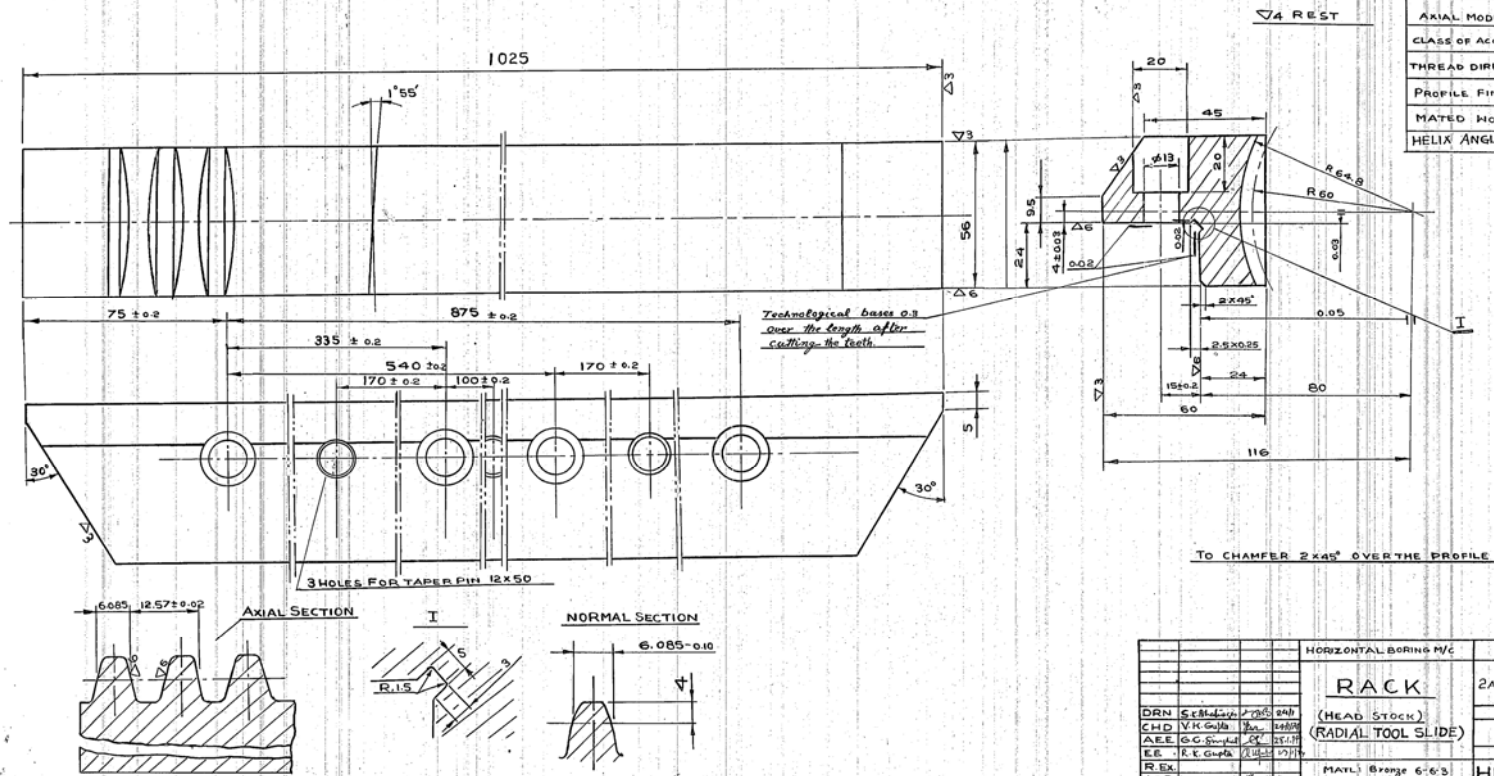




|                   |                |
|-------------------|----------------|
| AXIAL MODULE      | 4              |
| CLASS OF ACCURACY | 3              |
| THREAD DIRECTION  | R.H.           |
| PROFILE FINISH    | $\nabla 6$     |
| MATED WORM        | 3875           |
| HELIX ANGLE       | $1^{\circ}55'$ |

|             |  |  |  |                       |  |               |  |
|-------------|--|--|--|-----------------------|--|---------------|--|
|             |  |  |  | HORIZONTAL BORING P/C |  | 3911          |  |
|             |  |  |  | RACK                  |  | 2A60-5P-16    |  |
| DRN 6.54 IN |  |  |  | CHD 1/8 IN DIA        |  | WT. EG. SCALE |  |
| AEE 6.05 IN |  |  |  | (HEAD STOCK)          |  | R2 1:1        |  |
| EE 6.6 IN   |  |  |  | (RADIAL TOOL SLIDE)   |  |               |  |
| REL ADD     |  |  |  | MAT'L Bronze 6-6-3    |  | HEEP CM-II    |  |

