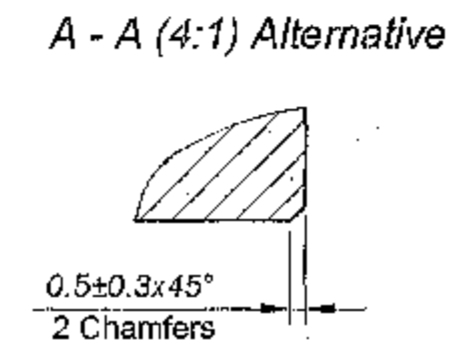
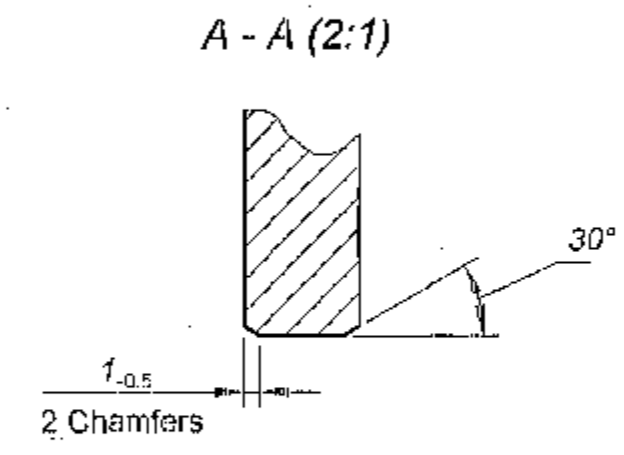
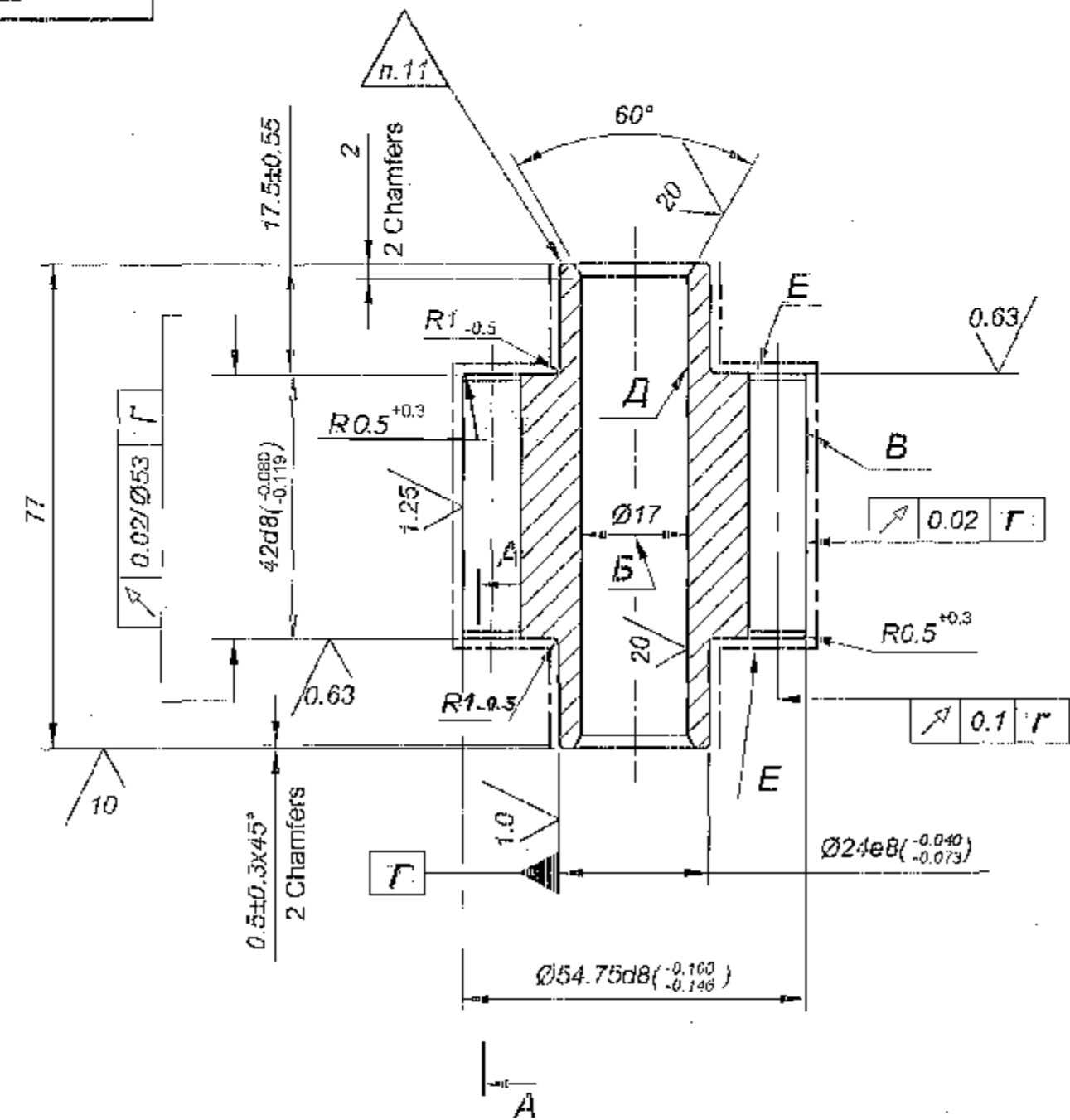


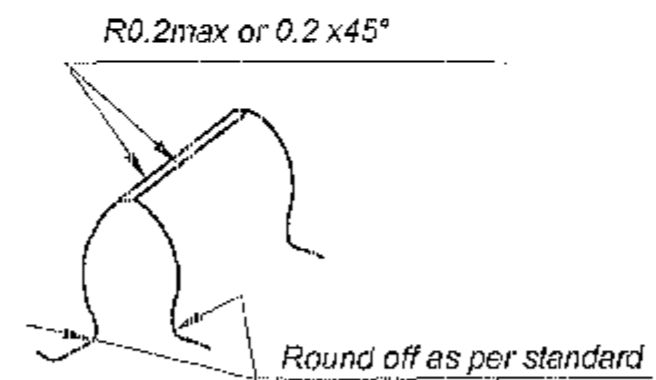
DRAWING NUMBER
3312-100-2

SHEET No. OF

5 ✓(✓)



Sketch for rounding off teeth



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 E and other surfaces h 0.4...0.9mm;
51...59 HRC ±.
3. 28...42 HRC ± 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, ± $\frac{IT14}{2}$.
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. Shoulder up to 0.25mm is allowed on surface 'D'.
9. Dimension B $\varnothing 12H16(^{+1.1})$ mm is permitted.
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.

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_r^* 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 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_a	14.23

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

F-4
35
253
SIZE A4 x 4

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

EST. WT. (kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.55	
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 :- 16 3312-00-22				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI			
TITLE :- OIL PUMP GEAR				D S CAT NUMBER				DRAWING NUMBER 3312-100-2			