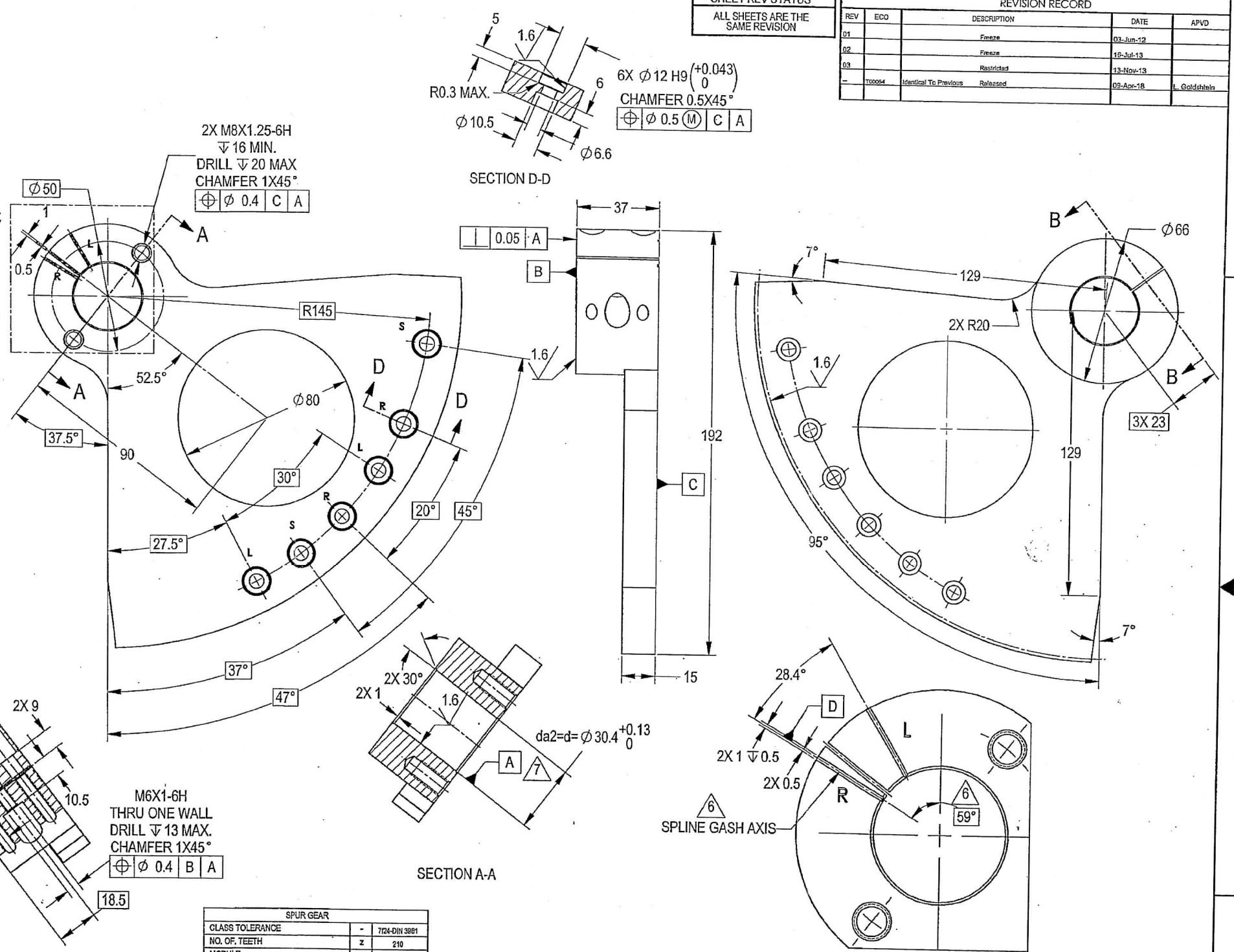
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Tolerance class	Permissible deviations for basic size range					
	over 0 to 1	over 1 to 3	over 3 to 6	over 6 to 30	over 30 to 100	over 100 to 500
f	±0.012	±0.015	±0.020	±0.030	±0.040	±0.050
m	±0.010	±0.012	±0.015	±0.020	±0.025	±0.030
c	±0.008	±0.010	±0.012	±0.015	±0.020	±0.025
v	±0.005	±0.006	±0.008	±0.010	±0.012	±0.015

SHEET REV STATUS
ALL SHEETS ARE THE SAME REVISION

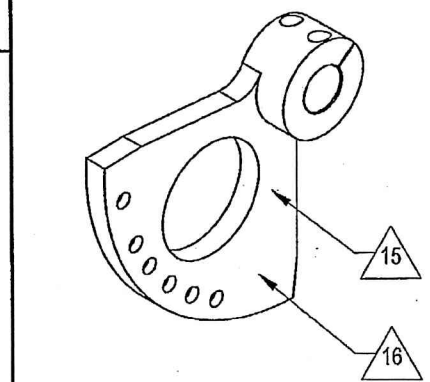
DWG 064331A-00		SH 1	1	
REV	ECO	DESCRIPTION	DATE	APVD
01		Freeze	03-Jun-12	
02		Freeze	18-Jul-13	
03		Restricted	13-Nov-13	
-	T0004	Identical To Previous	09-Apr-18	L. Goldstein

