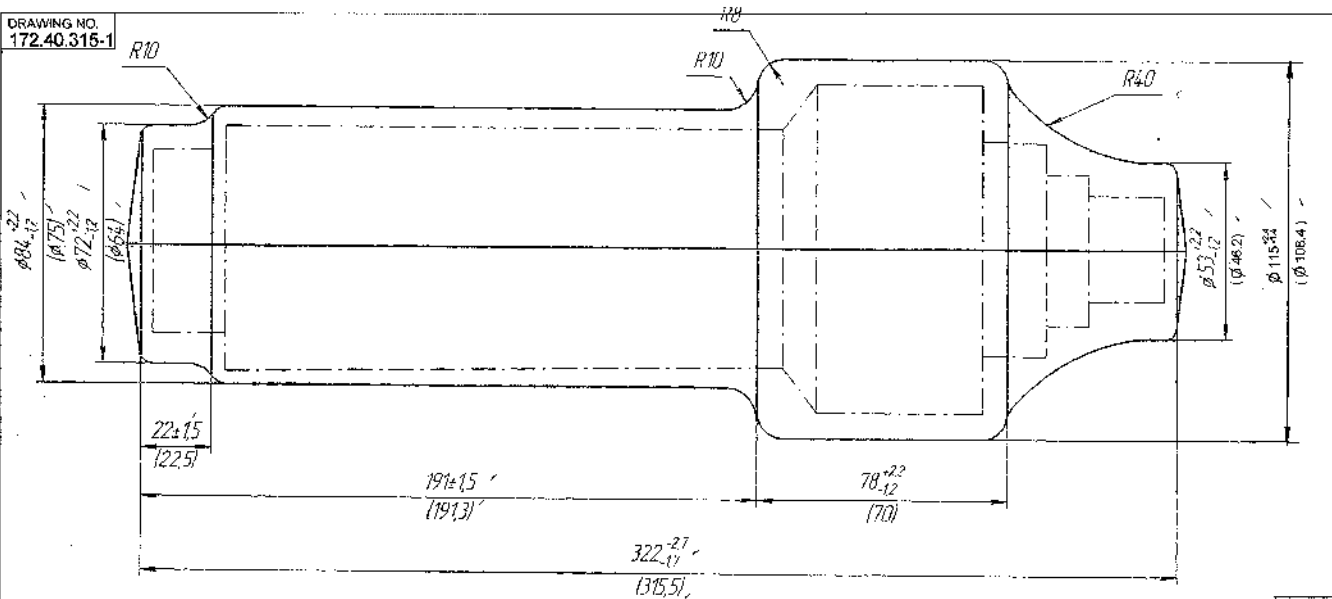


DRAWING NO.
172.40.315-1



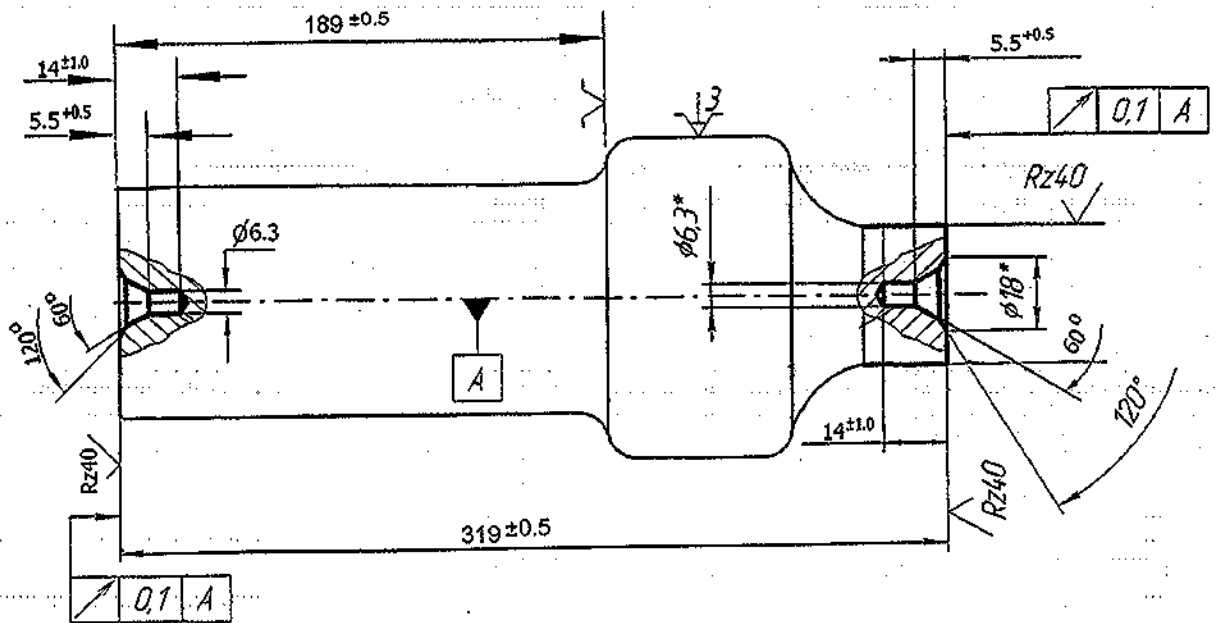
TECHNICAL REQUIREMENTS

- | | |
|--|--|
| <p>01. 207...268 HB.</p> <p>02. BURRS MAY BE ALLOWED ON THE PERIMETER OF CUT UP TO MAX. 1.7 MM.</p> <p>03. DISPLACEMENT ALONG PARTING OF DIE UP TO MAX. 1.2 MM IS ALLOWED.</p> <p>04. BENDING UP TO MAX. 1.2 MM MAY BE ALLOWED.</p> <p>05. UN-SPECIFIED STAMPING DRAFTS - 7°</p> <p>06. UN-SPECIFIED FILLET RADII - R 4 MM.</p> <p>07. DIMENSIONS IN BRACKETS ARE FOR MACHINING.</p> | <p>08. DIMENSIONS WITHOUT TOLERANCES ARE FOR MAKING DIE.</p> <p>09. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS AS WELL AS SLANTED CHIPPING OR FINISHING OF DEFECTS IN DEPTH UP TO 50% OF ACTUAL ONE SIDE MACHINING ALLOWANCE MAY BE ALLOWED.</p> <p>10. DE-SCALES (SHOT BLASTING)</p> <p>11. IT IS ALLOWED TO MARK MELT NO.</p> <p>12. FORGING ACCURACY CLASS II, GROUP OF FORGING M2. CATAGORY OF COMPLEXITY C1 GOST 7505-89</p> <p>13. PAINT RED OXIDE.</p> |
|--|--|

for reference only
T 92 dia 175 90-000/10

MATERIAL	FORGING WT.	T 90	
18X2H4BA GOST 4543-71	16.36 KGS		
ALT. MATERIAL	HAMMER	SCALE	
18X2H4MA GOST 4543-71	DG-13	NTS	
DRAWN	CHECKED	APPROVED	
<i>A. Srinivasan</i>	<i>M. Srinivasan</i>	<i>S. Srinivasan</i>	
DRAWING NO.	172.40.315-1/F		
NOMENCLATURE:	SECONDARY SHAFT		
HEAVY VEHICLES FACTORY AVADI, CHENNAI			

