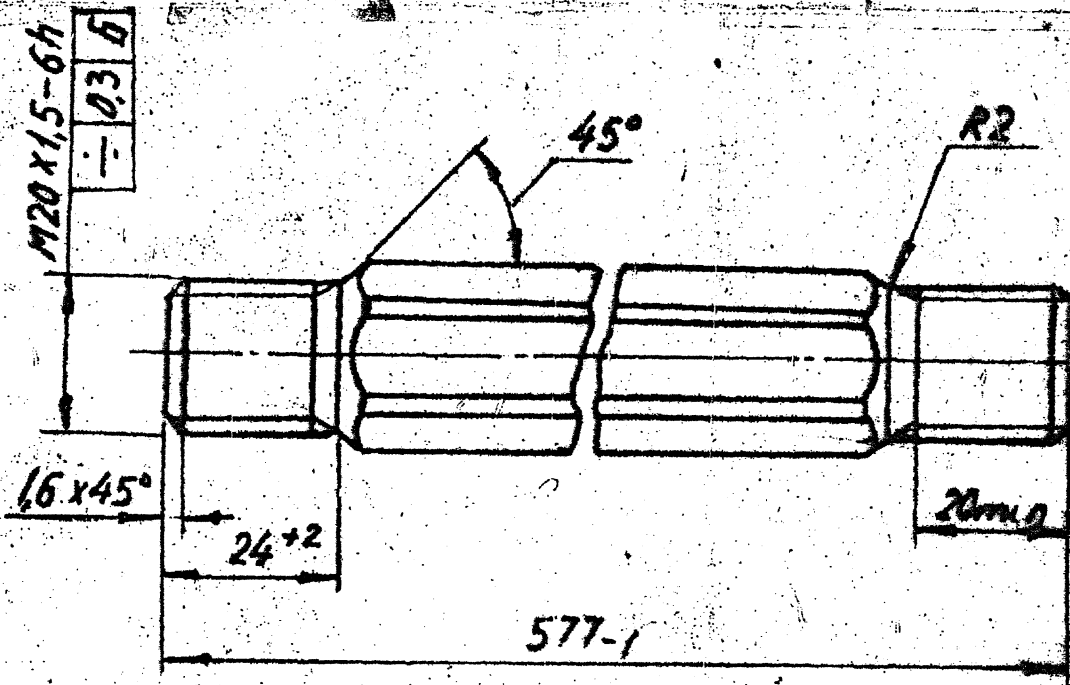
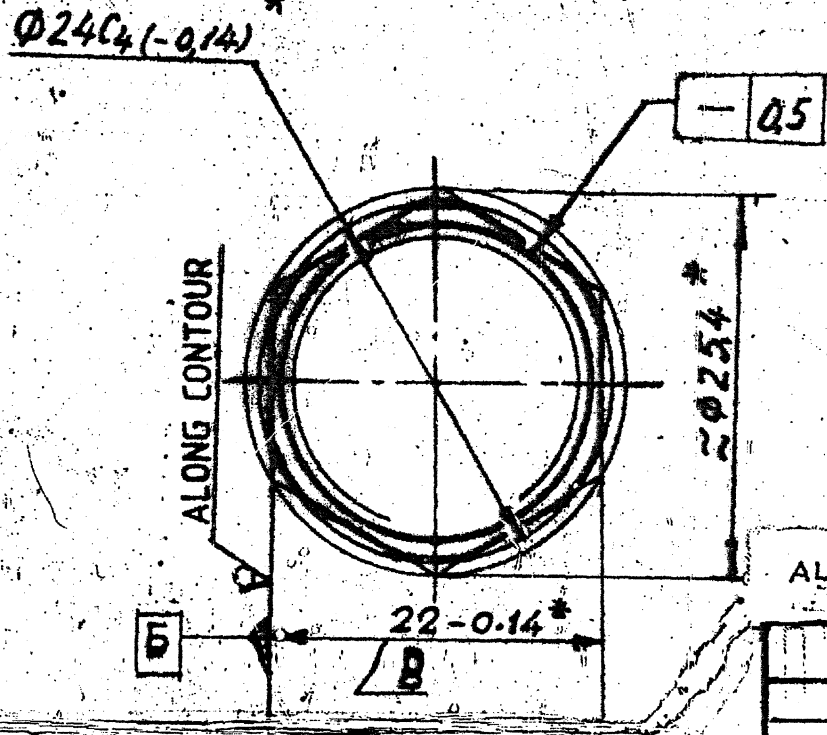


