



TECHNICAL REQUIREMENTS

- 01. GROUP 1.0001 8479.20
- 02. FORGING PARAMETERS: 16 M2, C3, 17 C0057 7905-89
- 03. HARDNESS 179 ... 289 BRIN (DIA OF INDENTATION: 3.7 ... 4.9MM)
- 04. DIMENSION FOR REFERENCE
- 05. UNSPECIFIED DRAWT ANGLE: 7°
- 06. UNSPECIFIED ROUN 3.0 MM
- 07. TOLERANCE OF SHIFT ALONG SURFACE OF PARTING LINE OF DIE: 1 MM
- 08. PERMISSIBLE LIMIT VALUE OF RESIDUAL FIN: 1.0MM AS PER DIMENSION K
- 09. PERMISSIBLE LIMIT OF BURR HEIGHT ALONG CONTOUR OF CUTTING 3MM
- 10. TOLERANCE OF FLATNESS AND CURVATURE: -1.0 MM
- 11. DIMENSIONS WITHOUT TOLERANCE NEED NOT BE CHECKED.
- 12. THE FOLLOWING LOCAL DEFECTS ARE ALLOWED ON UNMACHINED SURFACES WITHOUT RECTIFICATION: DENTS, NICKS, SCALDS AND TOOL MARKS IN AN AREA NOT MORE THAN 30% OF THE SURFACE AND DEPTH NOT MORE THAN 2 MM, WRINKLES, GRIPS, LAPS AND ROLLING DEFECTS OF INPUT MATERIAL WITH DEPTH NOT MORE THAN 2 MM ANYWHERE IN THE AREA NOT LESS THAN 12 MM FROM THE FACES. TOTAL NUMBER OF ALL SURFACE DEFECTS WITHOUT DRESSING SHOULD NOT BE MORE THAN TWO PER COMPONENT.
- 13. ON UNMACHINED SURFACES, SEPARATE DEFECTS WITHOUT RECTIFICATION ARE ALLOWED IF THE DEPTH DOES NOT EXCEED 50% OF THE ACTUAL MACHINING ALLOWANCE.
- 14. DE-SCALE (SHOT BLASTING)
- 15. ACCEPTANCE STAMPING ON ALL COMPONENTS
- 16. EVERY BATCH QTY 2 COMPONENTS TO BE LABELED WITH MARKING OF DRAWING NO. AND BATCH NO. DETAILS.
- 17. PAINT RED-OXIDE.

Hes/MPM

REF-5K-16045

HEAVY VEHICLES FACTORY
 17255 0225F
 11/23/17

MATERIAL	PRESSURE	WT	T 90
STEEL 30XC	27 KGS		
ALT. MATERIAL	BARBER	SCALE	
	MM	MTS	
DEALER	ORDERED	APPROVED	
1. 8/11/17	M. J. J.	S. J. S.	
DRAWING NO.	17255 0225F		
FORGING/CLAMP			
HEAVY VEHICLES FACTORY			
AVAIL. GENERAL			