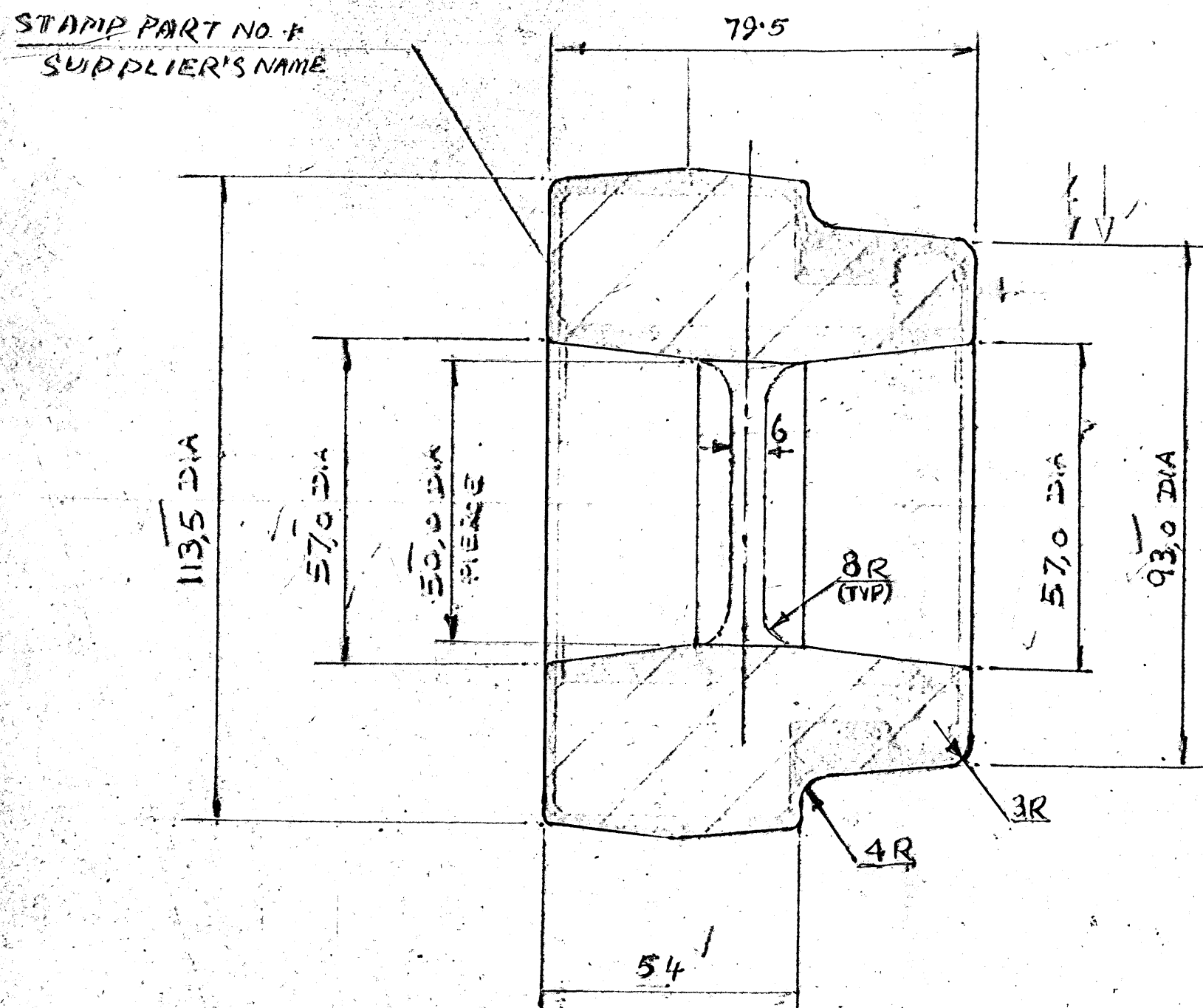


ALL DIMS. ARE IN MM.



NOTE: 1) ALL LOCATING, RESTING AND CLAMPING POINTS
TO BE CLEAN, SMOOTH, FLAT AND CYLINDRICAL

2) ALL THE TOLERANCES TO BE AS PER
IS: 3489 (PART I TO III) - 1974

3. FORGING TO BE SUPPLIED AFTER APPLYING RED OXIDE PRIMER FOR RUST PREVENTION.

4. SAMPLE TO BE APPROVE BEFORE BULK SUPPLY.

5. GRAIN SIZE: ASTM 50R FINE

5. INCLUSION RATING:- 3ABCD THIN SERIES OR
FINER AS PER IS: 4163-1967.

MATERIAL CONSTITUENTS

S.N.	DETAILS	MARK IV
1	MATERIAL	EN355
2	IS EQUIVALENT	822M 17
3	TYPE OF STEEL	2% Ni Cr Mo CH Steel (Low Cr)
4	C	0.2 Max
5	Si	0.35 Max
6	Mn	0.4-0.7
7	Ni	1.8-2.2
8	Cr	1.4-1.7
9	Mo	0.15-0.25

TOLERANCES

TOLERANCES	
DIE WEAR (TOTAL)	+1.1 , -0.4
DIE THICKNESS	+1.5 , -0.0
MIS- MATCH	0.6
FLUSH EXTENSION	CLOSE TRIM
STRAIGHTNESS	0.6
CORNER + FILLET RADII.	+50% , -25%
DRAFT ANGLE	+2° , -1°
ECCENTRICITY TO THE PUNCH HOLE	1.0 (2.0 TIR)
SURFACE	0.4

SUPPLY CONDITION - PRE-MACHINED

OUTSIDE DIA. - 113.5 / 113.0
INSIDE DIA. - 57.5 / 57.0

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS		MATERIAL	EN 355, FINEGRAIN	LOCATE
DRAFT ANGLE	EXT. 5°	HEAT TREATMENT	ISO THERMAL ANNEALING FORGING TO BE SUPPLIED IN SHOT BLASTED COND.	REST
	INT. 7°	HARDNESS	160-210 BHN	
CORNER RADIUS	2	MICRO STRUCTURE	FINE FERRITE & PEARLITE	CLAMP
FILLET RADIUS	3	WEIGHT		

(R1)	NOTATION IN 11 & 12 UNDER TABLE CONCERNING DELETED REF. NUM/DATE/REVISION/NO. 157/ DATE/REVISION/NO. 157/	DATE	SIGN
INDEX	ALTERATION	DATE	SIGN

<u>FORGING DRAWING</u> <u>GEAR INPUT LOW</u> <u>AGB/STLN.</u> <u>MARK - IV</u>		1:1 SCALE 01-02-10 DATE 1/1 SHEET
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T.D.O	VEHICLE FACTORY SABALPUR	DRGNO. X 1602411-3(R1)
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