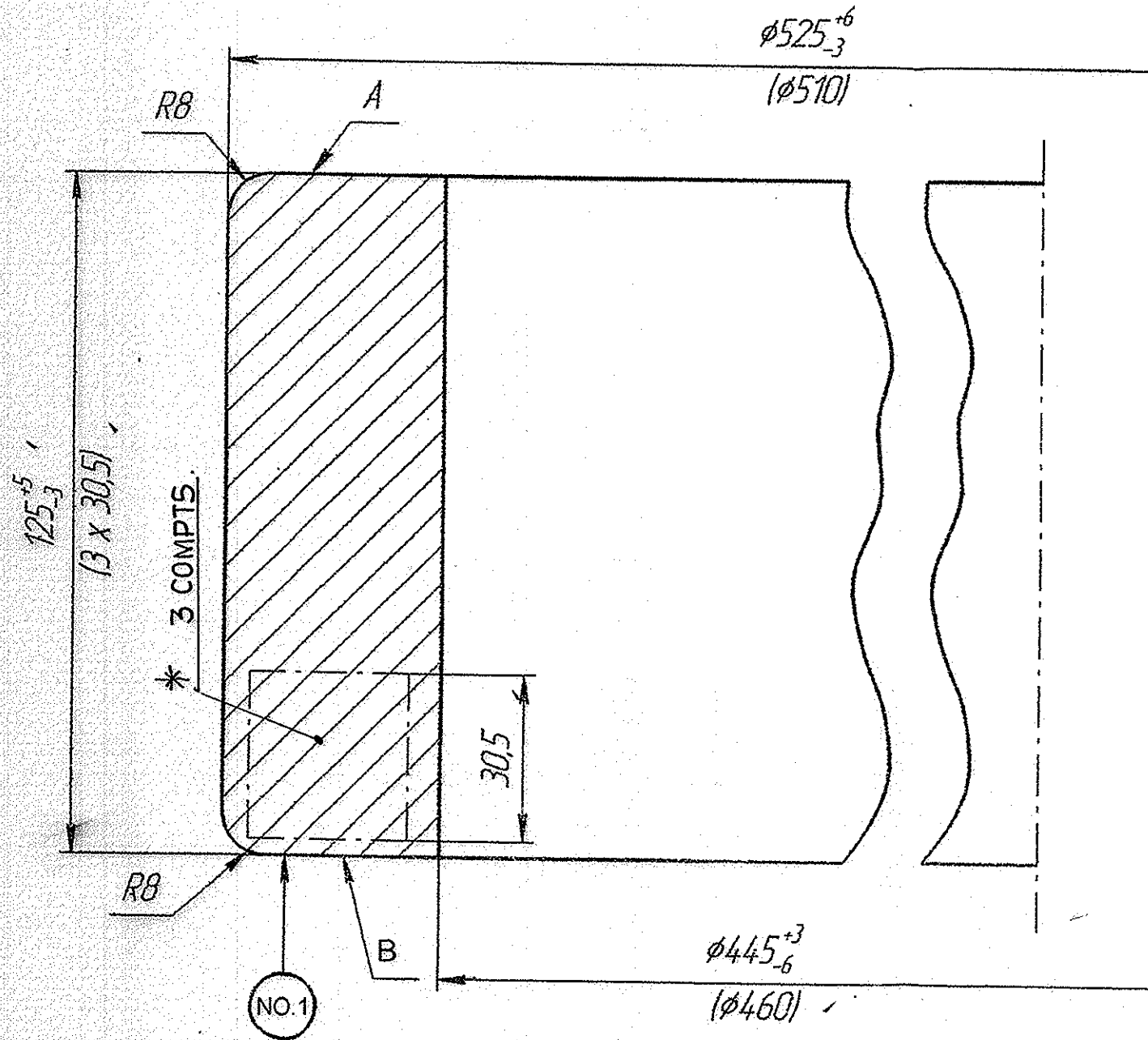


DRAWING NO.  
172.40.329/F

ROLLING



TECHNICAL REQUIREMENTS

01. MARK THE PART NO. AND CODE OF CHIEF.
02.  $\leq 256$  HB.
03. DE-SCALES (SHOT BLASTING)
04. ON SURFACE OF FORGING OCCASSIONAL DEFECTS WITHOUT THEIR REMOVAL ARE ALLOWED, IF THEIR DEPTH IS DETERMINED BY CONTROL CUTTING, AND SHOULD NOT EXCEED 0.5 ACTUAL MACHINING ALLOWANCE.
05. ON SURFACES A AND B DRAFT ANGLE  $3^\circ$  IS ALLOWED.
06. ALONG THE PARTING LINE OF GAUGE, BURRS ARE ALLOWED.
07. DEVIATION FROM CIRCLE AND CYLINDERICITY SHOULD BE WITHIN TOLERANCE LIMITS.
08. IN-COMPLETNESS IN PARTING LINE OF GAUGE UPTO R 15 IS ALLOWED.
09. PAINT RED OXIDE.

SECOND OPERATION(ROLLING)

( SHEET 2 OFF 2 )

FORGING IS COMMON FOR COMPT. NO.

172.40.331/F

T 90

MATERIAL	FORGING WT.	
20X2H4A GOST 4543-71,		
ALT. MATERIAL	HAMMER	SCALE
		NTS
DRAWN	CHECKED	APPROVED
<i>L. Ruff</i> 01/09/03	<i>M. Ruff</i> 01/09/03	<i>S. D. H.</i>

**NOTE:-**

THE FORGING TECH. REQUIREMENTS CALLS FOR DIE FORGING OPERATION AS WELL AS ROLLING OPERATION. INSPECTION IS REQUIRED AT EVERY STAGE.

