



TECHNICAL REQUIREMENTS

01. 207...268 HB.
02. ALTERNATIVE MATERIAL : STEEL 20X2H4A - W GOST 4543-71.
03. BURRS ON PERIMETER OF CUT - MAX. 1.3 MM.
04. AT PLACES "A" BURR IS ALLOWED UPTO 2.0 MM.
05. DISPLACEMENT ON PARTING OF DIE IS ALLOWED UPTO 1.0 MM.
06. STAMPING DRAFTS - 7°
06. FILLET RADII R 3.0 MM.
07. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
08. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS AS WELL AS FINISHING OF DEFECTS IN DEPTH UPTO 50% OF ACTUAL ONE SIDE MACHINING ALLOWANCE MAY BE ALLOWED.
09. DE-SCALES (SHOT BLASTING)
10. IT IS ALLOWED TO MARK PART NUMBER.
11. FORGING II ACCURACY CLASS, GROUP OF STEEL M2, CATAGORY OF COMPLEXITY C1 GOST 7505-74.
12. IT CAN BE MADE WITHOUT PIERCING OF HOLE.
13. PAINT RED OXIDE.

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MATERIAL	FORGING WT.	
20X2H4A GOST 4543-71	3.80 KGS	
ALT. MATERIAL	HAMMER	SCALE
20X2H4A-W Gost 4543-71	MPM	NTS
DRAWN	CHECKED	APPROVED
L. Ruff/27/8/03	M. S. 27/8/03	S. R. S.
DRAWING NO.	172.40.312/F	
NOMENCLATURE:	PLANET PINION Z-15	
HEAVY VEHICLES FACTORY AVADI, CHENNAI		