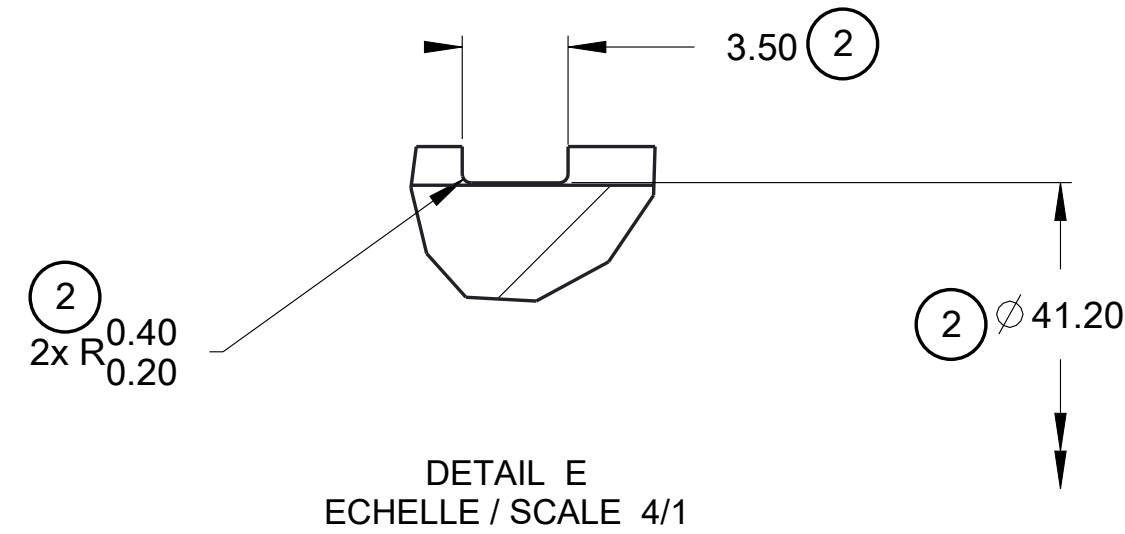


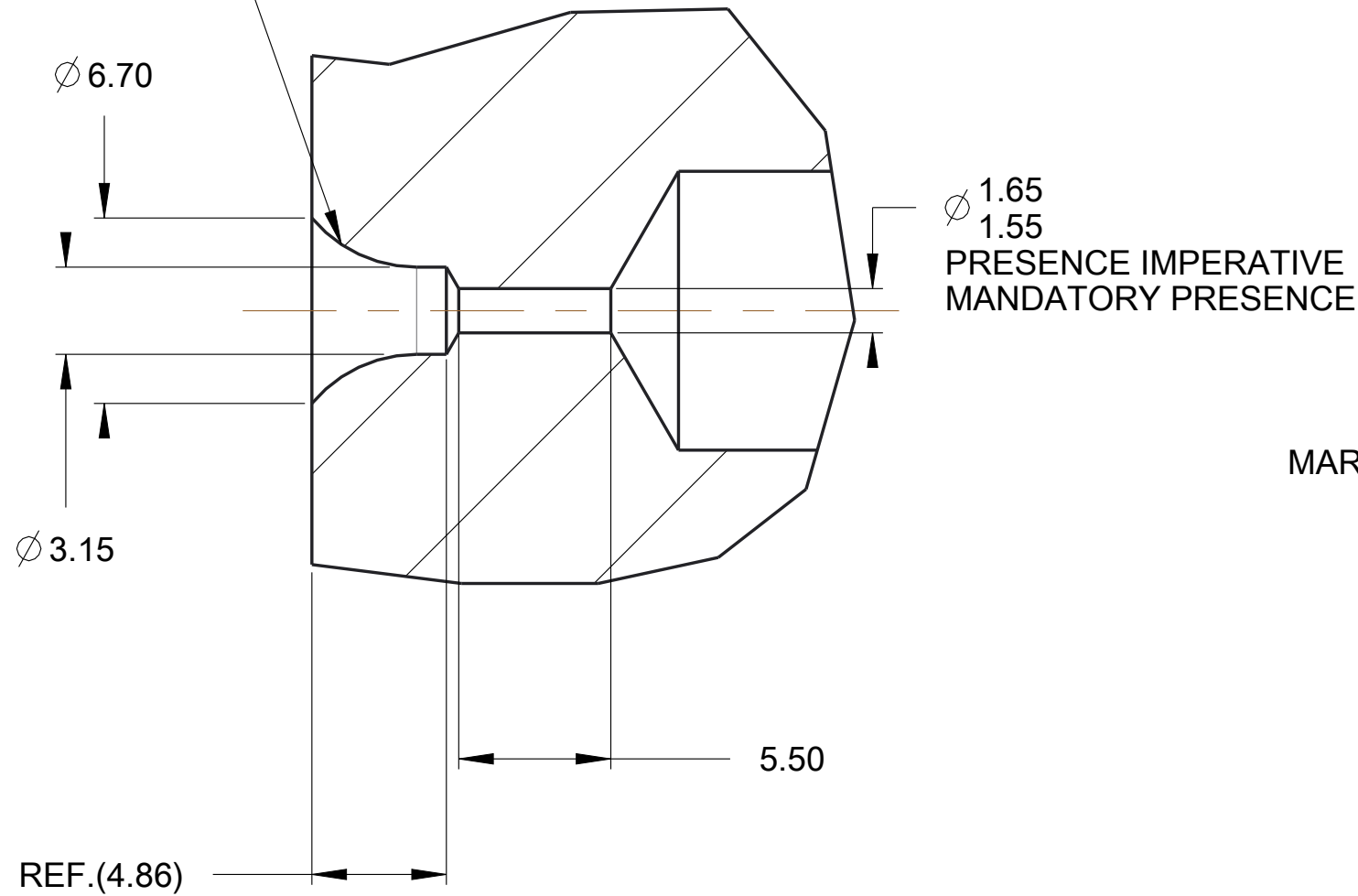


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