



TO BE POLISHED ALONG THE ENTIRE CONTOUR OF TEETH. CHAMFERS SHOULD BE MADE BEFORE CARBURIZATION. FINISHING IS ALLOWED AFTER CARBURIZATION.

- BEFORE PRESS-FITTING THE BUSH, THE GEAR SHOULD BE HEATED IN OIL UPTO THE TEMPERATURE OF 100 ... 120°C.
- REFITTING IS ALLOWED NOT MORE THAN ONCE WITH REPLACEMENT OF BUSH.
- CARBURIZING DEPTH FOR TEETH PROFILE IS  $h 0.6 \dots 0.9 \text{ mm}$ , FOR TIP CIRCLE IS  $h 0.5 \dots 0.9 \text{ mm}$ ;  $HRC_3 \geq 59$ .
- FINISH OF SURFACE 'A' SHOULD BE ACCEPTED AS PER STANDARD.
- TOOL LONGITUDINAL MARK TO A DEPTH OF NOT MORE THAN 0.03mm IS ALLOWED ON THE SURFACE A.
- RUN-OUT OF TEETH TIP CIRCLE RELATIVE TO SURFACE 'A' SHOULD NOT EXCEED 0.05mm.
- CONICITY AND ELLIPTICITY OF SURFACE A SHOULD NOT EXCEED 0.01mm.
- AFTER FINAL MACHINING THE THICKNESS OF LEADED BRONZE LAYER ALONG THE END FACE OF ASSEMBLED COMPONENT SHOULD BE  $(0.6 \pm 0.74) \text{ mm}$ . AFTER FINAL MACHINING THE RADIAL THICKNESS OF LEADED BRONZE LAYER OF ASSEMBLED COMPONENT SHOULD BE  $(0.75 \pm 0.25) \text{ mm}$ ; TO BE ENSURED BY TECHNOLOGY.
- SHARP EDGES ARE TO BE BLUNTED.
- QUALITY OF TEETH ENGAGEMENT SHOULD BE CHECKED BY BLUEING BY RUNNING-IN WITH STANDARD GEAR. IN THIS CASE, BLUE-IMPRINT SHOULD COVER 55% OF MIDDLE PORTION OF TOOTH FLANK IN HEIGHT AND 80% MIN IN LENGTH. THE IMPRINT SHOULD BE AS PER УБ-89-3 А.
- TOTAL ERROR OF DISTORTION SHOULD BE CHECKED, IF THE TEETH ARE NOT CHECKED BY BLUEING.
- GEARING ENGAGEMENT SHOULD BE CHECKED RELATIVE TO SURFACE A.
- MACHINING, DENTS AND CUTS ARE NOT ALLOWED ON SURFACE B.
- BURNS ON THE GROUND SURFACE OF TEETH PROFILE ARE NOT ALLOWED.
- AFTER GRINDING THE TEETH, THE UNIT IS TO BE CHECKED ON MAGNETIC-FIELD FLAW DETECTOR AND ACCEPTED ACCORDING TO ТТ-УБ-17.
- TO BE STAMPED BY ELECTRO-CHEMICAL METHOD.

MODULE		m	2.5
NUMBER OF TEETH		Z	52
BASIC RACK	PROFILE ANGLE	$\alpha'$	20°
	CO-EFFICIENT OF	ADDENDUM	$f'$ 0.8
		DEDENDUM	$f''$ 1.15
FILLET RADIUS		Zr	1
ADDENDUM MODIFICATION CO-EFFICIENT		$\xi$	0
DEGREE OF ACCURACY AS PER GOST 1643-56			6-6-5
BASE TANGENT LENGTH		L	42.4 $\pm$ 0.07
TOLERANCE ON BASE TANGENT LENGTH		$\delta_{L1}$	0.022
TOLERANCE ON COMPOSITE ERROR DOUBLE FLANK	TOTAL	$\delta_{\sigma a}$	0.058
	TOOTH TO TOOTH	$\delta_{\gamma a}$	0.022
BASE PITCH		$t_0$	7.38 $\pm$ 0.01
MAXIMUM DIFFERENCE OF BASE PITCHES OF SIMILAR PROFILES WITHIN THE GEAR			0.01
TO BE CHECKED IN CASE THE GEAR IS NOT CHECKED BY STANDARD GEAR.	TOLERANCE ON PROFILE	$\delta_{\gamma}$	0.012
	TOLERANCE ON TOTAL ERROR OF DISTORTION.	$\delta_{\delta a}$	0.01
	TOLERANCE ON RADIAL RUN-OUT OF TOOTHED RIM	$E_o$	0.038
BASE CIRCLE DIAMETER		$d_0$	122.16
RADIUS OF INVOLUTE CURVATURE AT THE START OF PROFILE WORKING SECTION		$\rho_0$	16.9

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

EST. WT. 1.28 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)  
 ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MAJINED CORNERS TO HAVE R OUTSIDE INSIDE EQUIVALENT. CHAMFERS ARE PERMISSIBLE.

DRN	M	MATERIAL	USED ON
CHD			с.д. 3338-401-10
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	AVA DI
DATE	18-05-96		
SCALE	1:1		
DIMENSIONS IN mm		TITLE: IDLE GEAR WITH BUSH ASSY	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		D S C4 NUMBER	
ALL THREADS TO CONFORM TO		PWA. NO. NUMBER	
D	23-2-25 AUTHYNOTN No. BK-86-74, BK90-374.	с.д. 3338-409	
ISSUE	DATE	NATURE OF AMENDMENTS	



