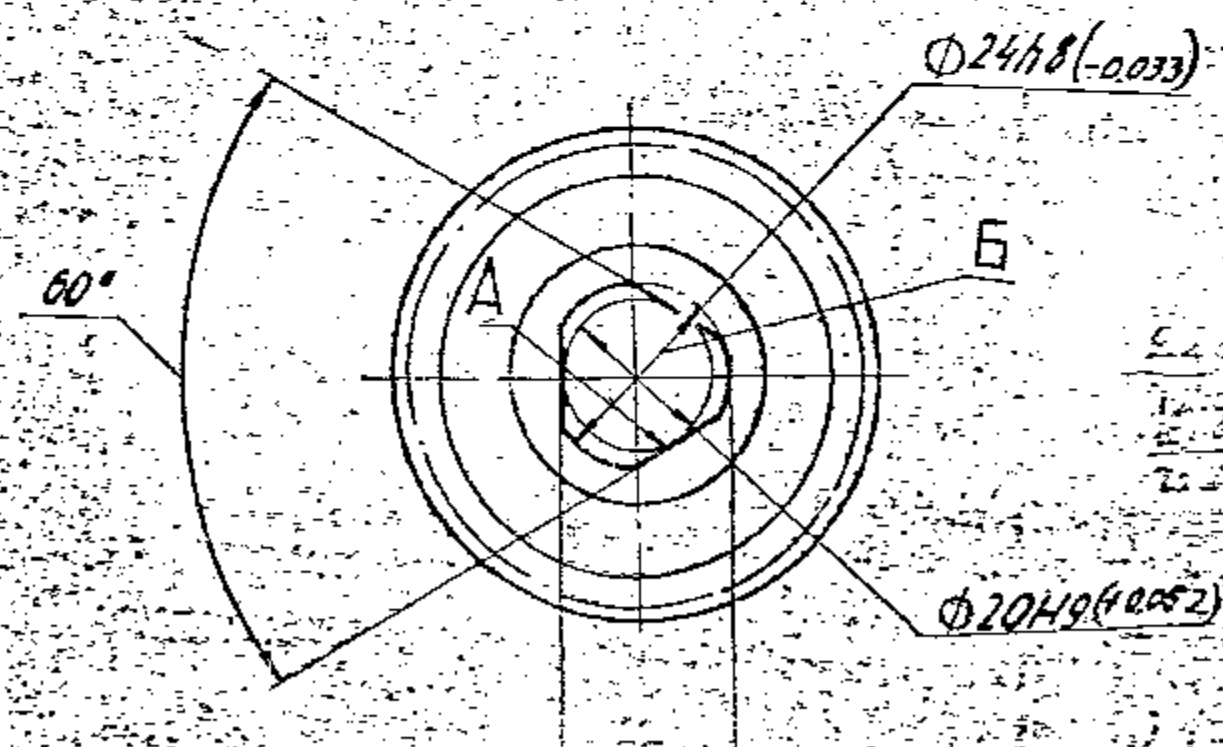
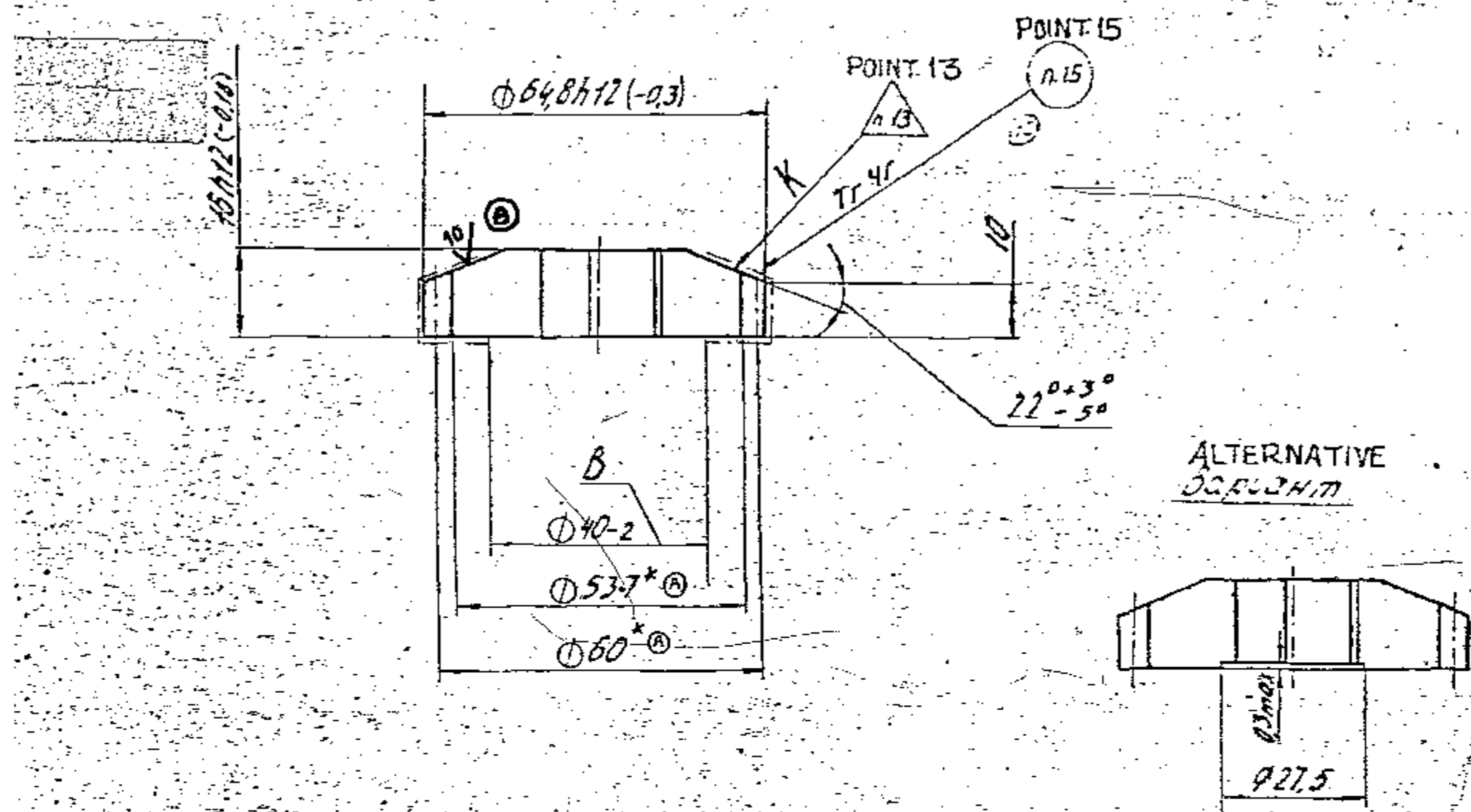


