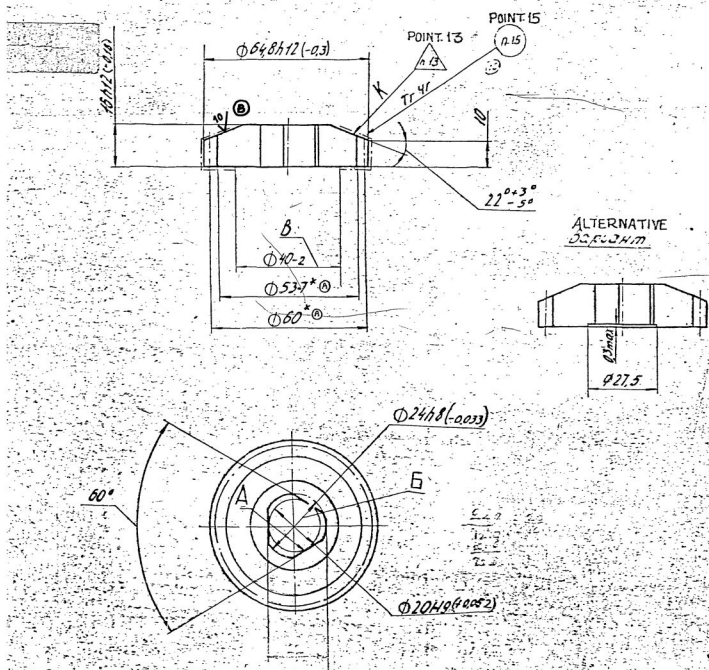


ЕСКД



1. ALTERNATE MATERIAL: STEEL, GRADE 18X2H4MA AS PER TY14-1-381-72.
2. INSPECTION GROUP III, TT-11.
3. TO BE CARBURIZED: FOR TEETH  $\frac{1}{4} 0.4$  TO  $0.9$  HRC,  $\geq 55$ .
4. HRC, 37-45 FOR THE NON-CARBURIZED SURFACES IS TO BE CHECKED AT RANDOM, BUT NOT LESS THAN 3 PIECES FROM A BATCH.
5. GEAR FACES MAY BE ADDITIONALLY CARBURIZED ON 2 SIDES UP TO  $\frac{1}{8}$  TO DEPTH  $\frac{1}{4}$  NOT EXCEEDING 0.2 mm.
6. IT IS ALLOWED TO CASEHARDEN ALL OVER, IN THIS CASE THE TOLERANCE FOR DIMENSION B BEFORE CARBURIZATION SHOULD BE DETERMINED BY TECHNOLOGICAL PROCESS.
7. COATING: CHEMICAL OXIDIZING, OIL FINISHING FOR SPARE PARTS.
8. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS: OF HOLES AS PER H14; OF SHAFTS - AS PER  $\frac{1}{14}$ , OF THE REST OF DIMENSIONS -  $\frac{1}{14}$ .
9. RUN-OUT OF TOOTHED RIM RELATIVE TO THE AXES OF SURFACE A SHOULD BE 0.1 mm, MAXIMUM, TO BE CHECKED IN CASE RUNNING-IN WITH STANDARD GEAR IS NOT CARRIED OUT.
10. PITCH VARIATION OF SURFACE A IS TO BE CHECKED BY SPECIAL GAUGE CONSTRUCTED TO SUIT THE MAXIMUM DIMENSIONS OF MATED COMPONENT.
11. QUALITY OF ENGAGEMENT IS TO BE CHECKED BY IMPRINT OF PAINT: RUN-IN WITH A STANDARD GEAR, AS PER INSTRUCTIONS UB-42.
12. COMPONENTS ARE TO BE CHECKED ON MAGNETIC-FIELD PLAN DETECTOR ACCORDING TO THE TECHNICAL REQUIREMENTS UB-17.
13. NOT TO BE MARKED BY PUNCHING.

14. DIMENSIONS OF HOLE ARE TO BE CHECKED BEFORE HEAT TREATMENT.
15. IN CASE THE COMPONENT IS INTENDED AS SPARES MANUFACTURE CODE AND THE PART NUMBER OF COMPONENT ARE TO BE MARKED.
16. DIMENSIONS FOR REFERENCE.

