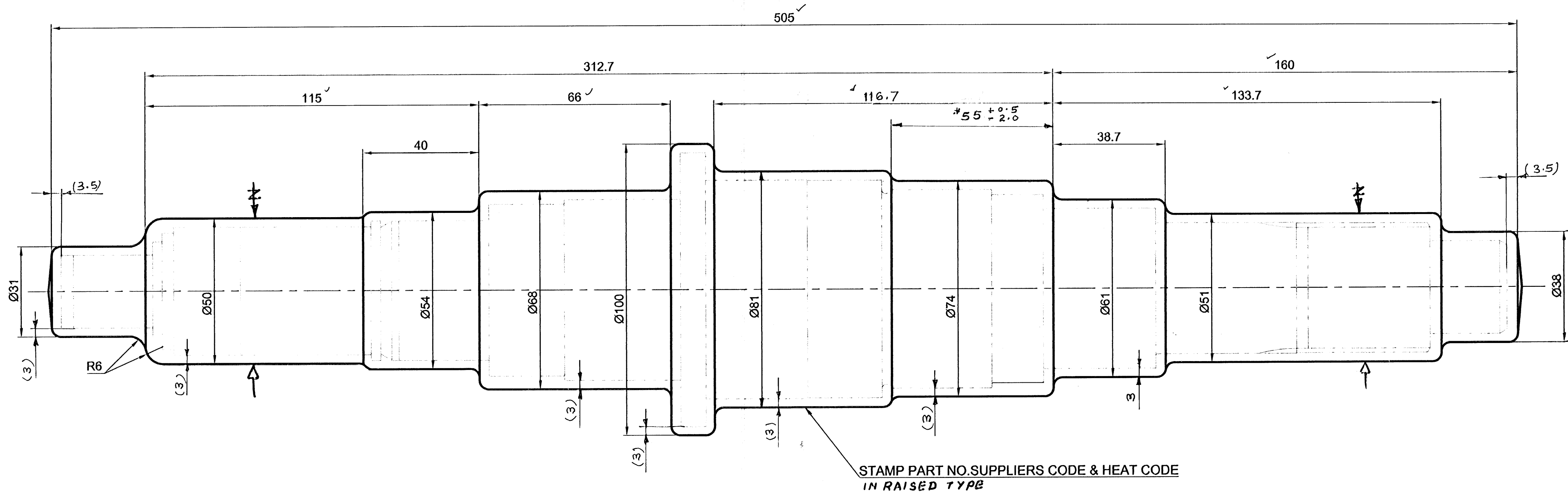


ALL DIMENSIONS ARE IN MM.



NOTE: 1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER. 2. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS:3 - 47-13 BY BRUSHING OR SPRAYING. 3. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY. 4. STEEL SHOULD BE FREE FROM CENTRE , SEGREGATION,PIPING,FLAKES ETC. 5. DIMS. IN BRACKET INDICATES MACHINING . ALLOWANCE. 6.  CLAMPING FACE } FOR 1st MACHINING - STOP FACE OPERATION. 7. DRAFT ANGLE: INNER - — , OUTER - 5° 8. UNSPECIFIED RADII: CORNER - 2R, FILLET - 3R	MATERIAL: 222 H17(En 355) OF BS-970 HARDENABILITY: JOMINY HARDENABILITY VALUE OF J 6/16" - 35 TO 39 HRC (FOR TEST PIECE) COMP.OF En 355 : C 0.14-0.20, Si 0.35 max., Mn 0.40-0.70, S 0.05 max, P 0.05 max, Ni 1.75-2.225, Cr 1.30-1.70, Mo 0.15-0.25 PHYS.PROP.: HEAT-TREATMENT: ISO THERMAL ANNEALING . HARDNESS: 150 - 210 BHN MICRO STRUCTURE: UNIFORM LAMELLER PEARLITE & FERRITE BAINITE & INTERMEDIATE STRUCTURE 10% MAXIMUM. EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS PRESENT,MINIMUM NUMBER OF BANDS/mm SHALL BE 14 (WHEN VIEWED AT 100X MAGNIFICATION) GRAIN SIZE: ASTM 5 - 8 INCLUSION RATING: 3A,3B,3C,3D MAX. OF IS 4163		FORGING TOLERANCE.AS PER IS : 3469 - 1974 <table><tr><td>FORGING WEIGHT (APPROX)</td><td>ENVELOP WEIGHT</td><td>COMPLE- XITY</td><td>INTRAC OF MATL.</td><td>FORGING GRADE</td></tr><tr><td>13 KG</td><td>—</td><td>—</td><td>—</td><td>NORMAL</td></tr><tr><td colspan="2">KIND OF DIMS.</td><td>TOL.</td><td colspan="2">KIND OF DIMS.</td></tr><tr><td colspan="2">LENGTH</td><td>+2.0 -0.5</td><td colspan="2">RESIDUAL FLASH</td></tr><tr><td colspan="2">THICKNESS/DIA</td><td>+2.0 -0.5</td><td colspan="2">TRIMMED FLAT</td></tr><tr><td colspan="2">MISMATCH</td><td>0.9</td><td colspan="2">DRAFT ANGLE</td></tr><tr><td colspan="2">STRAIGHTNESS</td><td>1.0</td><td colspan="2">RADII</td></tr></table> * INTERNAL DIMS. REVERSE SIGN + & -					FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE	13 KG	—	—	—	NORMAL	KIND OF DIMS.		TOL.	KIND OF DIMS.		LENGTH		+2.0 -0.5	RESIDUAL FLASH		THICKNESS/DIA		+2.0 -0.5	TRIMMED FLAT		MISMATCH		0.9	DRAFT ANGLE		STRAIGHTNESS		1.0	RADII		FORGING DRAWING FOR MAIN SHAFT GEAR BOX,STLN.MK-IV VEHICLE FACTORY JABALPUR				RA mtr. R.C.R. KOLTE JWM / DDO JWM/GS S. GUPTA DRN. TCD. REF. DRG. M/C. DDO SECTION 27/03/2014 DATE 1/1 SHT. A2		21-04-11 APPD Std DGM/GS	
	FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE																																													
	13 KG	—	—	—	NORMAL																																													
	KIND OF DIMS.		TOL.	KIND OF DIMS.																																														
	LENGTH		+2.0 -0.5	RESIDUAL FLASH																																														
	THICKNESS/DIA		+2.0 -0.5	TRIMMED FLAT																																														
	MISMATCH		0.9	DRAFT ANGLE																																														
	STRAIGHTNESS		1.0	RADII																																														