

M/S. HYUNDAI MOTOR CZECH.

6/5/2008

INSTRUCTION MANUAL

M/C NAME: GEAR CHECKER & WASHING M/C

M/C TYPE : G T I - 1 A W

M/C NO. : M S - 1 8 8 9

MFG. DATE : 2 0 0 7 . 7

8. PARTS LIST FOR EQUIPMENT

9. ASSEMBLY DRAWING/CIRCUIT DIAGRAM

10. JIG DRAWING - CONSUMABLE DRAWING

Consumable List

11. INSTRUCTION MANUAL FOR EQUIPMENT

Part Equipment

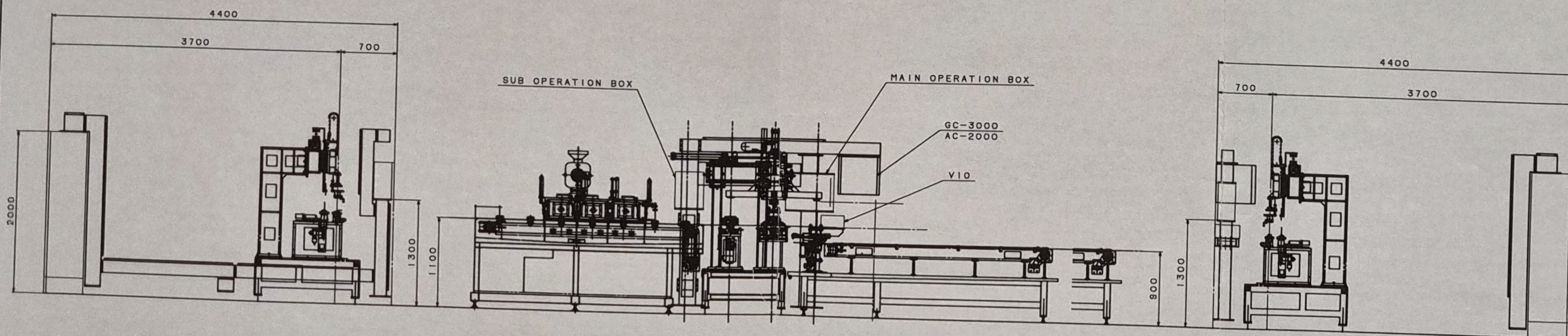
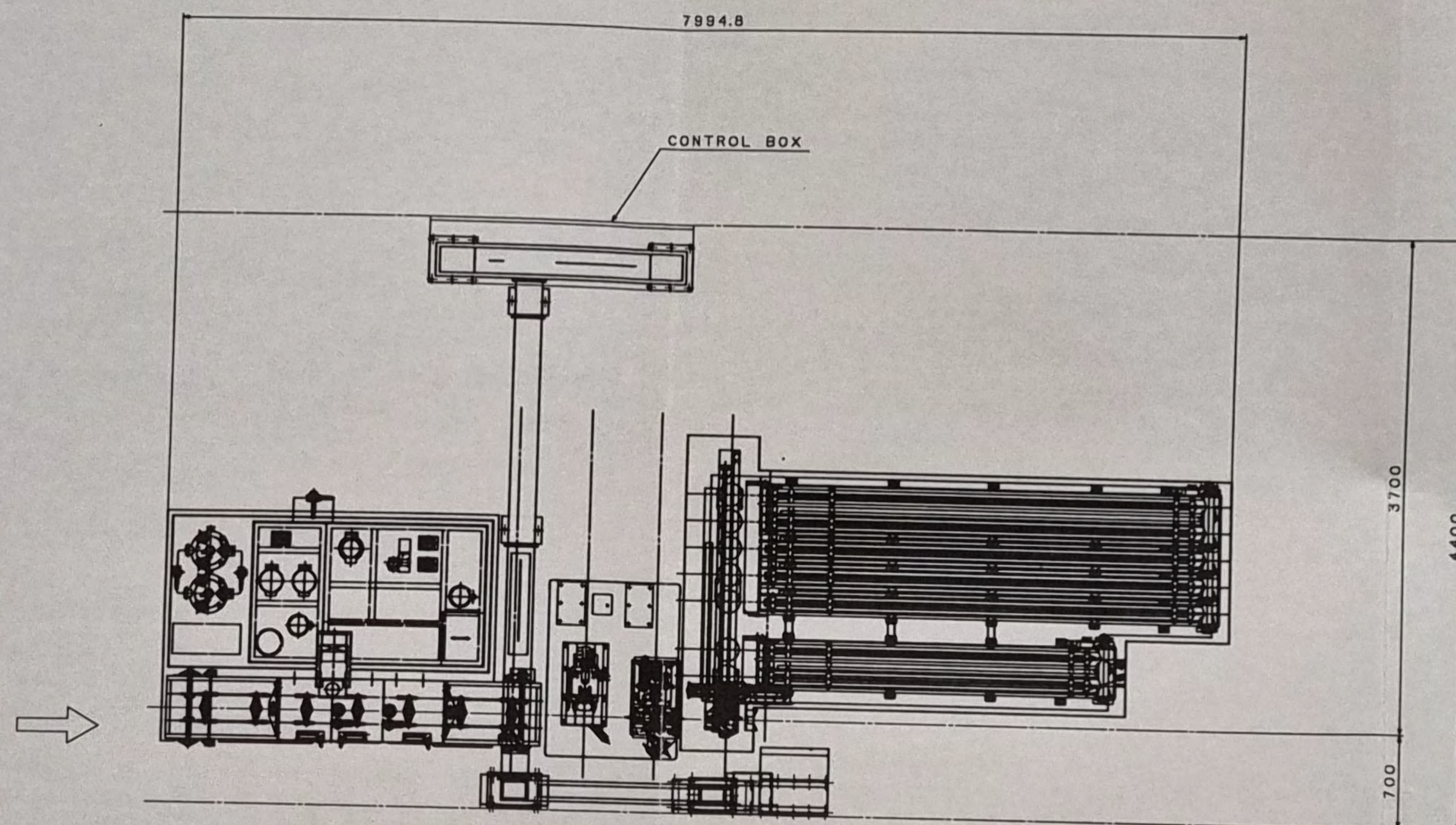
1. MACHINE GEAR CHECKER GC-3000, AC2000