MODULE		m	3
NUMBER OF TEETH		Z	20
PROFILE ANGLE		$\alpha^{\circ}$	20°
ADDENDUM COEFFICIENT		$h_a^*$	0.8
COEFFICIENT OF RADIUS OF CURVATURE OF CASEMENT CURVE		$\rho_f$	0.526 $\phi 0.40$
COEFFICIENT OF BOTTOM CLEARANCE		$c^*$	0.348 $\phi 0.250$
BASIC RACK MODIFICATION COEFFICIENT		x	0
DEGREE OF ACCURACY		-	-
BASIC TANGENT LENGTH		w	22.98 $\phi 0.01$
TOLERANCE ON COMPOSITE ERROR DOUBLE FLANK	TOTAL	F'	0.120
	TOOTH-TO-TOOTH	f1''	0.050
PAINT IMPRINT FROM CONTACT WITH TEETH OF STANDARD GEAR	ALONG LENGTH	-	-
	ALONG HEIGHT	-	-
BASIC DIAMETER		d <sub>B</sub>	56.98
RADIUS OF ACTIVE FLANK CURVATURE IN LOW POINT		$\rho_p$	$\pm 4.8$ $\phi 4.56$
BASE PITCH		$P_b$	8.85

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

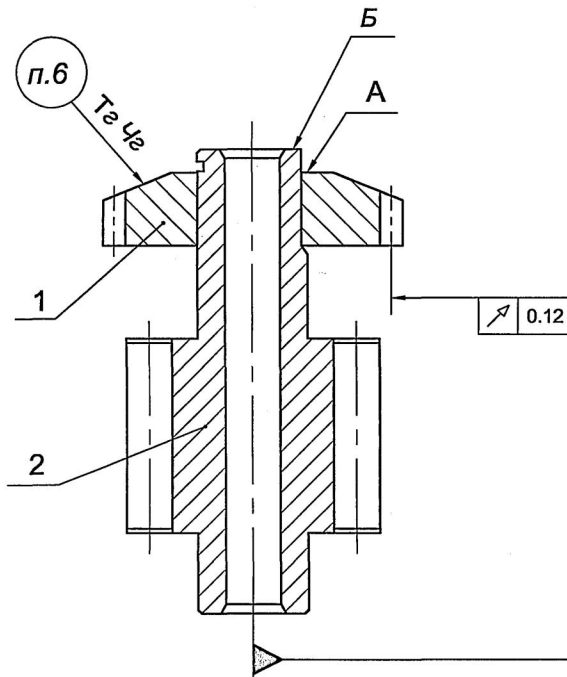
		EST MASS 0.25	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS) (A6/66)
B	15-134 AUTHY. NOTN. No. BK-84-243		
A	16.12.87 AUTHY BK 82-536		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL-	USED ON-
DRN	SCALE- 1:1	STEEL 18X2H4BA	CB3312-94-1
CHD	DIMENSIONS IN mm	TYK-1-381-72	CS 3312-95-1
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVAQI	
DATE	ALL THREADS CONFORM TO	TITLE- OIL PUMP DRIVE GEAR	
03-12-87		D S CAT NUMBER	DRAWING NUMBER 412-25-2





DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

DRAWING NUMBER  
**Cb.3312-94-3**



1. Trihedral connection of parts should be done by individual selection when the parts fail to be mated due to buckling of the hole surfaces during heat treatment, the following may be made to ensure clearance between the faces :
  - Grinding of faces of part 2 (beyond tolerance)
  - Grinding of journal diameter on trihedral length along  $\varnothing 24e8 \left( \begin{smallmatrix} -0.040 \\ -0.073 \end{smallmatrix} \right)$  :
  - The clearance between faces should not exceed 0.08mm.
2. While mounting the unit to pump check the coincidence of matching paired marks.
3. Interference is not allowed in mating of parts item 1 and 2.
4. Circumferential back lash of part item 1 with respect to part item 2 along trihedral measured as per  $\varnothing 60$ , should not exceed 0.3mm. While checking, the back lash of part item 1 should not over lap the groove of - part 2.
5. Apply marks and pair number on surface A and B. Marking by stamping method is not permitted.
6. Manufacturer's code and unit number are to be moulded in case the part is intended as spares.

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

EST. WT.(Kg) **0.74** 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

		DRN		MATERIAL :-	USED ON :- Cb 3312 - 00-22
		CHD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	TITLE :- <b>PAIRED GEAR ASSY.</b>
		APPD			
		DATE	17/2/07		
		SCALE:-	1:1	D S CAT NUMBER	DRAWING NUMBER <b>Cb.3312-94-3</b>
		DIMENSIONS IN mm			
		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
		ALL THREADS TO CONFORM TO			
8	7	6	ISSUE	DATE	NATURE OF AMENDMENTS

F-4  
25  
253

SIZE A3