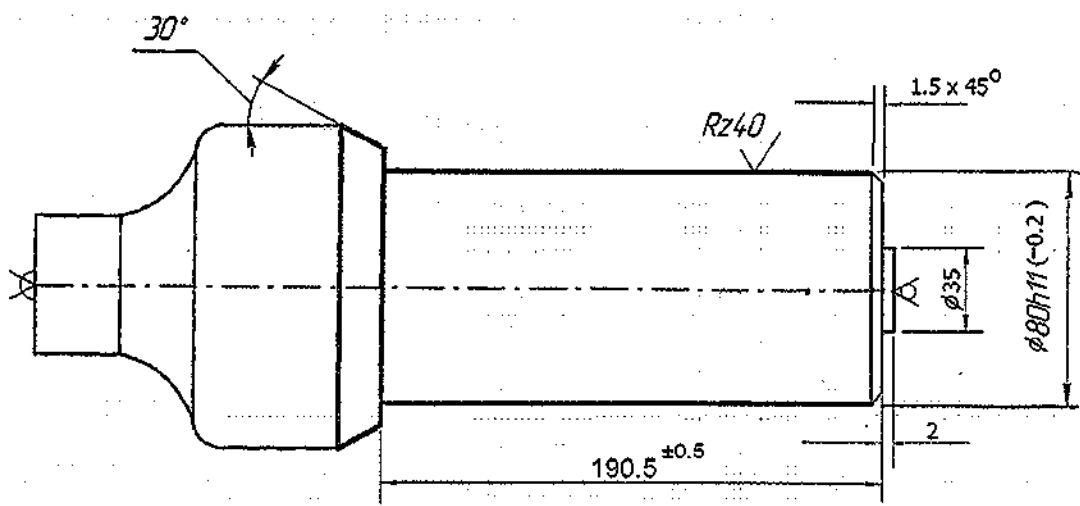
Rz80
✓(✓)✓



DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 010 FACING AND CENTERING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

<i>Mj</i>	<i>NOE</i>	<i>ckf</i>
PREPARED	CHECKED	APPROVED

Rz80
✓(✓)

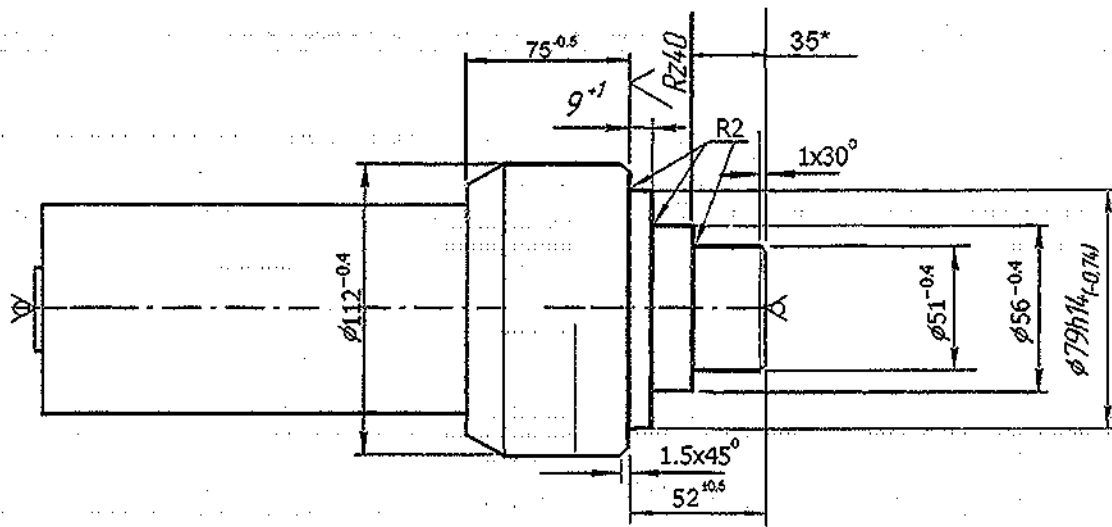


1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS
OF CENTER HOLES SHOULD BE 0.3mm MAX

DRG. NO.	: 172.40.315-1 /SMF DRIVEN SHAFT
OPN. NO.	: 030 TURNING
MATERIAL	: STEEL T8X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	: NOT TO SCALE

PREPARED	CHECKED	APPROVED

Rz80
✓(✓)

