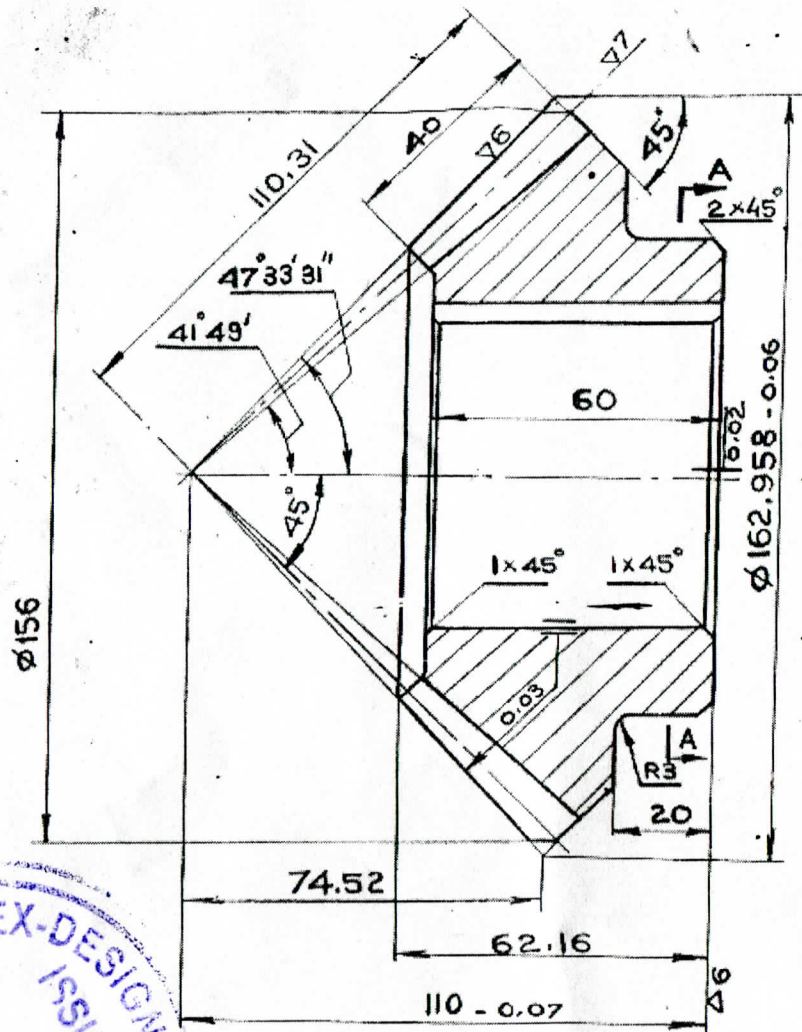
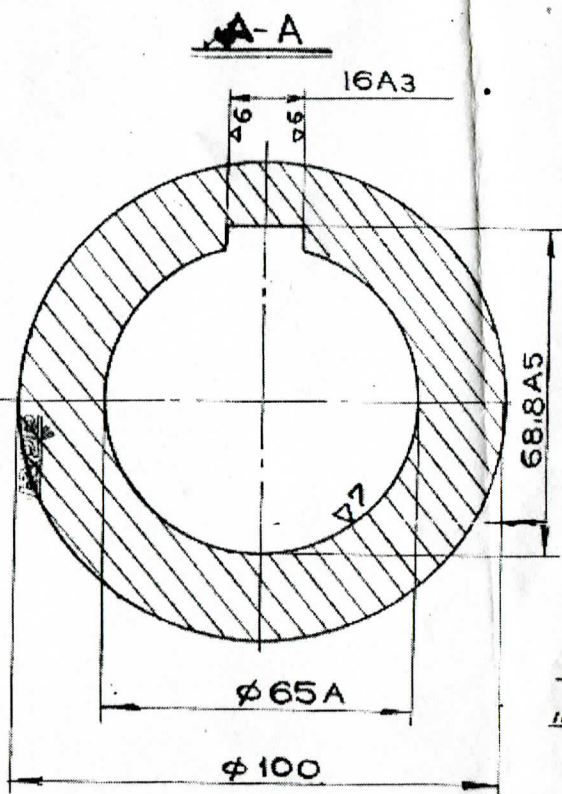


