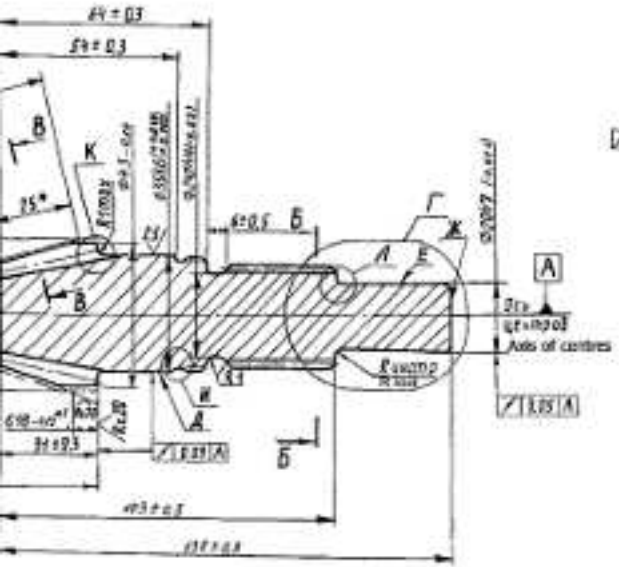
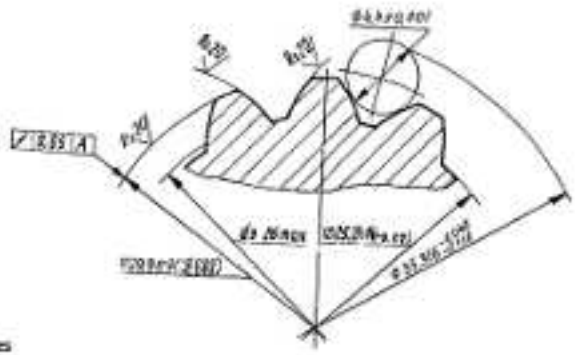
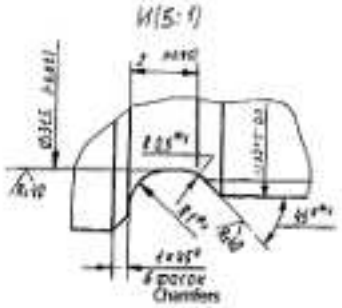
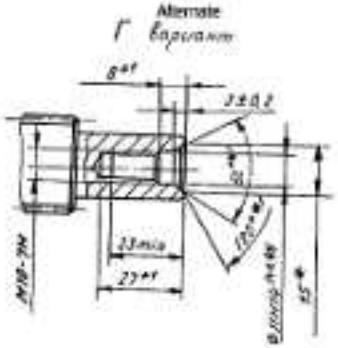






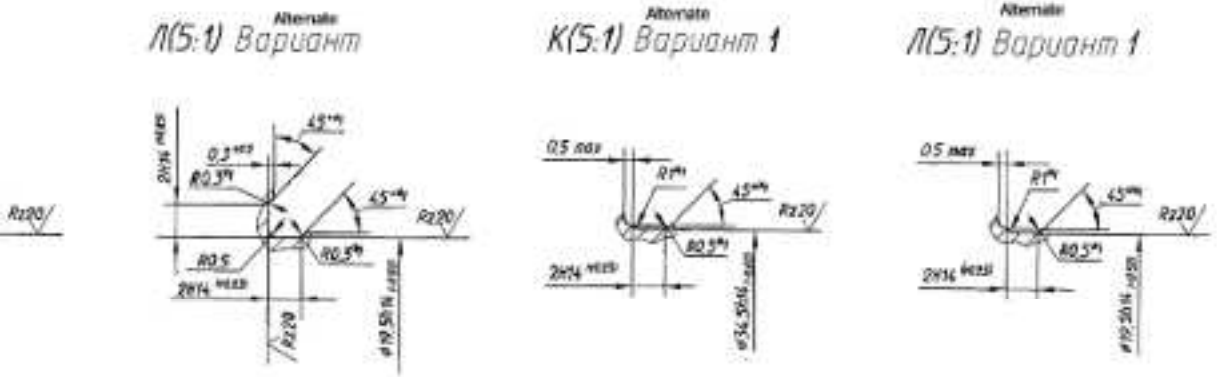


1. Check on master sample. Casehardening is permitted on surface Д, Е, Ж and in technological holes.
2. High temperature cyaniding h 0.3...0.8mm ≥ 56 HRC is permitted. Check on test piece.
3. Run - in with master gear can be substituted with checking of the geometrical elements of gear engaging.
4. Splines to be checked by spline gauge.
5. Dimension M to be checked before cutting the tooth.
6. On the faces of Component, technological holes with Ø10 max and depth 15 mm max are permitted.
7. Checking the butting of teeth of the gear with mated teeth of gearwheel 176.23.118-4 as per the bearing pattern, which should be 30-80% length of tooth and not less than 50% of working depth of tooth from each side.

   Mark the pairness number with part 176.23.118-4.
8. *Dimensions for references.
9. +/ Dimensions and surface finishing are ensured by tool.
10. Coating: Chemical phosphotizing, oxidizing oil finish or chemical oxidizing, oil finish.
11. Other requirements are as per specification 520.TY1.

Module	m	2	Facial
No. of teeth	Z	14	No. of
Profile angle	o	30°	Type
Addendum modification co-efficient	X	0	Spiral
Tooth thickness along reference circle arc	S_d	$3.142^{-0.010}_{-0.081}$	Direct
Reference diameter	d	28	Normal basic rack
Designation of drawing of mating gear	176.23.120-4		

Addendum modific efficient	
Pitch angle	
Accuracy as per GOST 1758-81	
Circumferential back lash	
Bearing pattern	
Thickness of tooth normal section (fi	
Measuring height si	
Gear cutting metho	
Tooth thickness alo reference circle arc	
Dimensions of tool head	Diame
	Devati tools
	Cutting
Root cone angle	
Designation of draw	



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

EST. WT Kgf 0.86	TO BE STAMPED OR MARKED WHERE INDICATED THIS + (LETTERS)

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

ISSUE	DATE	NATURE OF AMENDMENTS

DRN	
CHD	
APPD	
DATE	FS-11-89
SCALE- 1 : 1	
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 1100 - 69	
ALL THREADS TO CONFORM TO	