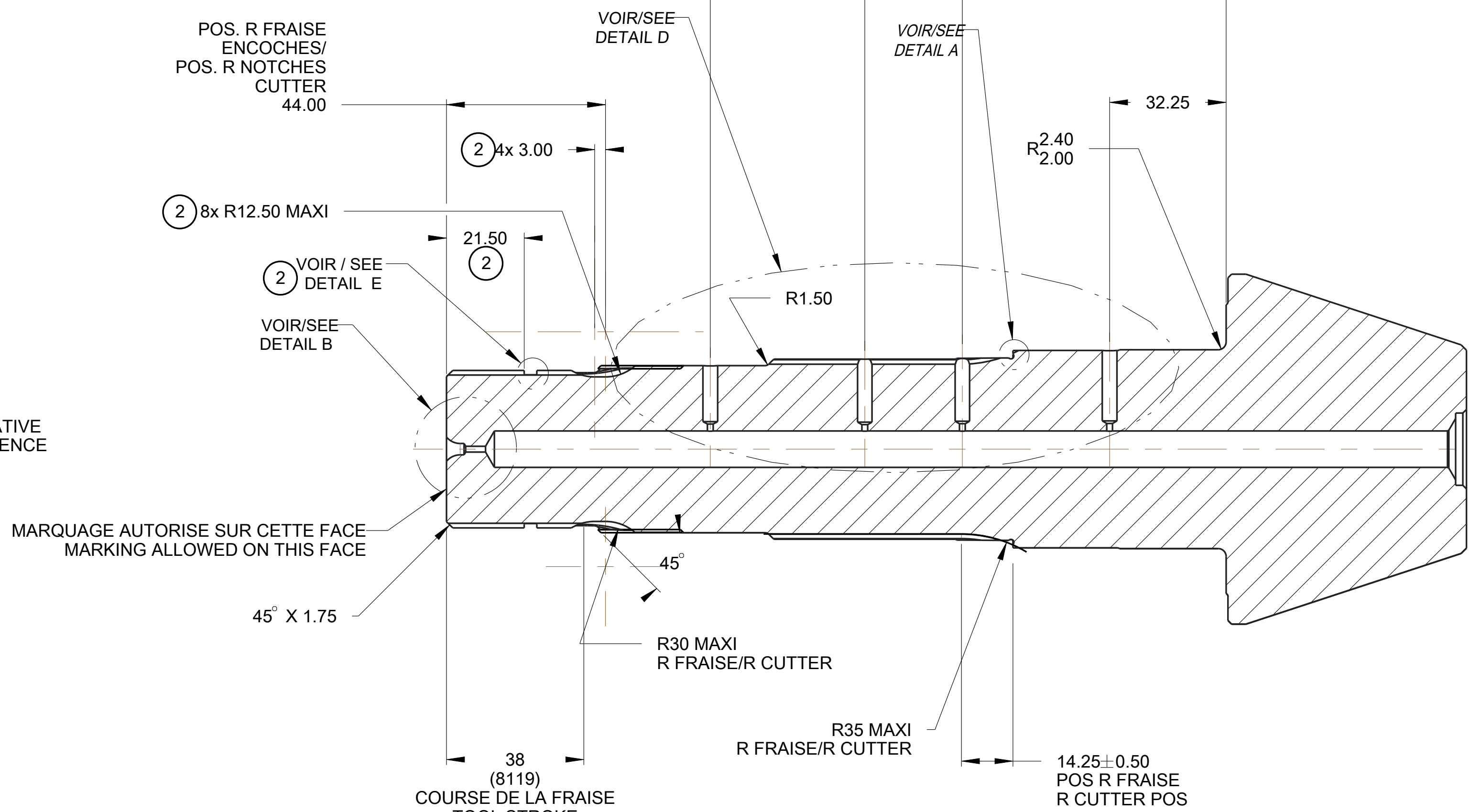
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NORME :
ISO 6411
R 3.15/6.7