1 23



NO. OF TEETH	26
FACE MODULE	6
PRESSURE ANGLE	20°
MEAN TOOTH SPIRAL ANGLE	35°
TOOTH ADDENDUM	4.92°
TOOTH DEDENDUM	6.12
TOOTH THICKNESS AT P.C.D.	9.426
WHOLE DEPTH OF TOOTH	11.04 +/- 0.2
SPIRAL DIRECTION	L.H.
MESHES WITH	KY-152-SP-38

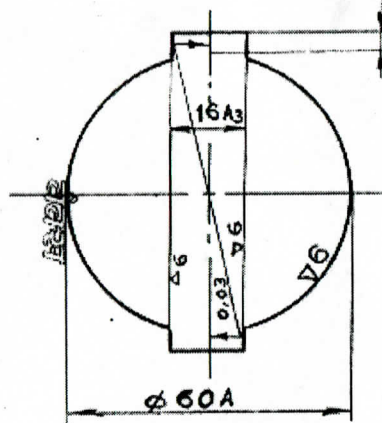
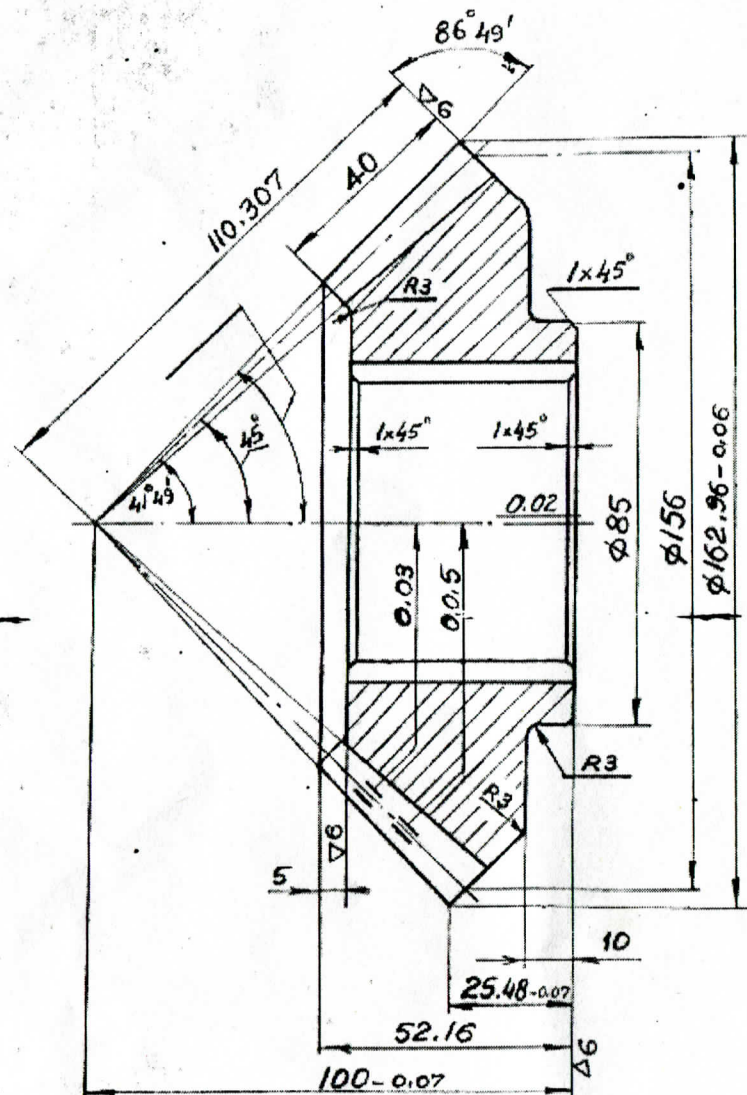


