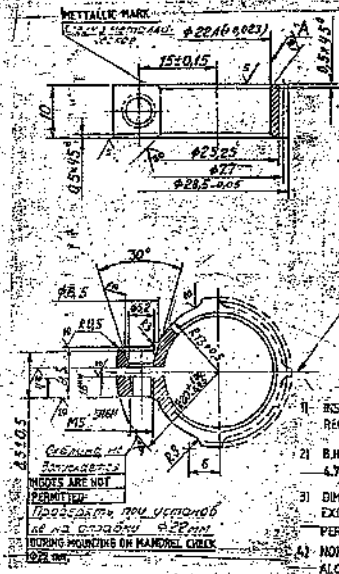


DRAWING NUMBER
327-55-1

28 (✓)



NON CONCORDANCE OF TOOTH AXIS WITH COMMON AXIS OF SURFACE A AND UNDER CUT NOT MORE THAN 0.5 mm ON 4.5 OUT OF TEETH

MODULE	0.75
No. OF TEETH	36
PRESSURE ANGLE	20°
ADDENDUM ALONG TOOTH GAUGE	0.763
TOOTH THICKNESS IN TOOTH GAUGE	1.80
PITCH GAUGE DIMENSION (ALONG TOOTH)	0.43

EXPLANATORY NOTE:-

MATERIAL QUOTED:-
ROUND BAR GOST 7417-75
GOST 1051-73

ROUND STEEL BRIGHT BAR TO GOST 7417-75
CHEMICAL COMPOSITION %
(AS PER GOST 1050-74 GRADE 45)
C = 0.42 - 0.50 ; Si = 0.17 - 0.37 ; Mn = 0.50 - 0.80
P = 0.035 Max. S = 0.25 Max.
Cu = 0.25 %

MECHANICAL PROPERTIES:
ULTIMATE TENSILE STRENGTH Kgf/mm^2 (min) = 61
YIELD POINT Kgf/mm^2 (min) = 36
% ELONGATION (min) = 16
% REDUCTION IN AREA (min) = 40
IMPACT STRENGTH Kg/cm^2 (min) = 5.

- INSPECTION GROUP IV'S PER TECHNICAL REQUIREMENTS 11.
- B.H.N 163-229 DIA OF INDENTATION 4.0-4.7 mm
- DIMENSIONS WITH UNSPECIFIED TOLERANCES EXCEPT $\phi 6.5$ SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 GOST 1010.
- NONPARALLELISM OF TOOTH GENERATRIX ALONG PITCH CIRCLE WITH THE AXIS OF SURFACE A SHOULD NOT EXCEED 0.03 mm ON TOOTH LENGTH.
- RUN-OUT OF TEETH PITCH CIRCLE RELATIVE TO THE AXIS OF SURFACE A SHOULD NOT EXCEED 0.05 mm.
- CONCENTRICITY OF THREAD HG-SH6H WITH CONE SHOULD BE CHECKED (RANDOM INSPECTION 20% FROM BATCH) WITH GAUGE BY BLUEING, PAINT IMPRINT SHOULD BE IN THE FORM OF A RING.
- THE RIM SHOULD BE SLIT AFTER CUTTING OF THE TEETH.
- SHARP EDGES SHOULD BE BLUNTED.
- ISOLATED BROTTING MARKS ARE ALLOWED ON SURFACE A.
- IT IS ALLOWED TO CHECK NON-PARALLELISM OF TOOTH GENERATRIX MAY BE CHECKED, BY RUNNING - IN 15 TEETH OF THE COMPONENT WITH STANDARD GEAR (BACKLASH BEING TAKE UP) IN THIS CASE, COMPOSITE ERROR DOUBLE FLANK SHOULD NOT EXCEED 0.057 mm (8th GRADE OF ACCURACY AS PER GOST 9178-59).
- COATING: CHEMICAL OXIDIZING, OIL FINISHING.
- IT IS ALLOWED TO CARRY OUT CHECKING BEFORE SLITTING THE COMPONENT.
- 4 - ϕ DIMENSION IS TO BE ENSURED WITH TOOL.

