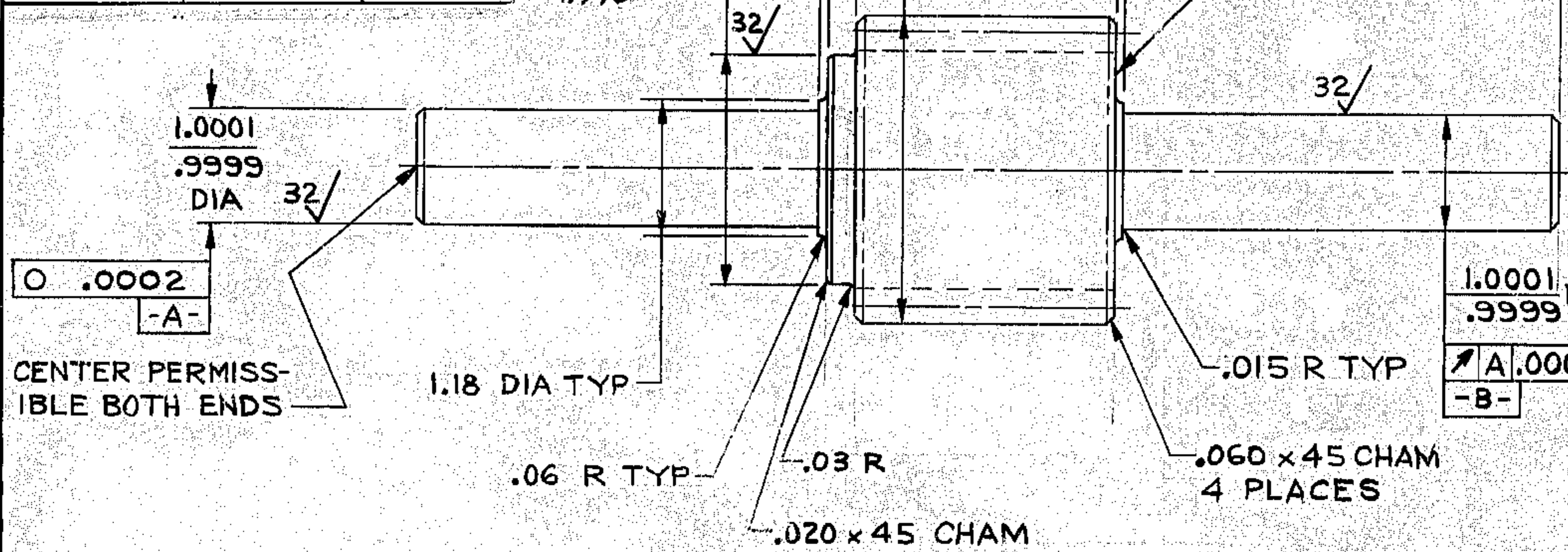


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REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROVED
C-3	A	2.000-1.990 DIA WAS 2.0001-1.9999 DIA	7-24-70	<i>E. J. ...</i>
	B	ADDED N/A No's	8-10-92	JH. PB

**HELICAL GEAR DATA (SEE NOTE 1)**

NO. OF TEETH	18	
DIA. PITCH (NORM.)	8	
PITCH DIA. (THEO.)	2.3003	
PRESSURE ANGLE (NORM.)	14 1/2°	
HELIX ANGLE	12°	
HAND OF HELIX	LEFT	
1/WHOLE DEPTH (REF.)	.314	
NORM. CIRC. TOOTH THK'S	.2295/.2275	
CHORD. ADD.	.1948	
NORM. CHORD. TOOTH THK'S	.229/.227	
MEAS. OVER BETWEEN TWO .240 DIA. PINS	2.7612/ 2.7571	
BASE CIRCLE DIA.	2.2238	
MIN. OPER. CENT. DIST.	72.522	
BACKLASH WITH MATE AT MIN. OPER. CENT. DIST.	.000/.006	
LEAD	33.9978	
START OF ACTIVE PROFILE	.0540	
MAX. SURFACE ROUGHNESS ON ACTIVE PROFILE	20/	
NO. OF TEETH IN MATE	116	
MATE PART NO.	2150.310E <sup>002</sup>	
CALC. <i>P.E.</i>	CHECKED	DATE



**NOTES:**

- 1- ENLARGED O.D. .1272, AGMA CLASS 15 EXCEPT AS NOTED, TOOTH TO TOOTH ERROR .0001 AND ACCUMULATED ERROR .0002
- 2- H.T.: NORMALIZE 3 HRS AT 1600°F, AIR COOL, TEMPER 4 HRS AT 1200°F. ROUGH MACHINE. HEAT TREAT TO 1500°F, OIL QUENCH. TEMPER 4 HRS AT 1050°F. CHECK HARDNESS. RETEMPER TO Rc 32-36.
- 3- ALL DIMENSIONS ARE IN INCHES
- 4- INTERPRET DWG PER USASI-Y14.5-1966
- 5- ALL SURFACES 125/PER USAS-B46.1-1962

CENTER PERMISSIBLE BOTH ENDS

REF. FILE 1186

FIND NO.	PART NO.	DESCRIPTION	QTY	MATERIAL	CODE IDENT
LIST OF MATERIAL (LM)					
LIMITS ON MACHINED DIMENSIONS EXCEPT AS NOTED		<b>WESTERN</b> HEAVY MACHINERY DIVISION GEAR CORPORATION EVERETT, WASHINGTON			
ANGULAR = ± 1°		DRAWN WINGERT 3-10-70			
LINEAR:		CHECK AURA INC 4-13-70			
.X = ± .1      .XXX = ± .010		ENGR			
.XX = ± .03      FRACTIONAL = ± 1/32		82402-44175D50			
BREAK ALL SHARP EDGES		APPROVED <i>John H. Stewart</i>			
MATERIAL		SIZE CODE IDENT NO. REV			
4340 STL, QQ-S-626		C 16603 2150.340C003 B			
NOTE 2		SCALE 1/1 WT — LB SHEET 1 OF 1			

NEXT ASSY: 2150.0005013E, 2150.0005014E

REV A

44175D50