

PLANNING SHEET - PDO / EFA / P-039

NOMENCLATURE

DRIVEN GEAR

DRAWING.No

402-98

ISSUE

OPN.No

000

OPERATION

FORGING

FORGING: 346-08/09

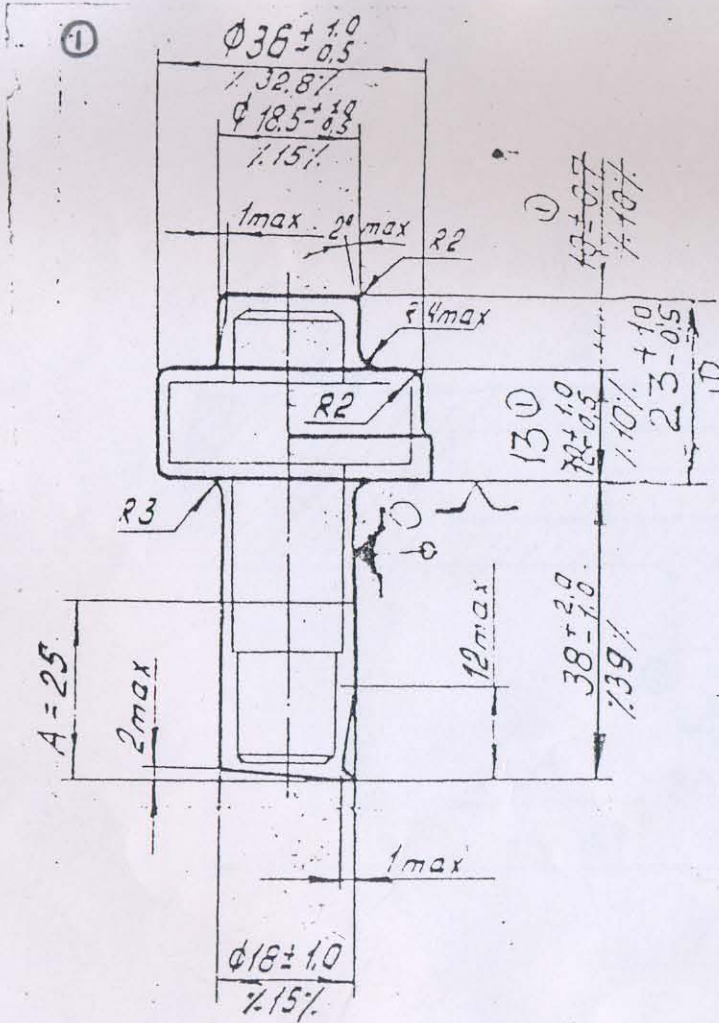
SPECIFICATIONS:

1. DRAFTS 6°
2. UNSPECIFIED RADII R-2 MM.
3. FLASH ALONG THE DIE PARTING LINE MAY BE UPTO 1.0 MM.
4. SHIFT (MISMATCH OF DIE FORGING AXES) UPTO 1.0 MM.
5. CURVATURE UPTO 1.0 MM.
6. MARK THE STEEL GRADE.

MATERIAL: STEEL 38XC

GOST 4543-71

HARDNESS : 243 BHN.



