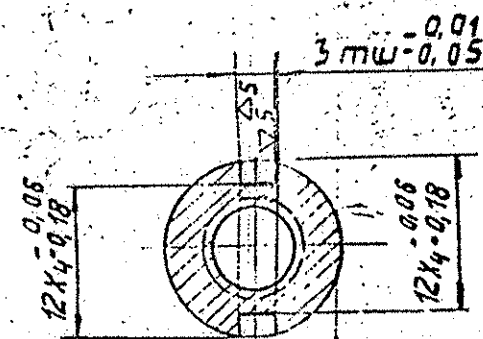
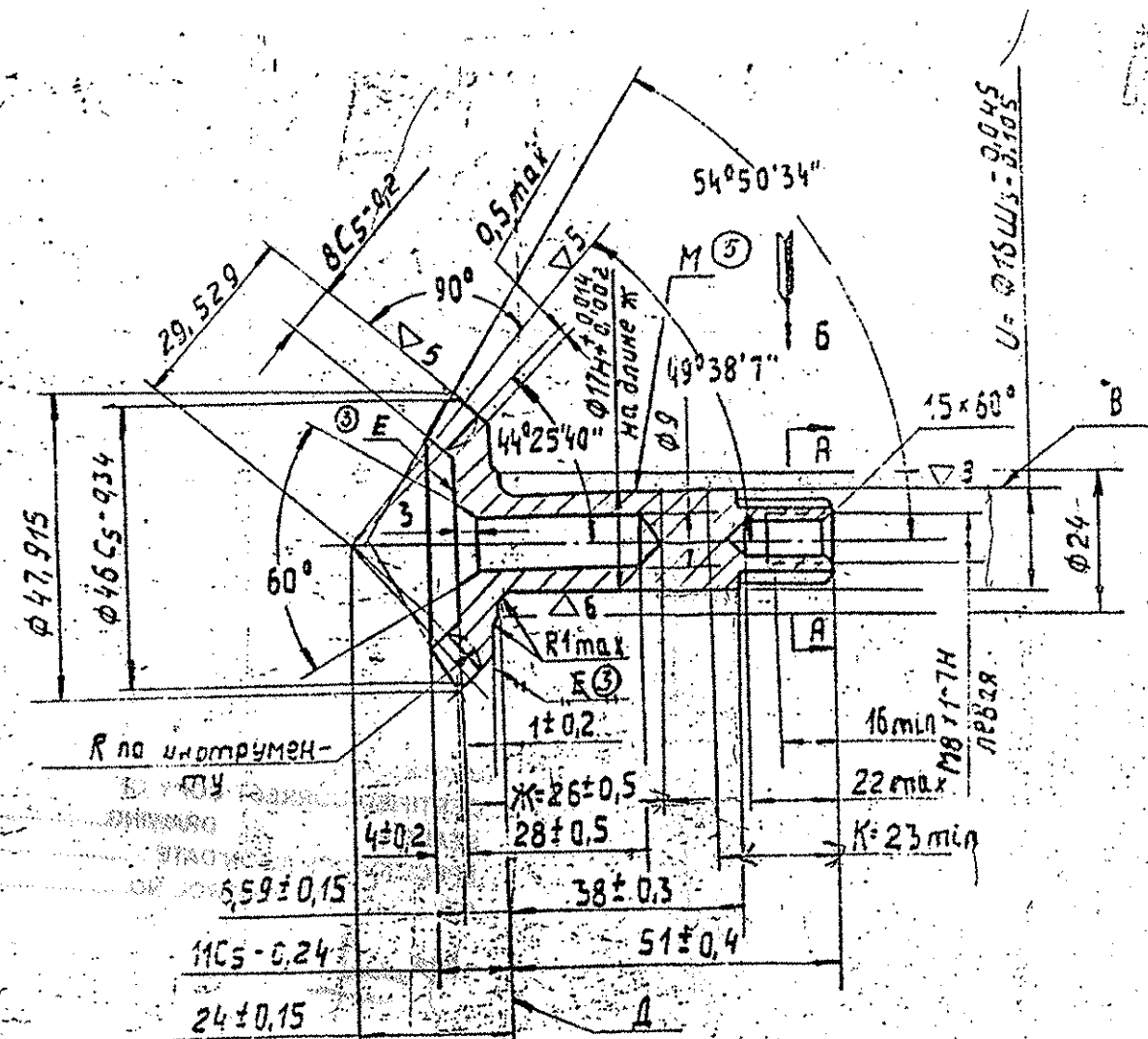
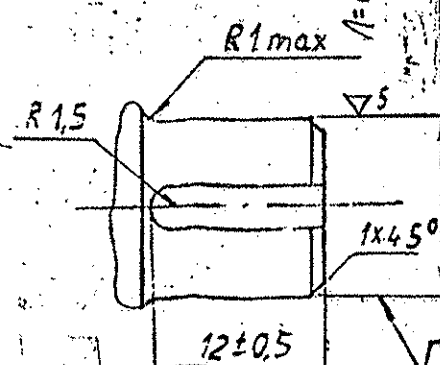


