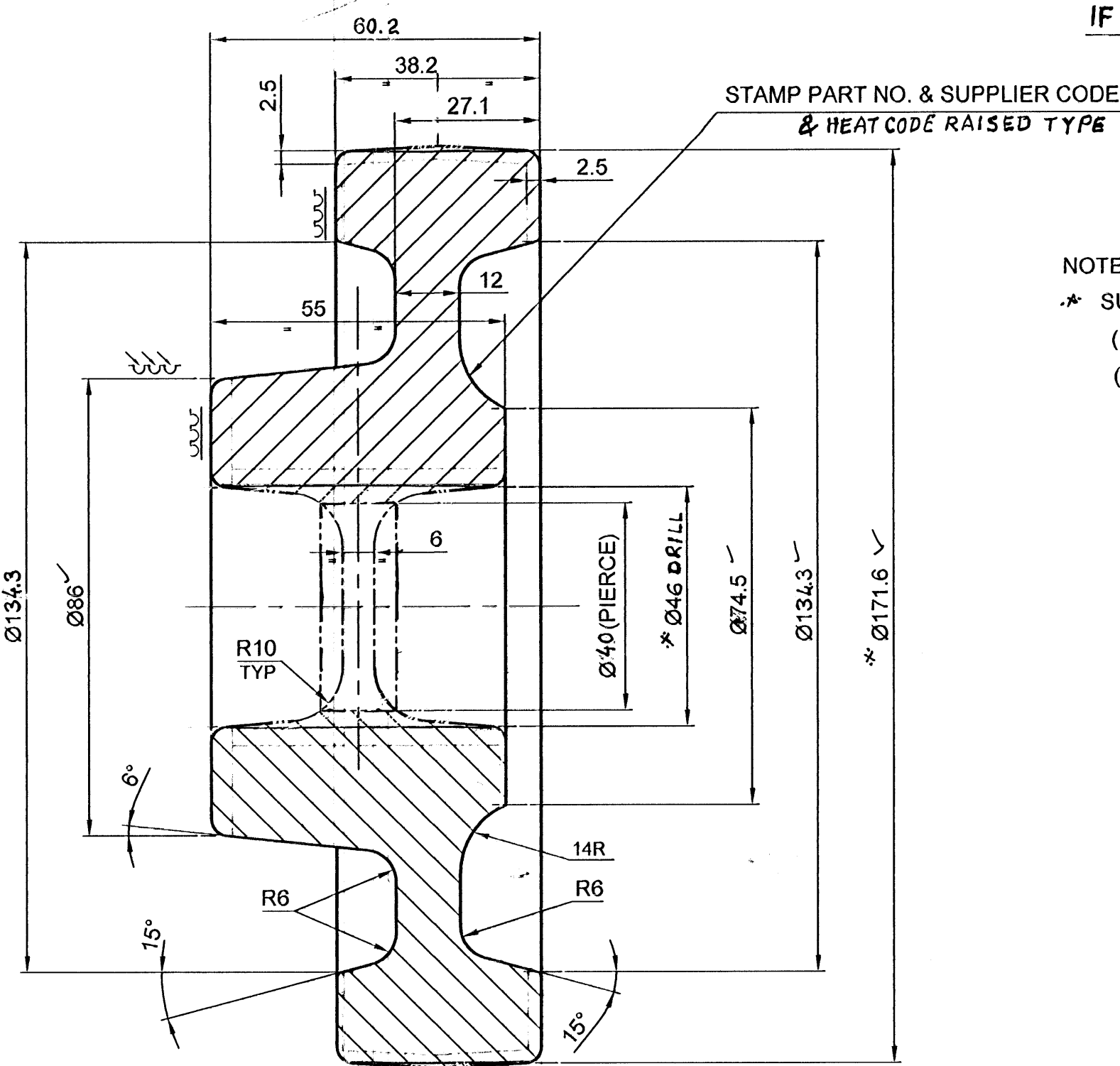


ALL DIMENSIONS ARE IN MM.

IF IN DOUBT PLEASE ASK.



NOTE :
* SUPPLY CONDITION PRE-MACHINED
(1) O/S DIA. 171.6/172.1
(2) I/S DIA. 46.0/46.5

NOTE:

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
2. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS: 3 - 47-13 BY BRUSHING OR SPRAYING.
3. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
4. STEEL SHOULD BE FREE FROM CENTRE , SEGREGATION,PIPING,FLAKES ETC.
5. DIMS. IN BRACKET INDICATES MACHINING . ALLOWANCE.
6.  CLAMPING FACE } FOR 1st MACHINING -
 STOP FACE } OPERATION .
7. DRAFT ANGLE: INNER - 7°, OUTER - 5°
8. UNSPECIFIED RADII: CORNER - 2R, FILLET - 3R

MATERIAL: 815 M17(En 353)OF BS-970

HARDENABILITY: JOMINY HARDENABILITY VALUE OF J6/16"=35 TO 39 HRC (FOR TEST PIECE)

COMP.OF En353:

C 0.14-0.20, SI 0.35MAX.,Mn 0.50-1.00,S 0.015-0.04, P 0.035MAX,Ni 1.0-1.5,Cr 0.75-1.25,Mo 0.08-0.15
PHYS.PROP.:

HEAT-TREATMENT: ISO THERMAL ANNEALING.

HARDNESS: 150 - 210 BHN

MICRO STRUCTURE:

UNIFORM LAMELLER PEARLITE & FERRITE BAINITE & INTERMEDIATE STRUCTURE 10% MAXIMUM. EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS PRESENT,MINIMUM NUMBER OF BANDS/mm² SHALL BE 14 (WHEN VIEWED AT 100X MAGNIFICATION)
GRAIN SIZE: ASTM 5 - 8
INCLUSION RATING: 3A,3B,3C,3D MAX. OF IS 4163

FORGING TOLERANCE AS PER IS : 3469 - 1974

FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE
5.65K.G				NORMAL
KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.	
LENGTH/DIA	+1.1 -0.4	RESIDUAL FLASH	—	
THICKNESS	+1.5 -0.0	TRIMMED FLAT	CLOSE TRIM	
MISMATCH	0.8	DRAFT ANGLE	+2° -1°	
STRAIGHTNESS	0.7	RADII	+50% -25%	
INTERNAL DIMS. REVERSE SIGN + & -				

INDEX	ALTERATION	DATE	SIGN.
FORGING DRAWING FOR HELICAL GEAR (CMG) GEAR BOX,STLN.MK-IV			
VEHICLE FACTORY JABALPUR			

R.C.R. KOLTE JWM / DDO	JWM/GS	APPD.
S.GUPTA DRN.	TCD.	DO/PROD. 6/10
REF. DRG. F1668511	SAMPLE 2	1:1 SCALE
M/C.	DDO SECTION	4/3/2013 DATE
DEMANDED BY		1/1 SHT. A3
DRG. NO. F1668511-3		