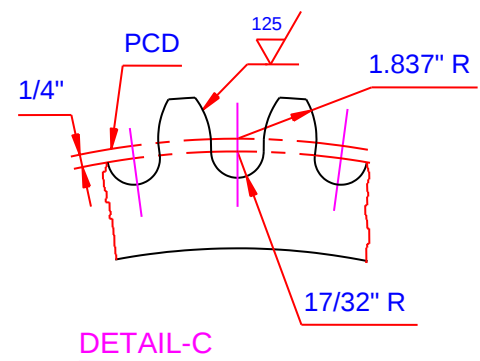
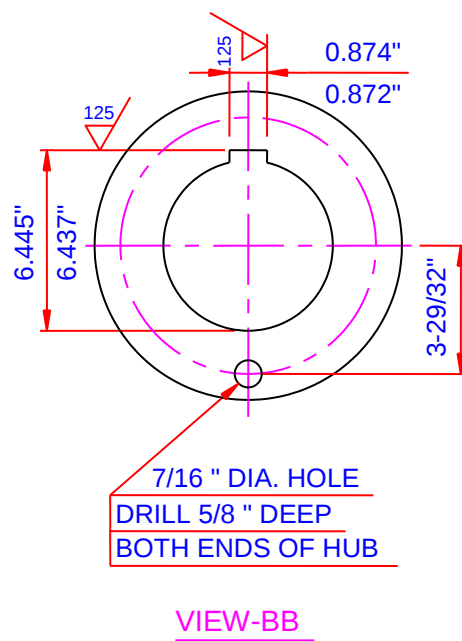
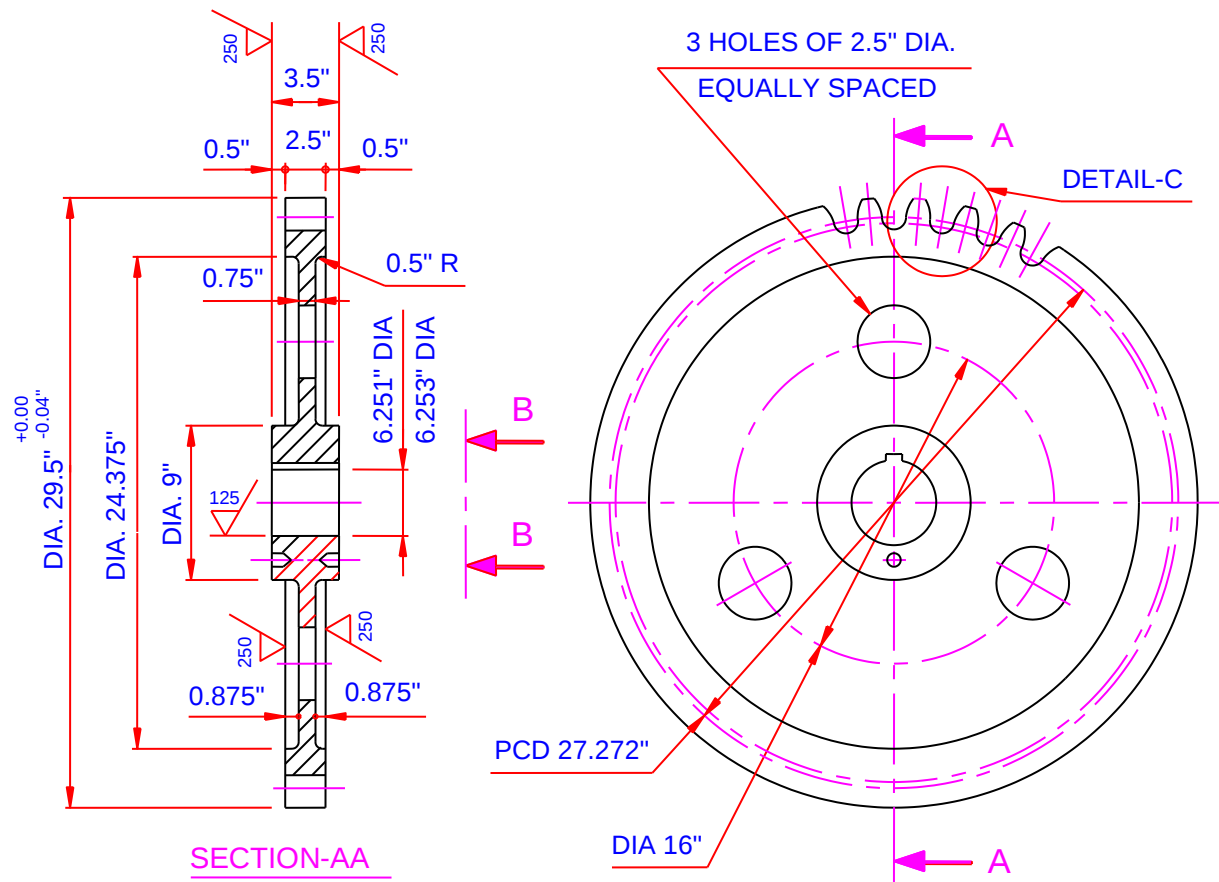