\* EACH FORGING CATER FOR THREE COMPTS.

DRAWING NO. 172.40.329/F

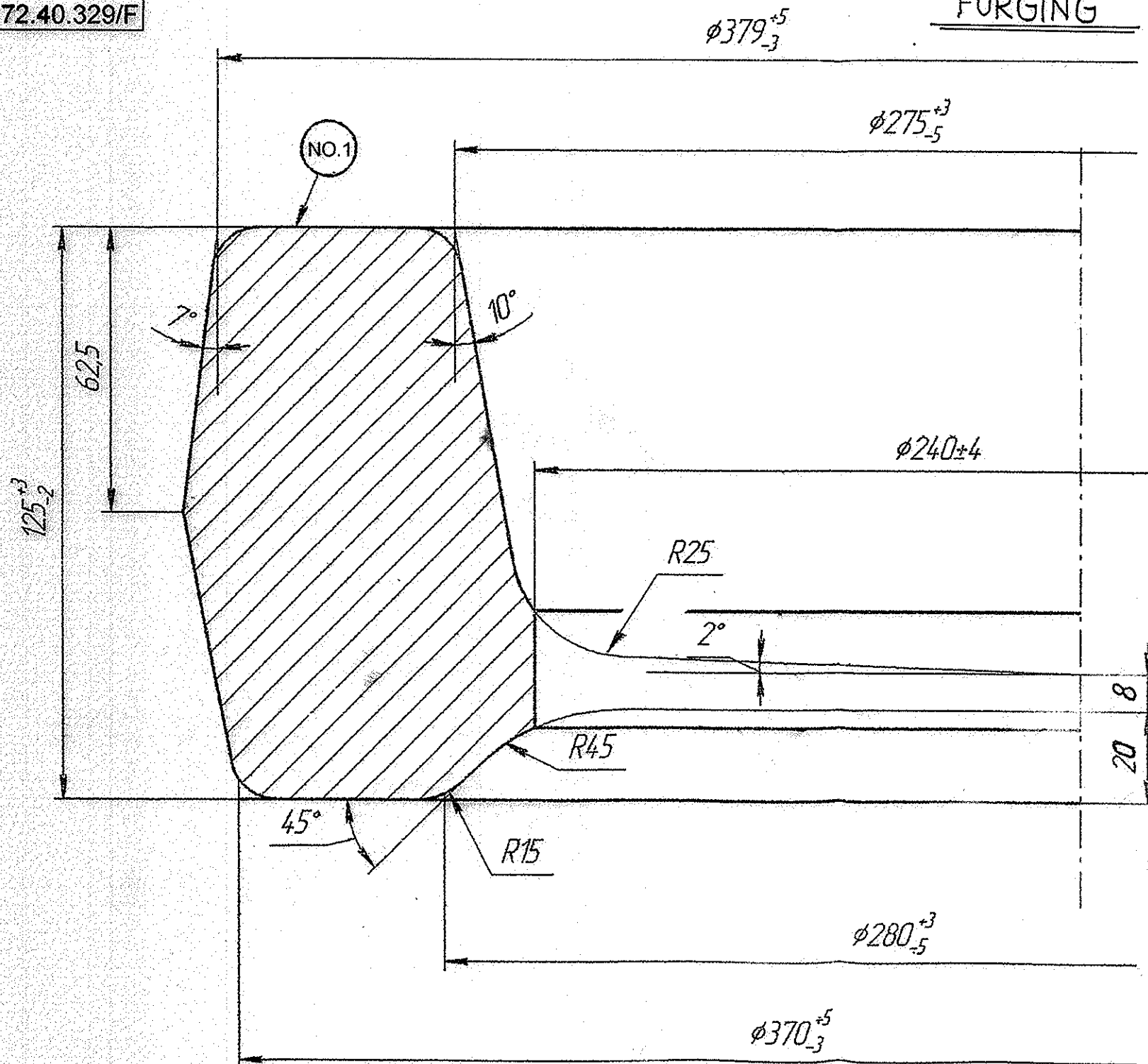
NOMENCLATURE: R.H MIDDLE ENGAGING RING

**FORGING**  
**HEAVY VEHICLES FACTORY**

AVADI, CHENNAI

DRAWING NO.  
172.40.329/F

FORGING



TECHNICAL REQUIREMENTS

01. MARK THE PART NO "329" AND CODE OF CHIEF
02. SURFACE DEFECTS SHOULD BE WITHIN TOLERANCE LIMITS.
03. MARK DUE TO CLAMPS SHOULD BE REMOVED COMPLETELY WITH CONTROL CUTTING.
04. SHIFT OF AXIS OF DIE IS UPTO 2.0 MM.
05. PROJECTIONS DUE TO CUTTING OF BURRS IS UPTO 2.5 MM.
06. ECCENTRICITY OF BROACHING HOLE IS UPTO 3.0 MM.
07. UN-SPECIFIED FILLET RADII R 10.
08. DIMENSIONS WITHOUT TOLERANCES NEED NOT BE CHECKED.

FIRST OPERATION.(FORGING)  
( SHEET 1 OFF 2 )

T 90

MATERIAL	FORGING WT.	
20X2H4A / GOST 4543-71	61.00 KGS	
ALT. MATERIAL	HAMMER	SCALE
		NTS
DRAWN	CHECKED	APPROVED
<i>I. Suthan</i> 01/09/03	<i>M. J. J.</i> 01/09/03	<i>S. S. S.</i>
DRAWING NO. 172.40.329/F		
NOMENCLATURE: R.H MIDDLE ENGAGING RING		
<b>FORGING</b>		
<b>HEAVY VEHICLES FACTORY</b>		
AVADI, CHENNAI		

FORGING IS COMMON FOR COMPT. NO. 172.40.331/F