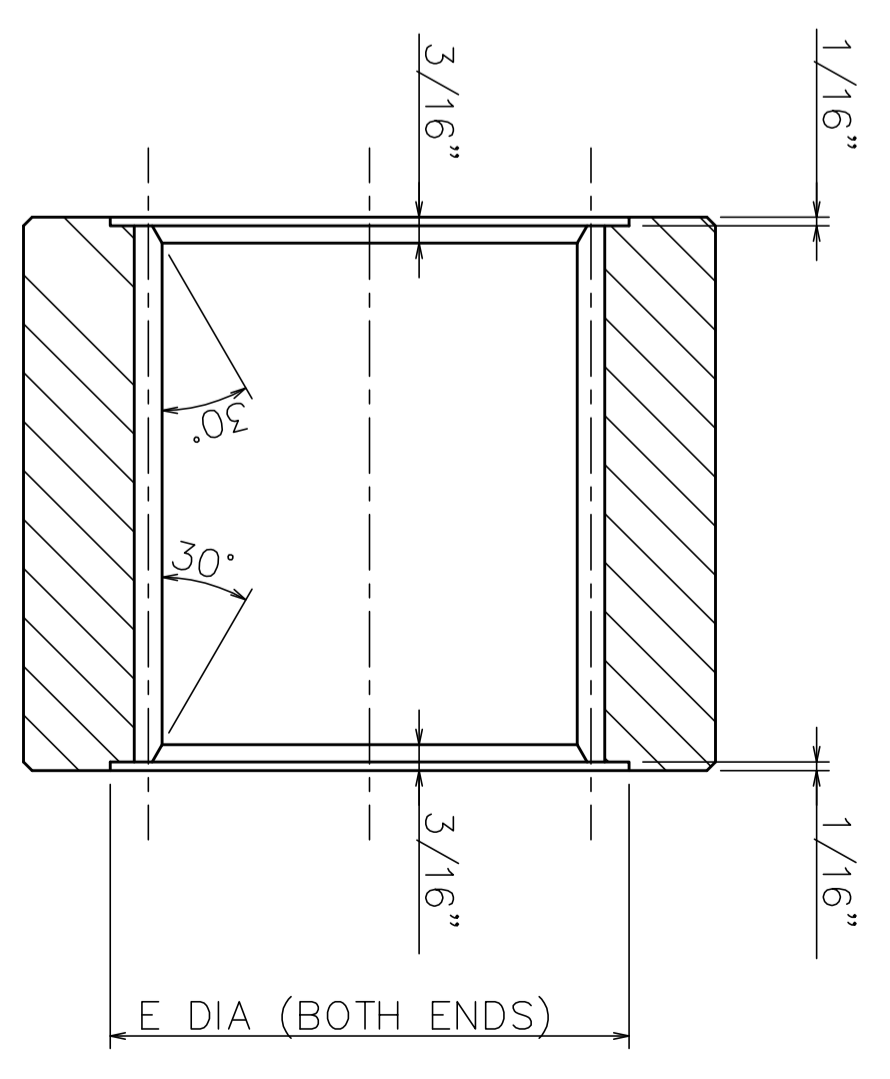
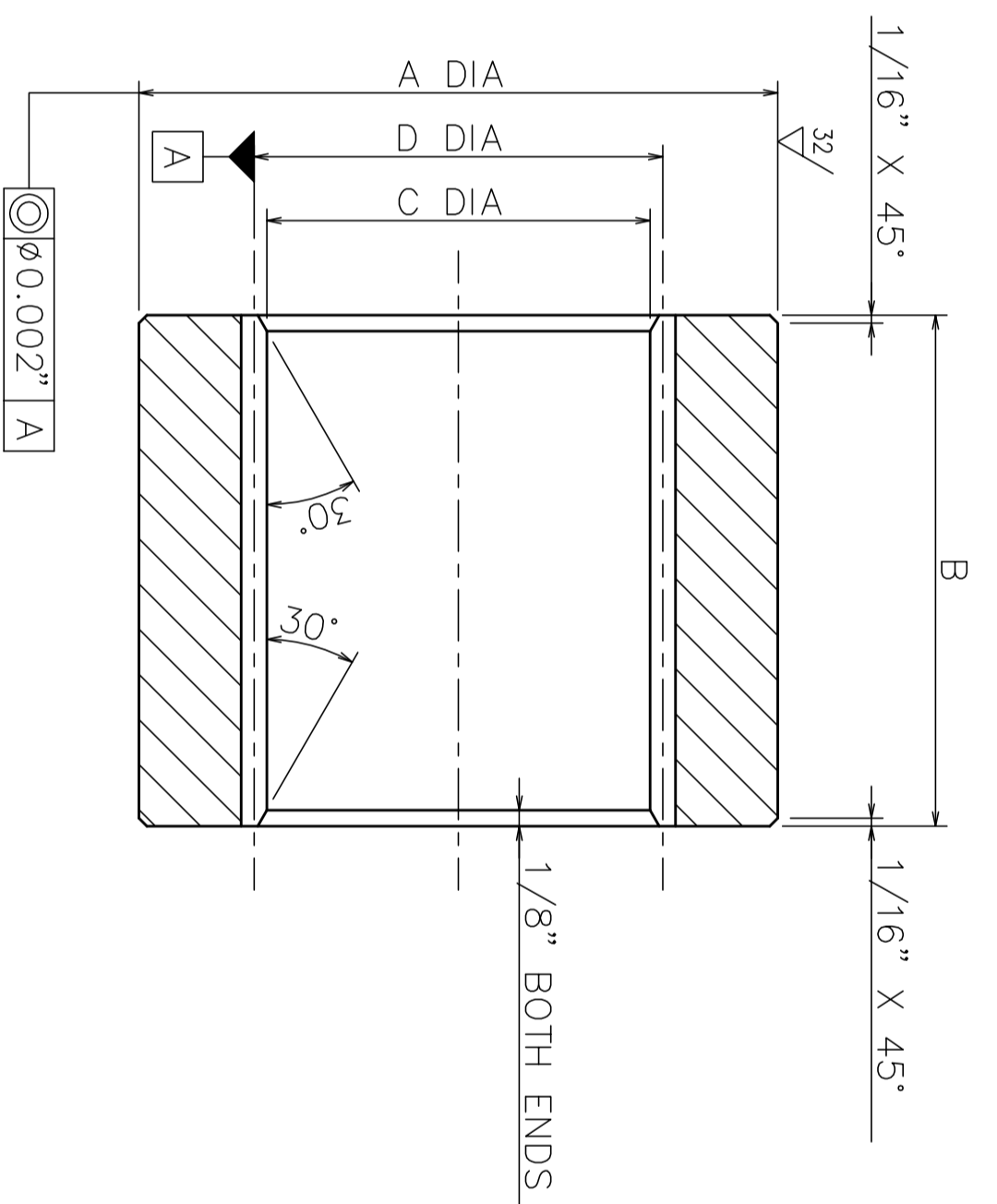