(A) ALTERNATE MATERIAL: STEEL 080 M40 (EN 8) TO BS: 970
PL-1-1983 OR 45 OR 10 IS: 1570

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

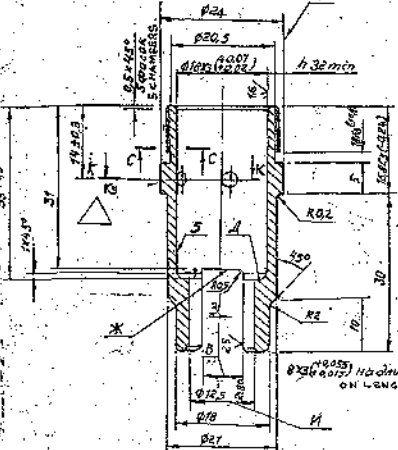
EST. WT. 0.018 kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS: LETTERS

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MARKED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

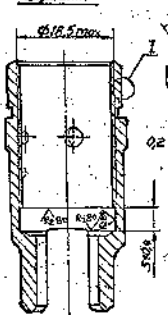
DRN	10-11-75	MATERIAL - ROUND BAR	USED ON -
EDD	10-11-75	GOST 7417-75	CB 327-06
EDD	10-11-75	45 GOST 1051-73	
APPD	15-1-76	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLE)	
DATE	15-1-76	SCALE - 2:1	A V A D I
SCALE	2:1	DIMENSIONS IN mm.	
		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-69	
		ALL THREADS TO CONFORM TO	
ISSUE	13-7-79	BY ALTERATION COMM. MINUTES POINT 8, GATE 27-2-00	TITLE TOOTHED RING
DATE		NATURE OF AMENDMENTS	D.S. CAT NUMBER
			DRAWING NUMBER 327-55-1

HS-L200

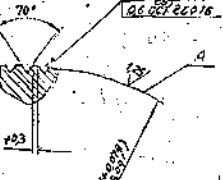
ECKA



ALTERNATIVE
Вариант



C-C
M10:1
SCALE 10:1

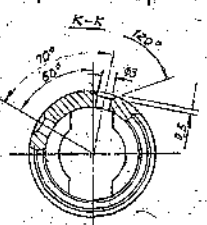
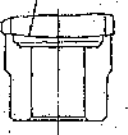


STRAIGHT KNURLING:
ПРЯМОУГОЛЬНАЯ
ГОРИЗОНТАЛЬНАЯ
ГОРИЗОНТАЛЬНАЯ

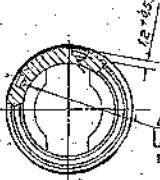
I
M10:1
SCALE 10:1



VIEW 3 ALTERNATIVE
Вид 3 вариант



ALTERNATIVE
K-K вариант



- ④ 6. DURING MACHINING ENSURE SURFACE FINISH OF T₁ AND DIMENSIONS:
 - 24 ± 0.02 mm
 - 12 ± 0.02 mm
 - ⑤ 12 ± 0.02 mm DIMENSION FOR REFERENCE
 - ⑥ ALTERNATE MATERIAL STEEL 070M20 (EN24) TO BS: 970 - Pt 1-1983 (OR) 20 Cr TO IS: 1570
- ВНИМАНИЕ
НЕ ДОПУСКАЕТСЯ
ВЫПУКЛОСТИ МЕТАЛЛА
(BULGING OF METAL IS NOT ALLOWED)

3327.04

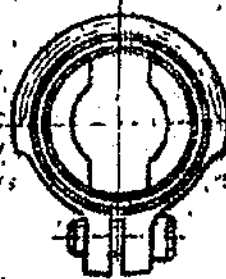
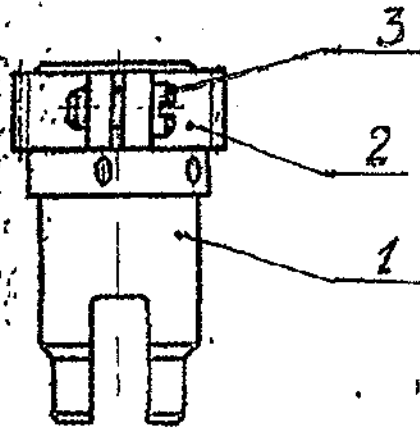
1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 (GT 1010).
2. RUN OUT OF SURFACE RELATIVE TO THE AXIS OF SURFACE SHOULD NOT EXCEED 0.03mm.
3. NON SYMMETRY OF AXIS OF SLOT B RELATIVE TO THE AXIS OF SURFACE SHOULD NOT EXCEED 0.02mm (MND)
4. RADIUS FROM CUTTER 30mm MAY BE LEFT AFTER MACHINING OF SLOT B.
5. ON SURFACE ISOLATED MARKS IN COMPLIANCE WITH STANDARD ARE ALLOWED.
6. COATINGS CHEMICAL COATING, OIL FINISHING.
7. THERE MAY BE NO COATINGS IN THE SURFACE OF SLOT B, ALONG ITS PROFILE AND ON SURFACE.
- ⑧ 8. ROUGHNESS IS NOT TO BE SPECIFIED.
9. HOLE MAY BE INCREASED UP TO DIMENSION 12.00mm.
10. ON FACE OF THE SLOT B CUTTING IN UP TO 0.5mm IS ALLOWED AFTER WITHDRAWAL OF GRINDING WHEEL.
11. ALTERNATE MATERIAL: STEEL GRADES, 25, 30 AND 40: GOST 1050-74.

