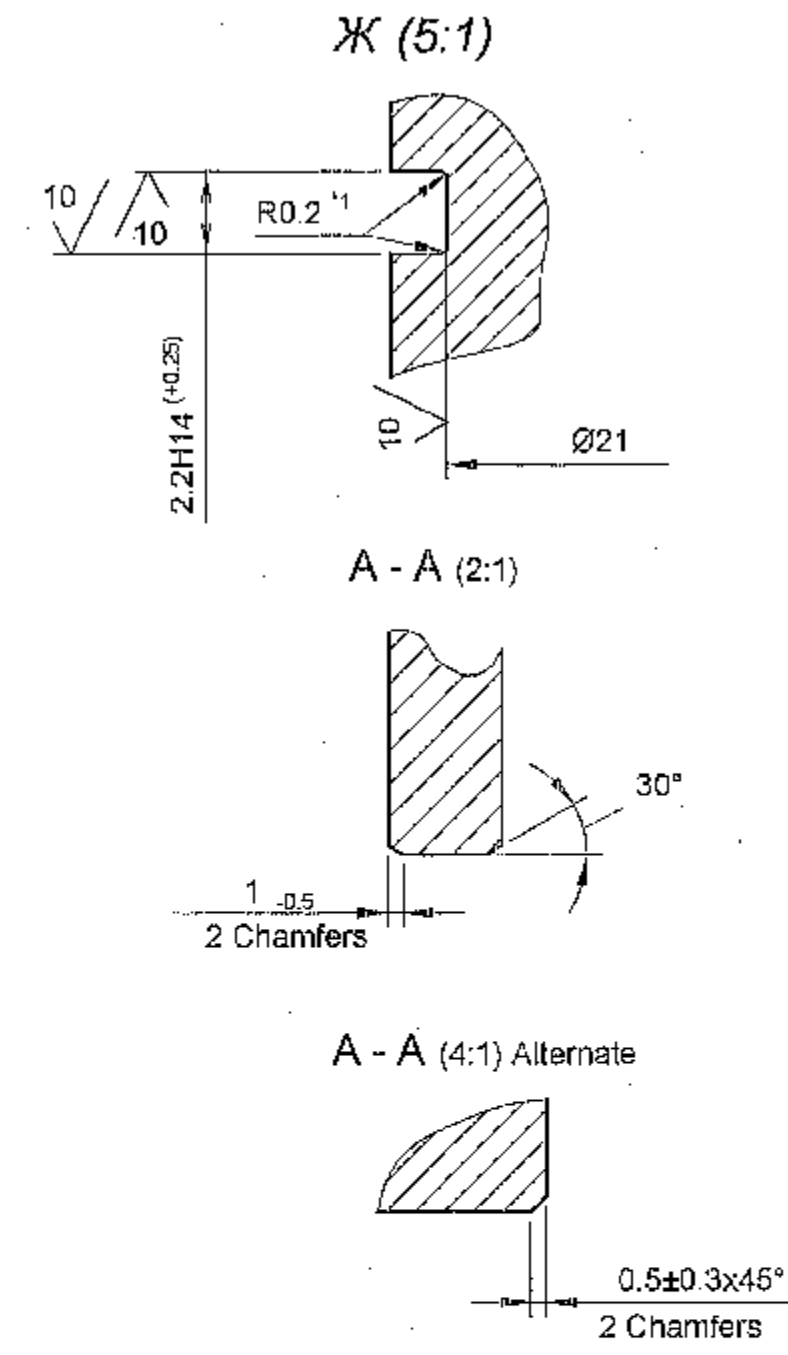
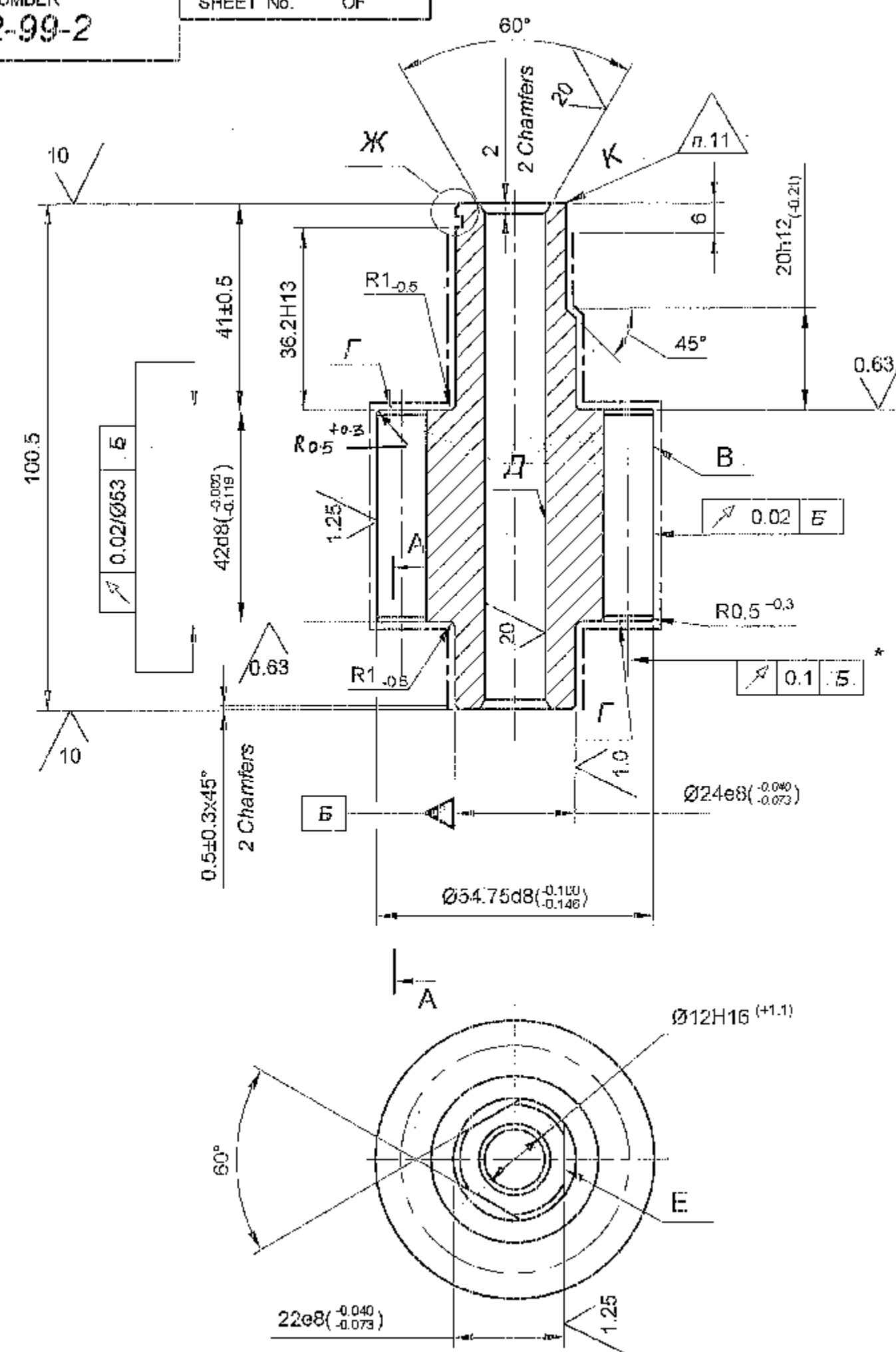