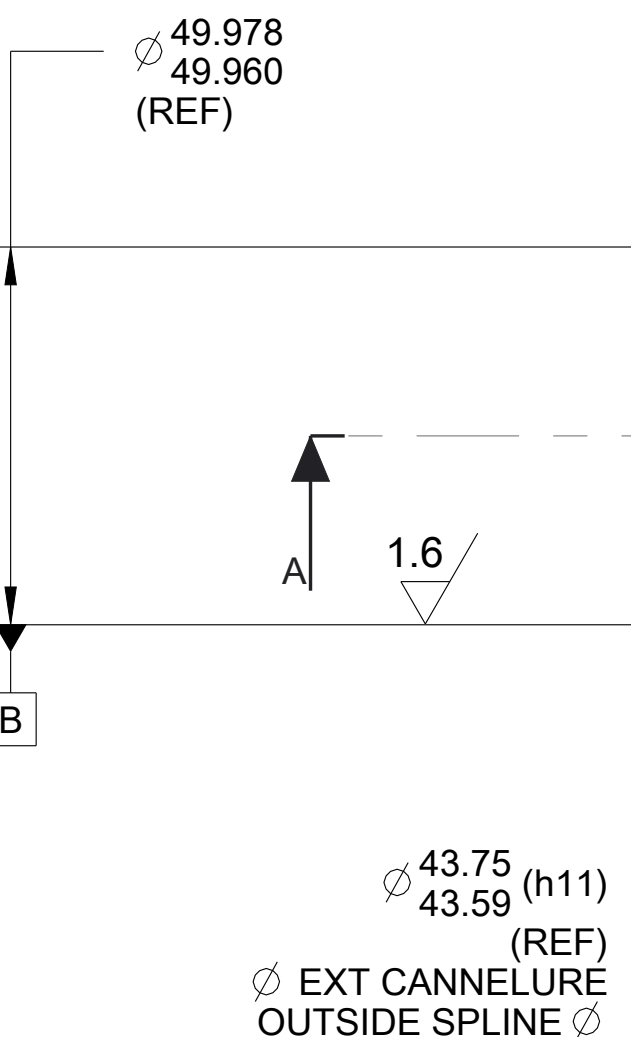
DETAIL B
ECHELLE/SCALE 4/1



COUPE/SECTION A-A

VOIR/SEE 4306901 PLANCHE/SHEET 1 DE/OF 1
CANNELURE 34 DENTS/34 TEETH SPLINE
SUIVANT/ACCORDING TO DIN 5480 (44-1.25-9e)