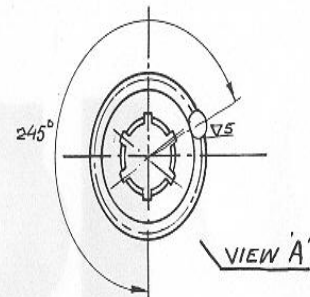
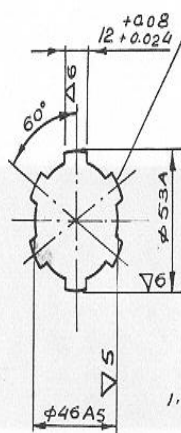
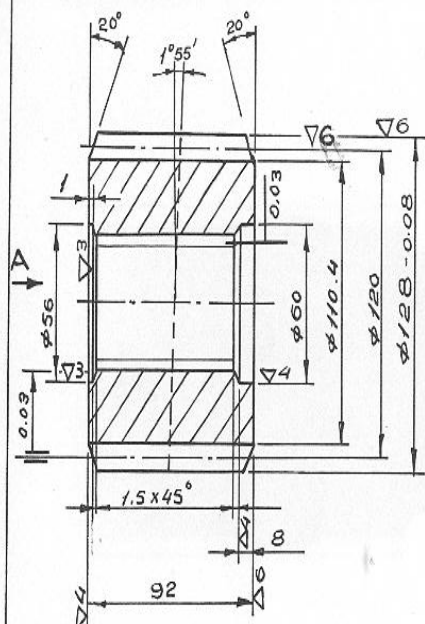
HEEP

45

74-6-088

▽4-REST

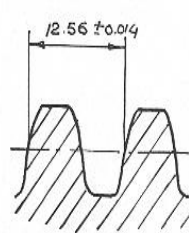
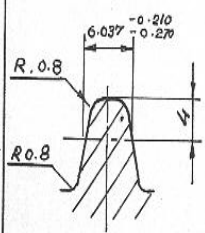
|                    |      |
|--------------------|------|
| NO. OF START       | 1    |
| MODULE             | 4    |
| PR. ANGLE          | 20°  |
| DIRECTION OF HELIX | R.H. |
|                    |      |
|                    |      |



1. CARBONISE TO A DEPTH OF 0.8MM. THERE AFTER HARDEN TO HRC-59
2. BLUNT ALL SHARP CORNERS.

NORMAL SECTION

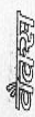
AXIS SECTION



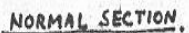
|     |        |         |        |              |              |
|-----|--------|---------|--------|--------------|--------------|
|     |        |         |        | H.BORING M/C | 25660-95-517 |
|     |        |         |        |              | 25660-SP-95  |
|     |        |         |        |              | WT.KG. SCALE |
|     |        |         |        |              | 6.62 1:2     |
| DRN | Supvil | 10/23   | 1/2/74 |              |              |
| CHD |        | 2/24    |        |              |              |
| SUP |        |         |        |              |              |
| REE |        | 21.9.74 |        |              |              |
| EE  |        | 21.9.74 |        |              |              |
|     |        |         |        | MAT: 20X     | HEEP CM-II   |

WORM

**12/12/12**



- 74-6-087



|                      |      |
|----------------------|------|
| MODULE               | 4    |
| NO. OF START         | 1    |
| Py. ANGLE            | 20°  |
| CLASS OF ACCURACY    | 7    |
| PROFILE FINISH       | ▽7   |
| DIRECTION OF (HELIX) | R.H. |

H.BORING M/C

25660-35-516

WORM

25660-SP-94

|         |       |
|---------|-------|
| WT. KG. | SCALE |
|---------|-------|

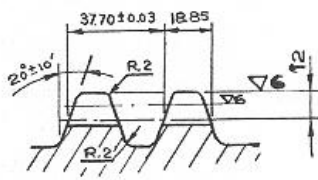
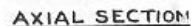
|      |     |
|------|-----|
| 6.36 | 1.2 |
|------|-----|

MAT: 20x

## HEEP

CM

$\nabla_4$  REST



|      |             |         |                          |             |       |
|------|-------------|---------|--------------------------|-------------|-------|
|      |             |         | HORIZONTAL BORING M/C    | 16405       |       |
|      |             |         | <u>PINION-WORM</u>       | 2A660-SP-40 |       |
| DRN  | S.K. Pruthi | 22/3    | <u>REDUCTION GEAR OF</u> | WT. KG.     | SCALE |
| CHD  | V.K. Gupta  | 29/8/74 | <u>SADDLE FEED</u>       |             | 1:2   |
| AEE  | G.C. Sarda  | 14.74   |                          |             |       |
| EE   | R.K. Gupta  | 14/74   |                          |             |       |
| REX: |             |         | MAT:- Br-A# 9-4          | HEEP        | CM-II |

DRAWING NO.

