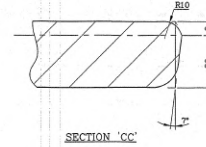
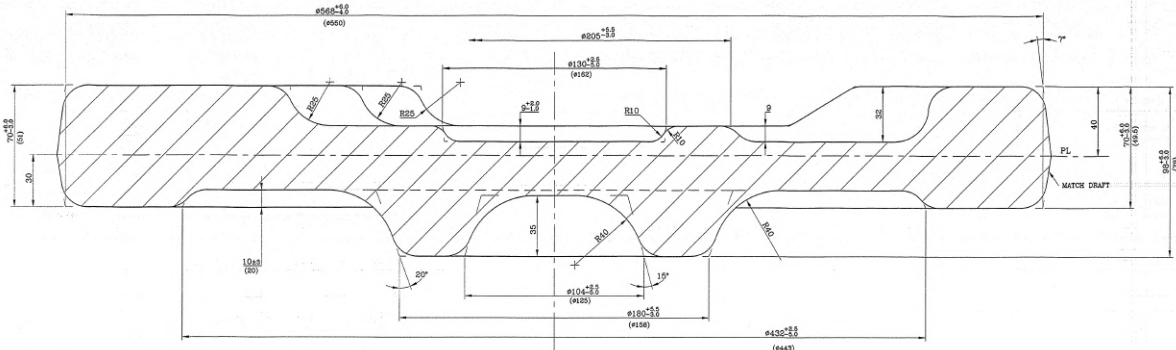
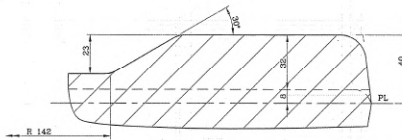
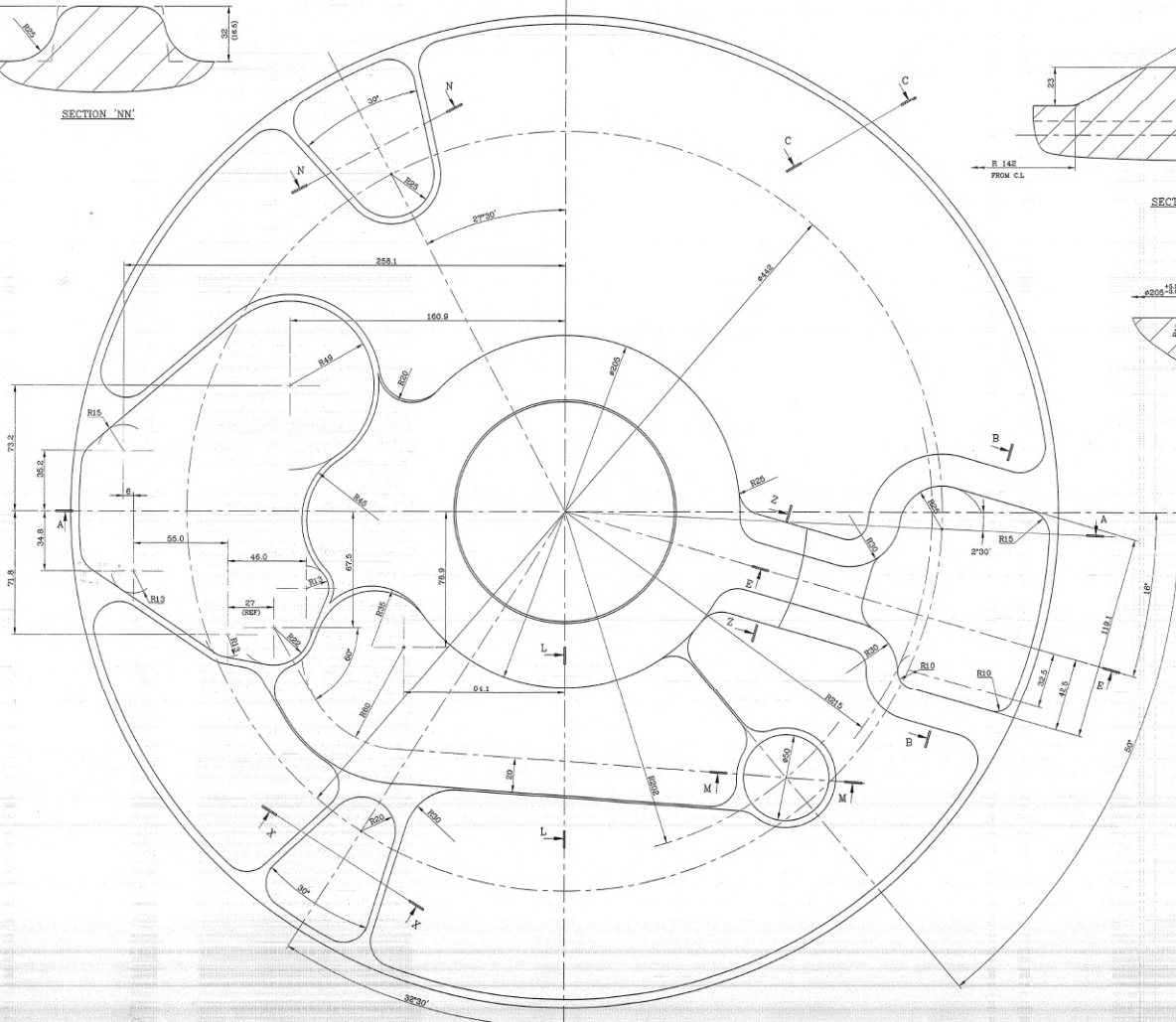


