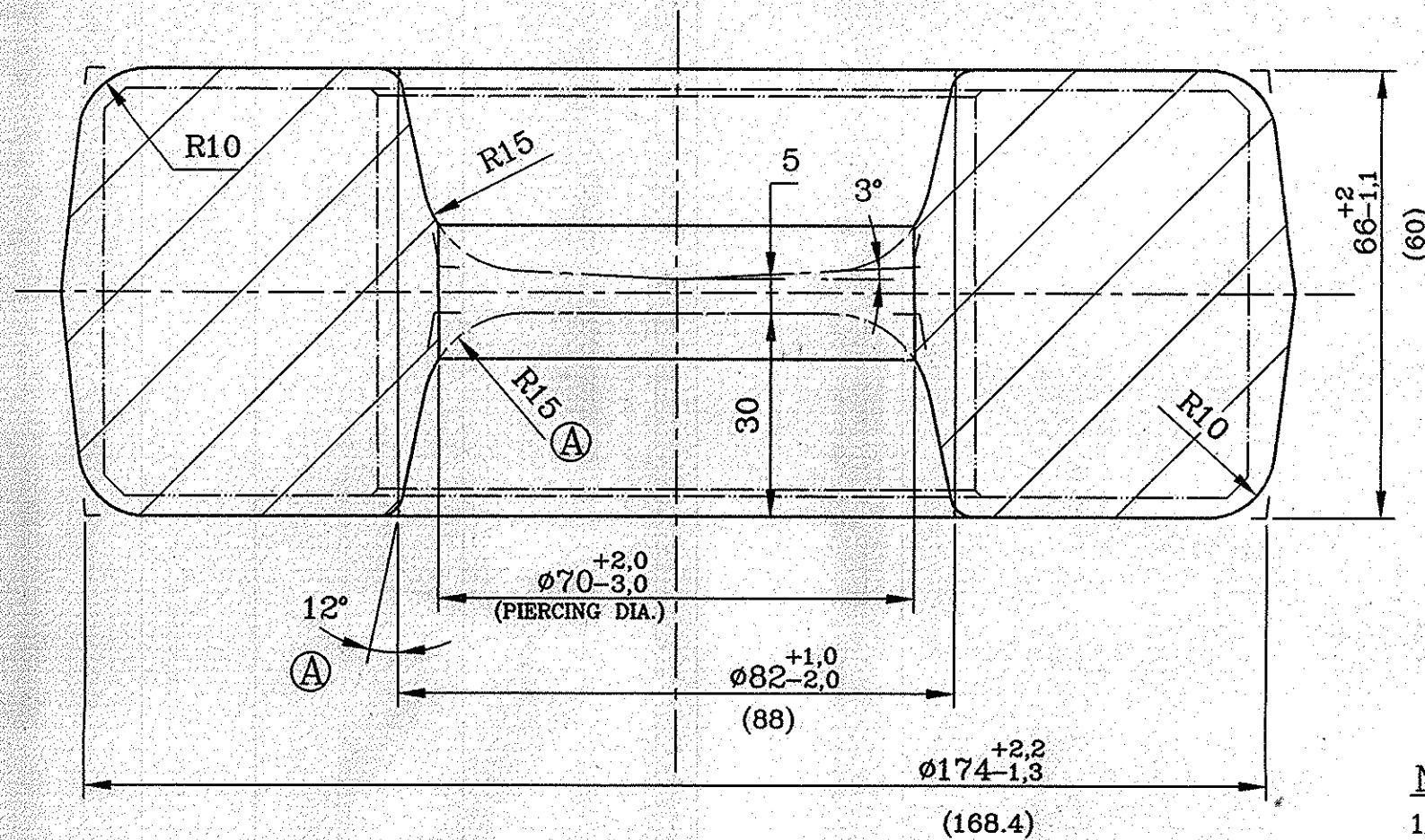


DRAWING NO.  
172.43.006/F

MODIFICATIONS & ADDITIONS

ISSUE	MODIFICATIONS & 'N' OF 'A'	SIGN.
A	RADII 15 WAS R.10 ,INNER DRAFT ANGLE 12° WAS 10°, 7° WAS 6°	<i>L. Sujin</i> 4/12
	AS PER JWM/FS INSTRUCTION, TO AVOID REJECTION, FORGING ARE MODIFIED	<i>L. Sujin</i> 4/12



NOTE:-

1. FOR BROACHING, HEAT TREAT BLANK TO DIA. OF IND. 3.6-3.8 MM

TECHNICAL REQUIREMENTS.

- |   |   |
|---|---|
| 01. HEAT TREAT. DIA. OF IND. $\geq$ 3.8 MM<br>CHECK ONE COMPT. FROM ONE BATCH FOR<br>OVER HEATING AFTER HEAT TREATMENT  | 06. BUCKLING SHOULD NOT EXCEED 0.5 MM                                   |
| 02. DE-SCALE (SHOT BLASTINGS)   | 07. UNSPECIFIED DRAFT = 7° (A)  |
| 03. IN MACHINING SURFACES, SURFACE DEFECTS<br>AND SCALE PITS ARE ALLOWED UPTO 0.5<br>OF ACTUAL MACHINING ALLOWANCE. IN<br>UN-MACHINED SURFACES, WITHIN TOLERANCE<br>LIMITS. | 08. UNSPECIFIED RADII = R 3.5 MM.                                       |
| 04. MISMATCH SHOULD NOT EXCEED 1.2 MM.  | 09. MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.                         |
| 05. RESIDUAL FIN ALONG THE PARTING LINE<br>SHOULD NOT EXCEED 1.5 MM.  | 10. UNTOLERANCED DIMENSIONS ARE FOR CONSTRUCTION/<br>NOT TO BE CHECKED. |
|   | 11. ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED<br>1.4 MM.           |
|   | 12. MARK PART NO. & STEEL GRADE   |
|   | 13. PAINT RED OXIDE.  |

T-72

MATERIAL	FORGING WT.	
20X2H4A GOST 4543-71	10.63 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-6	1:1
DRAWN	CHECKED	APPROVED
<i>L. Sujin</i> 4/12/06	<i>L. Sujin</i> 4/12/06	<i>L. Sujin</i> 4/12/06

DRAWING NO. 172.43.006/F  
NOMENCLATURE: PLANET, PINION

HEAVY VEHICLES FACTORY  
AVADI, CHENNAI