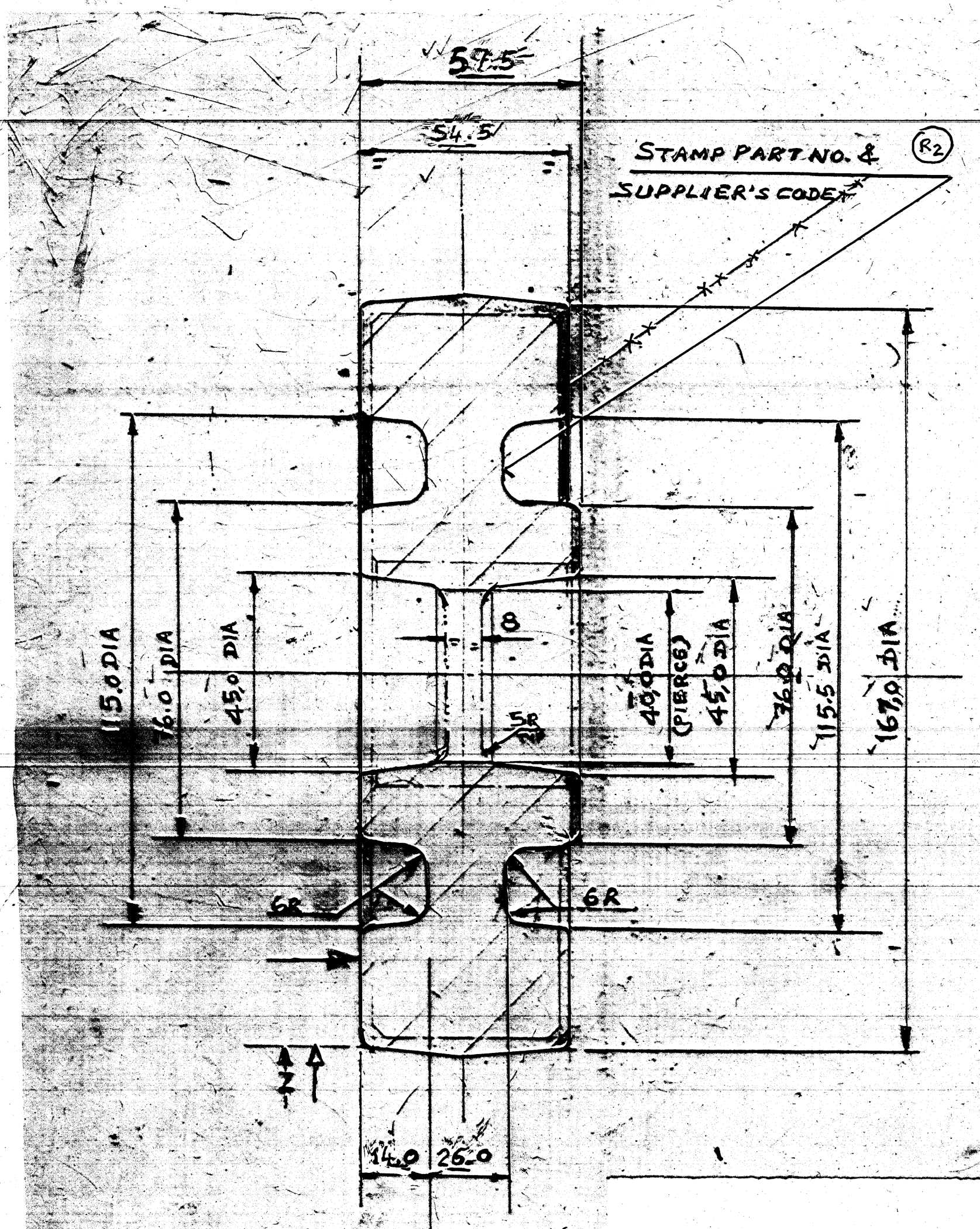


ALL THE DIMS. ARE IN MM.



SUPPLY CONDITION - PRE-MACHINED

OUTSIDE DIA. - 167.0/166.5
INSIDE DIA. - 45.5/45.0

- NOTE: 1) ALL LOCATING, RESTING AND CLAMPING POINTS TO BE CLEAN, SMOOTH, FLAT AND CYLINDRICAL.
- 2) ALL THE TOLERANCES TO BE AS PER IS: 3469 (PART I TO III) - 1974
- 3) FORGING TO BE SUPPLIED AFTER APPLYING RED OXIDE PRIMER FOR RUST PREVENTION.
4. GRAIN SIZE: ASTM 5 OR FINER
5. INCLUSION RATING: - 3ABCD THIN SERIES OR FINER AS PER IS: 4163-1967
6. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY. (R)

MATERIAL CONSTITUENTS

S.N.	DETAILS	MARK IV
1	MATERIAL	EN 355
2	IS EQUIVALENT	822 M. 17
3	TYPE OF STEEL	2% Ni Cr Mo CH Steel (Low Cr)
4	C	0.2 Max.
5	Si	0.35 Max.
6	Mn	0.4-0.7
7	Ni	1.8-2.2
8	Cr	1.4-1.7
9	Mo	0.15-0.25
10	Phosphorus	0.015 Max.
11	Sulfur	0.015 Max.
12	Lead	0.015 Max.

INDEX	ALTERATION	SIGN	DATE	ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS	MATERIAL	EN 355, FINE GRAIN	LOCATE
R2	POSITION OF STAMPING PART NO. & SUPPLIER'S CODE CHANGED REF. WM/Q.L. NO. 076/ QAT/RBR-II/16 DT. 1.9.16	DIR/ODC	8.9.16	DRAFT ANGLE	EXT. 3° INT. 7°	HEAT TREATMENT 160-210 BHN	REST
				CORNER RADII	2	MICRO STRUCTURE FINE FERRITE & PEARLITE	CLAMP
				FILLET RADII	3.5	WEIGHT	
				DIE WEAR (TOTAL)	+1.5, -0.4		
				DIE THICKNESS	+1.5, -0.0		
				MIS MATCH	0.8		
				FLUSH EXTENSION	CLOSE TRIM		
				STRAIGHTNESS	0.7		
				CORNER FILLET RADII	+50%, -25%		
				DRAFT ANGLE	+2°, -1°		
				ECCENTRICITY TO THE PUNCH HOLE	1.0 (2.0 TIR)		
				SURFACE	0.4		

FORGING DRAWING
GEAR 3 LAYSHAFT
AGB/STLN.
MARK - IV

REFERENCE DPG	1/1
MACHINE	01-02-10
DATE	01-02-10
IN L. BY	1/1
SHEET A2	
DRG. NO.	X1602611-3 (R2)
REFERENCE NO.	

13/1-1062-47-100