HEAT TREATMENT OF TEETH
INDUCTION HARDENING TORC-50

WEX-DESIGN BUREAU
ISSUED
117 AL
76-117038/30

						Y-TURNING & BORING MILL	A91.50.381	
						<u>BEVEL GEAR</u>	KY-152-SP-37	
DRN	D.S.BHATNAGAR	13						WT. KG
CHD								1:1
VR EXL	40X5							
SR ENR								
REPAIR						<u>STEEL 40X</u>	<u>HEEP</u>	<u>CM-II</u>

76-11-039/6038



V4 REST	
FACE MODULE	6
NO. OF TEETH	26
MEAN TOOTH SPIRAL ANGLE	35°
DIRECTION OF TEETH	R. H.
PROFILE ANGLE OF RACK	20°
ADDENDUM	4.32
TOOTH DEPTH	11.04
TOOTH THICKNESS	9.426
MESHES WITH PART NO. "	KY-152-SP-37 (A91.50.38)



HEAT TREATMENT OF TEETH CARBURIZE
TO RC 59
CARBURIZING DEPTH 1 MM

VERTICAL TURNING & BORING MILL		A91.34.375	
GEAR		KY 152-SP-38	
		WT. KG.	SCALE
		4.43	1:1
STEEL 18X1T		HEEP	CM-II

120 120 120

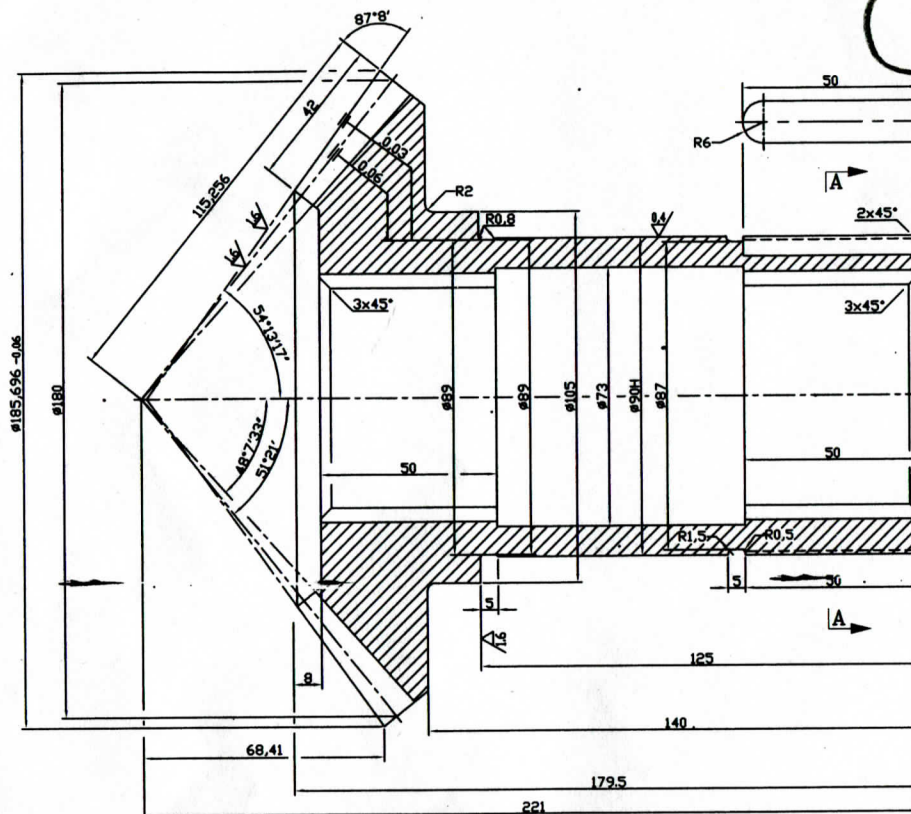
120 120 120

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM: DG 44(B)

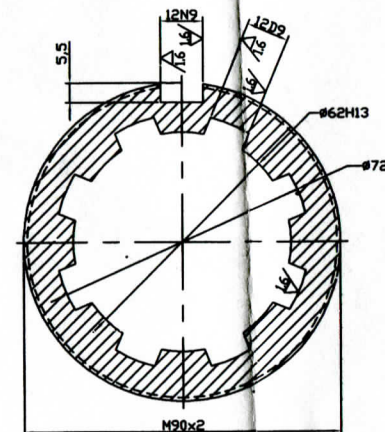
1A591-SP-132

DRAWING NO.