765 - 38 - 87



A-A
SCALE 2:1



VIEW. 5

Module		m	2.25
No. of teeth		z	20
Tooth type		-	Straight
Basic rack	Parameters	GOST 13754-81	
	Tooth height	n	14.95
Nominal tooth thickness along the pitch circle arc		= δ	- " -
Degree of accuracy as per GOST 1758 - 56		-	8 - X
Data for checking			
Circular pitch backlash — pair with standard gear	Size	cn	0.085
	Variation	δ_{co}	0.06
Run-out of toothing		E_D	0.05
Variation in circular pitch		δt	
Bearing pattern with teeth of standard gear	Tooth face width	%	60
	Tooth height	%	50
Data for reference			
Tooth thickness along chord at a distance of 2 mm from coarse pitch		s	2.803
Measurement height		hm	1.509
Teeth taper angle		δy	—
Mating gear		-	765-38-184

TECHNICAL CONDITIONS

Δ411 unless otherwise specified.

- 1) Blunt sharp edges
- 2) With respect to axis of surface M:
 - a) Run-out of surface D, should not exceed 0,03 mm.
 - b) Run-out of surfaces B and F should not exceed 0,04 mm.
- 3) Displacement of axes of key ways with respect to axis of surface T and between themselves should not exceed 0,1 mm (qualified tolerance).
- 4) Rockwell hardness is $HRC = 27$ to 34,5 or Brinell hardness is 341 to 285 (ϕ 3,3 to 3,6).
- 5) Check the meshing of bevel gears as per 765-TT107.
- 6) Mark as per instructions U-50-6. Place of marking is surface E.
- 7) Coating on section K: chrome-plated, 30 to 90 microns thick, oiled with varnish K9-815 GOST 11066-74. Protect key ways and threaded holes from coating. Check dimensions U and J after coating.
- 8) Gear may be made as per conventional dotted line.
- 9) Provide dimensions without deviations as per accuracy class 7, OST 1010.
- 10) CHROME PLATING TO BE CARRIED OUT 30-90 MICRONS ON 6, 16, 01-0,045 (0,105) ONLY.

[illegible]

