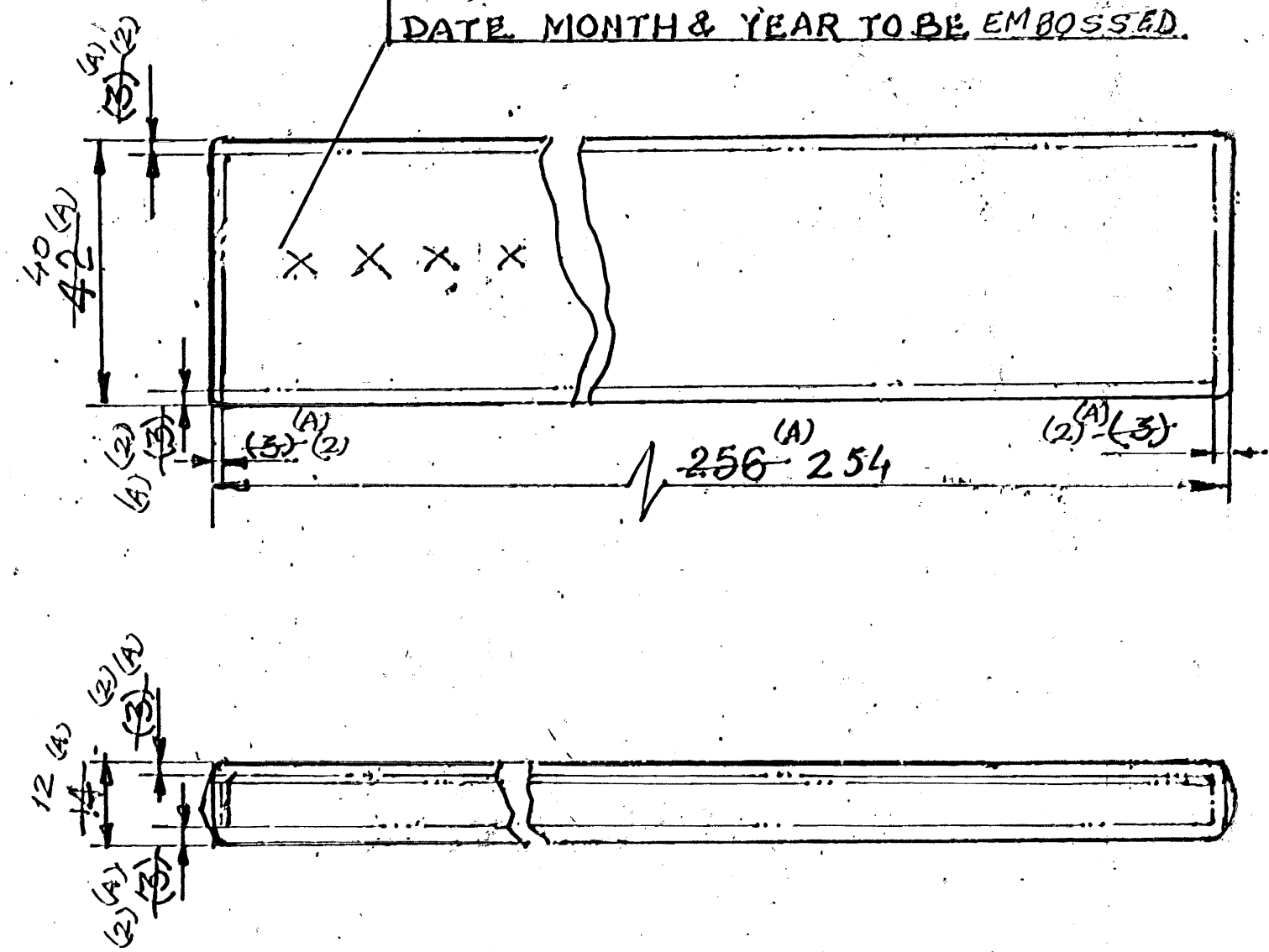


DRG. NO. - SUPPLIER'S INITIAL MFG.
DATE MONTH & YEAR TO BE EMBOSSED.



(A)	Dim 254 was 256, 40 was 42, 12 was 14 & Machining allow. 2 was 3, change as per JWM/TPB LNO. 138/TPB/13, dt. 28.6.2000 & HOS/ GMS LNO. HOS/45/GMS/M+D-01, dt. 27.6.2000 Per [Signature]					JWM/GMS 3.7.2000	WIN/NTM [Signature] JWM/TDO
INDEX	ALTERATION					DATE	SIGN
[Signature]		[Signature]	[Signature]			[Signature]	[Signature]
DRN	TCD	CKD	JWM/TDO	JWM/PR	WM/HT	AWM/TYPE	APPD
FORGING DRAWING					R&P. DRG No.		1:1
SELECTOR PLATE					M/C		SCALE
GEAR BOX					T.D.O		27.4.99
STALLION MK III					SECTION		DATE
M/S ASHOK LEYLAND					DEMANDED BY 1/CTE		1/1
VEHICLE FACTORY JBP,					DRG. No.		SHEET
					F2437614-3 (A)		

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: 3-47-13 BY BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
5. DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
6. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
7. DRAFT ANGLE -
8. UNSPECIFIED RADII - 2.5R
9. CLAMPING FACE & STOP FACE FOR 1ST MACHINING OPERATION.

MATL. C 45 K		EQUIV. MATL.		FORGING TOL. AS PER IS: 3469-74	
CHEMICAL COMPOSITION IN %		FORGING WEIGHT	ENVELOP WEIGHT	COMPLE. XTY.	INTRAC. OF MATL.
		1.178 kg	1.178 kg	S1	M1
HEAT TREATMENT:- NORMALISED		KIND OF DIM.	TOL.	KIND OF DIM.	TOL.
HARDNESS:- 170-205 BHN		LENGTH	+1.2	RESIDUAL FLAT	+0.6
MICRO-STRUCTURE:- FINE FERRITE & PEARLITE		WIDTH	-0.6		
GRAIN SIZE:- ASTM 5 OR FINER		THICKNESS	+0.7	TRIMMED FLAT	-0.6
INCLUSION RATING: 3A B C D THIN			-0.6		
SERIES OR FINER AS PER IS: 4163		MISMATCH	0.6	ANGULAR	+20
1987. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.					-10
		STRAIGHTNESS	1:1	RADII	+50%
					-25%
		INTERNAL DIMS. REVERSE SIGN. + & -			

MAT. DETAILS AS PER DRG. NO. 81.37551-0000-3