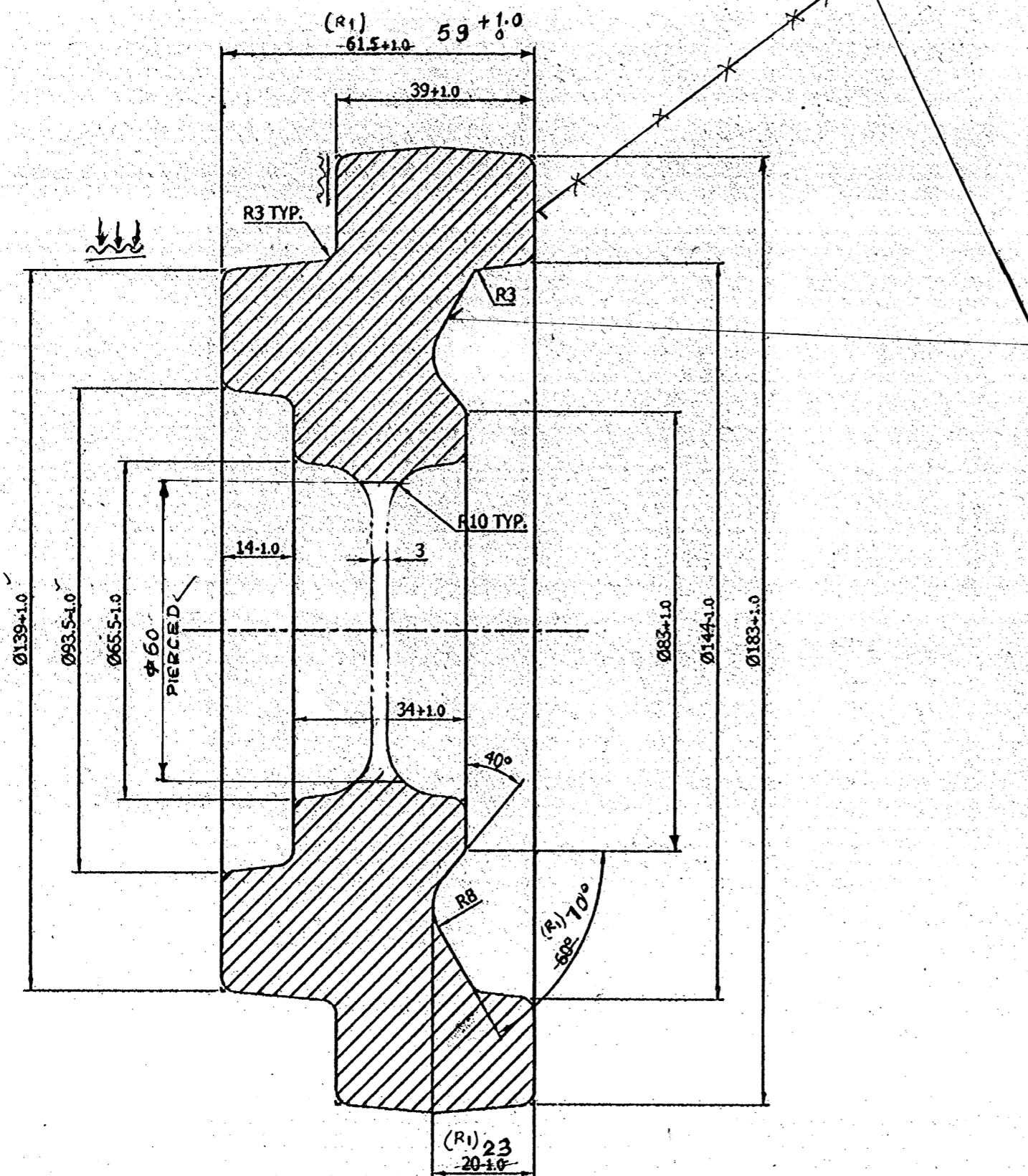


2691-2620-5413-3  
2691-2620-5445-3

STAMP DRG. NO., FIRM'S INITIAL, MONTH & YEAR  
(5 X 1 RAISED TYPE)



- NOTES:-
1. ALL DIMENSIONS ARE IN MM.
  2. DRAFT ANGLE: 5°
  3. CORNER RADII- 2 & FILLET RADII- 3 (UNLESS OTHERWISE STATED)
  4. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PITS, LAPS, CRACKS, UNFILLINGS ETC. (MAX. DEPTH DEFECT ALLOWED 0.5MM.)
  5. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLITE WITHOUT HARMFUL CONTINUOUS BANDING.
  6. GRAIN SIZE: ASTM NO. 5 - 8 AS PER 'MC' QUAD- EHN TEST (FILED GRADE AL KILLED CONDITION)
  7. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
  8. HARDNESS 150 - 200 BHN...
  9. MATL: 20Mn5Cr5
  10. FORGING ARE TO BE SHOT BLASTED
  11. HEAT TREATMENT - ISOTHERMAL ANNEALING
  12. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
  13. FORGING TO BE COATED WITH RUST PREVENTIVE RED OXIDE PRIMER
  14. FORGING RIDGES TO BE TRIMMED, CLEANED & SMOOTH FINISHED ALL OVER.
  15. CLAMPING FACE - RESTING FACE - FOR MACHINING OPERATION.

SUPPLY CONDITION - PRE-MACHINED  
OUT-SIDE. DIA - 183.0/183.5  
IN-SIDE. DIA - 65.5/66.0.

ITEM	DESCRIPTION	NO OFF	10 F MAT	15 MAT	SIZE/WT	REMARK	
(R1)	REF: WM/GMS L. NO 035/JWM/14 LPTA 715/12 DT. 24.5.12. DRG. NO. 2691-2620-5445-3 WAS 2691-2620-5413-3. DIMS. 59+1.0 23 & 70° WERE 61.5, 20 & 60° CHANGES MADE TO SUIT NEW COMP. ALTERATION					JWM/100 JWM/GS APTD	
INDEX		DATE	SIGN	DRN	TCD	CKD	C/CKD
DIM	TOL	FORGING DRAWING FOR REVERSE GEAR M/S. GB / LPTA - 715, BS- III				REFERENCE DRG 2691-2620-5445(d)	NT-5 SCALE
0-30	± 0.1					MACHINE	22.9.10 DATE
30-250	± 0.2					DEMANDED BY	1/1 SHEET
250-800	± 0.3					DRG NO	2691-2620-5413-3
800-2000	± 0.5					CHANGE NO	2691-2620-5445-3(R2)
> 2000	± 0.8	T.D.O.	VEHICLE FACTORY JABALPUR				

POSITION OF STAMPING FIRM'S  
INITIAL & DRG. NO. ETC CHANGED  
AS PER AWM/GS. L. NO 1035/AWM/GS  
AVD/01 DT. 22/7/15.

R2 INDEX ALTERATION DATE SIGN

JWM/DDG 24.7.15 AWM/R2

25/10/15