THE REST

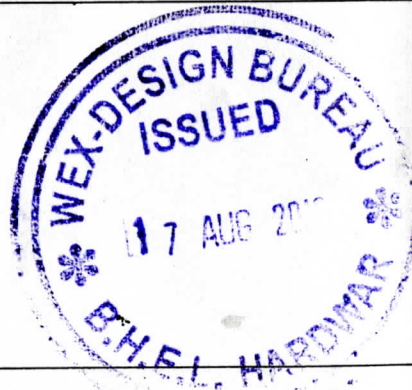
FACE MODULE	6
NUMBER OF TEETH	30
TYPE OF TOOTH	CIRCULAR
TOOTH SPIRAL ANGLE	35°
DIRECTION OF TEETH	R.H.
BASIC TOOTH PROFILE ANGLE	20°
OUTLINE ADDENDUM	4.36
TOOTH DEPTH	11.04
NOMINAL CIRCULAR TOOTH THICKNESS ON PITCH CIRCLE	8.98
ACCURACY GRADE ACCORDING TO ISCT 1758-56	GRADE C _m 7-x
HEIGHT CORRECTION FACTOR	0
TANGENTIAL CORRECTION FACTOR	0
MATES WITH PART NO.	A9153360
MAX. PERIPHERAL SPEED M PER SEC	0.0938
SHAFT ANGLE	90°



SEC.-A-A

TECHNICAL REQUIREMENTS:

1. HEAT TREATMENT OF TEETH INDUCTION HARDEN TO Rc 50.
2. RUNOUT OF #90H RELATIVE TO #72A SHALL NOT EXCEED 0.02.
3. BLUNT SHARP EDGES.
4. TOLERANCES FOR NON-MATING DIMENSIONS SHALL BE ACC. TO THE 7th CLASS OF ACCURACY.



MAT.-STEEL 40X

PLAN NO.-1-13

BLOCK-1

CBOM NO.		STATUS OF DRG.		TYPE OF PRODUCT V.BORING M/C		PLAN NO.-1-13	
AGREED	DATE	NAME	SIGN	DATE	NAME OF CUSTOMER/ PROJECT	BLOCK-1	
GRADE OF UNTOL. DIM.:--				DRN N.S.THAPA			
M/CG- N/B/M/R AA 0230208				CHD YUGENDRA			
WELDING-A/B/C/D-AA621104				APD SANJAY			
GAS CUTTING-T3'AA0621101				REF. TO ASSY. DRG.			
REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED
---				---			
DEPT. WEX		SCALE 1:1		WEIGHT (Kg.)		ITEM NO.	
CODE/DESIGN		TITLE BEVEL GEAR (R&H)		DRAWING NO. KY152-SP-132		NO. OF SHEETS 01	
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SIZE A2