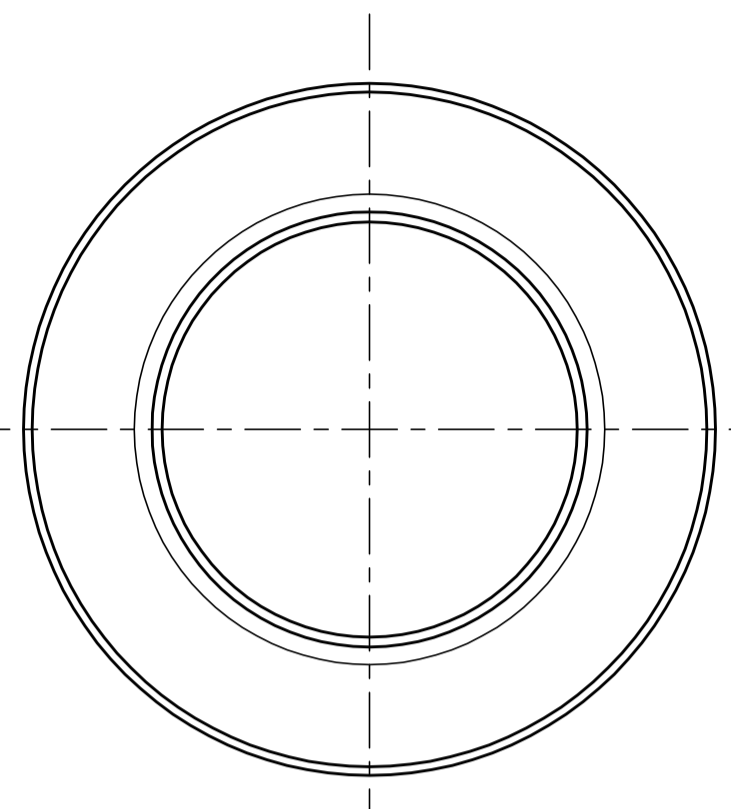