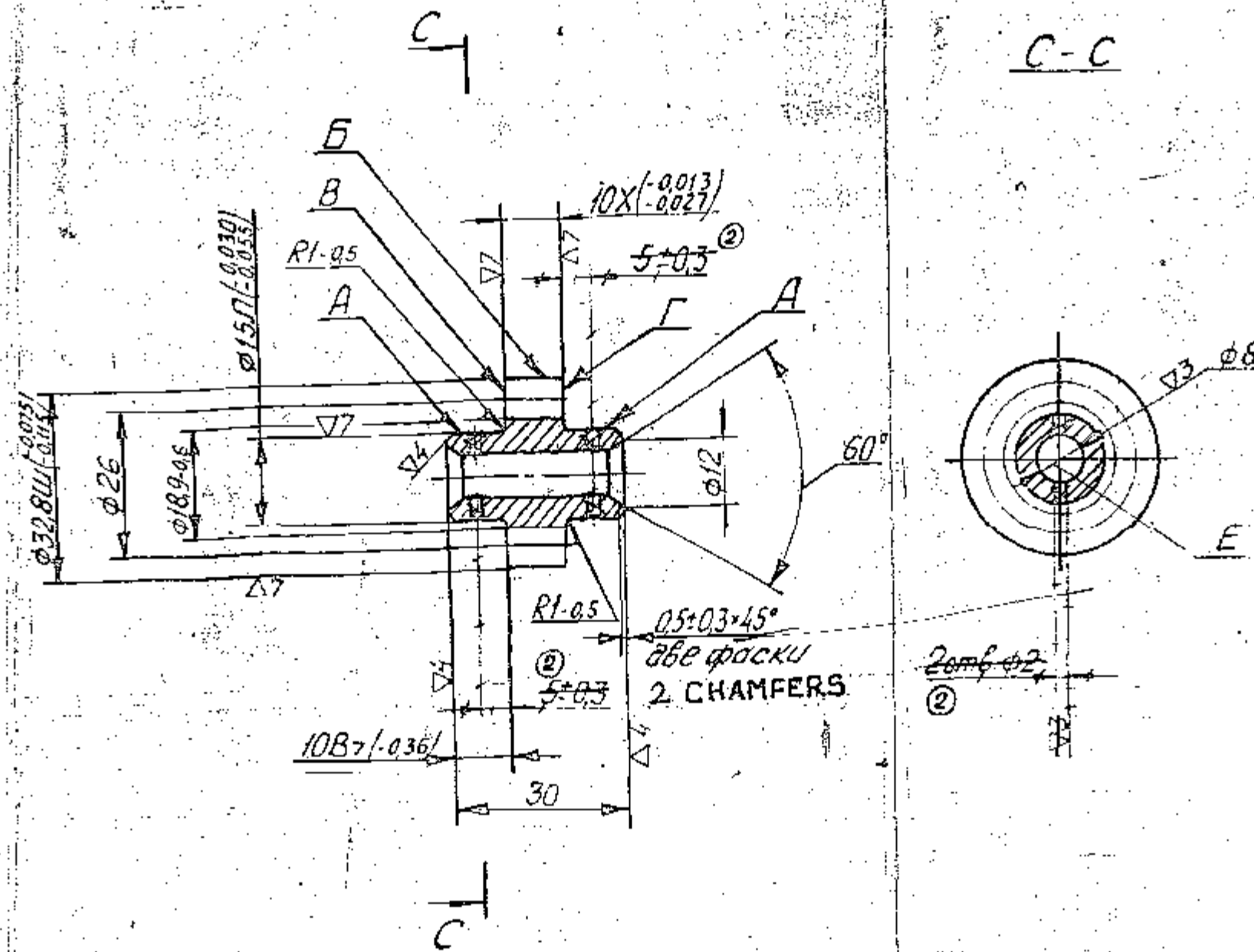
MACHINE

STD.TOOL & GAUGES

SPL.TOOLS & GAUGES

<i>Allyan</i>	<i>G</i>	<i>G</i>	122	1	06/04/01
PRED.	CHD.	APPD.	PDO. REF	ISSUE	DATE

DRAWING NUMBER
402 98



1. INSPECTION GROUP III AS PER TT 11.
 2. HRC 30-37.
 3. DIMENSIONS WITH UNSPECIFIED TOLERANCES ARE TO BE OBTAINED AS PER ACCURACY CLASS 7 OST 1010.
 4. SHARP EDGES ON TEETH ARE TO BE ROUNDED-OFF ON FACE TO RADIUS R 0.5mm ARE TO BE BLUNTED WITH CHAMFER $0.5 \pm 0.3 \times 45^\circ$.
 5. RUN-OUT OF SURFACE B RELATIVE TO SURFACE A SHOULD NOT EXCEED 0.05 mm.
 6. END PLAY OF SURFACE B AND F RELATIVE TO SURFACE A SHOULD NOT EXCEED 0.02 mm.
 7. RUN - OUT OF GEAR PITCH CIRCLE RELATIVE TO THE AXIS OF SURFACE A NOT EXCEEDING 0.1 mm SHOULD BE CHECKED, IN CASE, RUNNING-IN WITH STANDARD GEAR IS NOT CARRIED OUT. TOOTHED MASTER GEAR IS NOT CARRIED OUT.
 8. MESHING SHOULD BE CHECKED BY BLUING WITH STANDARD GEAR IN COMPLIANCE WITH INSTRUCTIONS 14B-42.
 9. COMPONENT SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC FIELD FLOW DETECTOR IN COMPLIANCE WITH TT U B-17.
 10. SHARP EDGES ARE NOT ALLOWED.
 11. COATING : CHEMICAL OXIDIZING, OIL FINISHING.
 12. DIMENSION E SHOULD BE OBTAINED $\phi 7.8$ mm.
- QUALITY OF ENGAGEMENT IS TO BE CHECKED BY IMPRINT OF PAINT USING TOOTHED MASTER GEAR IN ACCORDANCE WITH THE INSTRUCTION 14B-42.

Module	3.25	
Number of teeth	8	
Pressure angle	25°	
Pitch gauge Dimension	14.89-0.01	
Height measured with gear tooth caliper	3.64	
Thickness measured with gear tooth caliper	5.4-0.10	
Composite error double flank when running-in with standard gear without clearance.	Total	0.15
	Tooth-To-Tooth	0.045
Limit deviations of centre-to-centre distance when checking with standard gear with tooth thickness along reference circle and 5.436		-0.15
		-0.32

(B) TOOTHED MASTER GEAR
(A) SPACING ON CENTRES TOOTHED MASTER

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

EST. MASS 0.056 Kg	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.	

STEEL 38 X C	GOST 4543-71	CG 603 93 1
DATE 26-6-86	SCALE 1:1	CONTROLLED BY INSPECTION DEPARTMENT
ISSUE DATE	NATURE OF AMENDMENTS	GEAR DRIVEN
24.10.89	AUTHY. No. BK 96-67	DRAWING NUMBER 402 98

SIZE A2