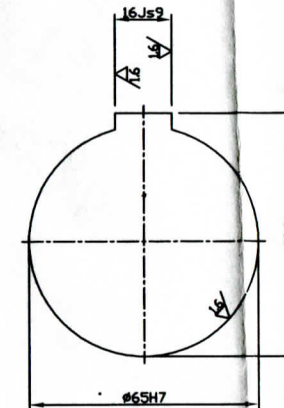
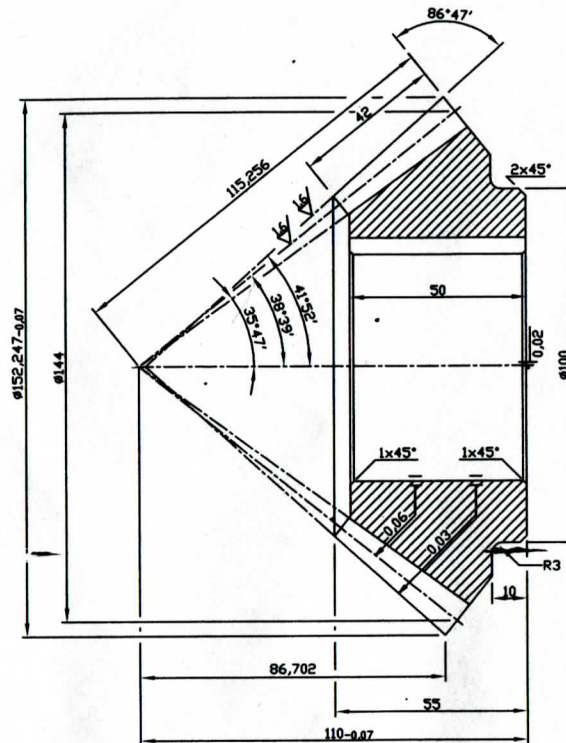
FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM: DG 44(B)

DRAWING NO.
KY-152-SP-133

✓ THE REST

NO. OF TEETH	24
FACE MODULE	6
TYPE OF TOOTH	CIRCULAR
PRESSURE ANGLE	20°
MEAN ANGLE OF SPIRAL	35°
TOOTH ADDENDUM	5,28
TOOTH DEDDENDUM	5,76
TOOTH THICKNESS ON PITCH CIRCLE	9,86
WHOLE DEPTH OF TOOTH	11,04
ACCURACY GRADE	Cm7-x
DIRECTION OF HELIX	L.H.
MATES WITH PART NO.	A9153361
MAX. PERIPHERAL SPEED M PER SEC	0,0938

HEAT TREATMENT
OF TEETH INDUCTION
HARDENING TO Rc50.

MAT.-STEEL 40x



CBOM NO.		STATUS OF DRG.		TYPE OF PRODUCT		VERTICAL TURNING & BORING MILL 10 000		PLAN NO.-1-013	
APPROVED	NAME	SIGN	DATE	NAME OF CUSTOMER/ PROJECT		BLOCK- I			
GRADE OF UNTOL. DIM:-				Bharat Heavy Electricals Ltd.		HARDWAR		NO. OF VAR.	
M/CG- N/E/M/R 0230208				DRN N.S.THAPA		CHD YOGENDRA		23/VI/2018	
WELDING-A/B/C/D-AA621104				APD SANJAY				73, 74	
GAS CUTTING-T3'AA0621101				REF. TO ASSY. DRG.				ITEM NO. NO. OF ITEMS	
REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	75, 77	
DEPT WEX				SCALE 1:1		WEIGHT (Kg.)			
CODE DESIGN				TITLE		DRAWING NO.		KY-152-SP-133 00	
				SPIRAL BEVEL GEAR		SHEET NO. 01		NO. OF SHEETS 01	
								SIZE A2	

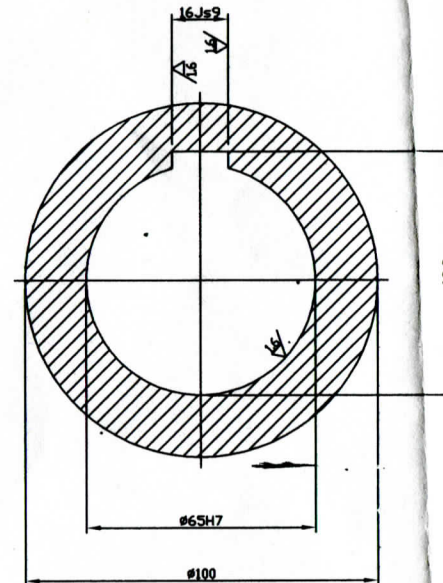
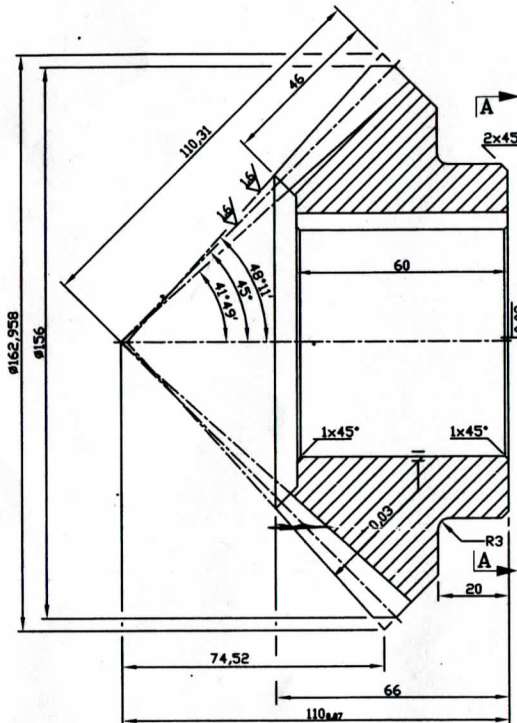
16-07-02/38
INVENTORY NO.
SIGN & DATE
A9150385
REF. DRG NO.