ЕСКД



1. ALTERNATE MATERIAL: STEEL GRADE 18X2H4MA AS PER TY14-1-381-72
2. INSPECTION GROUP III; TT-11.
3. TO BE CARBURIZED: FOR TEETH  $h$  0.6 TO 0.9 HRC<sub>3</sub> ≥ 55
4. HRC<sub>3</sub> 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  $\phi B$  TO DEPTH  $h$  NOT EXCEEDING 0.2 mm.
6. IT IS ALLOWED TO CASE-HARDEN 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  $h$  14, OF THE REST OF DIMENSIONS -  $\pm$  IT14/2
9. RUN-OUT OF TOOTHED RIM RELATIVE TO THE AXIS 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 FLAW DETECTOR ACCEPTANCE 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	$\alpha$	20°
ADDENDUM COEFFICIENT	$ha^*$	0.8
COEFFICIENT OF RADIUS OF CURVATURE OF CASEMENT CURVE	$\rho_f$	0.526 <sup>(A)</sup> 0.40
COEFFICIENT OF BOTTOM CLEARANCE	$c^*$	0.346 <sup>(A)</sup> 0.250
BASIC RACK MODIFICATION COEFFICIENT	x	0
DEGREE OF ACCURACY	-	-
BASIC TANGENT LENGTH	w	22.98 <sup>(A)</sup> 0.21
TOLERANCE ON COMPOSITE ERROR DOUBLE FLANK	TOTAL	F <sup>*</sup> 0.120
	TOOTH-TO-TOOTH	f <sup>1</sup> 0.050
PAINT IMPRINT FROM CONTACT WITH TEETH OF STANDARD GEAR	ALONG LENGTH	-
	ALONG HEIGHT	-
BASIC DIAMETER	$d_B$	56.38
RADIUS OF ACTIVE FLANK CURVATURE IN LOW POINT	$\rho_p$	1.48 <sup>(A)</sup> 4.56
BASE PITCH	$P_b$	8.85