2. JIG INVERTING FRN04512-4J

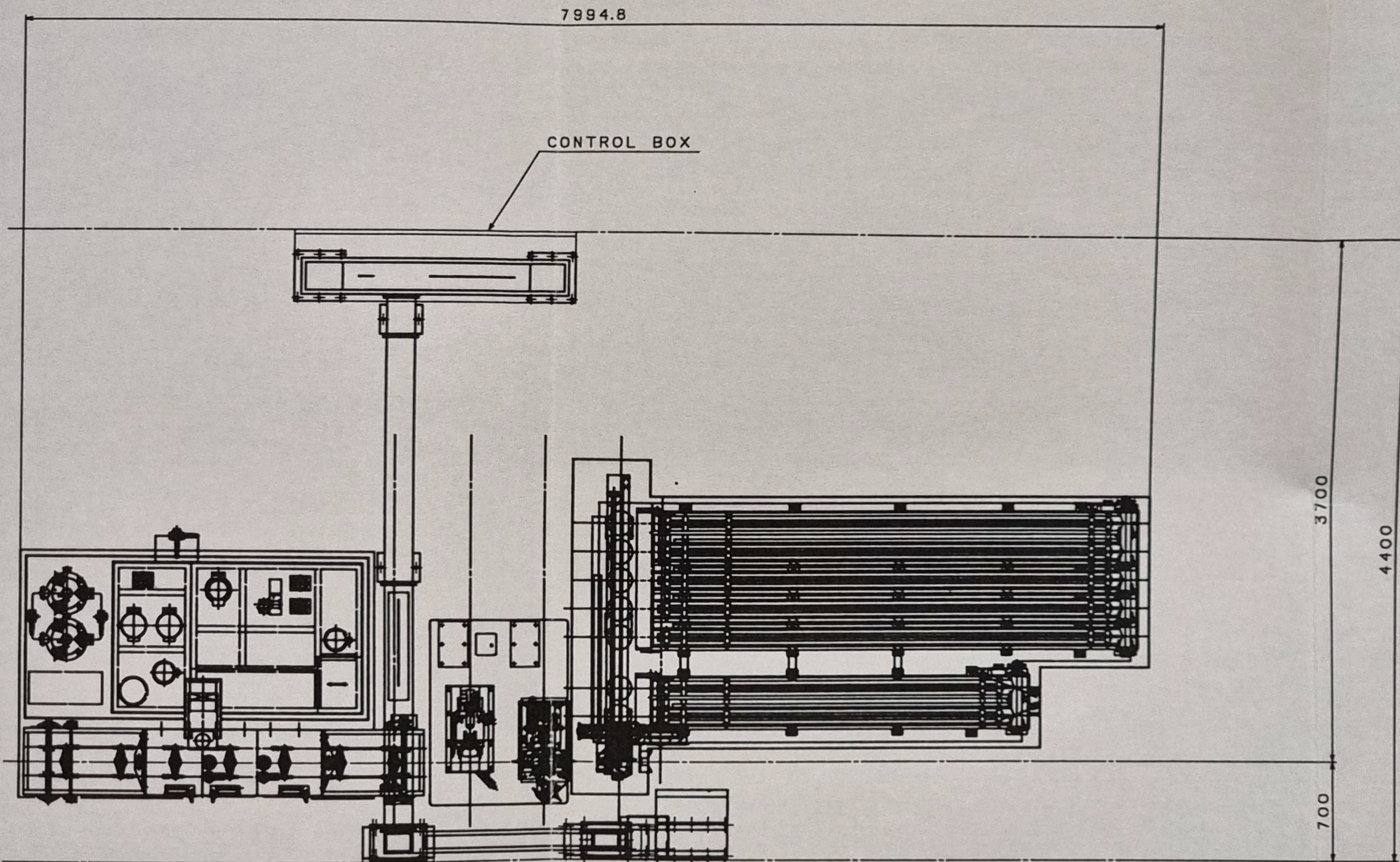
表面仕上りの種類	0.1-0.8	1.0-5.0	1.0-25	25-100	-	第三角法
一般寸法公差	0.05mm	0.1mm	0.15mm	0.2mm	0.3mm	THIRD ANGLE
公差	±0.1	±0.2	±0.3	±0.5	±0.8	PROJECTION