DIA. PRIMITIF/PITCH DIA:
Ø 0.08 | A-B



VOIR/SEE 4356880 PLANCHE/SHEET 1 DE/OF 1
CANNELURE 38 DENTS/38 TEETH SPLINE
SUIVANT/ACCORDING TO DIN 5480 (50-1.25-9H/9e)
SAUF Ø EXTERIEUR Ø 49.978/49.960 UNLESS MAJOR
DIAMETER Ø 49.978/49.960
DIA. PRIMITIF/PITCH DIAMETER:
Ø 0.08 | A-B

PROPRIÉTÉ SUIVANT LA NORME CLEANLINESS ACCORDING TO GSP02	
AIRES / AREAS	CLASSE / CLASS
SURFACE EXTERIE EXTERNAL AREA	64380 mm²
SURFACE INTERIE INTERNAL AREA	9883 mm²

CARACTERISTIQUES SPECIALES SUIVANT LA NORME SPECIAL CHARACTERISTIC ACCORDING TO GSP027	
CC	0
CS	4

ETAT DE SURFACE RA EN MICROMETRE ROUGHNESS RA IN MICROMETER		TOLERANCES GENERALES SAUF SPECIFICATION CONTRAIRE TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		SAUF INDICATION CONTRAIRE UNLESS OTHERWISE SPECIFIED	
DIMENSIONS NOMINALES	PLUS DE A	NOMINAL SIZE OF DIMENSION - (mm)	OVER TO	0.01 0.02 0.05 0.1 0.2 0.5 1 2 5 10 20 50 100 200 500 1000	0.01 0.02 0.05 0.1 0.2 0.5 1 2 5 10 20 50 100 200 500 1000
0 OU 1 DECIMALE (mm)	A 2 DECIMALES	0 OR 1 DECIMAL PLACE (mm)	2 DECIMAL PLACES	± 0.1 ± 0.2 ± 0.5 ± 1 ± 2 ± 5 ± 10 ± 20 ± 50 ± 100 ± 200 ± 500 ± 1000	± 0.1 ± 0.2 ± 0.5 ± 1 ± 2 ± 5 ± 10 ± 20 ± 50 ± 100 ± 200 ± 500 ± 1000
0 OU 1 DECIMALE °	A 2 DECIMALES	0 OR 1 DECIMAL PLACE °	2 DECIMAL PLACES	± 0.1 ± 0.2 ± 0.5 ± 1 ± 2 ± 5 ± 10 ± 20 ± 50 ± 100 ± 200 ± 500 ± 1000	± 0.1 ± 0.2 ± 0.5 ± 1 ± 2 ± 5 ± 10 ± 20 ± 50 ± 100 ± 200 ± 500 ± 1000