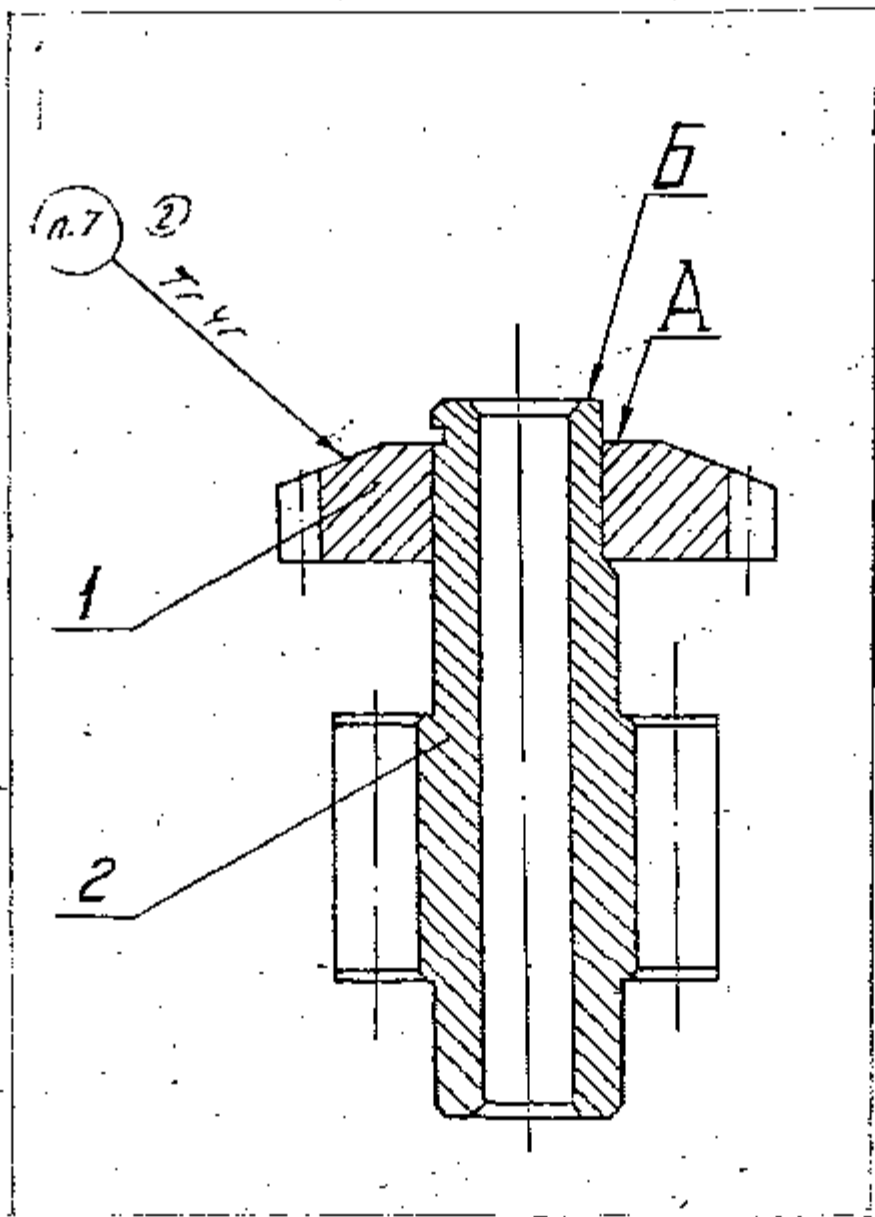
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST MASS	0.25	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	(A6) (66)
B	15.796 AUTHY. NOTN. No. BK-84-243	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
A	16.10.87 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	TY14-1-381-72	CB 3312-95-1
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
APPO		TITLE:-	OIL PUMP DRIVE GEAR
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
0312-87			412-25-2