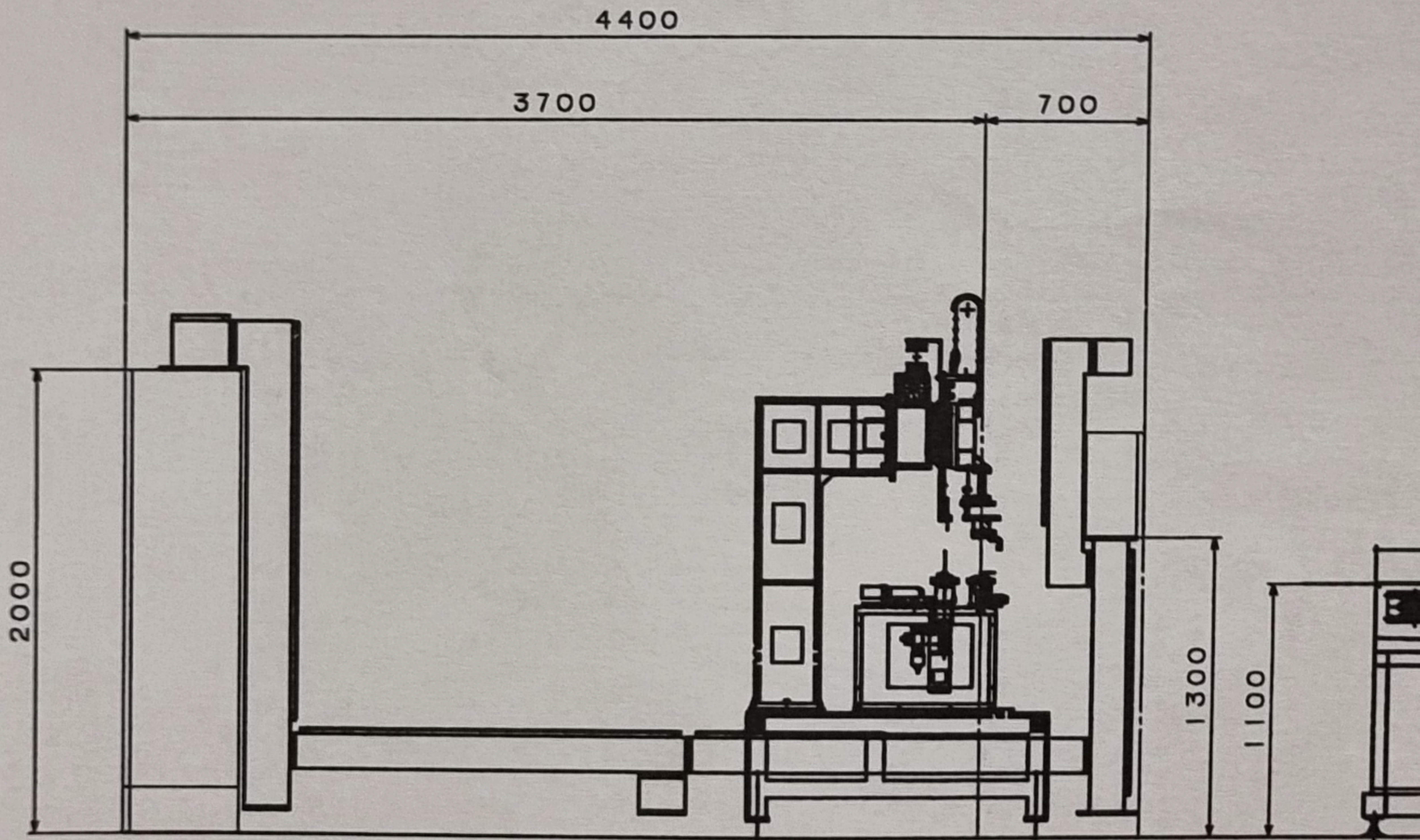
3RD/4TH SPEED 1/P LH-RH

OP NO	KIND	PART NO
ZC45/48/110	GEAR-3rd 1/P	M5CF1-1 1 43261-32010
		M5CF2-1 2 43261-23207
		3 43261-23217
		4 43261-23240
	GEAR-4th 1/P	M5CF1-1 1 43261-32020
		M5CF2-1 2 43261-23207
		3 43261-23220
		4 43261-23240