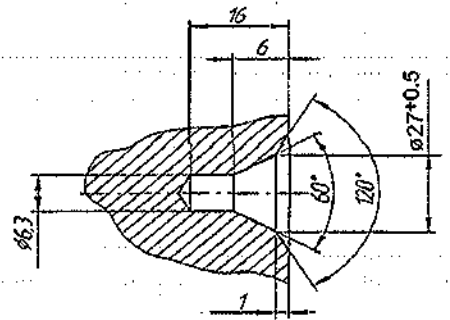
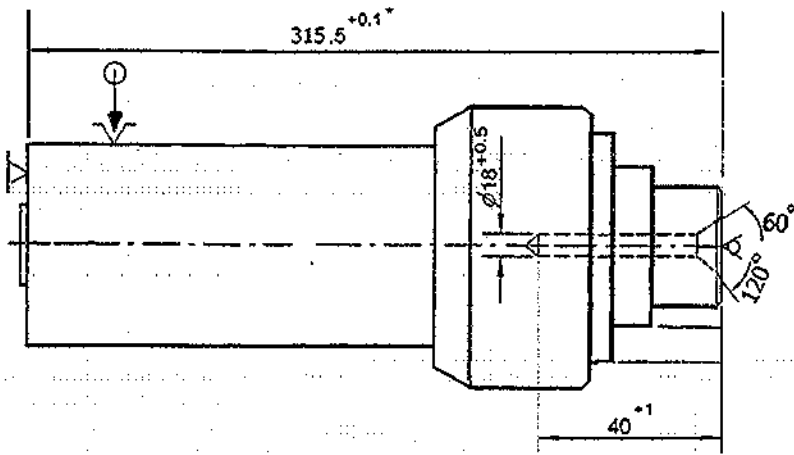


1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS OF CENTER HOLES SHOULD BE 0.3mm MAX

DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
CPN. NO.	: 040 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

PREPARED	CHECKED	APPROVED

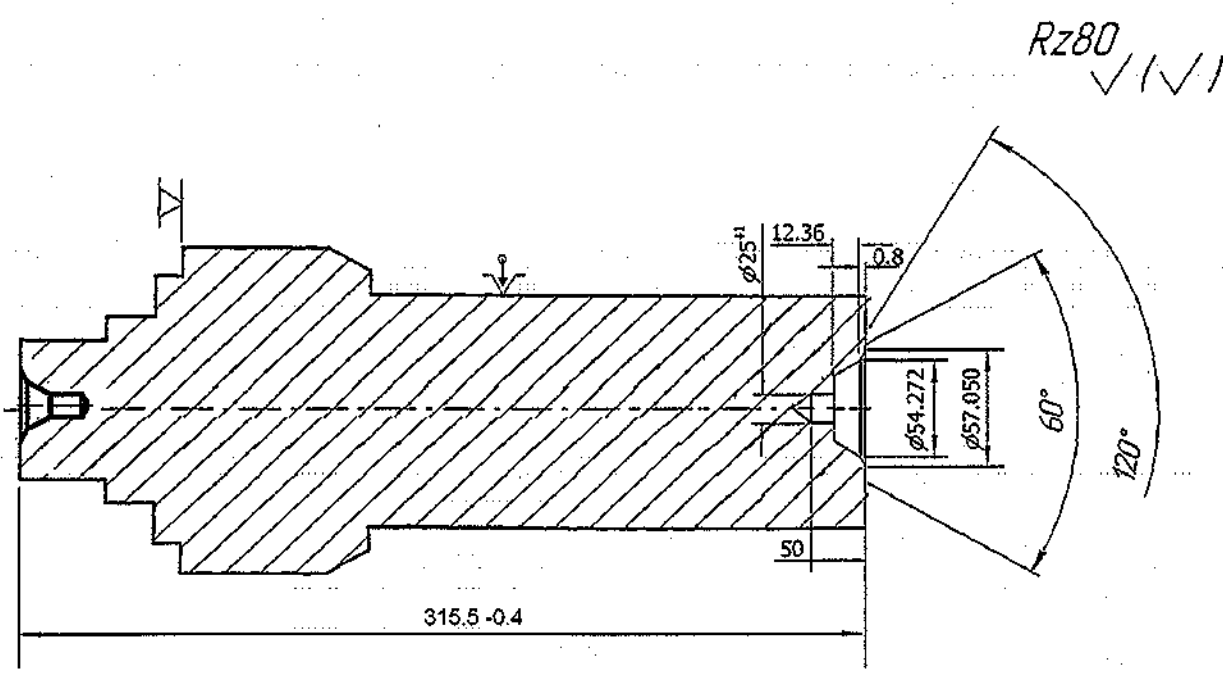
Rz80
√(√)



