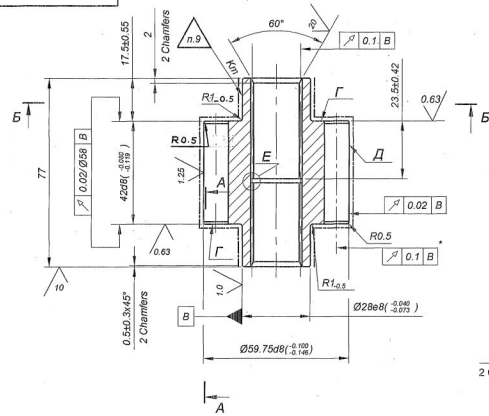
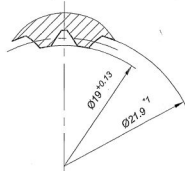


DRAWING NUMBER  
**3312-101-5**

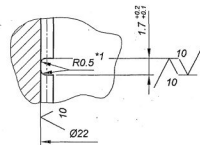
SHEET No. OF



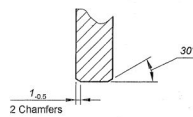
**Б-Б (5:1)**



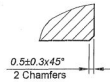
**E (4:1)**



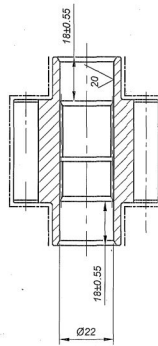
**A - A (2:1)**



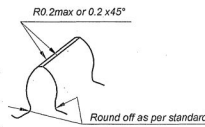
**A - A (4:1) Alternate**



**Alternate**



**Sketch for rounding off teeth**



1. Inspection group III as per TT-11.
2. To be carburized: Teeth surfaces  $h\ 0.6...1.0\text{mm}$ ; Surfaces 'D'  $h\ 0.25...0.90\text{mm}$ ; Faces  $\Gamma$  and other surfaces  $h\ 0.4...0.9\text{mm}$ ;  $51...59\ \text{HRC}\ 3$ .
3.  $26...42\ \text{HRC}\ 3$  non-carburized surfaces are to be checked at random. But not less than 3 components from each heat treated batch.
4. It is permitted to carburize all over.
5.  $H14, h14, \pm\ \frac{IT14}{2}$ .
6. Quality of gear meshing to be checked by bluing, the blue imprint should run-in with standard gear as per instruction IB-42.
7. Parts to be checked by magnetic defectoscope as per TT IB-17.
8. Coating : Chemically oxidized, oiled when parts are intended to send as spares.
9. Marking by punching method is not allowed.
10. \* Check in absence of run-in with standard gear.
11. \* Dimension to be ensured by tool.

Module	m	1
No. of teeth	Z	20
Profile angle	$\alpha$	30°
Addendum co-efficient	$f'$	0.95
Dedendum co-efficient	$f''$	0.50
Fillet radii	R	-
Addendum modification shift	X	-
Diameter of pin	$d_p$	1.732
Distance over pins	$M_h$	$17.47^{+0.15}$
Width of tooth space	S	$1.57^{+0.075}$
Diameter of reference circle	$d_d$	20

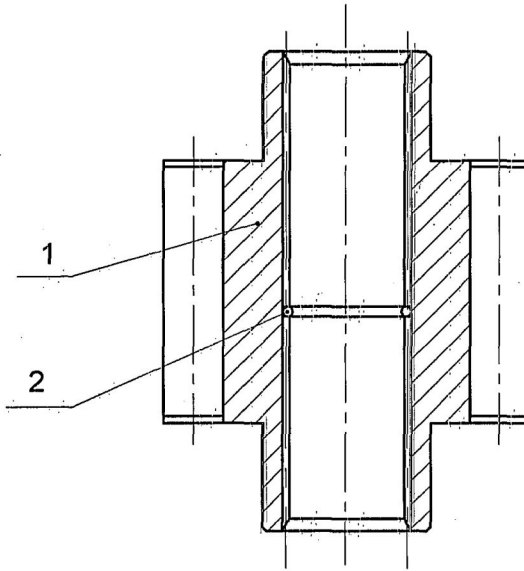
Module	m	5
No. of teeth	Z	10
Profile angle	$\alpha$	25°
Addendum co-efficient	$h_a^*$	1
Coefficient of Curvature radius of easement curve	$\alpha^*$	0.352
Coefficient of radial clearance	$c^*$	0.203
Coefficient modification shift	x	0
Degree of accuracy	-	-
Base tangent length	W	$22.7^{+0.08}$
Composite error double flank	Total	$F_{\Sigma}$ 0.130
	Tooth to tooth	$f_{\Sigma}$ 0.060
Bearing pattern with teeth of standard gear.	Along length	-
	Along height	-
Reference diameter.	d	50
Radius of curvature of active tooth profile in lower point	$Q_p$	1.48
Base - pitch	$P_b$	14.23

DRN	APPD	MATERIAL - Steel 12XH3A	USED ON - CE 3312-113-3
CHD	DATE	TY 14-1-381-72	
DATE	SCALE: 1:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
EST. WT. (kg)	TO BE STAMPED OR MARKED WHERE INDICATED THIS # ( LETTERS)	TITLE - <b>OIL PUMP GEAR</b>	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		D S CAT NUMBER	
ISSUE	DATE	NATURE OF AMENDMENTS	DRAWING NUMBER <b>3312-101-5</b>

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2



DRAWING NUMBER  
**Cb.3312-113-3**



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

		EST. WT.(Kg) <b>0.581</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (          LETTERS)
		<b>ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.</b>	
		MATERIAL :	USED ON :- <b>C6 3312-00-22</b>
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN	<i>san</i>	SCALE :- <b>1:1</b>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) <b>AVADI</b>
		DIMENSIONS IN mm	
CHD	<i>R. S. S. S.</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69	TITLE :- <b>GEAR WITH RING ASSY.</b>
APPD	<i>[Signature]</i>	ALL THREADS TO CONFORM TO	D S CAT NUMBER
DATE	<b>17/2/07</b>		DRAWING NUMBER <b>Cb.3312-113-3</b>
SIZE A4			