ISSUE	CHANGE	GRD	DATE	CHK
A	0630		2/6/75	
B	1187		28/2/80	
C	1512		2/87	
D	1892		6/88	

** ADDITIONAL MOTORS INDICATED ON VARIOUS BILLETS.



SECTION SHOWING MANUFACTURING METHOD FOR ITEMS MARKED THUS *

SPLINE DATA TO BS 3550:1963 & ASA B5.15:1660 INTERNAL INVOLUTE UNLESS OTHERWISE STATED

PART No.	MOTOR TYPE	DIM'N A	DIM'N B	DIM'N C	DIM'N E	SPLINE DESCRIPTION	PRESSURE ANGLE	PITCH	No. OF TEETH	PITCH CIRCLE DIA 'D'	ADDENDUM	CHORD THICKNESS	TOTAL BACKLASH	SPACE WIDTH	BETWEEN PINS DIM'N	MEASURING PIN DIA.
23654	B125/150/200 B270/325 (20°)	5.0016"	3.25"	3.002"	N/A	STANDARD INVOLUTE GEAR TOOTH FORM BASED ON 20° P.A.	20°	5/10	16	3.200"	0.100"	0.310"	0.012"	0.321"	2.8220"	0.3200"
24160	B060/080 B100 C080	4.0016"	2.50"	2.177"	N/A	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	6/12	14	2.333"	0.079"	N/A	N/A	0.265"	1.9160"	0.2880"
*24623	B400	5.0016"	4.00"	3.172"	3.672"	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	6/12	20	3.333"	0.083"	N/A	N/A	0.2651"	2.9210"	0.2880"
24768	B/C030 B/C045	3.5016"	3.25"	2.005"	N/A	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	8/16	17	2.125"	0.061"	N/A	N/A	0.1995"	1.8071"	0.2160"
25069	B125/150/200 B/C270/325 C200 (30°)	5.0016"	3.00"	3.172"	N/A	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	6/12	20	3.333"	0.083"	N/A	N/A	0.2651"	2.9210"	0.2880"
*25948	HDB400 HDB125,150,200 HDB270,325	5.5016"	4.00"	3.672"	4.172"	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	6/12	23	3.833"	0.083"	N/A	N/A	0.2652"	3.4137"	0.2880"
25093	HDB200/S3	5.0016"	3.25"	3.172"	N/A	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	6/12	20	3.333"	0.083"	N/A	N/A	0.2651"	2.9210"	0.2880"
26631	B010	2.9543"	1.97"	1.5104"	N/A	BS/ASA SPLINE-FLAT ROOT, SIDE FIT	30°	8/16	13	1.625"	0.0625"	N/A	N/A	0.1994"	1.3014"	0.2160"

NOTES: FINISHED PART LIBERALLY COATED WITH SHELL ENNIS 260

ALL DIMENSIONS ARE IN INCHES

UNLESS OTHERWISE SPECIFIED INTERPRET PER BS308 ANGULAR DIMENSIONS ± 1° TOLERANCE RECOMMENDS 0.25mm (1/32 dia) WHOLE No. (DECIMALS) FRACTIONS 1 PLACE 2 PLACE 3 PLACE mm ±0.030 ±0.024 ±0.12 ±0.015 ±0.005 REMOVE BURRS BREAK EDGES 0.25mm(0.010)MAX.		THIRD ANGLE PROJECTION	
MODEL REF.	DATE	KAWASAKI PRECISION MACHINERY (UK) LTD Staffa Products Eresettle Plymouth PL5 2SA	
DR. D.T.	02/06/75		
CHK. J.D.A.	03/97		
FORM P. MINTERN	04/03/97		
REL. PROTO.			
ENG. APPV. A. RENNIE	03/97		
SIZE A1	DRAWING No.	40000	
SCALE	ACT. SHEET 1	OF 1	