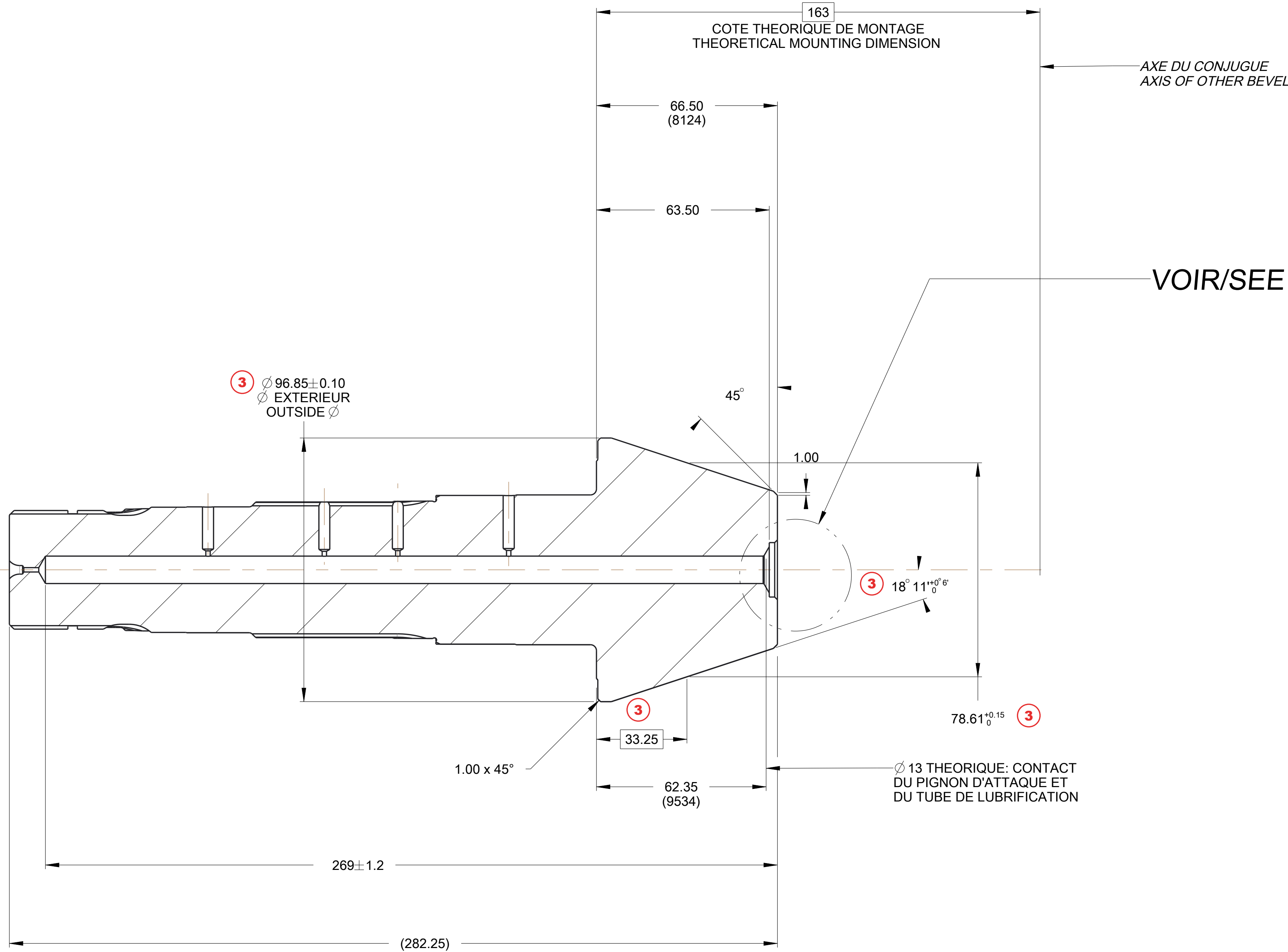
MATIERE / MATERIAL	PIECE SM / SM PART
18NCD6 GSP003	ECHELLE / SCALE 1/1
MAISSE / WEIGHT 5544 kg	PLANCHE / SHEET 1/2

ETAT / STATE Official Prototype	
PROFUSE PAR / PROOFED BY Ivaudet	DRAWING VERSION 012
011	011
GIMA	
PIGNON D'ATTAQUE 100t	
DRIVE PINION TO TOOTH	
N° 4364204H03	