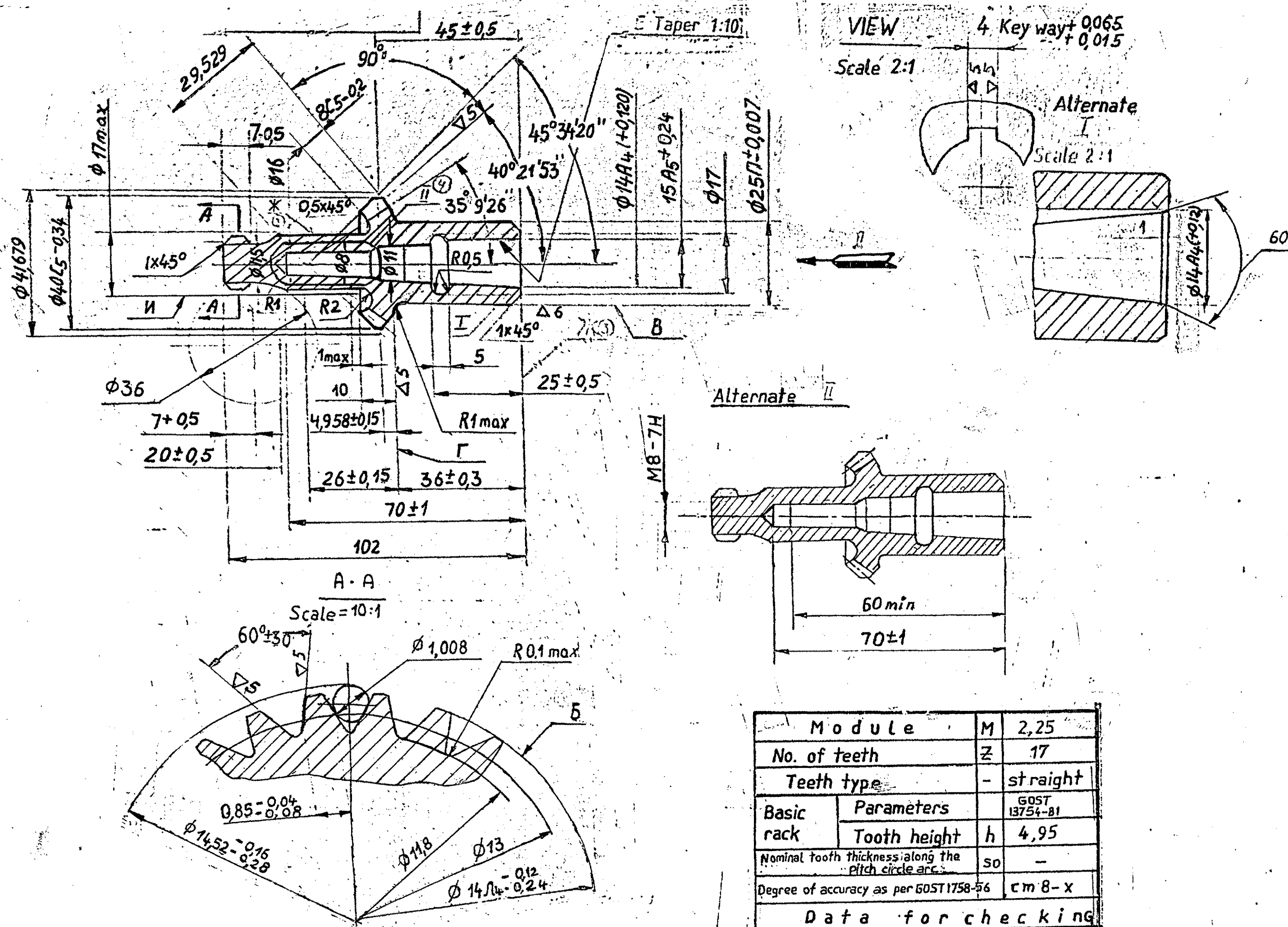
NOTE:-

1. ALL DIMENSIONS IN mm
2. PILOT SAMPLE SHOULD BE GOT APPROVED FROM AHSP
3. ASSY DRG. NEAREST ESWT. MATERIAL GIVEN IN RESPECTIVE COMPONENT DRGS.
4. OTHER TECH. CONDITIONS AS PER ORIGINAL DRG..

GEAR

765 - 38 - 87

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES) 73 OF 310



- 1) Blunt sharp edges
- 2) The followings are allowed with respect to the axis of surface B.
 - a) Run-out of surfaces F should not exceed 0,03 mm,
 - b) Run-out of surface B and E should not exceed 0,1 mm.
 - c) Displacement of axis of key way should not exceed 0,1mm.
- 3) Rockwell hardness should be c-27 to 34,5 or brinell hardness should be 341 to 285 (ϕ 3,3 to 3,6)
- 4) Check the meshing of level gears as per 765-TT107
- 5) Perform dimensions without deviations as per accuracy class 7.
OF OST 1010
- 6) Unspecified radii are R 0,5 mm
- 7) Mark as per instructions n -50-6. Marking place is surface X
- 8) Gear may be made as per conventionally dotted line.
In this case cut on surface H to depth 0,5 MM, MAX
is allowed
- 9) Alternate material is 38xc GOST 4543-71:

Module		M	2,25
No. of teeth		Z	17
Teeth type		-	straight
Basic rack	Parameters		GOST 13754-81
	Tooth height	h	4,95
Nominal tooth thickness along the pitch circle arc		so	-
Degree of accuracy as per GOST 1758-56			cm 8 - x
Data for checking			
Lateral clearance in pair with std. gear	Size	cn	0,085
	variation.	δcn	0,06
Runout of toothed rim with respect to surface B.		Eo	0,05
Variation in circular pitch		δt	
Bearing pattern with teeth of std. gear	Along length	%	60
	Along height	%	50
Data for references			
Tooth thickness along the chord at a distance 3 from big module		s	2,803
Measurement height		hm	1,509
Teeth taper angle		δy	
Mating gear		-	765-38-87

NOTE: -

1. ALL DIMENSIONS IN mm
2. PILOT SAMPLE SHOULD BE GOT APPROVED FROM AHSP.
3. ASSY DRG. NEAREST EGYPT. MATERIAL GIVEN IN RESPECTIVE COMPONENT DRGS.
4. OTHER TECH. CONDITIONS AS PER ORIGINAL DRG.

STEEL GDE 40 NI 6 Cr 4 MO 3 TO SPEC ND-15: 40 NI 2 Cr 1 MO 28 5517-78 OR STEEL TO SPEC NO B5 : 970 -19 A		00685-10 - WHILE COMPARING WITH ORIGINAL RUSSIAN PRINT SOME "DO" ERRORS HAVE BEEN OBSERVED, AND THE SAME IS CORRECTED	
NEAREST EQVT MATERIAL		DRAWING IS REVISED BASED ON COLLABORATOR'S DRG.	
4-5XGOST - 4543 - 71		AMAR 99 00641-10 - 11-7-98 ISSUE	
ORGL MATERIAL		AMENDMENTS	
ALL SHARP EDGES & CORNERS TO BE ROUNDED (REF. DRG.. NOT TO BE SCALED)		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.	
SCALE:- 1:1		USED ON:-	
DATE:- 8-5-90		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DRH. YS TCD. <i>[Signature]</i> CHD. <i>[Signature]</i> APD. <i>[Signature]</i>		WT:-(Kg) 0.282	
(()) - ()		GEAR	
		765 - 38 - 184	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			