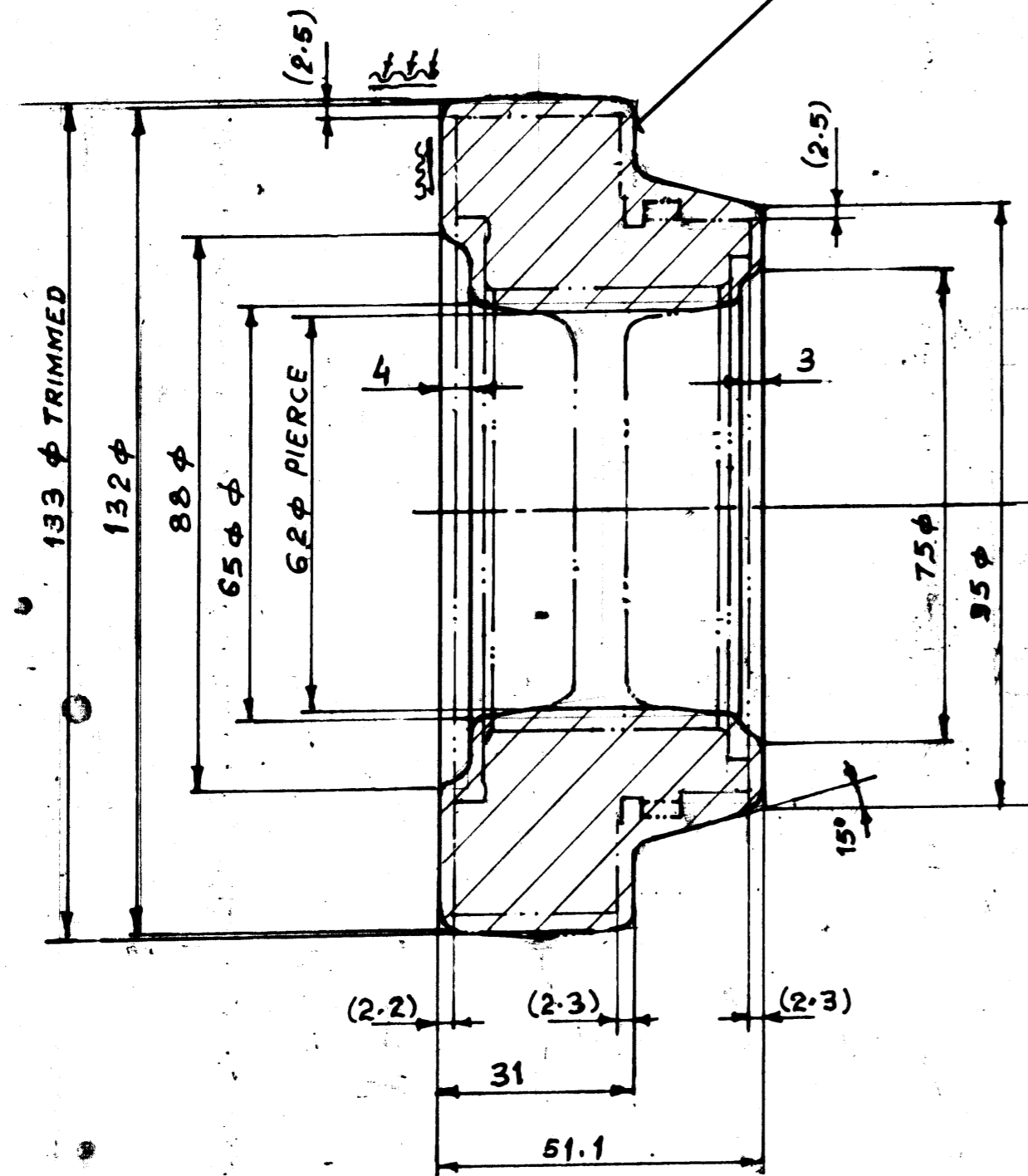


ALL DIMS ARE IN MM.

EMBOSS DRG. NO. & FIRM'S INITIAL & MONTH/YEAR



NOTE: SUPPLY CONDITION
 1) OUTSIDE DIA. 132.0/131.5
 2) BORE DIA. 65.0/65.5

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: 3-47-18 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 *hls*.
8. DRAFT ANGLE - INNER 8° - OUTER 3°
9. UNSPECIFIED RADII - CORNER-2 R, FILLET-3.5R

MATERIAL: SS:4027 EQVT. MATL.
 815 M17 BS 970-I T13
 CHEM. COMPOSITION

PHYSICAL PROPERTIES:

HEAT TREATMENT: ISOTHERMAL ANNEALING
 HARDNESS: 150-200 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					INDEX	ALTERATION				DATE	SIGN	
FORGING WEIGHT	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE	Re.k							
4.5 mm ALLOWANCE					DRN	TCD	CKD	o/CKD				
KIND OF DIMS	TOL.	KIND OF DIMS	TOL.	FORGING DRAWING 4 TH SPEED GEAR (M/SHAFT) G/BOX, LPTA-715 BS-III VEHICLE FY. JABALPUR								
HEIGHT/THICK.	+1.5 -0	RESIDUAL FLASH	-									
DIA	+1.2 -0.5	TRIMED FLAT	-									
MISMATCH	0.6	ANGULAR	+2° -1°									
STRAIGHTNESS	0.6	RADII	+50% -25%									
INTERNAL DIMS REVERSE SIGN +@-					DRG. NO. 2691 2620 5421		SCALE 1:1		DATE 9.9.2008		SIGN	
					REQD BY: M/C		SECTION		SHEET 1/1		DATE	
					DRG. NO. 2691 2620 5421-3							

46-2-13