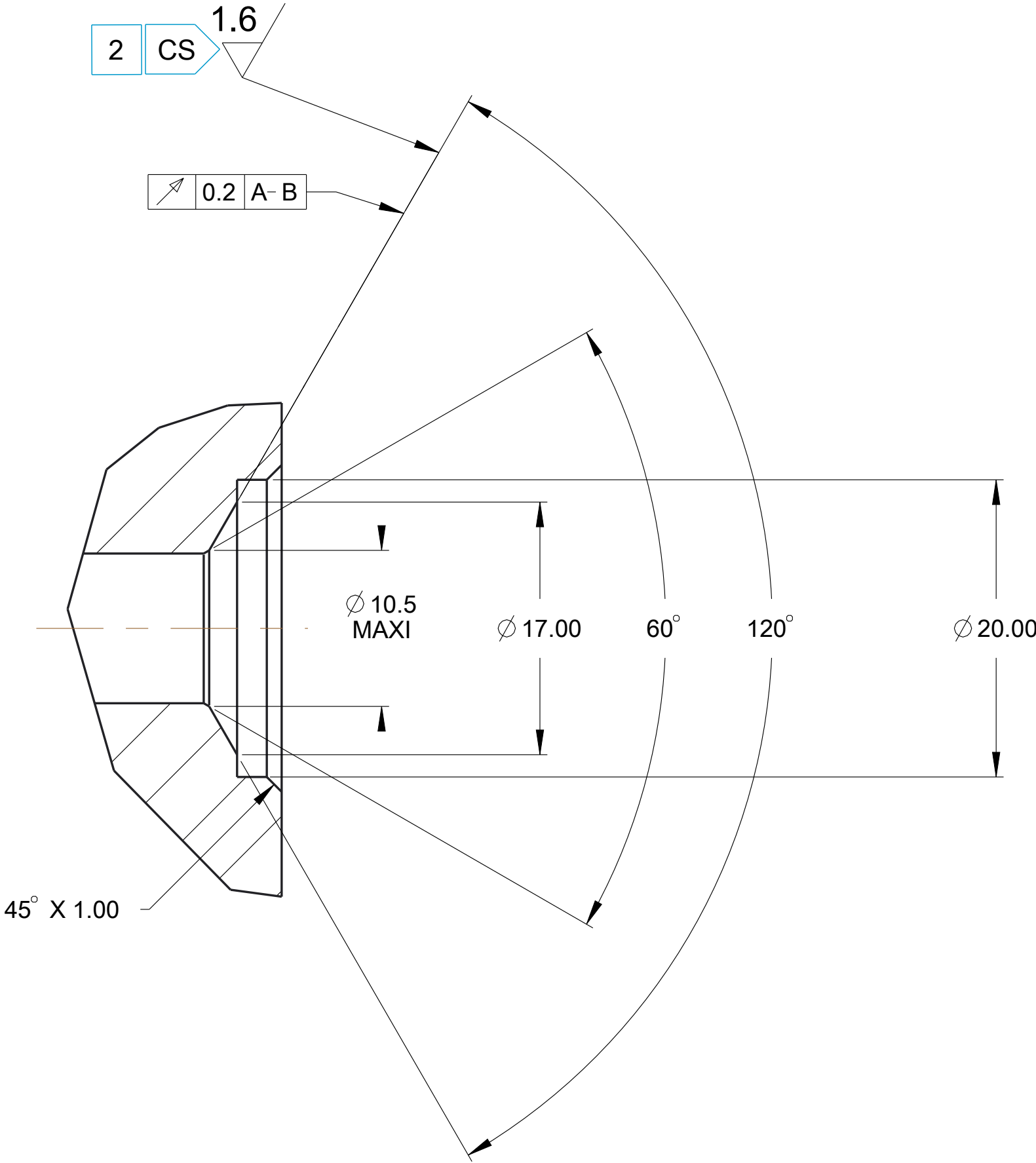
4364204H03

COURONNE CONJUGUEE REF 4364205H03.
RING GEAR OF OTHER BEVEL REF 4364205H03.

POUR FT DENTURE VOIR PLAN COUPLE CONIQUE 10/47 DENTS 4364206H03 PL 4/6.
FOR TECHNICAL DATA SEE BEVEL SET GEAR 10/47 TEETH DRAW 4364206H03 SH 4/6.



COUPE/SECTION A-A



DETAIL G
ECHELLE/SCALE 3/1

3 CS MATIERE:
ACIER FORGE 18 NCD6 OU 17 CrNiMo6 SUIVANT GSM003

4 CS TRAITEMENT THERMIQUE:
CEMENTATION + CARBONITRURATION SUIVANT BPS 1000
Ec 513 (FLANCS DE DENT): 1.4-1.8
Ec (FOND DE CANNELURES) : 0.9 MINI
PROTECTION CONTRE LA CEMENTATION DU M46x1.5
DURETE SUPERFICIELLE: 58-61 HRC
DURETE COEUR: 28-45 HRC
OXYDATION INTERNE TOLEREE 25 MICRONS MAXI
PRELEVEMENT A 13 mm DE L'EXTREME DENTURE
(COTE GROS BOUT)
LA DURETE SUPERFICIELLE ET LA PROFONDEUR DE
CEMENTATION SERONT MESUREES SUR UN FLANC MENANT
LA DURETE COEUR SERA MESUREE A L'INTERSECTION
DE L'AXE D'UNE DENT AVEC LE DIA. DE PIED DE DENT

