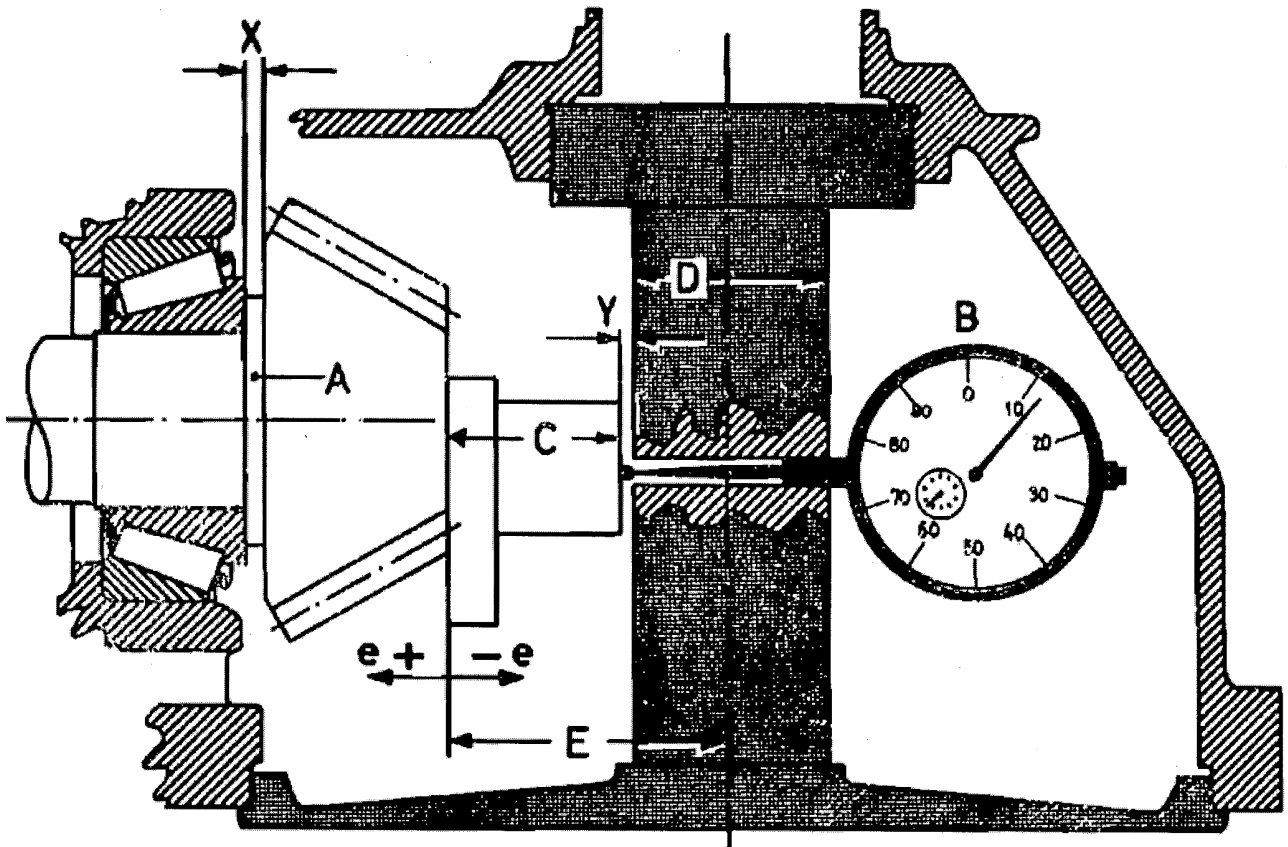


Fig. 19 Measuring Pinion Depth



Example I

1. E	59.00 mm (2.323 ["])
e +	0.15 mm (0.006 ["])
E target	59.15 mm (2.329 ["])
2. C	38.00 mm (1.496 ["])
D : 2 +	20.00 mm (0.787 ["])
	58.00 mm (2.283 ["])
3. Gauge preload	4.00 mm (0.158 ["])
Actual value B -	3.12 mm (0.123 ["])
Distance Y	0.88 mm (0.035 ["])
4. C + D	58.00 mm (2.283 ["])
Y +	0.88 mm (0.035 ["])
E actual	58.88 mm (2.318 ["])
5. E target	59.15 mm (2.329 ["])
E actual	58.88 mm (2.318 ["])
a	0.27 mm (0.011 ["])
6. Test shim A	4.05 mm (0.159 ["])
a -	0.27 mm (0.011 ["])
Shim X	3.75 mm (0.148 ["])

Example II

1. E	61.85 mm (2.435 ["])
e -	0.12 mm (0.005 ["])
E target	61.73 mm (2.430 ["])
2. C	38.00 mm (1.496 ["])
D : 2 +	20.00 mm (0.787 ["])
	58.00 mm (2.283 ["])
3. Gauge preload	7.00 mm (0.275 ["])
Actual value B -	3.12 mm (0.123 ["])
Distance Y	3.88 mm (0.152 ["])
4. C + D	58.00 mm (2.283 ["])
Y +	3.88 mm (0.152 ["])
E actual	61.88 mm (2.435 ["])
5. E target	61.73 mm (2.430 ["])
E actual	61.88 mm (2.435 ["])
a	0.15 mm (0.005 ["])
6. Test shim A	4.05 mm (0.159 ["])
a +	0.15 mm (0.005 ["])
Shim X	4.20 mm (0.164 ["])