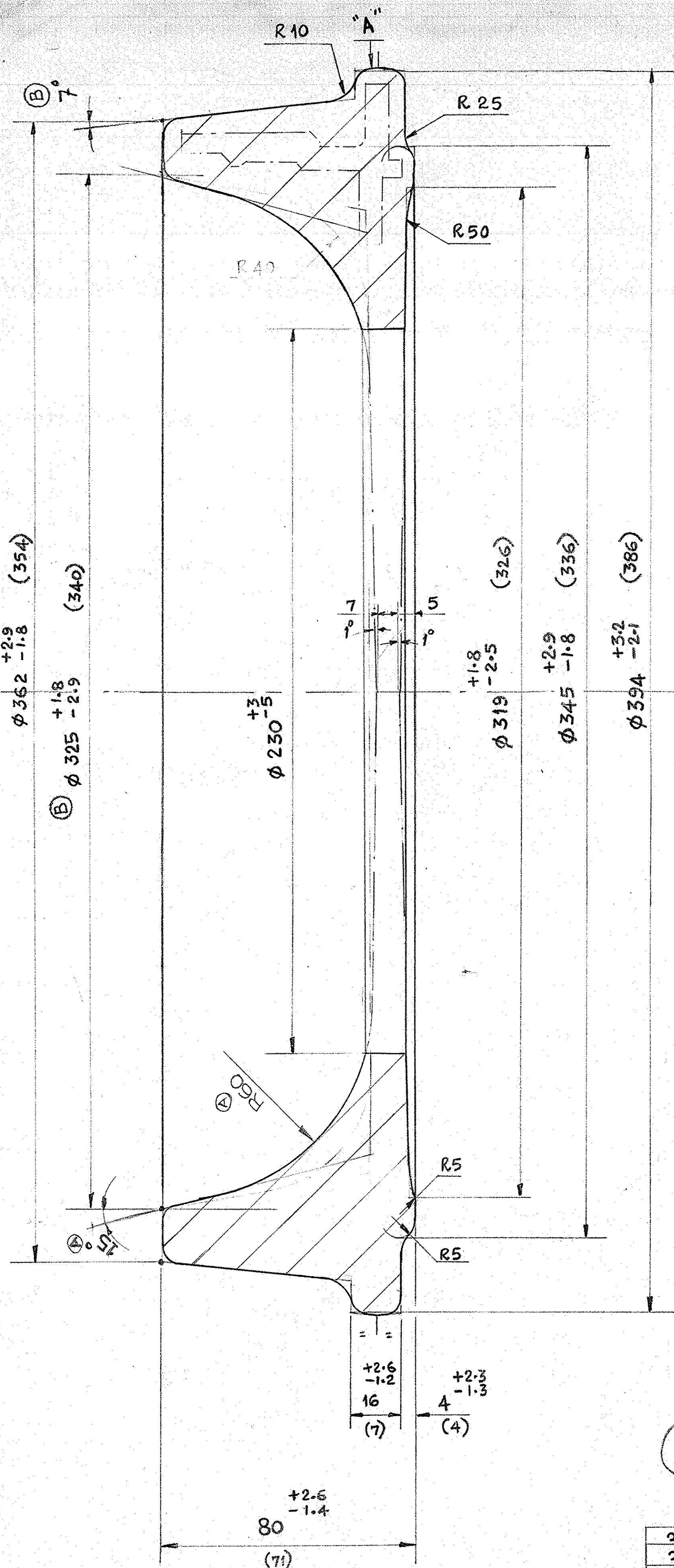


DRAWING NO.

172-40-271/F

ISSUE	MODIFICATIONS	DATE
(A)	ANGLE 15° WAS 10° R60 WAS R40.	19/12/88
(B)	DRAFT ANGLE 7° ADDED. DIA. 325 ±1.8 328 ±1.8 REASON: AVOIDING PRODUCTION PROBLEM	12.0.12.88 16/8/2006



NOTE:

1. HEATTREATMENT ~ NORMALISE, HARDNESS - DIA. OF INDENTATION ≥ 3.8
2. DESCALE.
3. DEPTH OF SURFACE DEFECTS AND PITS FROM SCALE UP TO 5 OF ACTUAL MACHINING ALLOWANCE IS ALLOWED.
4. MISMATCH SHOULD NOT EXCEED 1.6 mm.
5. RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 1.5mm. FOLDING OF FIN UP TO 3 mm AT "A" AND IN PIERCED HOLE IS ALLOWED.
6. BUCKLING SHOULD NOT EXCEED 1.5 mm.
7. SHIFT OF PIERCED HOLE UP TO 3 mm IS ALLOWED.
8. UNSPECIFIED RADII TO BE R5.
9. UNSPECIFIED DRAFTS TO BE 6°.
10. MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
11. DIMENSIONS WITHOUT TOLERANCES ARE NOT TO BE CHECKED.

MATERIAL: STEEL 38 XC GOST 4543-71

WEIGHT OF FORGING: 28 Kg.

(17)

20090	PIERCING TOOL.	1500T	
20089	TRIMMING TOOL.	1500T	
20088	STAMPING DIES.	OG-32	
TOOL NO.	DESCRIPTION	MACHINE	EQUIP. TO BE USED WITH.
SCALE	COMPONENT ~ T-72.	MACHINE	COMPNT / FORGING.
1:1	172-40-271/F. RIM	DG 32	1 OFF.
			H.V.F. AVADI.
DGN.	CHD.	APPD.	AUTHD.
FORGING DRAWING			DRAWING NO.
			172-40-271/F