⑨ MATERIAL ROUND BAR 20 Cr TO BS: 970-75 (OR) GOST 1050-74 (A-B)

EST. MASS	0.035 Kg	TO BE STAMPED OR MARKED WHERE UNLATER THIS # LETTERS
SCALE	2:1	
DRAWN		
CHECKED		
APPROVED		
DATE		
DIMENSIONS IN mm		CONTROLLED BY INSPECTION (HEAVY VEHICLES) AVAL
TOLERANCE ON DIMS UNLESS OTHERWISE STATED		
ALL THREADS CONFORM TO		
TITLE		SLEEVE ROTARY
D S CAT NUMBER		3327.04

DRAWING NUMBER

CB 3327 06



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

(A-8)

EST WT
0.063 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

MATERIAL

USED ON

CB 20-27-00-4
CB 327 00 45

ISSUE DATE

NATURE OF AMENDMENTS

SCALE : 1 : 1

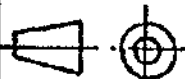
DRN

DIMENSION IN mm

CHD *Daiva*

TOLERANCE ON DIMNS
UNLESS OTHERWISE
STATED.

TCD *Shukron*



TITLE:

CONTROL SLEEVE ASSY

APPD *W. S. S.*

ALL THREADS TO
CONFORM TO

D S CAT NUMBER

DRAWING NUMBER

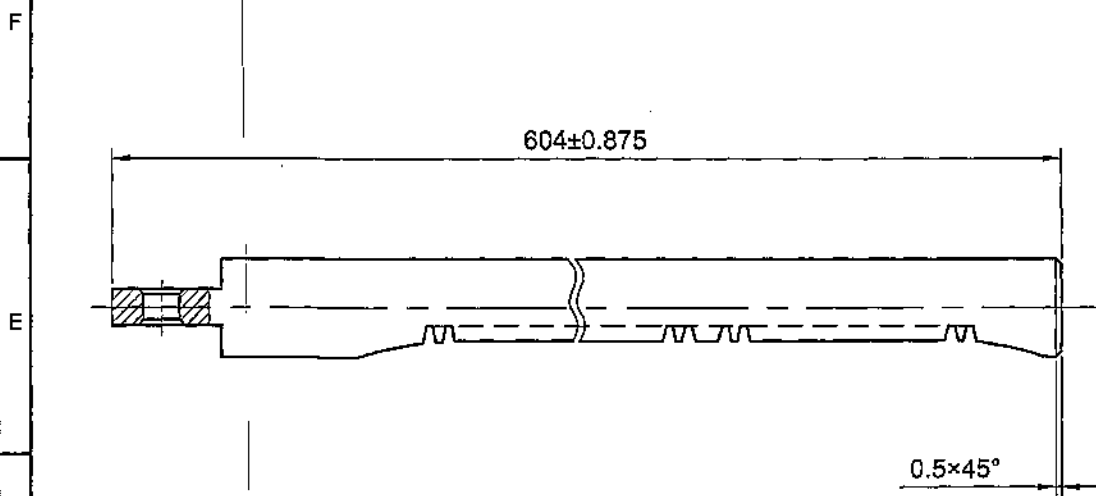
DATE 08-5-86

CB 3327 06

SIZE A4

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

DRAWING NUMBER
327-75-11



F-5
53
283

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

		EST. WT. (Kg) 0.78	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.	
		MATERIAL :- BLANK 327-75-6	USED ON:- CB 327-00-73
ISSUE DATE	NATURE OF AMENDMENTS		
DRN <i>Atarlu</i>	SCALE :- 1:1 DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
CHD <i>R. K. Reddy</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69		TITLE :- TOOTHED CONTROL RACK
APPD <i>[Signature]</i>	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 327-75-11
DATE 21/3/07			
SIZE A4			

