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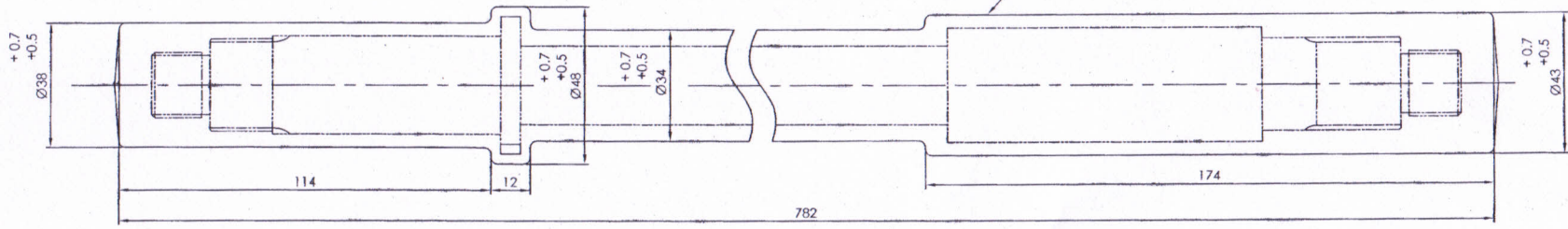
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STAMP : FIRM'S CODE & PART NO.



NOTES :

- 1) FORGING TO BE SUPPLIED IN SHOT BLASTED & NORMALISED CONDITION
- 2) FORGING SHOULD BE FREE FROM SURFACE DEFECTS VIZ. CRACK, FOLDS FLASHES, FINS ETC. :
- 3) DRAFT ANGLE 5° UNLESS OTHERWISE SPECIFIED.
- 4) MISMATCH SHOULD NOT EXCEED 1mm.
- 5) PILOT SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
- 6) ALL FORGING RADII ARE 3 mm MAX. UNLESS OTHERWISE SPECIFIED.
- 7) MARK DRAWING NO.
- 8) PAINT RED OXIDE.
- 9) ALL FORGINGS TO BE TESTED WITH MAGNETIC PARTICLE FLOW DETECTION.
- 10) FIRM HAS TO SUBMIT ONE TEST PIECE FOR TENSILE TEST AND THREE TEST PIECES FOR IMPACT TEST PER LOT.
- 11) ALL FORGING HARNESS TO BE TESTED.

*MATERIAL:- JS : 5517-1978
40 Ni 6 Cr 4 Mo 3 (RS-100)

1	FORGING FOR SHAFT	x	40Ni6Cr4Mo3-1978 (RS-100)	WEIGHT : 6.8 Kg APPX																																																																																																																																																																																																																				
संख्या NO OFF	विवरण DESCRIPTION	पुंज क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अन्य REMARKS																																																																																																																																																																																																																		
<table border="1"> <tr> <td>सामान्य सहिष्णुता GENERAL TOLERANCE</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>रेखक परिमाण LINEAR DIMENSION</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0-30</td> <td>±0.1</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>30-120</td> <td>±0.2</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>120-225</td> <td>±0.3</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>225-375</td> <td>±0.4</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>375-500</td> <td>±0.5</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>500-1000</td> <td>±0.8</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1000-2000</td> <td>±1.2</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>कोणिक परिमाण ANGULAR DIMENSION</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1:5</td> <td>±1'</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1:10</td> <td>±2'</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1:20</td> <td>±3'</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1:50</td> <td>±5'</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1:100</td> <td>±10'</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>मापक 'मि.एम' में SCALE IN 'mm'</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0</td> <td>±0.05</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.05</td> <td>±0.08</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.08</td> <td>±0.10</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.10</td> <td>±0.15</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.15</td> <td>±0.20</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.20</td> <td>±0.30</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.30</td> <td>±0.40</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.40</td> <td>±0.50</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.50</td> <td>±0.60</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.60</td> <td>±0.80</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>0.80</td> <td>±1.00</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1.00</td> <td>±1.50</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>1.50</td> <td>±2.00</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>2.00</td> <td>±3.00</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>							सामान्य सहिष्णुता GENERAL TOLERANCE							रेखक परिमाण LINEAR DIMENSION							0-30	±0.1						30-120	±0.2						120-225	±0.3						225-375	±0.4						375-500	±0.5						500-1000	±0.8						1000-2000	±1.2						कोणिक परिमाण ANGULAR DIMENSION							1:5	±1'						1:10	±2'						1:20	±3'						1:50	±5'						1:100	±10'						मापक 'मि.एम' में SCALE IN 'mm'							0	±0.05						0.05	±0.08						0.08	±0.10						0.10	±0.15						0.15	±0.20						0.20	±0.30						0.30	±0.40						0.40	±0.50						0.50	±0.60						0.60	±0.80						0.80	±1.00						1.00	±1.50						1.50	±2.00						2.00	±3.00					
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मूलमाप व अनुपात
NOMINAL SIZE & FIT



मशीनी औजार आदिरूप फैक्टरी, अम्बर्नाथ
MACHINE TOOL PROTOTYPE FACTORY, AMBARNATH

D.O.