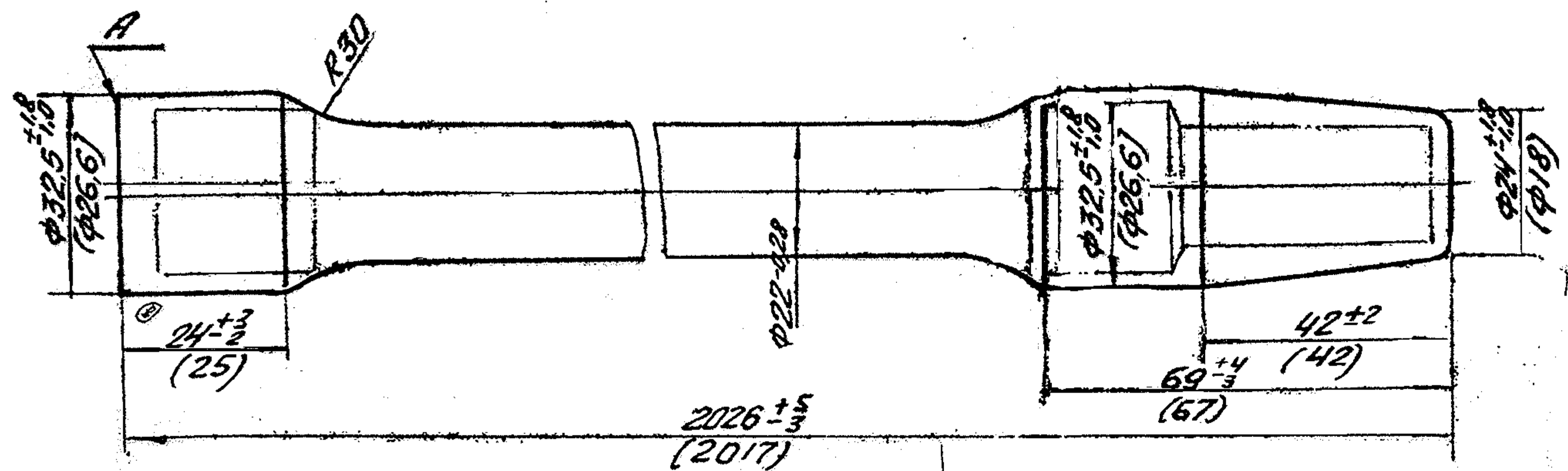


TECHNICAL REQUIREMENTS.



MATL.: 60C2XA GOST 14959-69  
 ALT. MATL. 60C2XΦA, 65C2BA  
 GOST 14959-69  
 WEIGHT OF FORGING. 6.3 Kgs

1. ~~HEAT TREAT.~~ DIA. OF IND.  $\geq 3.6$   
 ANNEAL (MAX. 285 BHN)
2. REQUIREMENT TO SURFACE OF  $\varnothing 22^{-0.28}$  TO BE IN ACCORDANCE TO GOST 1051-73 GROUP 'A'.  
 2a. Paint Red oxide
3. CURVATURE OF THE COMPONENT SHOULD NOT EXCEED 5 mm ON TOTAL LENGTH.
4. GRIPPING MARKS OF DIES AND FOLDING OF FINS ALONG DIE PARTING LINE ARE ALLOWED.
5. MISMATCH SHOULD NOT EXCEED 0.5 mm.
6. RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 2 mm AND AT "A" MAX. 3 mm.
7. SHIFT OF  $\varnothing 32.5$  AXIS RELATIVE TO THAT OF  $\varnothing 22$  SHOULD NOT EXCEED 5 mm.
8. UNFILLING OF HEAD CORNERS UPTO R6 mm IS ALLOWED.
9. ELLIPTICITY <sup>OF BAR</sup> OVER A LENGTH OF 150 mm FROM THE HEAD IS ALLOWED PROVIDED THE MINIMUM AND MAX. DIA. OF ELLIPCE DO NOT EXCEED 20.5 mm AND 22.8 mm RESP.

CHD.	Raman 2/8/85
APPD.	J. Srinivasan 6/9/85
ORG. No.	175-02-460/F
TITLE:	BAR TORSION
HEAVY VEHICLES FACTORY AVADI. MADRAS.	

A	HEAT TREATMENT DETAILS ADDED.	Raman 11/5/87
ISSUE	N OF A	SIG & DC.
NOTIFICATION OF AMENDMENTS.		

175-02-460/F