1. Сопоставление деталей по трехгранникам  
производ. - в пункт индивидуального подбора.  
При невозможности сопряжения (из-за короб-  
ления от воздействия от термообработки) допус-  
кается производить сошлифовку граней Б  
дет. поз. 2 (сверх допуска) до обеспечения зазора  
по граням и сошлифовку диаметра цапф  
на длине трехгранника по  $\phi 24_{-0,013}^{+0,040}$  при  
этом зазор по граням должен быть не  
более 0,08 мм.

2. Радиальное биение зубчатого венца  
шестерни поз. 1 относительно оси шестер-  
ни поз. 2 не более 0,12 мм.

3. При установке узла в насос прове-  
рить совпадение рисок спаренности.

4. Натяг при сопряжении дет. поз. 1 и 2  
не допускается.

5. Окружной люфт дет. поз. 1 относительно  
дет. поз. 2 по трехграннику, замеренный на  
 $\phi 60$  мм должен быть не более 0,3 мм. При про-  
верке люфта дет. поз. 1 не должна пере-  
крывать канавку дет. поз. 2.

6. Нанести риску и номер спаренности  
на поверхности А и Б. Нанесение удар-  
ным способом не допускается.

7. Маркировать шифр предприятия-изготовителя  
и обозначение узла - при отправке в заочасть.

1. TRIHEDRAL CONNECTION OF COMPONENTS SHOULD BE DONE BY INDIVIDUAL SELECTION WHEN THE COMPONENTS 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 COMPONENT 2 (BEYOND TOLERANCE),  
-GRINDING OF JOURNAL DIAMETER ON TRIHEDRAL LENGTH ALONG  $\phi 24_{-0,013}^{+0,040}$ .  
-THE CLEARANCE BETWEEN FACES SHOULD NOT EXCEED 0.08 mm.
2. RUN OUT OF TOOTHED RIM OF GEAR 1 RELATIVE TO THE AXIS OF GEAR 2, SHOULD NOT EXCEED 0.12 mm.
3. DURING INSTALLATION OF THE UNIT INTO PUMP COINCIDENCE OF MATCHING MARKS SHOULD BE CHECKED.
4. DURING MATING OF COMPONENTS 1 AND 2 INTERFERENCE IS NOT ALLOWED.
5. CIRCUMFERENTIAL PLAY OF COMPONENT 1, RELATIVE TO COMPONENT 2 ON TRIHEDRAL MEASURED AT DIA. 60 mm SHOULD NOT EXCEED 0.3mm. COMPONENT 1 SHOULD NOT OVER-LAP THE GROOVE OF COMPONENT 2 DURING PLAY CHECKING.
6. MARK AND MATCHING NUMBER SHOULD BE PUT ON SURFACES A AND Б. TO BE MARKED OTHERWISE THAN BY PUNCHING.
7. MANUFACTURER'S CODE AND UNIT NUMBER ARE TO BE MARKED IN CASE THE COMPONENT IS INTENDED AS SPARES.

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

EST. WT. 0.7 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
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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	Равичаба	MATERIAL :-	USED ON :- Cb3312-00-15
EDD	Равичаба		
TCO	Равичаба		
APPD		CONTROLLEATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	7-03-90	A V A D I	
SCALE	1:1		
DIMENSIONS IN mm		TITLE	PAIRED GEARS ASSY.
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		D S CAT NUMBER	DRAWING NUMBER Cb3312 94 1 Cb.
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	





