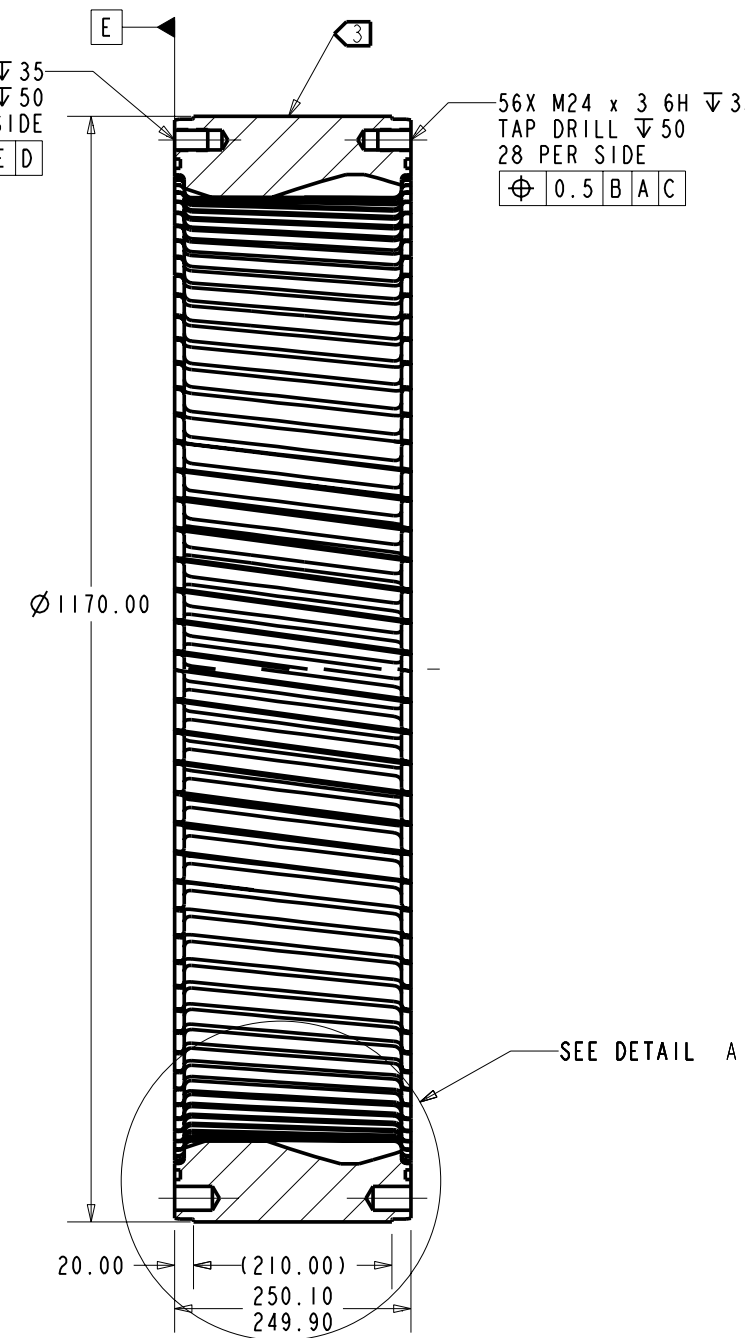


56X M24 x 3 6H ∇ 35
TAP DRILL ∇ 50
28 PER SIDE
 \oplus 0.5 F E D

56X M24 x 3 6H ∇ 35
TAP DRILL ∇ 50
28 PER SIDE
 \oplus 0.5 B A C



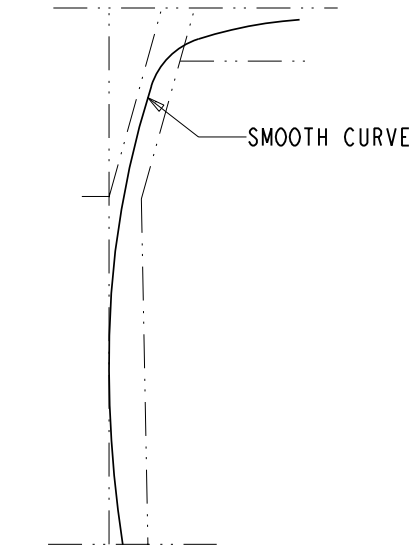
SECTION A-A

NOTES:

