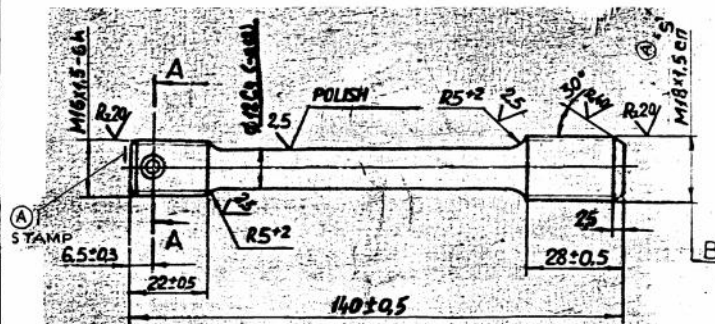


22-05-07



A-A



GROUP OF THREAD 'B'

GROUP No.	PITCH DIAMETER OF THREAD
1	17.146 TO 17.166
2	17.166 TO 17.186
3	17.186 TO 17.206
4	17.206 TO 17.226

ALTERNATE MATERIAL - STEEL 40X45 (EN-19) TO BS 970 PL-1 1983

EXPLANATORY NOTE :

10. REFERENCE MATERIAL QUOTED : CHROMIUM STEEL OF HIGH QUALITY (A) TO GRADE 38XA.

a) CHEMICAL COMPOSITION :

GRADE	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
38XA	0.35-0.42	0.17-0.37	0.50-0.80	0.80-1.10	0.025	0.025	0.30	0.30
	M A X I M U M							
40X	0.36-0.44	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035	0.30	0.30
45X	0.41-0.49	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035	0.30	0.30

b) PHYSICAL PROPERTIES:

GRADE	TENSILE STRENGTH Kgf/mm ² (min)	YIELD POINT Kgf/mm ² (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kgf/cm ² (min)
38XA	95	80	12	50	9
40X	100	80	10	45	6
45X	105	85	9	45	5

(A) REPAIR SIZE DIMENSION:

CATEGORY	DESIGNATION OF SIZE.	DIMENSION 'S'
20-50-22 R1	DIAMETER	M 20 x 1.5 CP
	DIAMETRICAL PITCH	19.026 +0.34 +0.26

STAMP R1 WHERE MARKED THUS -

Rz 80 (✓)

- INSPECTION - GROUP 1 AS PER TECHNICAL REQUIREMENTS TT-11 RRC 33 TO 37 OR HB 302 TO 341.
- ALTERNATE MATERIAL IS STEEL 40X 45X GOST 4543-71.
- MAKE THREAD B AS PER STANDARD 1220M-4, ISSUE 7.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:-
HOLE HOLES - AS PER 4,
OTHERS - AS PER 14.
- COATING: CHEMICALLY OXIDIZED, OILED.
- TOLERANCE ON ALIGNMENT OF HOLE AXIS WITH RESPECT TO AXIS OF THE PART SHOULD NOT EXCEED 0.3mm.
- CHECK THE PART BY USING THE GEOMETRIC FLAW DETECTOR. CARRYOUT ACCEPTANCE IN COMPLIANCE WITH INSTRUCTIONS UB 20-17.
- PERMITTED WITH IN THE AREA OF THE HOLE FOR THE CUTTER PH ARE:-
(1) FLATTENED PROFILE OF THREAD.
(2) OVAL CHAMFER.
(3) DECREASE IN THE MAJOR DIAMETER OF THE THREAD DOWN TO 0.3mm.
- CHECK FILLET RADI AND CHAMFERS BEFORE MAKING THE THREAD.
- DETERMINE THE GROUP OF THREAD B AS PER THE MAXIMUM PITCH DIAMETER.
- MARK THE GROUP NUMBER AS PER DIMENSION OF THE PITCH DIAMETER OF THREAD 'B'.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

6	29/09	3 rd ALTN. COMM. MINUT	POINT 2, DT. 27-2-09	EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
B	25/12/96	AUTHY. Lt. No B1262/DB-II/No of A dt 17.9.96		0,180 Kg	LETTERS!
A	27/3/88	AUTHY. SPECN. FOR REPAIR DRES. PART III			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R. OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE		NATURE OF AMENDMENTS			
DRN	gns	SCALE - 1:1		MATERIAL - 38XA GOST 4543-71	USED ON:- C620-01-02-B
CHD		DIMENSIONS IN mm.		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APD		ALL THREADS CONFORM TO		TITLE - ADAPTOR STUD	D S CAT NUMBER
DATE	20/07/96			DRAWING NUMBER 20-50-22 1	