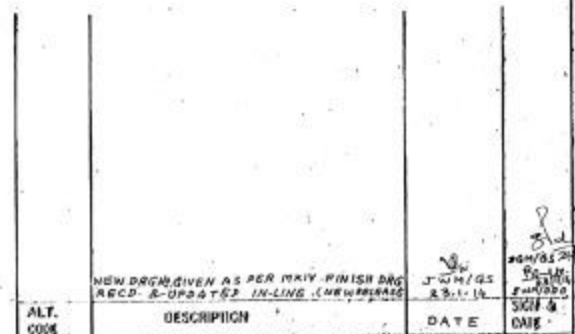




1. FOR INTERNAL DIMENSIONS, TOLERANCES
REVERSE, + AND - SIGNS,
2. ALL LOCATING, RESTING & CLAMPING SURFACES
TO BE CLEAN, SMOOTH FLAT & CYLINDRICAL.
3. FORGING TO BE PRE-DRILLED BEFORE HEAT TREATMENT.

TOLERANCES		ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS		DRAFT ANGLE	EXP INT	5°	CORNER RADIUS	2.0
ONE WEAR (TOTAL)	+1.8 - 0.5					10°	FILLET RADIUS	3.2
ONE THICKNESS	+1.5 - 0.5	→ LOCATE	MATERIAL	CK45 (Z150) STEEL TO DIN 17200 WITH SPECIAL REQ. OR C1 0.005 RIN		SCALE :	1994	SIGN
MISMATCH	0.7	→ REST	HEAT TREATMENT	HARDENED AND TEMPERED AS PER Z150		1:1	DRN	DATE
FLASH EXTENSION	CLOSE TRIM	→ CLAMP	MICRO STRUCTURE	AS PER Z150			Q10	11/7
STRAIGHTNESS	0.9					AFD	U8	11/7
CORNER & FILLET RADIUS	+0.05 - 0.25	WEIGHT	0.55KG APPROX	CORE STRENGTH		PART NAME OUTPUT FLANGE		
DRAFT ANGLE	1°2' - 1°	HARDNESS		750-900 N/MM²		PART NO. F1402311 & E1402311 G		
ECCENTRICITY WRT DRILLED HOLE	0.8 (1.0 TIR)	ASHOK LEYLAND LTD				93-09-09		
SURFACE	0.5	CHENNAI MADRAS				5 T.N.M.		
		JIG AND TOOL DESIGN OFFICE				2F GU/ MK IV		
		DWG NO.				F1402311-3		