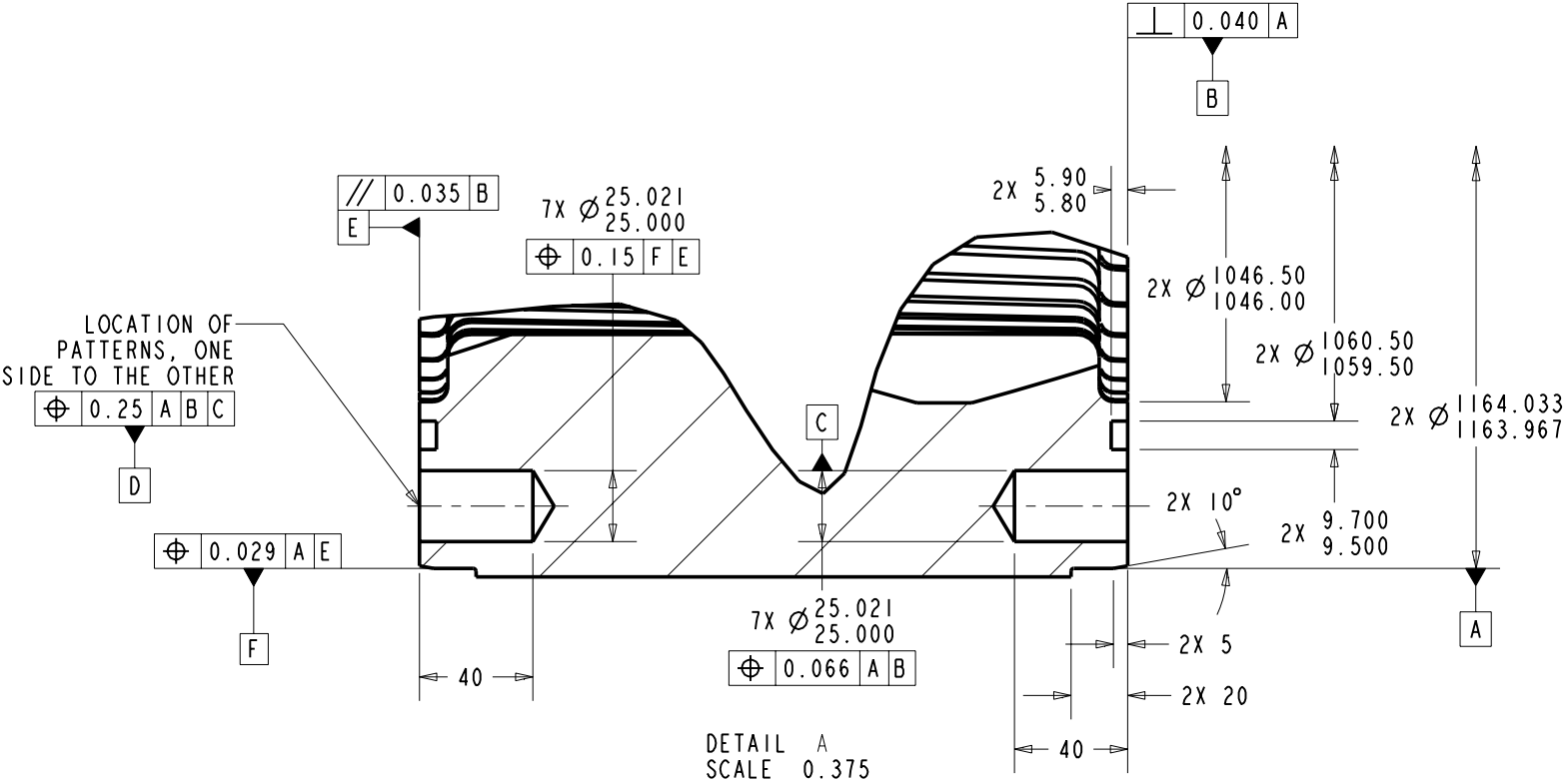
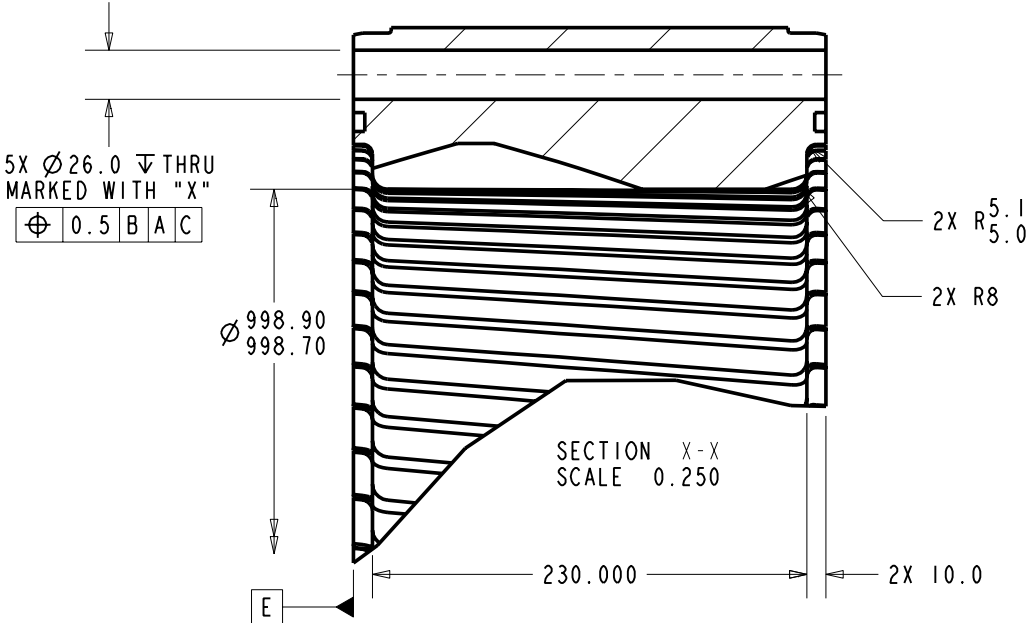
1. MATERIAL: 34CrNiMo 6; ALT. 4140H, 4340H, RING FORGING. NORMALIZE OR ANNEAL TO 231 BHN MAX HARDNESS.
2. HEAT TREAT: QUENCH AND TEMPER, AFTER ROUGH MACHINING TO 35 - 38 Rc.
3. IDENTIFY WITH PART NUMBER, SUPPLIER CODE NUMBER, MANUFACTURERS LOT NUMBER, AND REV. LEVEL.
4. REMOVE SHARP EDGES AND BURRS.
5. RADIAL ALIGNMENT OF TEETH TO OTHER FEATURES NOT REQUIRED.