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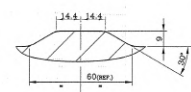
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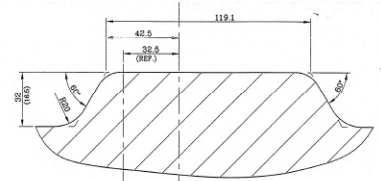
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SECTION 'EE'



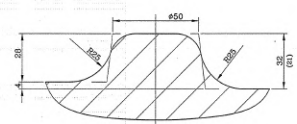
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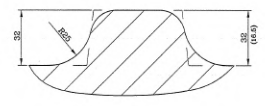
SECTION 'BB'



SECTION 'LL'



SECTION 'MM'



SECTION 'XX'

TECHNICAL REQUIREMENTS:

- STEEL GRADE 30XGCA GOST 4543-71
- ACCURACY CLASS OF FORGING TS, STEEL GROUP M2, ACCURACY LEVEL C3, STARTING INDEX 20, GOST 7505-89
- FORGING GROUP II AS PER GOST 8479-70
- 228.269 HB [HARDEN & TEMPER] (2)
- DESCALES (SHOT BLASTING)
- MARKING THE CODE OF CHIEF
- SURFACE DEFECTS AND RECESSES DUE TO SCALES ON MACHINING SURFACE WITHOUT THEIR ELIMINATION UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE (IF ITS DEPTH IS DETERMINED BY CONTROL CUTTING) IS ALLOWED ON NON-MACHINING SURFACES. OCCASIONAL FOLDERS AND DENTS WITH DEPTH UPTO 3.0 MM IS ALLOWED IF THE DEPTH OF SURFACE DEFECTS EXCEEDS THE MACHINING ALLOWANCE. REMOVAL OF THEM IS CARRIED OUT BY CONTROL CUTTING WITH SUBSEQUENT WELDING AS PER INSTRUCTIONS. ADK 25090.00016
- SHIFT OF AXIS OF DIE IS UPTO 2.5 MM.
- BURRS ALONG THE PARTING LINE OF DIE IS UPTO 3.0 MM
- UN-SPECIFIED DRAFT ANGLE 7°
- UN-SPECIFIED RADI R 10
- DIMENSIONS IN BRACKETS ARE FOR MACHINING.
- DIMENSIONS WITHOUT TOLERANCES ARE FOR CONSTRUCTING THE DIE. NEED NOT BE CHECKED
- PAINT RED OXIDE.

ISSUE	MODIFICATIONS & ADDITIONS	DATE
A	1. REWORK 2. SCALLOPPED FORGING 3. HAS BEEN MODIFIED IN LINE WITH COMPONENT DSG 4. 20.00.00000000 5. 3.00 PER TRANSMISSION M/C 6. REQUIREMENTS. CENTER 7. LOCATION PAD PROFILE 8. SLOTTED AND PAD DIA 130 9. AND DEPTH 1MM INTRODUCED. 10. FOR LINE WITH 100% 11. 0.00.0000000000000000 12. ANALYZED COMPONENT IS 13. IDENTIFIED AND 14. REMOVED AND 15. 0.00.0000000000000000 16. 0.00.0000000000000000 17. 0.00.0000000000000000 18. 0.00.0000000000000000 19. 0.00.0000000000000000 20. 0.00.0000000000000000	11/11/15
B		

MATERIAL	FORGING WT	T-90'S
30XGCA GOST 4543-71	98 KGS	
ALT. MATERIAL	HAMMER	SCALE
		1:1
DRAWN	CHECKED	APPROVED
DRAWING NO. 172.40.384/F NOMENCLATURE: R.H. FRONT FLANGE HEAVY VEHICLES FACTORY AVADI, CHENNAI		