

GEAR-SHAFT

MATL RUSSIAN ORIGN - STEEL 30khRA
OST 3-98-80

INDGNS. EQUIVALENT: AS PER CQA(MET)

STEEL 25cr13M06

IS: 4367-91

(Secondary refined steel)

ALL DIMENSIONS ARE IN MM.
UNTOL DIMNS. ARE AS PER IS:2102.

- 1> Heat treatment - normalization .
- 2> Dressing from scaling - shot blasting .
- 3> Displacement in joint plane should not be above 0.6 mm.
- 4> Remaining burrs on line on stamp joints should not be more than 0.9 mm.
- 5> Face burrs should not be more than - mm .
- 6> Rod curvature should not be more than 0.8 mm .
- 7> Eccentricity of broached holes should not be more than 0.5 mm .
- 8> Surface defects with depth should not be more than 0.5 mm .
- 9> Unspecified stamping deviation not more than 7°.
- 10> Unspecified radii 2.0 mm .
- 11> Allowance as per II class GOST 7505-74
- 12> Tolerance as per II class GOST 7505-74
 - Vertical $\begin{matrix} +1.3 \\ -0.7 \end{matrix}$
 - Horizontal $\begin{matrix} +1.5 \\ -0.7 \end{matrix}$ Forging for GKM .
- 13> Number of components with forging 1 piece .
- 14> Dimensions in brackets - for machining .
- 15> Mark letter size .
- 16> Handing over of component is permissible .
- 17> Dimensions with * are designated for inspection, remaining are ensured with stamp.

ITEM NO.	NO. OFF	MATERIAL	DESCRIPTION
1	NO. OFF	STEEL 30khRA OST 3-98-80	

LIST OF PARTS

Compt. : GEAR SHAFT AO-18.03.019	St. Drg. No. : AO-18 for AK--630 GUN.
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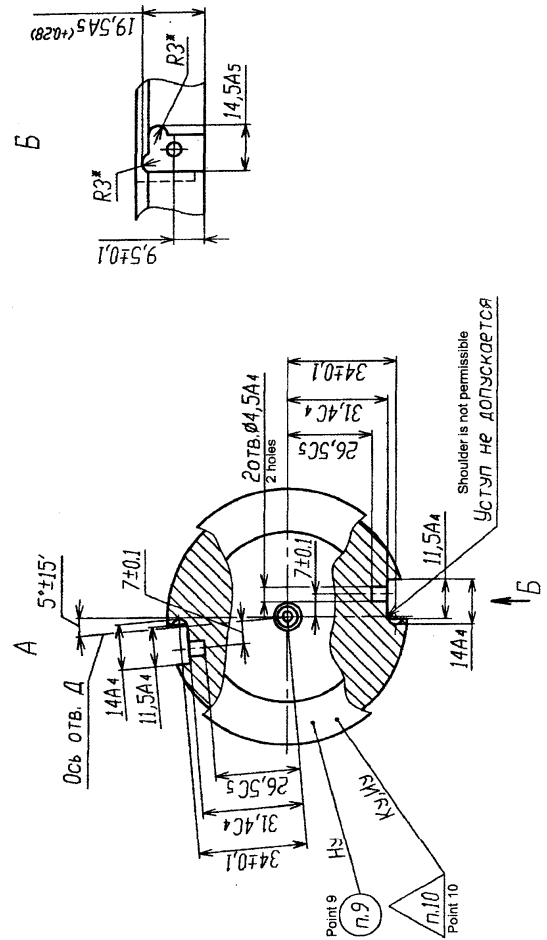
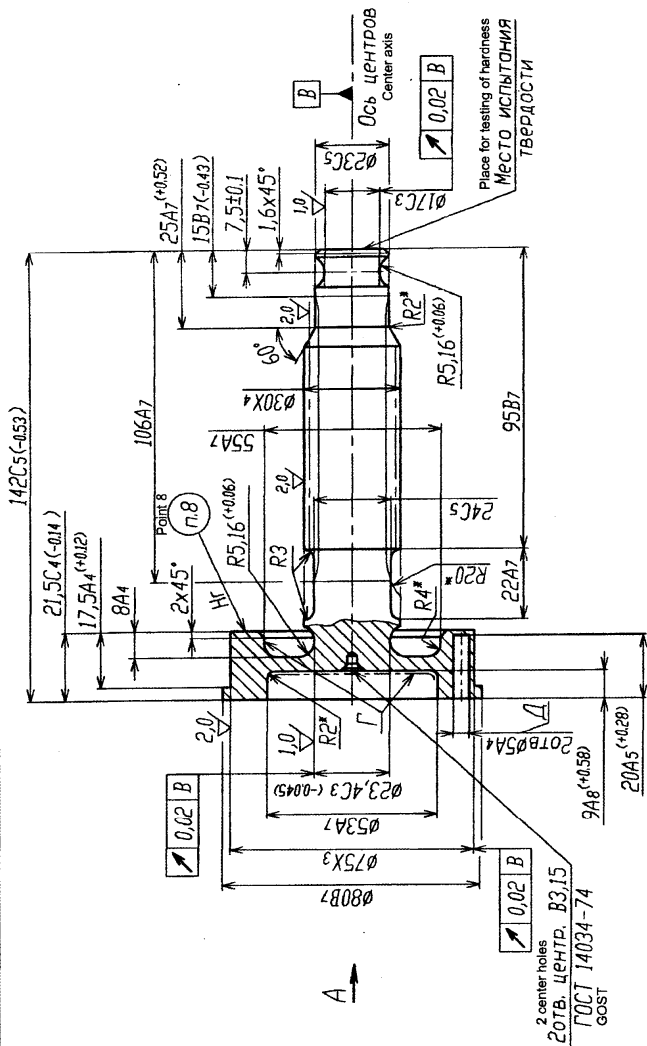
STAMPING FOR GEAR SHAFT

DRG. NO.: F-2302

DT. & SG.	DESCRIPTION	APPROVED BY:	NO. OF SHEETS:
		DATE:	SIGN.: G & S FY. COSSIPORE
			SHEET NO.: 1

6105081.0A

Rz20 (M)



Module	M	2
Number of teeth	z	13
Normal basic rack		GOST 13755-8
Addendums modification coefficient	x	0
Accuracy level as per GOST 1643-81		7-B
Average length of general standard	W _{mr}	9,22 ^{+0,07} _{-0,1}
Index diameter	d	26
Tooth height	h	4,5
Mating designation of gear rack		AO-18.03.005

- Blank - stamping die
- 4.3.5...51.5 HRCe.
- Dimensions are ensured by tool.
- Inner angles R = 0.4 mm.
- Blunt edge R = 0.6 mm.
- Comply with requirements of plant
- Coat Cad. 12 phos. accreted chrom / impregn. adhesive BF 4 (1). OM2. Non cadmium plating of surface Γ center hole and hole D is permissible.
- Adhesive BF 4 GOST 12172 74.
- Mark 10 balls with letter size 5. Pr3 GOST 26.008 85 and fill enamel PF 115. black. Enamel PF 115 GOST 6465 76.
- Mark with letter size 3. Pr3 GOST 26.008 85.
- Stamp.

AC 18.03.019		Type	Weight	Scale
Amend	Sheet	Doc No	Sign	Date
Developed by	Shaft - pinion			
Checked by	Steel 30KhTRAOST 3 - 88 - 80			
Technician	Sheet 1			
Head of bureau	Sheets 1			
Head of OCD	11			
Approved by	1			

Inv. No.	Sign and Date	Alternate Inv. No.	Duplicate Inv. No.	Sign and Date
Refer. No.				
First remarks				