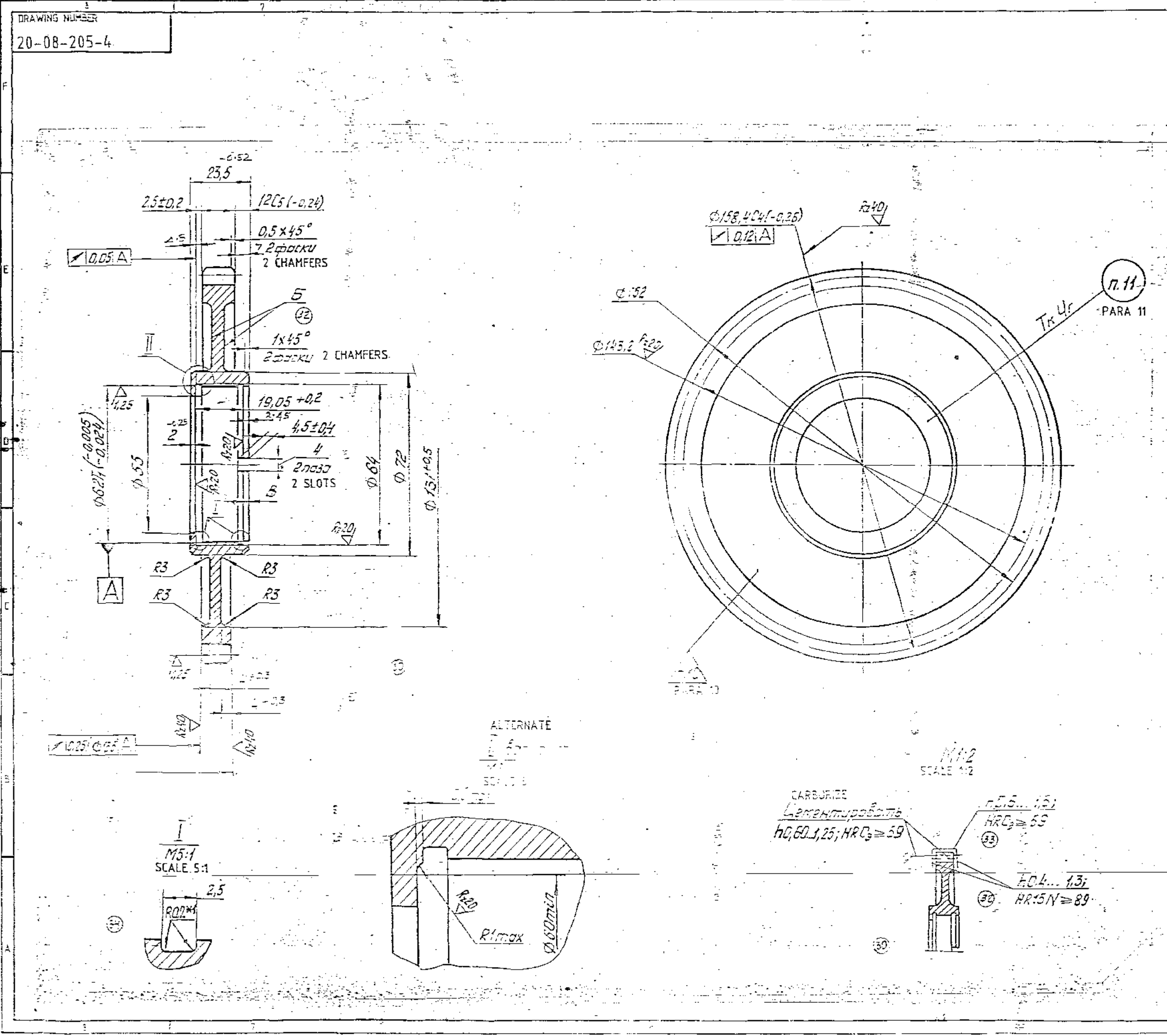


100% INDICATED BASED ON RUSSIAN ORIGINAL ISSUE 34 1748-03 1

SIZE A2



- Группа контроля III по ТТ-11.
- НРС 37... 46, кроме мест, обозначенных особ.
- Допускается местная подциментация поверхностей Б, поверхности Ф 72 мм и торцев.
- Неуказанные предельные отклонения размеров отверстий - по А₁, валов - по В₁.
- Овальность поверхности А не более 0,01 мм.
- Конусность поверхности А на длине 14 мм не более 0,01 мм.
- Допускается прослабление ф 62₇ (-0,005) до ф 52₇ +0,1 мм на участке В от торца до канавки под замок.
- При шлифовке зубьев допускается недошлифовка боковой поверхности до впадины не более 0,2 мм, при этом площадь зацепления зубьев шестерен при обкатке с эталоном в беззазорном состоянии не должна нарушаться.
- Измерительная шестерня по ГОСТ 6512-74.
- Качество зацепления зубьев проверяется по эталону - краем обкаткой с эталоном в беззазорном состоянии по инструкции УБ-42, пятно контакта по длине и высоте зуба должно соответствовать значениям, указанным в таблице чертежа.
- Притупление на торцу зуба притупить по эталону.
- Деталь проверять на магнитном дефектоскопе по инструкции УБ20-17.
- Клеить графитовый, графитовый или углеродный порошок.
- Маскировать на заплатах, поставленных в запасные части.
- Обозначение детали:

- 2) твердый знак.
- 12) допускается карбидить электрохимическим способом.
- 13) Размеры обеспечиваются инструментом.

Модуль	m	4
Число зубьев	Z	38
Угол профиля	α	20°
Коэффициент высоты головки	h*	0,8
Коэффициент радиального зазора	c*	0,3
Коэффициент смещения исходного контура	x	0
Степень точности по ГОСТ 1643-72		
Длина общей нормали	W	55,266 ^{+0,07} _{-0,16}
Допуск на колебание длины общей нормали	V _W	0,036
Допуск на колебание за один оборот зубчатого колеса	F _L	0,10
Допуск на колебание измерительного межосевого расстояния	f _L	0,028
Допуск на радиальное биение зубчатого венца	F _r	0,058
Шаг зацепления	Номинальное значение	11,808
	Предельные отклонения	f _{pr} ±0,011
Суммарное пятно контакта с зубьями эталонного зубчатого колеса	по высоте	% не менее 50
	по длине	% не менее 70
Допуск на погрешность профиля зуба	f _α	0,014