- NOTES:
- INTERPRET THIS DRAWING IAW ASME Y14.100M.
 - MATERIAL: ALLOY STEEL PLATE SAE 4130 PER SAE-AMS 6345 OR SAE 4340 PER AMS 6359. (EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).
 - HEAT TREATMENT: QUENCH AND TEMPER ENTIRE PART; HARDNESS 35 ± 4 HRC.
 - DEBURR AND REMOVE SHARP EDGES APPROX. 0.3X45°.
 - GENERAL TOLERANCES ACCORDING TO ISO 2768-m.
 - ANGLE BETWEEN THE SPLINE GASH AXIS AND AXIS DATUM SYMBOL D WILL BE MAX. 0°30'.
 - DATUM TARGET A IS REFERRING TO PITCH DIAMETER (FLANK CENTRING SPLINE).
 - THE SPUR GEAR TOLERANCE AND DEVIATION SHALL BE MEASURED BY FITTING UP ON A SHAFT SPLINED DEVICE (SPLINE W32X0.8X30X38X7h). THE SPLINE HUB MUST BE TIGHT (TORQUE 16.5Nm ± 5%) WITH 2 SCREWS M6X30-DIN 912-12.9.
 - MAGNETIC PARTICLE INSPECT NO IDENTIFICATION OF CRACKS OR DISCONTINUITIES PERMITTED (IN ACCORDANCE WITH ASTM E 1444-05).
 - GEAR TEETH INVOLUTE MUST BLEND WITH FILLET AND/OR APPROXIMATE RADIUS AT OR BELOW FROM DIAMETER; NO STEP OR UNDERCUT PERMITTED.
 - PHOSPHATE COATING TYPE M, CLASS 2, 0.005-0.010 MM THICK PER MIL-DTL-16232.
 - THE DIMENSIONS ARE BEFORE COATING.
 - QUALITY ASSURANCE PROVISIONS:
13.1 QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RD40392477P.
 - THE DEVIATION Fp, fp AND Fr WILL BE NOT MEASURED IF Fp* IS MEASURED.
 - IDENTIFY PART PER MIL-STD-130 BY STAMPING. CHARACTERS 1.25 MM HIGH MIN MEETING REQUIREMENTS OF MIL-STD-202F METHOD 215J. LOCATION APPROX. AS SHOWN.
 - MARK S/N. LOCATION APPROX AS SHOWN.
 - PACKAGING AND PACKING:
THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH COMMERCIAL PRACTICE.



SPUR GEAR		INTERNAL INVOLUTE SPLINE	
CLASS TOLERANCE	- 7/24-DIN 3881	REFERENCE DIAMETER	φB 32
NO. OF TEETH	z 210	PRESSURE ANGLE	a 30°
MODULE	m 1.5	MODULE	m 0.8
ADDENDUM MODIF. COEFFICIENT	x 0.008168	NO. OF TEETH	z 38
SPLINE DATA/PRESSURE ANGLE	- DIN 867/20°	SPLINE DATA	- DIN 5480
BOTTOM CLEARANCE	- 0.25mm	TEST DIMENSION BETWEEN PINS	MI 28.826 φ±0.049
REFERENCE DIAMETER	d 315	PINS DIMENSION	DM 1.5
BASE TANGENT LENGTH	Wz3 104.022 φ±0.038	PITCH DIAMETER	d 30.4
SINGLE PITCH TOLERANCE	fp 0.012	HUB ROOT DIAMETER	df2 32.16 N12
TOTAL PITCH TOLERANCE	Fp 0.045	INVOLUTE SPLINE	N32x0.8x30x38x6H
TOOTH TRACE TOTAL DEVIATION	Fp* 0.067		
TOTAL PROFILE DEVIATION	Ff 0.012		
TWO-FLANK WORKING DEVIATION	Ff* 0.039		
RUN-OUT A	Fr 0.022		
IDENT. - NO. OF MATING GEAR	- 022253A-00		
NO. OF TEETH OF MATING GEAR	- 17		
CENTER DISTANCE IN CASING	a 171		
AND TOLERANCE	Aa ±0.06		

UNLESS OTHERWISE SPECIFIED		SIGNATURE & DATE		ORDNANCE FACTORY TIRUCHIRAPPALLI	
DIMENSIONS ARE IN MM PER ASME Y14.5M - 1994		DRAWN		FOR: ELEVATION BEARING ASSY	
TOLERANCES		CHECKED		OF: 12.7MM SRCG	
LINEAR SEE NOTE 5	ANGULAR SEE NOTE 5	HOS/DDO			
1st ANGLE PROJECTION		OFFICER/PRODN			
SURFACE TEXTURE IN Micro M		OFFICER/QC			
		OFFICER/DDO			
SIZE D	CAGE CODE 2291A	DWG NO 064331A-00	REV -		
SCALE 1/1	AUTOMATED DRAWING (SW)		SHEET 1 OF 1		



(WEIGHT APPROX.: 2.390 Kg.)

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OF APPROVED DRAWINGS
AT THIS DATE: 26-11-2020

Design & Drawing Office
Ordnance Factory

PROJECT OFFICER

PLM Control