図番	品名	規格	材質	単位	数量	備
001	ZC45/48/110	MS-1889	鋼板	台	1	山陽マシン(株)
002						
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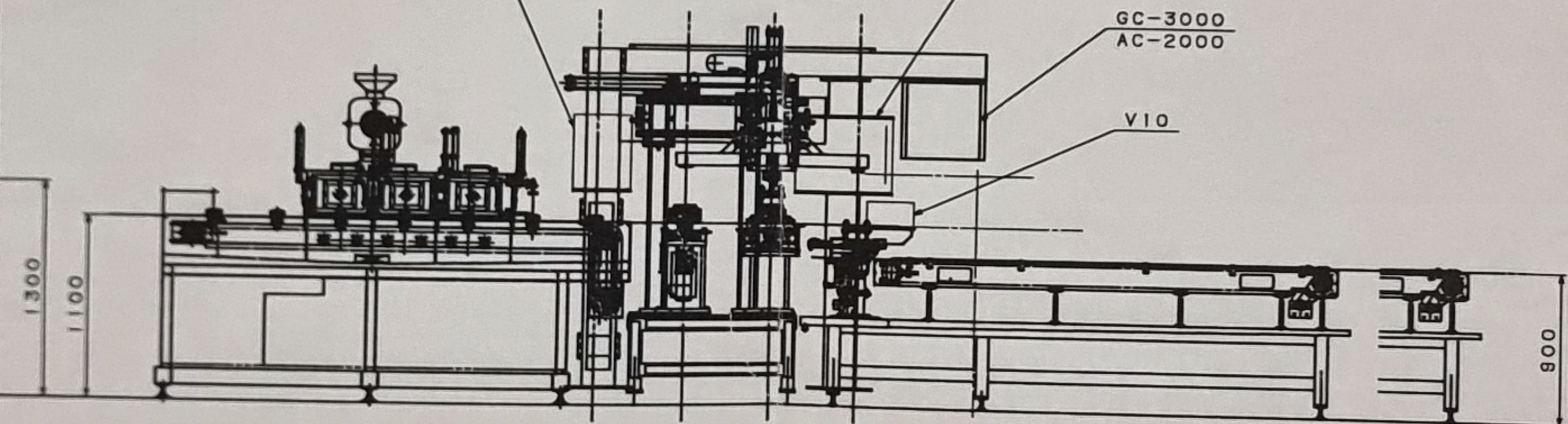