CONSENT AND CONFIDENTIAL
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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

FORM: DG 44(B)

DRAWING NO. KY-152-SP-134



SEC.-A-A

NO. OF TEETH	26
FACE MODULE	6
TYPE OF TOOTH	CIRCULAR
PRESSURE ANGLE	20°
MEAN ANGLE OF SPIRAL	35°
TOOTH ADDENDUM	4.92
TOOTH DEDDENDUM	6.12
TOOTH THICKNESS ON PITCH CIRCLE	9.426
WHOLE DEPTH OF TOOTH	11.04 -0.07
ACCURACY GRADE	Cn 7-x
DIRECTION OF HELIX	RH
MATES WITH PART NO.	A9150381
MAX. PERIPHERAL SPEED M PER SEC	0.08

THE REST

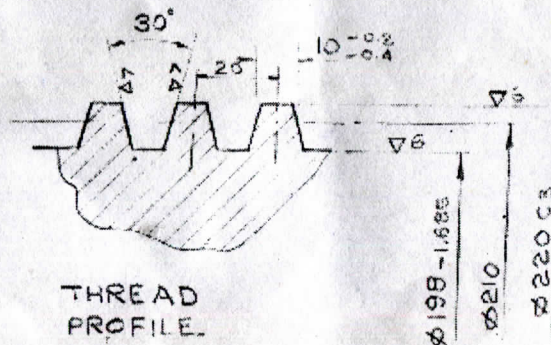
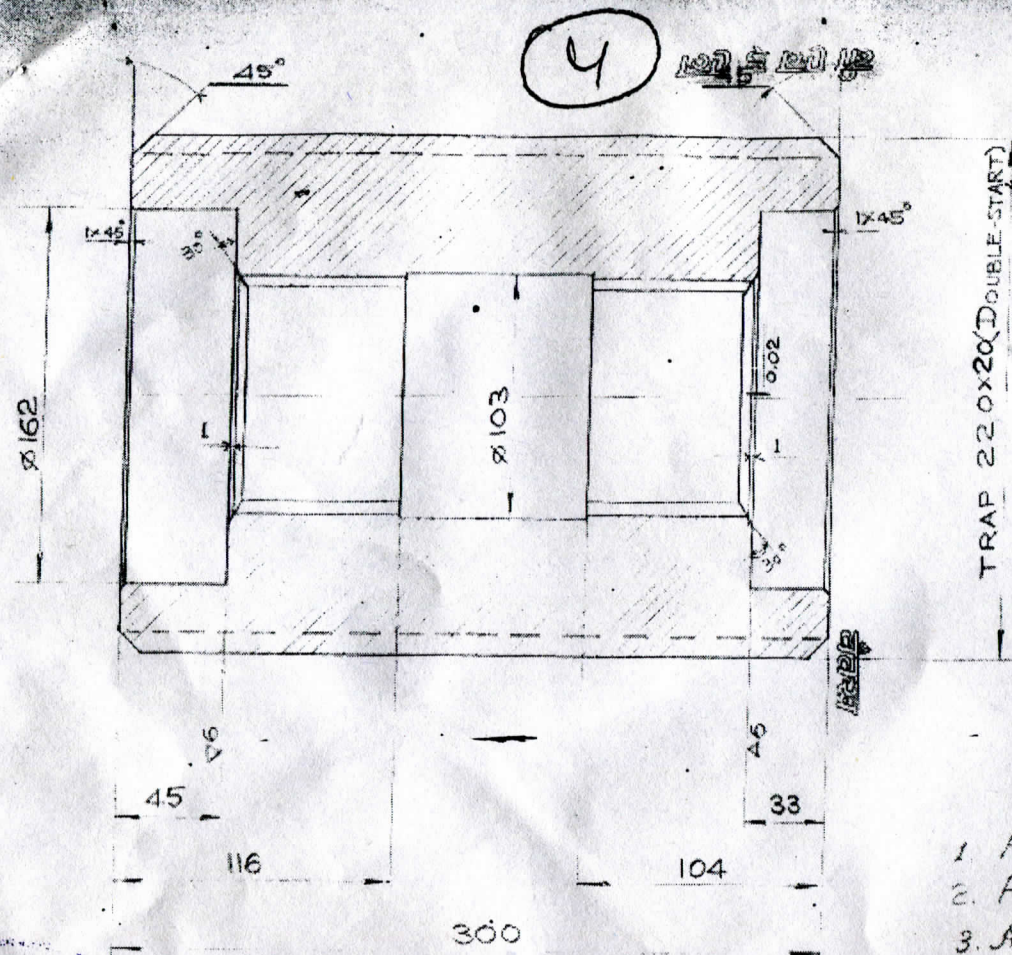
HEAT TREATMENT OF TEETH
INDUCTION HARDENING TO Rc50.

