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89076 W1 696

DRG. NO.

0~1 FRICTION UNDERHANG  
PERMITTED

FACE GROOVE PATTERN  
(BOTH SIDE)

P

THICKNESS VARIATION ON ENTIRE  
CIRCUMFERENCE TO BE OF MAX. 0.040.  
RADIAL DIRECTION THICKNESS VARIATION  
(OUTER PERIPHERY THICKNESS MEAN VALUE-INNER  
PERIPHERY THICKNESS MEAN VALUE)  
TO BE WITHIN -0.010 ~ +0.020.

0.40

5.4 $\pm$ 0.1

1x45°

0.5

0.40

1x45°

+1.0

Ø355.5 $\pm$ 0

±1.5

Ø372

FRICTION I.D.

Ø4.35 $\pm$ 0.8

a

b

0.10

MACHINING DEVIATIONS FOR LINEAR DIMENSIONS

ABOVE UP TO AND INCLUDING VALUE	6	30	120	315	1000	2000	4000	THE REST
±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	12.5

02

0.4 MIN.  
NOT INTO STEEL

4.0 $\pm$ 0.1

8.8 $\pm$ 0.25

1.6 $\pm$ 0.25

0.4 MIN.  
NOT INTO STEEL

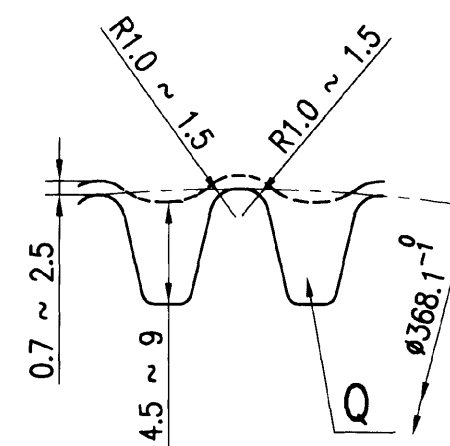
0.8

3.8

0.8

DETAIL S (OIL GROOVE DETAILS)

SCALE: NTS



DETAIL P

SCALE: NTS

NOTE :

- THIS DWG. REPRESENTS A DISC MFD. BY M/s WELLMAN PRODUCTS GROUP, USA
- REMOVE BURRS.
- HARDNESS OF HARDENED LAYER FOR SECTION Q: MINIMUM HRC 40. TEMPERING TEMPERATURE TO BE 250°C.
- CORE PLATE MAY BE PUNCHED.
- ITEM NO. 02, PAPER SEGMENT IS MANUFACTURED USING PAPER FRICTION TO PART NUMBER WMPC13556.
- PERMITTED SURFACE ROUGHNESS FACES(PAPER FRICTION) a AND b TO BE MAXIMUM 5.0
- PERMISSIBLE OVER PIN DIMENSION VARIATION IN THE SAME DISC TO BE OF MAX. 0.15

SPUR GEAR-INTERNAL

GEAR TOOTH PROFILE	-	STANDARD
TOOTH FORM	-	COARSE
MODULE	m	3
NO. OF TEETH	Z	120
PRESSURE ANGLE	$\alpha$	14°30'
AMOUNT OF ADDENDUM MODIFICATION	xm	-
ACCURACY GRADE	-	Gr.8-DIN 3962
TIP CIRCLE DIA.	d <sub>a</sub>	355.5 $\pm$ 0
PITCH CIRCLE DIA.	d	360
BASE CIRCLE DIA.	d <sub>b</sub>	348.53
ROOT CIRCLE DIA.	d <sub>f</sub>	368.1 $\pm$ 0
OVER PIN DIMENSION	M <sub>D</sub>	353.18 $\pm$ 0.86 (Ø5)
MATING GEAR	PART NUMBER	959 TM 51932 959 TM 52167 959 TM 52012
	NO. OF TEETH	120

02	—	FACING	8	PAPER SEGMENT (WELLMAN NO.- M670-4)			K13556	
01	—	PLATE	1	SAE1045H (WELLMAN NO.- CORE GB45)			C13557	t=3.8
SL. NO.	DRG/STD NO.	DESCRIPTION	QTY	MATERIAL	UNIT WT.	TOTAL WT.	WELLMAN STOCK NO.	REMARKS
NEXT ASSY. 959 TM 02002								
				PRODUCT PLANETARY TRANSMISSION			DESIGN REF.	
				USED ON	QTY	MATL:		
				BH100A	14	H.T.		
						S.T.		
							Wt. in kg 1.7(APPROX)	SCALE 1:2
959DRAH001	AMEND NO.	SIGNATURE	DATE	TITLE DISC-H,L&4			SHEET NO.	1
DRA/ECN	NAME						NO. OF SHEETS	1
APPROVED	V.SEKAR		2011-06-30					
REVIEWED	SRINIVASAH		2011-06-30					
CHECKED	SASIKUMAR		2011-06-30					
DRAWN	BHARATH S		2011-06-30					
STD.	SRINIVASAH		2011-06-30					
				beml BEML LIMITED KGF			DRG. NO. 959 TM 92068	