

First use

Reference No.

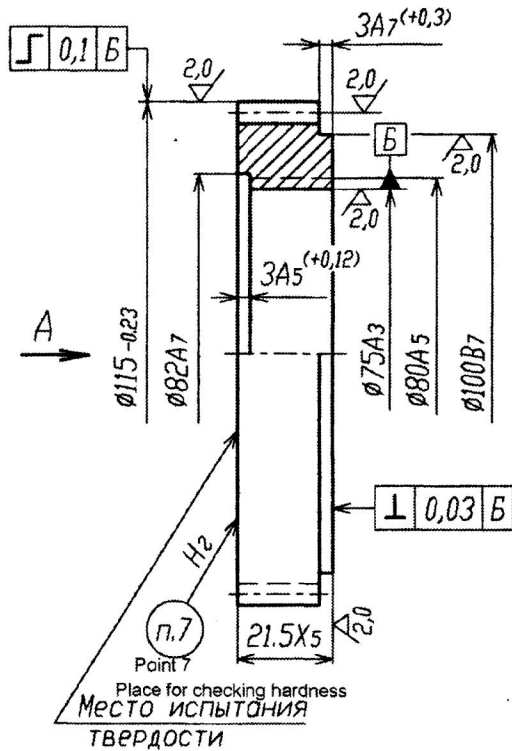
Sign and Date

Duplicate Inv. No

Alternate Inv. No

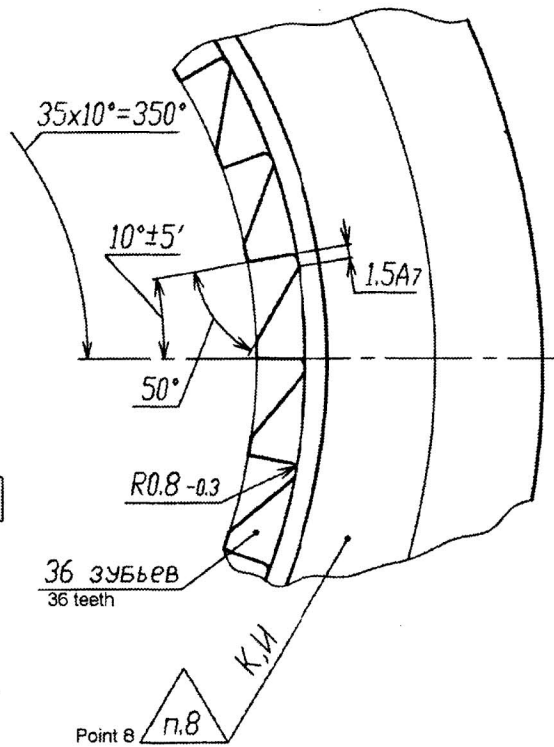
Sign and Date

Orig. inv. no.



A(2:1)

Rz20 (✓)



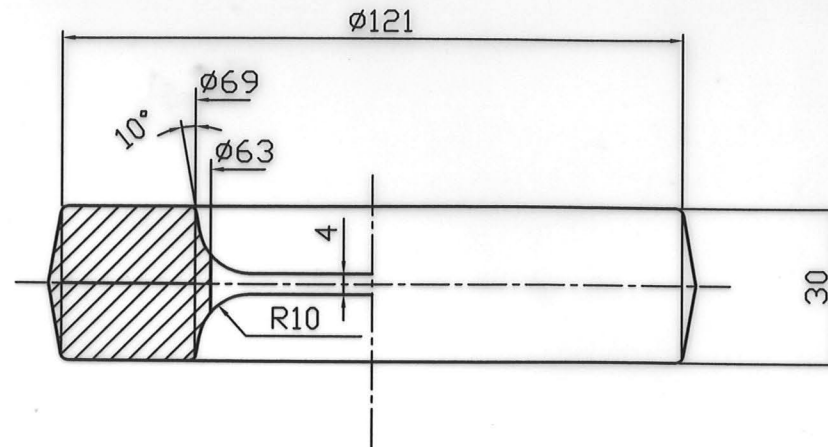
Module	m	2.5
No. of teeth	Z	44
Tangent basic rack	-	GOST 13755-81
Addendum modification coefficient	X	0
Accuracy grade as per GOST 1643-81	-	7-V
Tooth depth	h	5.625
Base tangent length	W	$34.75_{-0.114}^{-0.177}$
Reference diameter	d	110
Designation of drawing of adjoining wheel	-	AO-18.01.001

- 1.43.5...51.5 HRC<sub>E</sub>.
2. Maximum deviation of angles between any internal non adjoining teeth  $\pm 5'$ .
3. Inner angles R-0.4 mm.
4. Blunt edges R-0.6 mm.
5. Test data are selected as per GOST 1643-81 depending on conditions and possibilities of the manufacturer.
6. Coating: Chem.phos.accel.Cr./impregnation with lacquer BT-987 GOST 6244-70, single coating.
7. Mark in letter size PO-3 GOST 2930-62.
8. Stamp

AO - 18.03.025

					<b>AO - 18.03.025</b>			
					Pinion	Type	Weight	Scale
						O <sub>2</sub>	0.754	1:1
					Sheet		Sheets 1	
					Steel 30KhRA OST 3-98-80			
Amen.	Sheet	Doc.No.	Sign	Date				
Developed by								
Checked by								
Head of Q.C.D								
Approved by								

ALL DIMENSIONS ARE IN MM.  
 UNTOL DIMNS. ARE AS PER IS:2102.



- 1> Displacement as stamp joint up to 0.8 mm.
- 2> Burrs along perimeter cut up to 1 mm .
- 3> Burrs on matrix joint up to - mm.
- 4> Face burrs up to - mm.
- 5> visual defects: forging marks,nicks and cavities due to scaling etc. with depth up to 0.5 mm.
- 6> unspecified radii 1.5 mm .
- 7> Unspecified stamping deviation not more than -  $7^\circ$ .
- 8> Allowance and Tolerances as per II class GOST 7505-74

Vertical +1.5  
 -0.7  
 Horizontal +1.6  
 -0.8  
 Die forging.

- 9> No. of components with forging - 1 piece.
- 10> Heat treatment - normalization.
- 11> Rod arrow bent - mm.

MATL RUSSIAN ORIGN - STEEL 30khRA  
 OST 3-98-80  
 INDGNS. EQUIVALENT:AS PER CQA(MET)  
 STEEL 25cr13M06  
 IS: 4367-91  
 (Secondary refined steel)

1	1	STEEL 30khRA OST 3-98-80	GEAR BOX
ITEM NO.	NO. OFF	MATERIAL	DESCRIPTION

LIST OF PARTS

Schedule No.		Compt. : AO-18.03.025		St. Drg. No. :	
Scale: 1:1				STARTER ASSY. AK--630 M-GUN.	
Drawn By:				<p style="text-align: center;"><b>GEAR BOX</b></p>	
Traced By:					
Checked By:					
Approved By:					
DT. & SG.		DRG. NO.:		F - 2301	
DESCRIPTION		APPROVED BY:		NO. OF SHEETS:	
		DATE:		SHEET NO.:	
		SIGR.:		G & S FY. COSSIPORE	
				1	