Допуск на погрешность направления зуба	F _β	0,013
Диаметр основной окружности	d _b	142,833
Радиус кривизны эвольвенты в начале рабочего участка профиля	ρ _b	14,126
Радиус кривизны эвольвенты в конце рабочего участка профиля	ρ _c	34,240
Угол дуги выпуклости эвольвенты	φ	16°08'13"

Модуль	m	4
Число зубьев	Z	38
Угол профиля	α	20°
Коэффициент высоты головки	h*	0,8
Коэффициент радиального зазора	c*	0,3
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Степень точности по ГОСТ 1643-72		
Длина общей нормали	W	55,266 ^{+0,07} _{-0,16}
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Угол дуги выпуклости эвольвенты	φ	16°08'13"

- Control group III is according to TT-11.
- ННС 37...46, except the places marked especially. Local partial carburizing of B surfaces, surface of 72 mm in diameter and faces is allowed.
- Non-indicated limit deviations of dimensions: holes - by A₁, shafts - by B₁.
- Ovality of A surface is not more than 0.01 mm.
- Taper of A surface per 14 mm of length is not more than 0.01 mm.
- It is allowed to loosen diam. 62₇ (-0.005) up to diam. 52₇ +0.1 mm on B section from a face to a groove for a lock.
- In grinding the teeth the undergrinding of the side surface up to the tooth space is allowed to be not more than 0.2 mm, with that the smoothness of the engagement of gear teeth should not be broken during rolling with a gaging plug in out of clearance condition.
- The measuring gear is according to GOST 6512-74.
- Adopt the dulling along the tooth face according to a gaging plug.
- Check a part by a magnetic flux detector according to UB20-17 instruction.
- Stamp with engraving, etching or striking.
- Mark on the parts supplied as spare parts:
1) designation of a part;
2) trade-mark.
- It is allowed to stamp by electrochemical method.
- Dimensions are ensured by a tool.

13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
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13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82
13013	1341-82	13013	1341-82

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

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