DRAWING NUMBER:
613 44 058

Rz80 (✓)



VIEW A
SCALE: 2:1



ALT. MATL: EN 24 TO BS 970

1. HB311.....415 ISOTHERMAL HARDENING. HARDNESS IS TO BE CHECKED AT A DISTANCE NOT EXCEEDING 50mm FROM THE END. DRESSING NOT EXCEEDING 0.6mm IN DEPTH AND NOT EXCEEDING 15mm IN LENGTH IS ALLOWED. IMPACT STRENGTH IS AT LEAST 8Kgm/Cm² SECOND FLAT IS ALLOWED DURING REPEATED CHECKING FOR HARDNESS. AFTER HEAT TREATMENT DIMENSION 'B' MAY BE CHANGED TO 22-0.2.
- 2.* DIMENSIONS FOR REFERENCE.
3. FLAT CUT SHAPE OF THREAD BOTTOM IS NOT ALLOWED.
4. PRIOR TO ZINC PLATING, SHOT BLASTING OF THE THREADED ENDS OF COMPONENT IS TO BE CARRIED OUT. THREADS ARE TO BE CHECKED PRIOR TO BLASTING. BLASTING OF THE WHOLE PIN IS ALLOWED.
5. COATING: Zn⁶ CHROMATIZING 'T' WITH SUBSEQUENT REMOVAL OF HYDROGEN EMBRITTLEMENT AFTER PLATING & PASSIVATION TO BE KEPT IN FURNACE AT 100° TO 200°C. FOR 2 HRS (MIN) & THEN NATURAL COOLING.

EXPLANATORY NOTE:-

- 7.6. REFERENCE MATERIAL QUOTED:
HEXAGONAL BAR AS PER Ty14-1-2564-78 OF CHROME SILICON STEEL OF GOOD QUALITY GRADE 38XC GOST 4543 -71.
- a) CHEMICAL COMPOSITION:-

| CONTENT OF ELEMENTS % | | | | | |
|-----------------------|-----------|-----------|-----------|---------|-------|
| C | Si | Mn | Cr | S | P |
| | | | | MAXIMUM | |
| 0.34-0.42 | 1.00-1.40 | 0.30-0.60 | 1.30-1.60 | 0.035 | 0.035 |

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.30% EACH

- b) MECHANICAL PROPERTIES:-

| TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH Kgm/Cm ² |
|---|------------------------------------|-----------------|------------------------|--|
| MINIMUM | | | | |
| 95 | 75 | 12 | 50 | 7 |

- 8.7. REFERENCE NOTE 5 ON COATING :
TO BE ZINC COATED Fe Zn. 6 IS : 1573-70 AND FOLLOWED BY CHROMATE PASSIVATION TO IS:1340-77.
6. TOTAL DECARBURIZATION VALUE SHOULD NOT EXCEED 0.27mm IN CREST OF THREAD AND 0.08mm IN BOTTOM OF THREAD. MEASUREMENT OF DECARBURIZATION LAYER DEPTH TO BE CARRIED OUT AS PER GOST 1759-70

DRG. CREATED BASED ON RUSSIAN ORIGINAL ISSUE-1

KVD No:- 72805

F 188/88

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST WT 1.814 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

| | | | |
|--|-----------------|--|-------------------------------------|
| DRN | <i>Shoudam</i> | MATERIAL: HEXAGONAL BAR USED ON | |
| CHD | <i>Shoudam</i> | Ty 14-1-2564-78 | 613 44 22 Cb A1 |
| TCD | <i>B. Tomiy</i> | 38XC GOST 4543 -71 | |
| APPD | <i>Shoudam</i> | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | |
| DATE | 28 -02 -86 | | |
| SCALE: | 1:1 | | |
| DIMENSIONS IN mm | | | |
| TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69 | | TITLE PIN | |
| ALL THREADS TO CONFORM TO IS : 4218 Pt IV | | D S CAT NUMBER: | DRAWING NUMBER 613 44 058 |
| 3A | 26.11.93 | QID Lt No. 83027/D/TRACK/IND-1#23 | |
| 3 | 1-7-91 | NOTN. N32-B9 AL.12/SK.3 | |
| 2 | 20-10-88 | AMDT. LIST 6, PART II, BOOK-11 | |
| 6. ISSUE | DATE | NATURE OF AMENDMENTS | |

Received with letter No. OFM/TDS/TA/07A Dt. 22-11-2010