		Bharat Heavy Electricals Ltd Boiler Auxiliaries Plant Ranipet - 632 406		EDC / AIR PREHEATERS TECHNICAL SPECIFICATION Effective Date: 06.02.2017	
Specification No : APSQ – 071			Rev. No : 05		Page No : 01 of 02
01.	Item	PINION – 36 TEETH			
02.	Material code	96 320 336 0000			
03.	Application	Used to drive the Rotor of Regenerative Air Preheaters.			
04.	No. of teeth	36			
05.	Diametral pitch	1.32"			
06.	Circular pitch	2.38"			
07.	Total tooth depth	1.895"			
08.	Chordal height (hk)	22.14mm			
09.	Chordal width (sk)	-0.282 -0.376 31.74 mm.			
10.	Width across 5 teeth	-0.282 -0.376 272.6 mm.			
11.	Quality & tolerance	DIN - 3967 - 9C			
12.	Mating gear	Pin Rack Pin dia 1.0"			
13.	Dimensions	Shall be as per drawing in page 02 of 02			
14.	Material	a.Single piece type	Forged steel as per AISI 4150		
		b.Weld web type	Hub : Forged steel as per AISI 1020		
			Web : Forged steel as per AISI 1020		
			Rim : Forged steel as per AISI 4140		
15.	Heat treatment	Teeth shall be flame hardened / induction hardened to 550 to 600 BHN. Hub not to be hardened.			
16.	GENERAL a) Only latest revision shall be referred for all the Standards specified. b) Manufacture of Pinion shall be as per NTPC / BHEL approved Quality Plan SQP : APH :112. c) The pinion shall be packed properly in wooden box to avoid damage during transit.				
17.	INSPECTION a) Inspection by BHEL. b) Certificates as per SQP shall be submitted.				
05	06.02.17	(Sd) VMR	(Sd) SCH	(Sd) RSB	Reviewed & re-affirmed.
04	02.05.11	(Sd) VMR	(Sd) SCH	(Sd) KP	Clause 14 updated.
03	16.12.10	(Sd) VMR	(Sd) KP	(Sd) PPS	Clause 16 (b) changed & 16 (c) added.
02	20.04.02	(Sd) RR	(Sd) PPS	(Sd) GRV	Page modified
01	23.12.98	(Sd) GA	(Sd) PPS	(Sd) GRV	Tolerance added for OD & Keyway; hk value altered.
00	20.04.98	(Sd) GA	(Sd) PPS	(Sd) GRV	FRESH ISSUE
Rev.No	Date	Prepared	Checked	Approved	Record of Revisions.

PINION - 36 TEETHTOLERANCE

ALL TOOTH SURFACE
LIMITS UNLESS OTHERWISE NOTED
FRACTIONAL 1/64". WOBBLING SHALL NOT
EXCEED 1/32".

ALL DIMENSIONS ARE IN INCHES.