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GENERAL TOLERANCES (FREE SIZE TOLERANCES) PER DIN 7168-m	
LINEAR DEVIATION	ANGULAR DEVIATION
0.5 UP TO 6	10 UP TO 10
6 UP TO 30	10 UP TO 50
30 UP TO 120	10 UP TO 120
120 UP TO 400	10 UP TO 400
±0.1	±1°
±0.2	±30'
±0.3	±20'
±0.5	±10'

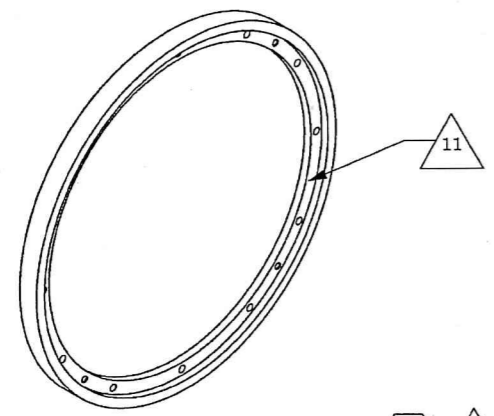
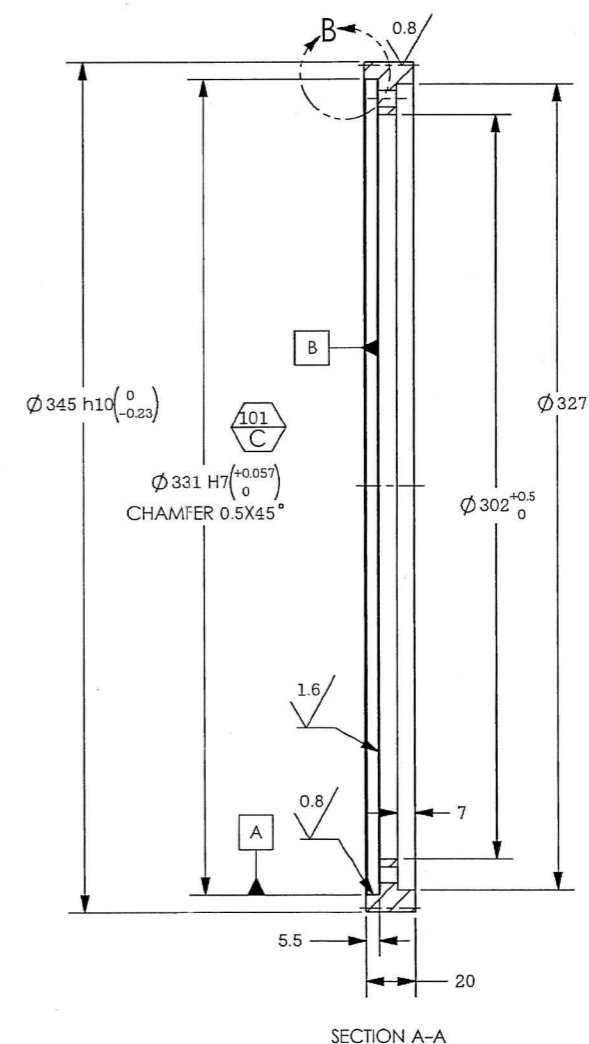
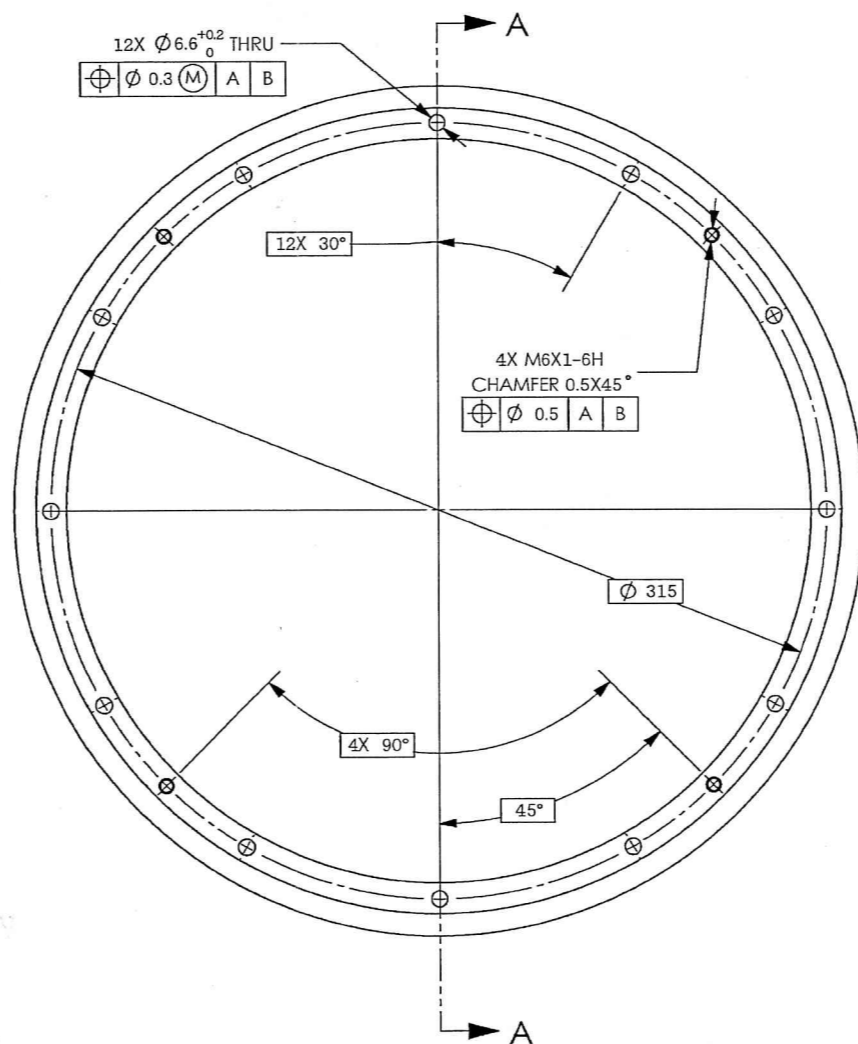
ABOVE 400 MM SEE SPEC DIN 7168-m