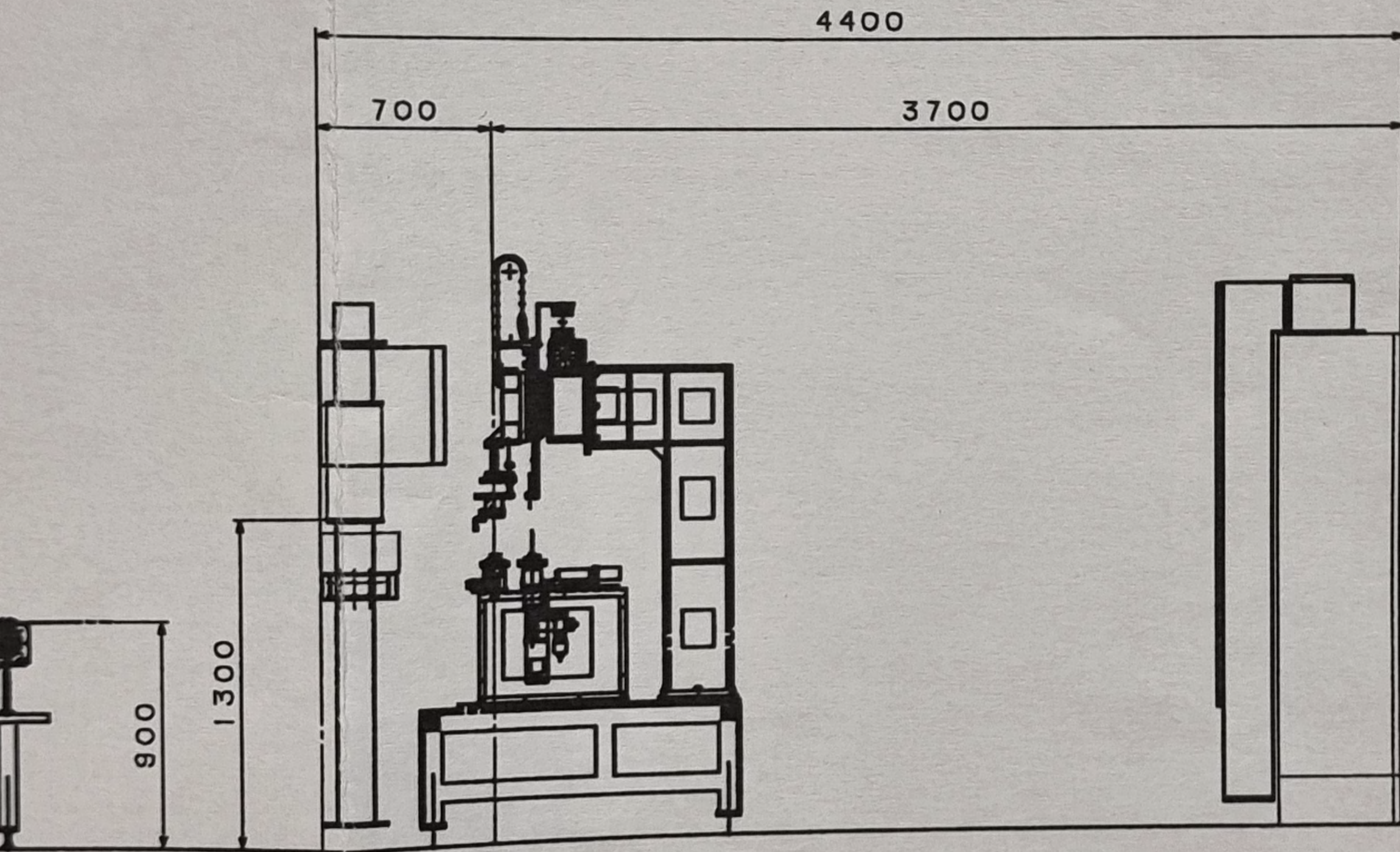
SUB OPERATION BOX

MAIN OPERATION BOX

GC-3000
AC-2000

V10





表面粗度の範囲 S	0.1-0.5 ▽▽▽▽	1.5-6.5 ▽▽▽	1.25-25 ▽▽	35-100 ▽	-	第三角法 THIRD ANGLE PROJECTION
一般寸法公差 mm	0.5以上5以下 ±0.1	5以上30以下 ±0.2	30以上120以下 ±0.3	120以上315以下 ±0.5	315以上1000以下 ±0.8	

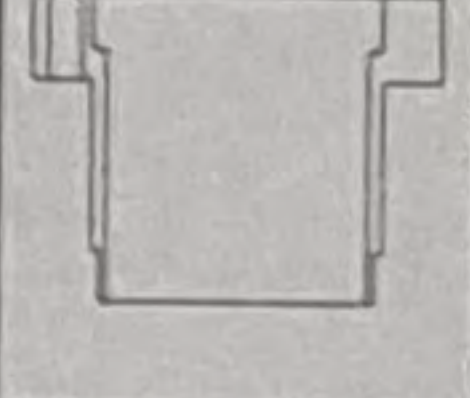
3RD/4TH SREED I/P LH-RH

OP NO	KIND			PART NO
ZC45/48/110	GEAR-3rd I/P	M5CF1-1	1	43261-32010
		M5CF2-1	2	43261-23207
			3	43261-23217
			4	43261-23240
	GEAR-4rd I/P	M5CF1-1	1	43281-32020
		M5CF2-1	2	43281-23207
			3	43281-23220
			4	43281-23240

							ZC45/48/110
製作台数 NO. SET	符号 MARK	品名 NAME	規格 SIZE	材質 MATERIAL	1/4 金分製造 SET	製作台数 NO.	記 事 REMARKS
承認 APPROVED BY	検 図 CHECKED BY	製 図 DRAWN BY K.M	尺度 SCALE 1/25 日付 DATE 07, 6, 30	現代自動車 廠内 Washing & Tester 全体図			
山陽マシン (株)			型 式 TYPE MS-1889	組立図番 ASSY Dwg. NO. 000		図 番 Dwg. NO. 000	
						△ C	

