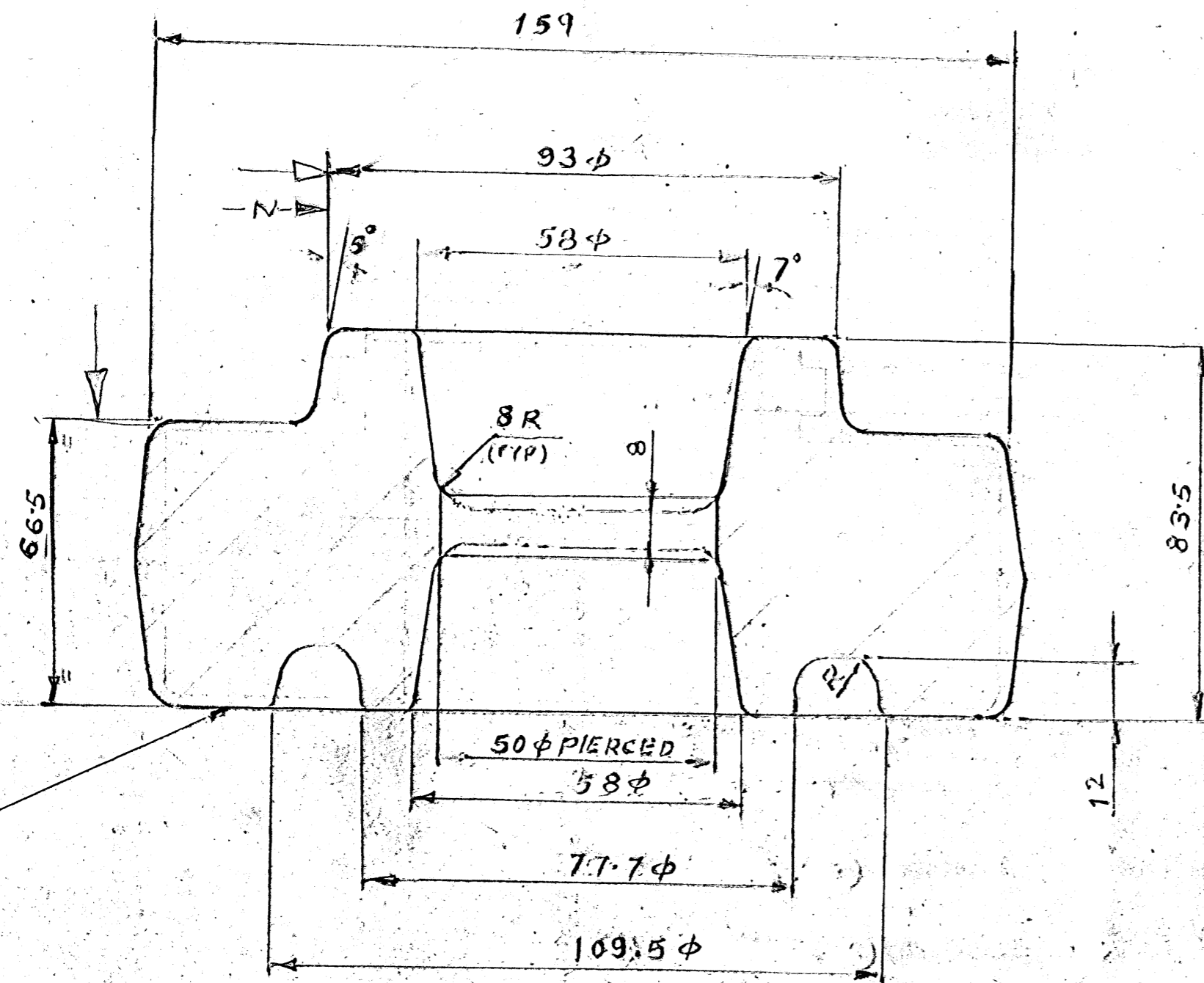


ALL DIMS ARE IN MM.



STAMP PART NO & SUPPLIER'S CODE

SUPPLY CONDITION - PRE-MACHINED

OUTSIDE DIA. - 159.0/158.5
INSIDE DIA. - 57.5/58.0

- NOTE: 1) ALL LOCATING, RESTING AND CLAMPING POINTS TO BE CLEAN SMOOTH FLAT AND CYLINDRICAL
2) ALL THE TOLERANCES TO BE AS PER IS: 3469 (PART I TO III) - 1974
3) SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
4) FORGING TO BE SUPPLIED AFTER APPLYING RED OXIDE PRIMER FOR RUST PREVENTION
5. GRAIN SIZE :- ASTM 5 OR FINER
6. INCLUSION RATING :- 3ABCD THIN SERIES OR FINER AS PER IS: 4163-1961.

MATERIAL CONSTITUENTS

S.N	DETAILS	MARK IV
1	MATERIAL	EN 355
2	IS EQUIVALENT	822 M 17
3	TYPE OF STEEL	2% Ni Cr Mo CH Steel (Low cy)
4	C	0.2 Max
5	Si	0.35 Max
6	Mn	0.4-0.7
7	Ni	1.8-2.2
8	Cr	1.4-1.7
9	Mo	0.15-0.25
10		
11		
12		

TOLERANCES

DIE WEAR (TOTAL)	+1.2, -0.6
DIE THICKNESS	+1.1, -0.5
MIS MATCH	0.8
FLUSH EXTENSION	CLOSE TRIM
STRAIGHTNESS	0.7
CORNER + FILLET RADII	+50%, -25%
DRAFT ANGLE	+2°, -1°
ECCENTRICITY TO THE PUNCH HOLE	0.040" (0.080" IR)
SURFACE	0.5

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS		MATERIAL	EN 355 FINE GRAIN	LOCATE
DRAFT ANGLE	EXT 3° INT 7°	HEAT TREATMENT	ISO THERMAL ANNEALING FORTY TO BE SUPPLIED IN SHOT BLAST CONDITION	REST
CORNER RADII	2	HARDNESS	160-210 BHN	CLAMP
FILLET RADII	3	MICRO STRUCTURE	FINE FERRITE & PEARLITE	
		WEIGHT		

(R1)	NOTE AT S. NO. 10, 11 & 12 UNDER THE CONT. HEADING DELETED. REF. SUPP. AT (R&R-E) L. NO. 46/14/1/2004. DATE 4.2.13. NAT/R&R-2/CS VALUE OF 1.2.13	DATE	4/2/13	SIGN	DRN	APPD	1:1 SCALE 01-02-10 DATE 1/1 SHEET
INDEX	ALTERATION	DATE		SIGN			
FORGING DRAWING GEAR, INPUT-HIGH AGB/STLN. MARK - IV							
VEHICLE FACTORY JABALPUR							X 1601211-3(R1)

4/2/13