DRAWING NUMBER
3312-99-2

SHEET No. OF



1. Inspection of group III as per TT-11.
2. To be carburized: Teeth surfaces h 0.6...1.0mm;
Surfaces 'B' h 0.25...0.90mm;
Faces Γ and other surfaces h 0.4...0.9mm;
51...59 HRC \emptyset .
3. 26...42 HRC \emptyset 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. Pitch variation of surface 'E' to be checked by special gauge constructed to suit the minimum dimensions of mated parts.
8. Parts to be checked by magnetic defectoscope as per TT. IB-17
9. Shoulder up to 0.25mm is allowed on surface 'D'.
10. Coating : Chemically oxidized, oiled when parts are intended to send as spares.
11. Marking by punching method is not allowed.
12. * Check in absence run-in with standard gear.
13. * ¹ Dimension to be ensured by tool.

Module		m	5
No. of teeth		Z	9
Normal basic rack	Profile angle	α	25°
	Addendum co-efficient	h_a^*	1
	Coefficient of Curvature radius of easement curve	Q_s^*	0.352
	Coefficient of radial clearance	c^*	0.203
Coefficient modification shift		x	0
Degree of accuracy		-	-
Base tangent length		W	22.58 ^{-0.08} / _{-0.20}
Composite error double flank	Total	F_i	0.130
	Tooth to tooth	f_i	0.060
Bearing pattern with teeth of standard gear.	Along length	-	-
	Along height	-	-
Reference diameter.		d	45
Radius of curvature of active tooth profile in lower point		Q_p	0.55
Base - pitch		P_α	14.23

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

EST. WT. (kg) 0.595	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	CHD	APPD	DATE	SCALE:- 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
MATERIAL :- Steel 12XH3A TY 14-1-381-72	USED ON :- CB 3312-95-4	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI			TITLE :- OIL PUMP DRIVE GEAR		D S CAT NUMBER	DRAWING NUMBER 3312-99-2		