REV	CHANGED FROM	BY	DATE	APVD	REPORT ERRORS & CHANGES REMOVE ALL SHARP EDGES DIMENSIONS ARE IN MM UNSPECIFIED TOLERANCES:	Powertrain Engineers Inc W293 N3819 Round Hill Circle Pewaukee Wi, 53072			
A	RELEASED	PEI	8/28/07		DECIMALS: FINISH: ANGLES:	TITLE			
B	RELEASED FOR DESIGN REVIEW	PEI	11/19/07		X, ± 1.0 X, ± 0.5 XX ± 0.25	GEAR, ANNULAS			
					NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY.	SIZE B	FIRST USED ON	DWG NO.	REV B
					DRAWN CHECKED	SCALE: 0.125	WEIGHT: 480.0 Kgs	251240	SHEET 1 OF 2

HELICAL GEAR DATA	
NUMBER OF TEETH	99
NORMAL MODULE	10.0000
NORMAL PRESSURE ANGLE	20.0000°
WHOLE DEPTH CONSTANT	2.400
OPERATING PITCH DIA.	1016.4000
GENERATING PITCH DIA.	998.5306
PROFILE SHIFT COEFFICENT	-.965
BASE DIAMETER	937.3634
MINOR DIAMETER MAX.	998.700
FORM DIAMETER	1034.325
ROOT DIAMETER (REF)	1047.049
TOOL TIP RAD. MIN.	3.70
HELIX ANGLE, GENERATED	7.4947
HELIX HAND	LEFT
LEAD	23844.673
NUMBER OF TEETH IN MATE	39
OPERATING CENTER DISTANCE	308.000
BACKLASH W/ MATE (MIN/MAX)	.2992/.3558
QUALLITY PER AGMA 2015-1, DATUM SURFACE	A-B
ACTIVE FLANK GRADE	7
TRAN. CIR. TT. Ø GEN DIAMETER (MIN)	8.594
TRAN. CIR. TT. Ø GEN DIAMETER (MAX)	8.514
SIZE OVER 16 BALLS (MAX/MIN)	997.898/997.699



PROFILE MODIFICATION



REPORT ERRORS & CHANGES REMOVE ALL SHARP EDGES DIMENSIONS ARE IN MM. UNSPECIFIED TOLERANCES: DECIMALS: FINISH: ANGLES:			Powertrain Engineers Inc W293 N3819 Round Hill Circle Pewaukee Wi, 53072			
X, ±1.0 ,X ±0.5 ,XX ±0.25			Ra 6,3 µm			≤ ±0.5
COPYRIGHT © NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY.			TITLE GEAR, ANNULAS			
DRAWN CHECKED		PEI	DATE	SIZE B	FIRST USED ON	DWG NO. 251240
				SCALE: 0.125	WEIGHT: 480.0 kgs	REV B
						SHEET 2 OF 2