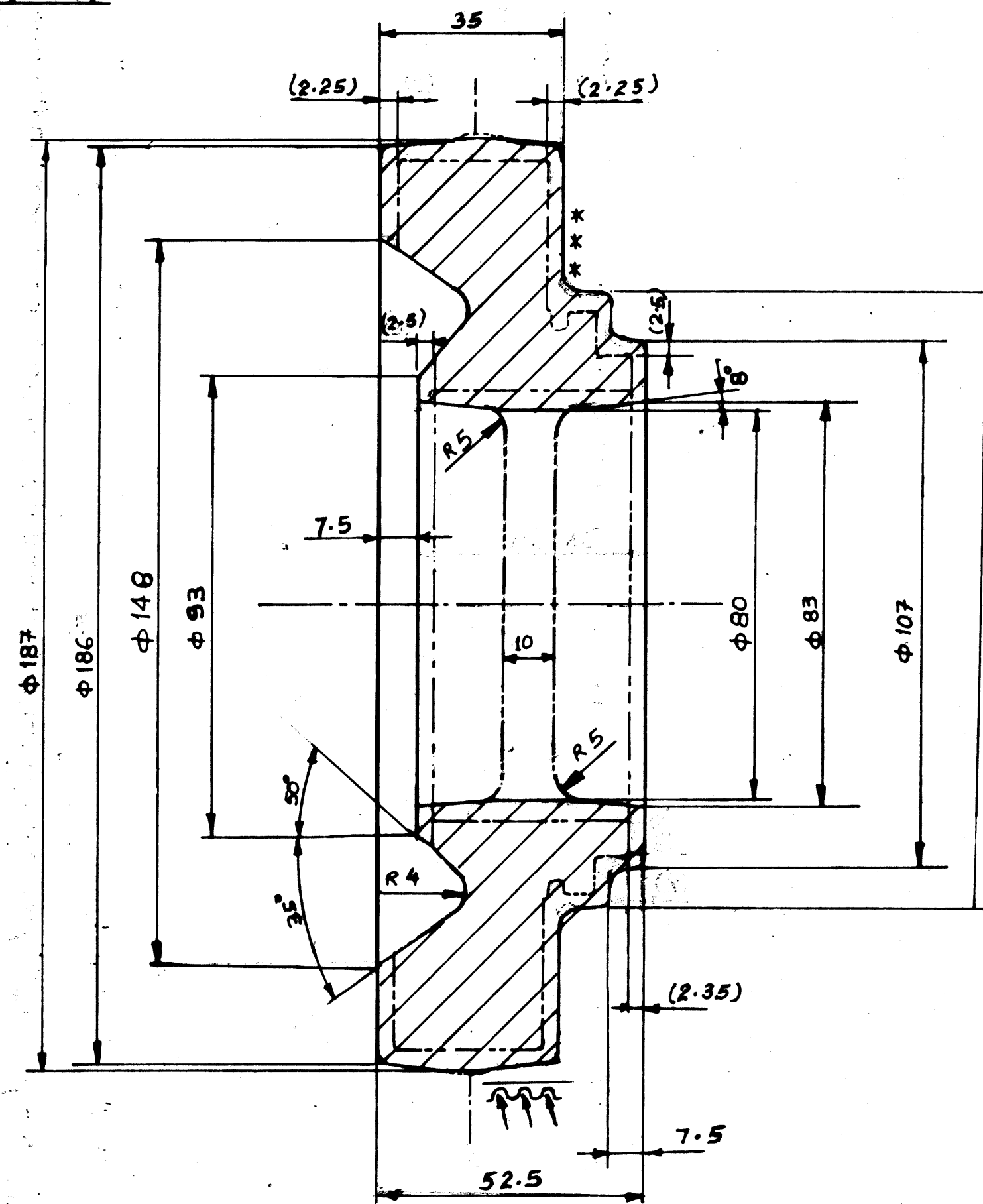


ALL DIMS. ARE IN M.M.

DRG. NO. SUPPLIER'S INITIAL
MFG. MONTH & YEAR TO BE RAISED (***)



NOTE: SUPPLY CONDITION

1) OUT SIDE DIA. 106.0/105.5

2) BORE DIA. 83.0/83.5

NOTE:

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
2. FORGING TO BE SHOT BLASTED.
3. FORGING TO BE COATED WITH RED OXIDE PRIMER TO ISS: 3-47-13 BY BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
5. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
6. DIMENSIONS IN BRACKET INDICATES MACHINING ALLOWANCE.
7. CLAMPING FACE 30°
8. DRAFT ANGLE - INNER 3° - OUTER 3°
9. UNSPECIFIED RADII - CORNER-2 R, FILLET-3 R

MATERIAL: 815 M17 BS 970-1, T13	EQVT. MATL.
CHEM. COMPOSITION	
PHYSICAL PROPERTIES:	
HEAT TREATMENT: ISOTHERMAL ANNEALING	
HARDNESS: 100 - 200 BHN	
MICROSTRUCTURE: FINE FERRITE & PEARLITE	
GRAIN SIZE: A.S.T.M. 5 OR FINER	
INCLUSION RATINGS: 3 ABCD THIN SERIES OR FINER AS PER IS 4163-1967. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.	

FORGING TOL. AS PER IS: 3469-1974				
FORGING HEIGHT	ENVELOP HEIGHT	COMPLE. XITY	INTRAC. OF MATL.	FORGING GRADE
6 kg/APPX				
KIND OF DMS	TOL.	KIND OF DMS	TOL.	
DIE WEAR	+1.4 -0.4	FLASH EXTENSION	CLOSE TRIM	
DIE THICKNESS	+1.5 -0.0			
DIA	+1.5 -0.7	TRIMED FLAT		
MISMATCH	0.6	ANGULAR	+1° -0.5°	
STRAIGHTNESS	0.6	RADI	+50% -25%	
INTERNAL DMS REVERSE SIGN +0-				

INDEX	ALTERATION	DATE	SIGN
DRN	TCD		
FORGING DRAWING		DRG. NO.	1:1
		26912620 0416	SCALE
FDR:- 2nd SPEED GEAR MAIN SHAFT		TDO	09.09.04
G/BOX. LPTA-715(BSE)		M/C SECTION	DATE
		REQD BY:	1/1
		REPT FOR	SHEET
VEHICLE FY. JABALPUR		DRG. NO.	26912620 0416-3

4.6-2-15