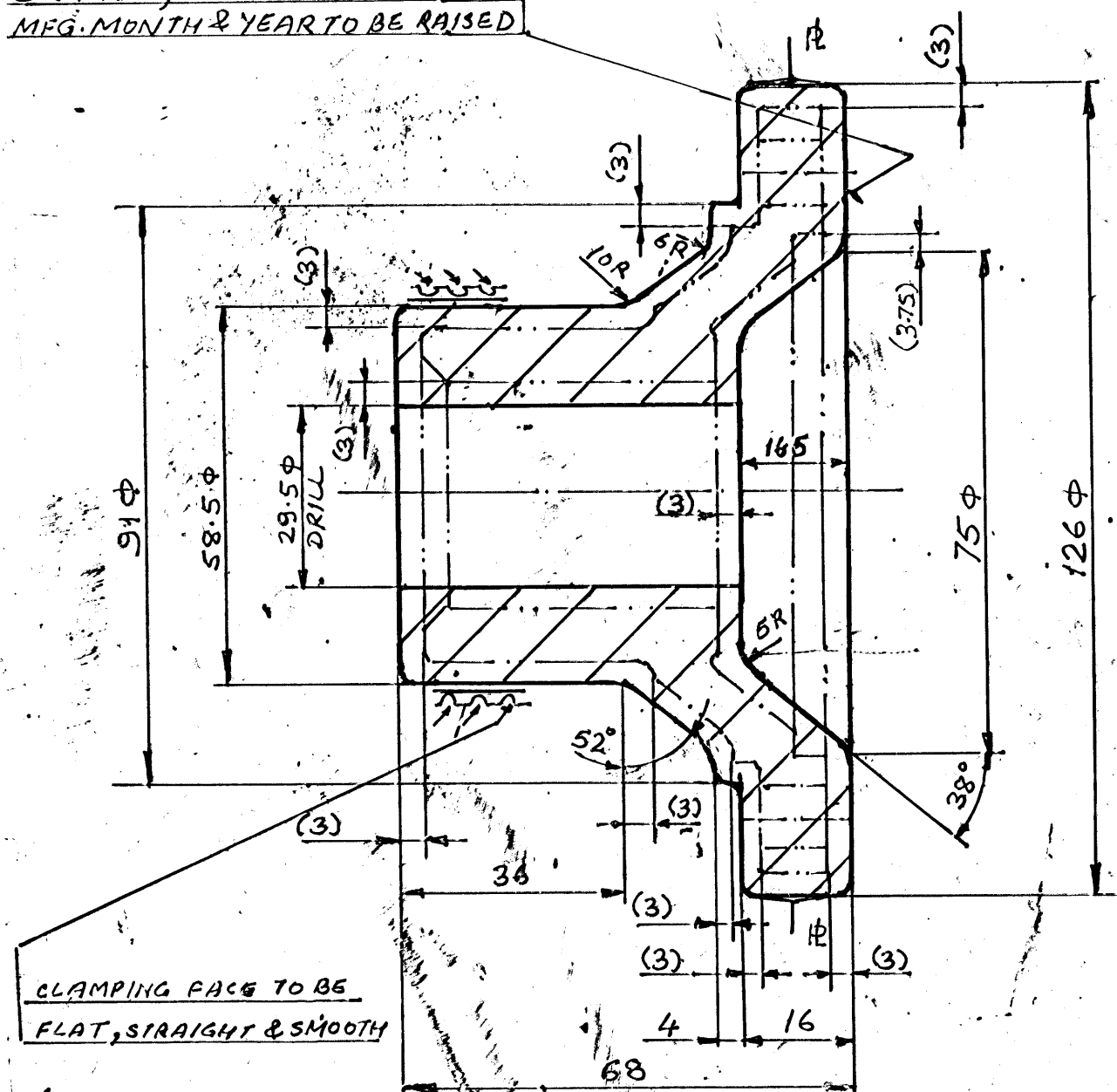


ALL DIMS. ARE IN M.M.

DRG. NO., SUPPLIER'S INITIAL
MFG. MONTH & YEAR TO BE RAISED



NOTE:-

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER
2. FORGING TO BE SHOT BLASTED.
3. FORGING TO BE COATED WITH RED OXIDE PRIMER TO JSS: 3-47-13 BY BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
5. DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
6. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
7. DRAFT ANGLE - 3°
8. UNSPECIFIED RADII. - R5R
9. CLAMPING FACE & STOP FACE FOR 1ST MACHINING OPERATION.

MATL: 45C8

EQVT. MATL.

T3 SS: 4027

CHEMICAL COMPOSITION IN %

HEAT-TREATMENT :- NORMALISED

HARDNESS:- 207 BHN MAX.

MICRO-STRUCTURE: FINE FERRITE & PEARLITE

GRAIN SIZE:- ASTM 5 OR FINER

INCLUSION RATING: 3 A B C D THIN

SERIES OR FINER AS PER IS: 4163

1967. STEEL SHOULD NOT HAVE ANY

LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.

FORGING TOL. AS PER IS: 3469-74

FORGING ENVELOP COMPLE INTRAC FORGING

WEIGHT WEIGHT XITY. OF MATL GRADE

(APPROX) 1.4 kg 5.85 kg S3 M1 NORMAL

KIND OF DIM. TOL. KIND OF DIM. TOL.

LENGTH/DIA +1.2 -0.6 RESIDUAL FLAT +0.7

THICK. +0.9 -0.5 TRIMMED FLAT -0.7

MISMATCH 0.6 ANGULAR +2° -1°

STRAIGHTNESS 0.6 RADII. +50% -25%

INTERNAL DIMS. REVERSE SIGN. + & -

(A) REDRAWN LEAVING MACHINING ALLOWANCE ON 38° & 52° TAPER FACES. CHANGE AS PER P.S.		DATE		SIGN	
INDEX	ALTERATION	DATE		SIGN	
19	Chl	11/11/99		V. F. J. J.	
DRN	TCD	CKD	JWM/TDO	JWM/PR	WM/HT DO/TDO APPD
FORGING DRAWING					REF. DRG. No.
FOR:- COUPLING FLANGE					1:1 SCALE
FOR:- FRONT AXLE & AGB, LPTA 713					M/C T.D.O 11/11/99
M/S TELCO					SECTION DATE
VEHICLE FACTORY JBP.					DEMANDED BY 1/1 SHEET.
13/3-2051					DRG.No. 312.2622.045-3(A)
30.6.013					A-3