OP. No	ZC45/48-110
EQUIPMENT No.	
OBJECT WORK	GEAR-3RD/4TH SPEED I/P
ORIGINAL MAKER	SANYO MACHINE
REMODEL MAKER	
CONTRACT PRICE	

M/C TYPE CHANGE STANDARD

GRINDING WORK ITEM			M/C TYPE																GRIND. WORK SHAPE	REMARKS		
			GEAR 3RD SPEED I/P								GEAR 4TH SPEED I/P											
			M5CF1-1		M5CF2-1						M5CF1-1		M5CF2-1									
			43260-32010		43260-23207		43260-23217		43260-23240		43280-32020		43280-23207		43280-23220		43280-23240					
			GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH	GEAR 3RD SPEED I/P	GEAR CLUTCH				
			43261-32010	43262-32000	43261-23207	43262-23207	43261-23217	43262-23207	43261-23240	43262-23207	43281-32020	43282-32000	43281-23207	43262-23217	43281-23220	43262-23217	43281-23240	43262-23217				
GEAR ITEM	MODULE		1.664	1.62	1.7	1.78	1.73	1.78	1.63	1.78	1.905	1.620	1.7	1.78	1.63	1.78	1.605	1.78				
	PRESSURE ANGLE		17.5°	20°	17.3°	20°	17.0°	20°	17.7°	20°	16°	20°	17.0°	20°	17.5°	20°	17°	20°				
	TOOTH NO.		27	45	35	48	34	48	37	48	28	45	42	48	41	48	45	48				
	TOOTH WIDTH																					
	INTERNAL DIA.		Φ37G6	Φ73.7	Φ48G6	Φ60H7	Φ48G6	Φ60H7	Φ48G6	Φ60H7	Φ37G6	Φ48H7	Φ52.5G6	Φ60.5H7	Φ52.5G6	Φ60.5H7	Φ52.5G6	Φ60.5H7				
EXTERNAL DIA.			Φ60.88	Φ44H7	Φ74.70	Φ88.6	Φ73.4	Φ88.6	Φ75.81	Φ88.6	Φ70.77	Φ73.7	Φ86.45	Φ88.6	Φ83.75	Φ88.6	Φ88.75	Φ88.6				
MATERIAL																						
HEAT TREATMENT																						
CLASS.	PART NAME	SHAPE																				
PROGRAM	NO.		1	2	3	4	5	6	7	8											MAJOR REMOLDING CONTENT	REMARKS
1ST CHECKER	MASTER		MS07748	MS07749	MS07750	MS07751	MS07752	MS07753	MS07754	MS07755												
	MONITOR		MS07781	MS07782	MS07783	MS07784	MS07785	MS07786	MS07787	MS07788												
	JIG		NO.1 Φ37	NO.2 Φ48			NO.1 Φ37	NO.3 Φ52.5														
2ST CHECKER	JIG		NO.1 Φ37	NO.2 Φ48			NO.1 Φ37	NO.3 Φ52.5														
	STOPPER FRONT/BACK		1	2			1	3														
	STOPPER UP/DOWN		1	2			1	3														
LOADER	JAW		1	2			3															
WASHING	JIG		M/C#3-A	M/C#3-B			M/C#3-A	M/C#3-B														
TOTAL																						

2008.6

ZC45 48-110

ENGLISH

GEAR CHECKER
& WASHER M/C
MS-1889

INSTRUCTION MANUAL

1. M/C LAYOUT
2. EXPLAMATION OF
OPERATION
3. STANDARD
LUBRICATION
4. TABLE OF PARTS
CHANGE
5. CHECK SHEET
6. DATA
7. MAINTENANCE
8. LIST OF PURCHASE
PARTS
9. A' SSY & CIRCUIT
DRAWING
10. CONSUMPTION PARTS
DRAW
11. M/C USED MANUAL

ALL ELECTRICAL DATA

SANYOMACHINE CO., LTD

0886