1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS OF CENTER HOLES MAY BE UPTO 0.3mm MAX


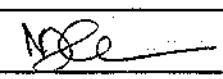
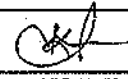
DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 045 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	
	NOT TO SCALE

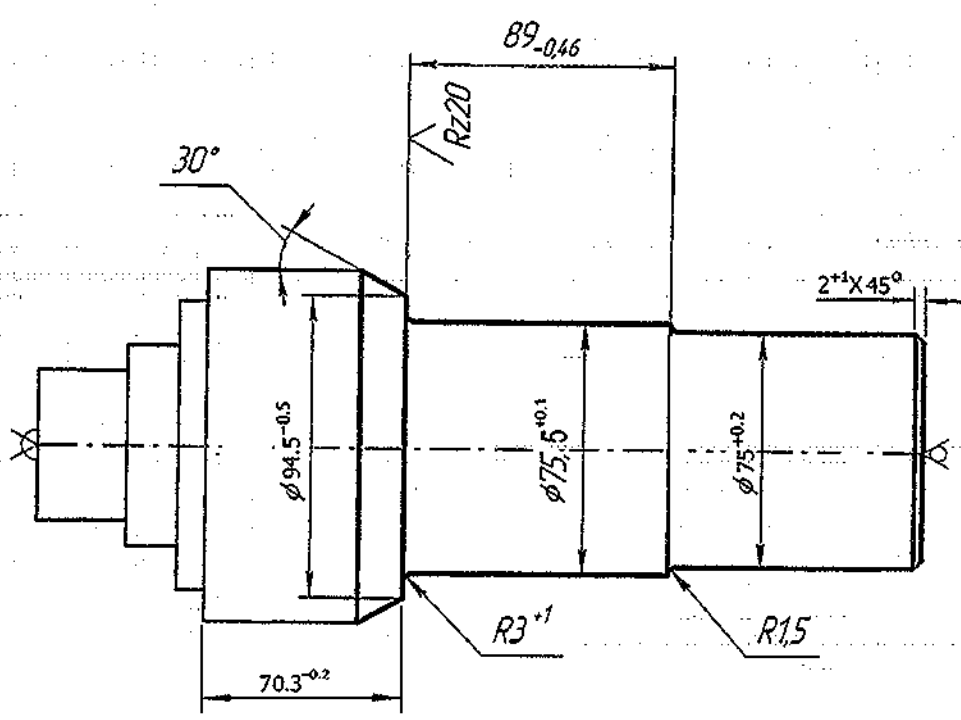
PREPARED	CHECKED	APPROVED



1. RUN-OUT BASE SURFACES WITH RESPECT TO CENTERS IS ALLOWED UPTO 0.3MM MAX.

DRG. NO	: 172.40.315-1 /SMF DRIVEN SHAFT
OPN. NO.	: 050 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