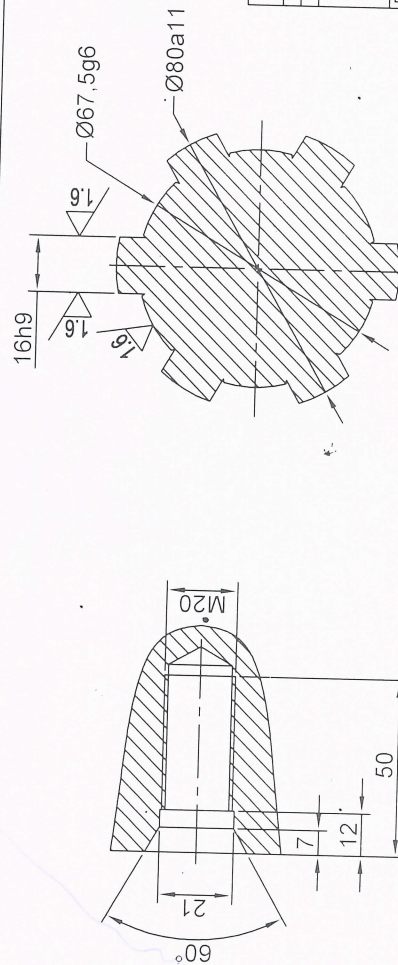
THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED  
IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

SAMPLE

|               |             |
|---------------|-------------|
| INVENTORY NO. | SIGN & DATE |
|---------------|-------------|

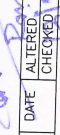
SEC. - B - B

SEC. - A-A

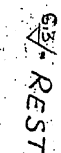


1. BLUNT ALL SHARP CORNERS
2. INDUCTION HARDENING OF TEETH TO HRC 50-52.

MAT. - En-24°

|                                                                                                                                                                              |                    |                    |                                                                                     |                              |                               |                    |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|--------------------|-------------------------------------------------------------------------------------|------------------------------|-------------------------------|--------------------|
| CBOM NO.<br>—                                                                                                                                                                | STATUS OF DRG<br>— |                    | TYPE OF PRODUCT<br>H BORER                                                          |                              | PLAN NO. 1-1                  |                    |
| APPROVED<br>DATE                                                                                                                                                             | NAME               | SIGN               | DATE                                                                                | NAME OF CUSTOMER/<br>PROJECT |                               | BLOCK-III          |
| <br> |                    |                    |  |                              | BHARAT HEAVY ELECTRICALS LTD. |                    |
|                                                                                                                                                                              |                    |                    | HARDWARE                                                                            |                              | DRAWING NO.<br>26660-SP-      |                    |
| REV                                                                                                                                                                          | DATE               | ALTERED<br>CHECKED | DEPT. WEX                                                                           | SCALE<br>1:1                 | WEIGHT (Kg.)                  | REF. TO ASSY. DRG. |
|                                                                                                                                                                              |                    | CODE/DESIGN        |                                                                                     | TITLE                        |                               |                    |
|                                                                                                                                                                              |                    |                    |                                                                                     | PINION<br>(SADDLE LOWER)     |                               |                    |
| 4                                                                                                                                                                            |                    | 3                  |                                                                                     | 179                          |                               | 00                 |
|                                                                                                                                                                              |                    |                    |                                                                                     | SHEET NO. 1                  |                               | NO OF SHEETS 01    |

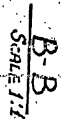
SIZE A2



|                            |           |
|----------------------------|-----------|
| MODULE                     | 16        |
| NO. OF TEETH               | 27        |
| PRESSURE ANGLE             | 20°       |
| PITCH                      | 50.265    |
| ANGLE OF TEETH             | 0°        |
| DEGREE OF Accuracy         | 0.5       |
| QUALITY OF SURFACE<br>TEST | 16<br>V   |
| MATING. DRG. No.           | 7A25E122g |

NOTE: 1. max. possible error in pitch on  
6. Leeth =  $\pm 0.09$

2



|                             |       |                               |               |
|-----------------------------|-------|-------------------------------|---------------|
| PLANNER                     |       | Block.                        |               |
| BHEL HARDWARE               |       | BHARAT HEAVY ELECTRICALS LTD. |               |
| CN-11                       | SCALE | MAN. GCI-25                   | DRN 32.000000 |
| RACK                        |       | CAD. <i>Plaid</i>             | 1708.000000   |
| : Plant off. Skaap corners. |       | APP                           | 5.479         |
| 7A256 SP-9                  |       |                               |               |

Start off sharp corners