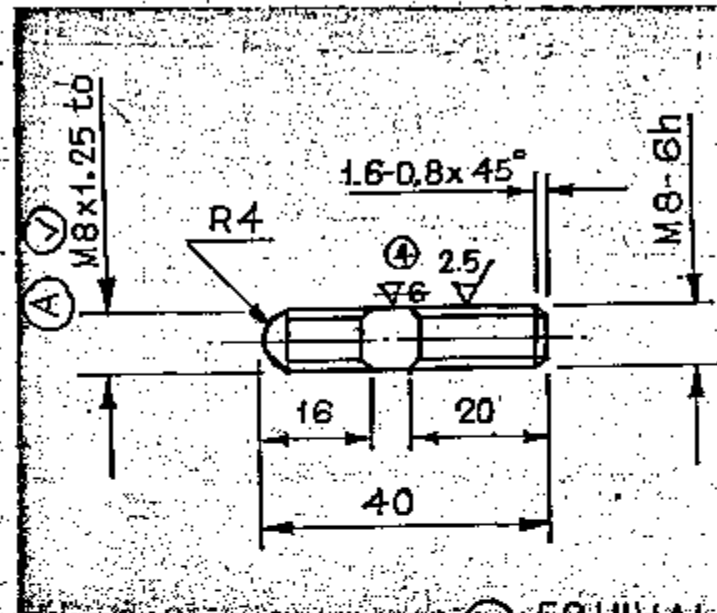


DRAWING NUMBER
350-08-2A

④ Rz80 ✓ (✓)



③ EQUIVALENT MATERIAL STEEL
835M15 (EN39B) BS:970

1. INSPECTION GROUP IV TT-11
2. HRC 35-39
3. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
4. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.

⑤ ~~THE THREAD MAY BE MADE BY ROLLING WITH THE DIAMETER OF UNTHREADED PORTION WITHIN THE PITCH DIAMETER OF THREAD.~~

7. ALTERNATE MATERIAL: STEEL 18X2H4MA TY 14-1-381-72

8. COATING: CADMIUM 3, CHROMATIZING AS PER UJ, П-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.

⑥ BOTH THE THREADS SHOULD BE MADE BY ROLLING AFTER HEAT TREATMENT. DIAMETER OF UNTHREADED PORTION WITHIN THE PITCH DIAMETER OF THREAD.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

9. EXPLANATORY NOTE :-

GOST 7417-75

MATERIAL QUOTED: 18X2H4 BATY14-381-72

HOT ROLLED CHROMIUM-NICKEL TUNGSTEN STEEL OF HIGH QUALITY.

18X2H4 BA = GRADE OF STEEL AS PER TY 14-1-381-72

CHEMICAL COMPOSITION % (AS PER GOST 4543-71)

CARBON	= 0.14-0.20
SILICON	= 0.17-0.37
MANGANESE	= 0.25-0.55
NICKEL	= 4.00-4.40
CHROMIUM	= 1.35-1.65
TUNGSTEN	= 0.80-1.20
PHOSPHORUS	= 0.025
SULPHUR	= 0.025
COPPER	= 0.30

} MAX.

MECHANICAL PROPERTIES (AS PER GOST 4543-71)

ULTIMATE TENSILE STRENGTH $Kgf/mm^2 = 105$ (MIN)

YIELD POINT $Kgf/mm^2 = 80$ (MIN)

% ELONGATION = 12 (MIN)

REDUCTION IN AREA % = 50 (MIN)

IMPACT STRENGTH $Kgf.m/cm^2 = 12$ (MIN)

④ 10. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THIS BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS.

SL. No.	R.	REMARKS
1.	M 10 X 1.5 to	ALL OTHER CONDITIONS
2.	P.C.D. = 9.026 $+0.170$ $+0.095$	AS PER STD. DRG.

DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69.	TITLE	D'S CAT NUMBER	DRAWING NUMBER
				28-1-85	1:1	MATERIAL: ROUND BAR GOST 7417-75	USED ON CE 306-01-20	STUD M8x40		350-08-2A
						18X2H4BATY14-1-381-72	CE 306-02-20			
						CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVAIL.				
						4 th Alt. Comm Meeting Minutes Point No. 15 Dated 26.10.09				
						AUTHY: MINUTES OF MEETING VIDE LT. No 81262/D B II / N OF A Dt 2-1-98.				
						REPAIR SIZE DIMENSION ADDED				
						ALL THREADS TO CONFORM TO				
						NATURE OF AMENDMENTS				

EXPLANATORY NOTE ADDED ON 20-1-92

KVD NO 78866