		
PREPARED	CHECKED	APPROVED

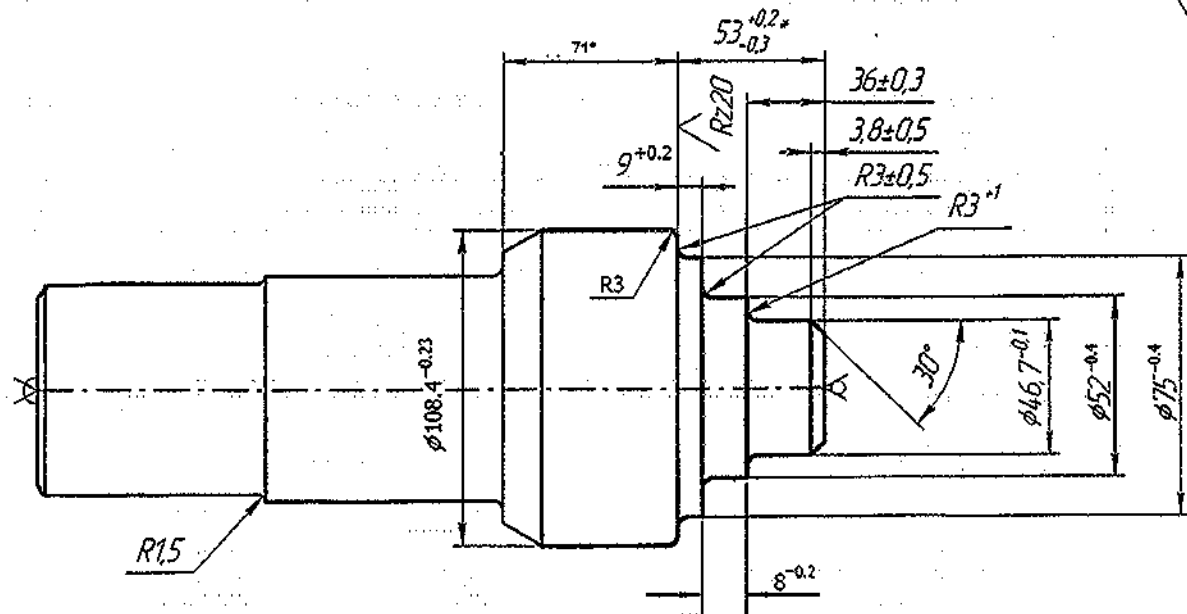


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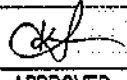
DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 070 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.
	NOT TO SCALE

<i>Mjv</i>	<i>[Signature]</i>	<i>[Signature]</i>
PREPARED	CHECKED	APPROVED

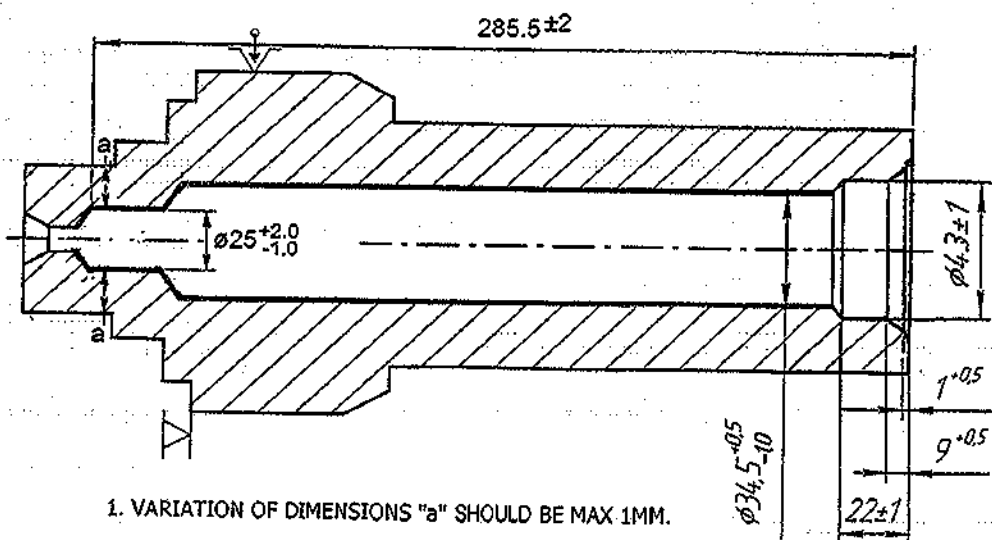
Rz40
✓(✓)



DRG. NO.	: 172.40.315-1 / SMF DRIVEN SHAFT
CPN. NO.	: 060TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

		
PREPARED	CHECKED	APPROVED

Rz80
 ✓(✓)



1. VARIATION OF DIMENSIONS "a" SHOULD BE MAX 1MM.

DRG. NO	: 172.40.315-1	DRIVEN SHAFT
OPN. NO.	: 055 DRILLING	
MATERIAL	: STEEL 18X2H4BA	
HARDNESS	: 207-268 BHN	
SHEET NO.		NOT TO SCALE

PREPARED	CHECKED	APPROVED