SHEET REV STATUS  
ALL SHEETS ARE THE SAME REVISION

REVISION RECORD				
REV	ECO	DESCRIPTION	DATE	APVD
01		Freeze	08-Jul-08	
02		Freeze	08-Nov-09	
03		Restricted	01-Dec-09	
-	T00064	Identical To Previous Released	09-Apr-18	L. Goldstein

NOTES :

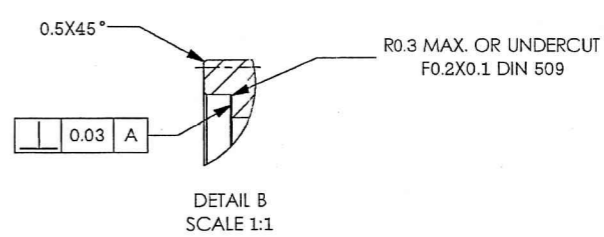
- INTERPRET THIS DRAWING IAW ASME Y14.100M.
- MATERIAL: STEEL ALLOY SAE 8620 OR SAE 9310. (EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).
- HEAT TREATMENT: CARBURIZE THE TEETH ONLY. QUENCH AND TEMPER ENTIRE PART. CASE HARDNESS MIN. 650 HV1; CORE HARDNESS 300-390 HV5. CASE DEPTH UP TO 550 HV1, 0.3-0.5 MM MEASURED ON PITCH DIAMETER AFTER GRINDING.
- DEBURR AND REMOVE SHARP EDGES APPROX. 0.3X45°.
- GENERAL TOLERANCES ACCORDING TO DIN 7168-m.
- MAGNETIC PARTICLE INSPECT NO IDENTIFICATION OF CRACKS OR DISCONTINUITES PERMITTED (IN ACCORDANCE WITH ASTM E 1444-93).
- GEAR TEETH INVOLUTE PROFILE MUST BLEND WITH FILLET AND/OR APPROXIMATE RADIUS AT OR BELOW FROM DIAMETER; NO STEP OR UNDERCUT PERMITTED.
- BLACK OXIDE CLASS 2 PER MIL-DTL-13924.
- QUALITY ASSURANCE PROVISIONS:
  - QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RD40392477P.
  - CRITICAL CHARACTERISTICS NOS. 1 TO 2.
  - MAJOR CHARACTERISTICS NO. 101.
- IDENTIFY PART PER MIL-STD-130 BY STAMPING OR BY LABELLING. CHARACTERS 3.2 MM HIGH MEETING REQUIREMENTS OF MIL-STD-202F METHOD 215J. LOCATION APPROX. AS SHOWN.
- PACKAGING AND PACKING: THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH COMMERCIAL PRACTICE.



DESIGN & DRAWING OFFICE  
 Ordnance Factory,  
 Tiruchirappalli-620016

CERTIFIED CORRECT COPY  
 OF APPROVED DRAWINGS  
 AT THIS DATE: 26/11/2020

SPUR GEAR		
CLASS TOLERANCE	-	7124-DIN 3961
NO. OF TEETH	Z	228
MODULE	m	1.5
ADDENDUM MODIF. COEFFICIENT	X	0.007595
SPLINE DATA/PRESSURE ANGLE	-	DIN 867/20°
BOTTOM CLEARANCE	-	0.25xm
REFERENCE DIAMETER	d	342
BASE TANGENT LENGTH	W <sub>25</sub>	113.256 0/-0.038
SINGLE PITCH TOLERANCE	f <sub>p</sub>	0.012
TOTAL PITCH TOLERANCE	F <sub>p</sub>	0.045
TOOTH TRACE TOTAL DEVIATION	F <sub>b</sub>	0.007
TOTAL PROFILE DEVIATION	F <sub>f</sub>	0.012
TWO-FLANK WORKING DEVIATION	F <sub>f</sub> '	0.036
RUN-OUT A	F <sub>r</sub>	0.032
IDENT. - NO. OF MATING GEAR	-	019903A-00
NO. OF TEETH OF MATING GEAR	-	17
CENTER DISTANCE IN CASING	a	184.5
AND TOLERANCE	A <sub>a</sub>	js6



UNLESS OTHERWISE SPECIFIED		SIGNATURE	DATE	ORDNANCE FACTORY TIRUCHIRAPPALLI	
UNLESS OTHERWISE SPECIFIED PER ASME Y14.5M - 1994		DRAWN	11/09/20	FOR: TRAVERSE BEARING ASSY	
TOLERANCES LINEAR SEE NOTE 5 ANGULAR SEE NOTE 5		CHECKED		OF: 12.7MM SRCG	
1ST. ANGLE PROJECTION		HOS/DDO	3/19/20	TITLE: GEAR CROWN	
SURFACE TEXTURE IN MICRO M		OFFICER/PRODN		SIZE: C	CAGE CODE: 2291A
		OFFICER/QC		DWG NO: 019789A-00	
		OFFICER/DDO	3/19	SCALE: 1/2	SHEET 1 OF 1

DWG NO 019789A-00  
 SH 1