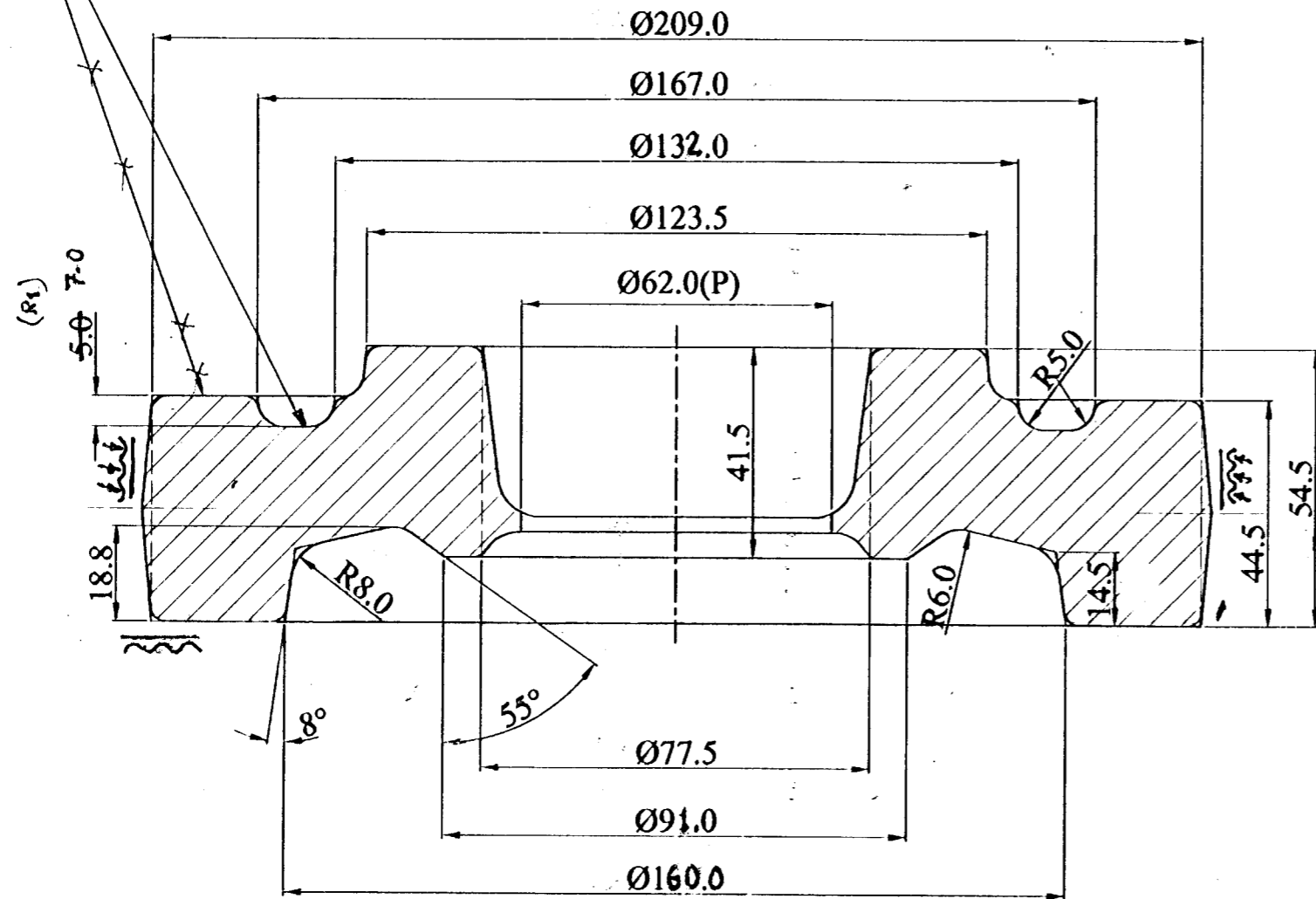


ALL DIMS. ARE IN M.M.

(R<sub>2</sub>) STAMP PART NO., FIRM'S INITIAL, MONTH & YEAR  
(5 x 1 RAISED TYPE)



- NOTES:-
1. ALL DIMENSIONS ARE IN MM.
  2. DRAFT ANGLE: OUTER-5°, INNER-7°  
CORNER RADII-2 & FILLET RADII-5  
(UNLESS OTHERWISE STATED)
  3. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PITS, LAPS, CRACKS, UNFILLINGS ETC. (MAX. DEPTH DEFECT ALLOWED 0.4 MM.)
  4. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLIT WITHOUT HARMFUL CONTINUOUS BANDING.
  5. GRAIN SIZE: ASTM NO. 5-8 AS PER 'MC' QUAI- EHN TEST (FILED GRADE AL KILLED CONDITION)
  6. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
  7. HARDNESS: 180-200 BHN
  8. MATL: 20Mn5Cr5
  9. FORGING ARE TO BE SHOT BLASTED
  10. HEAT TREATMENT - ISOTHERMAL ANNEALING
  11. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
  12. FORGING TO BE COATED WITH RUST PREVENTIVE RED OXIDE PRIMER
  13. FORGING RIDGES TO BE TRIMMED, CLEANED & SMOOTH FINISHED ALL OVER.
  14. CLAMPING FACE - RESTING FACE - FOR MACHINING 1ST OPERATION.

SUPPLY CONDITION!

OUTSIDE DIA. - 209.0/209.5  
INSIDE DIA. - 77.0/77.5

ECCENTRICITY OF PIERCING	0.6
THICKNESS	+1.5, -0.0
DIE WEAR	+2.1, -0.0
FLASH PROJECTION	0.8
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
FLATNESS	0.8
MISMATCH	0.7

TOLERANCES UNLESS OTHERWISE SPECIFIED  
INT. DIMS. REVERSE SIGN + & -

ITEM	DESCRIPTION	NO OFF	10 F MAT	18 MAT	SIZE/WP	REMARK	
(R <sub>2</sub> )	STAMPING POSITION OF FIRM'S INITIAL & PART NO ETC CHANGED R.F.F. L.No 035/AWM/GS/AUD/01.DT.22.12						
(R <sub>1</sub> )	DEPTH OF GROOVE 7 WAS 5 CHANGED AS PER JWM/GS L.No.035/JWM/GS(LPTA) DT. 06.02.12						
INDEX	ALTERATION	DATE	SIGN	DRN	TCD	CKD	C/CKD
DIM	TOL	<p style="text-align: center;"><b>FORGING DRAWING</b> <b>FOR</b> <b>1ST SPEED GEAR, M/S.</b> <b>GB / LPTA - 715, BS- III</b></p>		REFERENCE DRG.		NT-5	
0-30	± 0.1			2691 2620 5412		SCALE	
30-130	± 0.2			MACHINE		28.9.10	
150-800	± 0.3			DEMANDED BY		DATE	
800-2000	± 0.5					1/1	
> 2000	± 0.8			SHEET			
T.D.O.	VEHICLE FACTORY JABALPUR			DRG NO		CHANGE NO	
				2691 2620 5412 - 3 (R <sub>2</sub> )			

13/3-2001 46-2-01

13/3-2001