MAT.-STEEL 40x



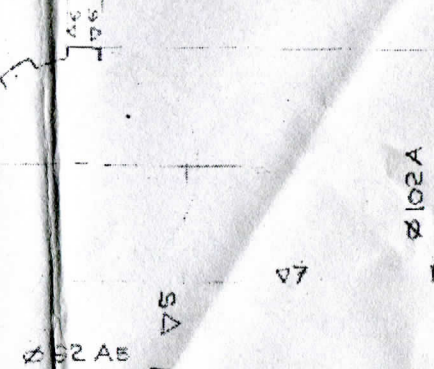
GRADE OF UNTOL. DIM.:-		CBOM NO.		STATUS OF DRG.		TYPE OF PRODUCT		VERTICAL TURNING & BORING MILL 10 000		PLAN NO.-1-013	
M/CG- X/E/M/F AA 0230208		NAME		SIGN		OR		BLOCK- I		DATE	
WELDING-A/B/C/D-AA621104		NAME		SIGN		NAME OF CUSTOMER/ PROJECT		BLOCK- I		DATE	
GAS CUTTING-T3/AA0621101		NAME		SIGN		Bharat Heavy Electricals Ltd. HARDWAR		BLOCK- I		DATE	
REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	WEX	SCALE	WEIGHT(Kg.)	REF. TO ASSY. DRG.	ITEM NO.
		CHECKED			CHECKED	CODE/DESIGN		1:1			
TITLE						DRAWING NO.		KY-152-SP-134		00	
SPIRAL BEVEL GEAR						SHEET NO.		01		NO. OF SHEETS 01	

SIZE A2



10 SPLINES

14 U₃ (+0.075 / +0.04)



TECHNICAL REQUIREMENTS

1. Runout tolerance (on lead diameter) 0.02 mm
2. Pitch error tolerance 0.02 mm
3. Accumulated error over the entire length 0.03 mm
4. Extreme (imperfect) thread turns shall be removed until the thickness is at least 5 mm.
5. Blunt sharp edges.

GRADE
WEX/1

00

V. B. M/C			A91.34.202	
SCREW FOR			KY152- SP-11	
HORIZONTAL MOVEMENT OF TOOL - POST			SCALE	
BRONZE 6-6-3			1:2	
HEEP WEX				