SAUF INDICATIONS CONTRAIRES:
ETAT DE SURFACE 3.2 MICRO-METRES
SUPPRIMER ANGLES VIFS: CH. 0.5 MAXI A 45°

ETAT DE SURFACE DENTURE:
FLANCS: 1.6
FONDS ET RACCORDEMENTS: 3.2

3 CS MATERIAL:
FORGED STEEL 18 NCD6 OR 17 CrNiMo6 ACCORDING TO GSM003

4 CS HEAT TREATMENT:
CARBURIZING + CARBONITRIDING ACCORDING TO BPS 1000
Ec 513 (TOOTH FACE): 1.4-1.8
Ec (SPLINE ROOT) : 0.9 MINI
PROTECTION AGAINST THE CARBURIZING OF M46x1.5
SURFACE HARDNESS: 58-61 HRC
CORE HARDNESS: 28-45 HRC
INTERNAL OXYDATION ALLOWED 25 MICRO-METERS MAX
MEASUREMENT WILL BE MADE AT 13mm OF THE BIGGER
DIAMETER OF THE GEAR
THE SURFACE HARDNESS AND THE DEPTH OF
CARBURIZING WILL BE MEASURED ON A WORKING FLANK
THE CORE HARDNESS WILL BE MEASURED AT THE INTERSECTION
OF ONE TOOTH AXLE WITH THE ROOT OF TOOTH DIAMETER

UNLESS OTHERWISE SPECIFIED:
SURFACE ROUGHNESS OF 3.2 MICRO-METERS
SMOOTH OFF SHARP CORNERS: CH. 0.5 MAX AT 45°

TEETH SURFACE ROUGHNESS:
FLANK: 1.6
DEPTH AND BLEND RADIUS: 3.2

ETAT DE SURFACE RA EN MICROMETRE ROUGHNESS RA IN MICROMETER		TOLERANCES GENERALES SAUF SPECIFICATION CONTRAIRE TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DIMENSIONS NOMINALES	PLUS DE A	NOMINAL SIZE OF DIMENSION - (mm)	OVER TO
0 OU 1 DECIMALE (mm)	A	0 OU 1 DECIMAL PLACE (mm)	TO
A 2 DECIMALES		2 DECIMAL PLACES	
TOLERANCES ANGULAIRES / ANGULAR TOLERANCE		TOLERANCES ANGULAIRES / ANGULAR TOLERANCE	
0 OU 1 DECIMALE °		0 OU 1 DECIMAL PLACE °	
A 2 DECIMALES		2 DECIMAL PLACES	

SAUF INDICATION CONTRAIRE:
(1) APPLIQUER LE PROCEDE DE FABRICATION GPS 45
(2) LES DIMENSIONS SONT EN mm
(3) RESPECT DE LA CRITICITE CONFORMEMENT A LA GSP027

UNLESS OTHERWISE SPECIFIED
(1) PPE PROCESS SPECIFICATION GPS 45 APPLIES
(2) DIMENSIONS IN mm
(3) RESPECT OF CRITICITY ACCORDING TO GSP027

MATIERE / MATERIAL	PIECE SM / SM PART
18NCD6 GSP003	ECHELLE / SCALE
	1/1
MASSE / WEIGHT	PLANCHE / SHEET
5544 kg	2 / 2

DESIGNATION	PIGNON D'ATTAQUE 100t
NAME	DRIVE PINION TO TOOTH
N° 4364204H03	

N°	MODIFICATIONS	DATE - MT
1	DUPLICATION DE 4363641 GPO541006 23/04/2016 ACK	
2	4364204H02 ETAT / WAS H01 4364205H02 ETAT / WAS H01 4364206H02 ETAT / WAS H01 RBT 18/07/2018	
3	4364204H03 ETAT / WAS H02 4364205H03 ETAT / WAS H02 4364206H03 ETAT / WAS H02 MATERIAL TT CPM06 ADDED ADD DIMENSIONS SECTION AA TV1 02/02/2021	
ETAT / STATE Official Prototype		
PROOF: PAR / PROOFED BY tvautet	DRAWING VERSION 012	IS VERSION 011

