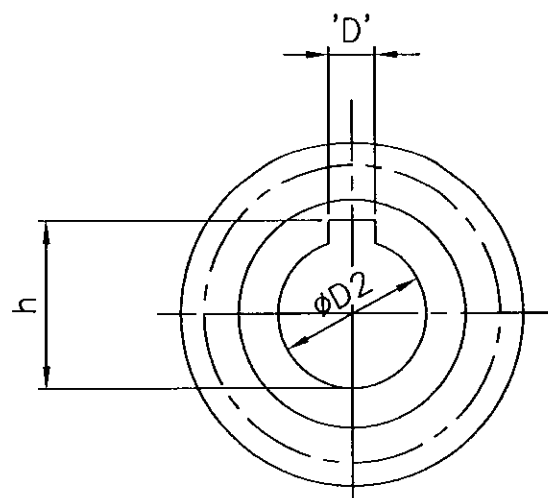
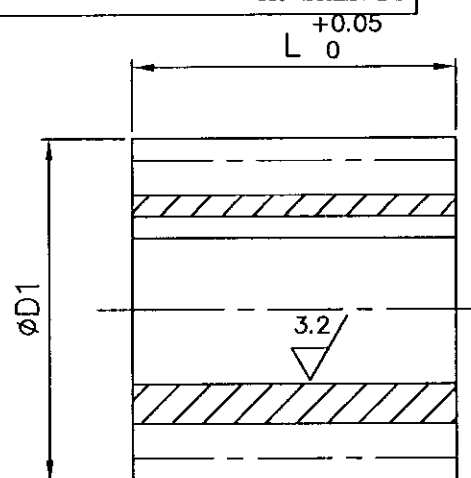


3-20-201-00119

DRAWING NO.

0.8 / (3.2)



DESCRIPTION	VARIANT NO.1 CASE HARDENED WORM 10	VARIANT NO.2 CASE HARDENED WORM 12	VARIANT NO.3 SOFT WORM 10
O D	1.45"	1.1666"	1.45"
WHETHER L.H- OR RH.	R.H	L.H	RH
KEY WAY WIDTH 'D'	5JS9	4JS9	5JS9
HEIGHT 'h'	18.3 ^{+0.1} / ₀	13.8 ^{+0.1} / ₀	17.3 ^{+0.1} / ₀
FACE 'L'	35mm	22mm	35mm
LEAD ANGLE 'Y'	4° 34'	4° 45'	4° 34'
LEAD	0.3142"	0.2618"	0.3142"
PRESSURE ANGLE	14 ¹ / ₂	14 ¹ / ₂	14 ¹ / ₂
NO.OF STARTS 'Z'	1	1	1
DIAMETRAL PITCH	10	12	10
HOLE DIA D2	16H8	12H8	15H8
PITCH CIRCLE DIA D1	1.25"	1"	1.25"
PART CODE	842020112200	842020113600	842020113500

TOLERANCE	VALUE
5JS9	±0.015
4JS9	±0.015
12H8	+0.027 0
15H8	+0.027 0
16H8	+0.027 0

NOTES

1. THREADS GROUND AND POLISHED
2. TO BE CASE HARDENED TO A DEPTH OF 0.8MM TO 1MM TO A HARDNESS RC 60-66 FOR STYLES 01 & 02 ONLY

3. TOLERANCE ON GEAR.	10DP	12DP
1. RADIAL RUNOUT ON PCD (TIR)	0 -0.018mm	0 -0.018mm
2. CHORDAL TOOTH THICKNESS AT ADDENDUM	3.99 ^{-0.16} / _{-0.235 mm}	3.32 ^{-0.105} / _{-0.18 mm}
3. AXIAL PITCH ERROR	±0.011mm	±0.011mm
4. MIN BACKLASH WHEN TEETH ARE IN CONTRACT	0.095mm	—

4. TOLERANCE ON GEAR BLANK

TIP DIA 0

-0.039

RADIAL RUNOUT OF THE CYLINDER 0.016

RADIAL AXIAL RUN OUT OF THE REF SURFACE 0.0125

5. FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.

01	WORM 10 D 40	15-039-116	A 193 B7			0.150			3
01	WORM 12 D 50	15-027-142	IS157013Ni3Cr			0.100			2
01	WORM 10 D 50	15-027-142	IS157013Ni3Cr			0.150			1
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.,

UNIT: HIGH PRESSURE BOILER PLANT.

TIRUCHIRAPALLI-620014.

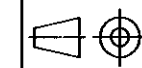
365-121

DEPT

VL

CODE 330

TITLE



SCALE

NTS

WEIGHT (KG).

CARD

CODE

U 01

DRAWING NO.

REFERENCE INFORMATION

DRAWING NO.

3-20-201-00119

NO. OF
ITEMS

REV

09

REV	DATE	ALTERED
09	11.06.01	CHD & APPD

DRG.UPDATED AND REDRAWN.

DCN: SB:1298

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