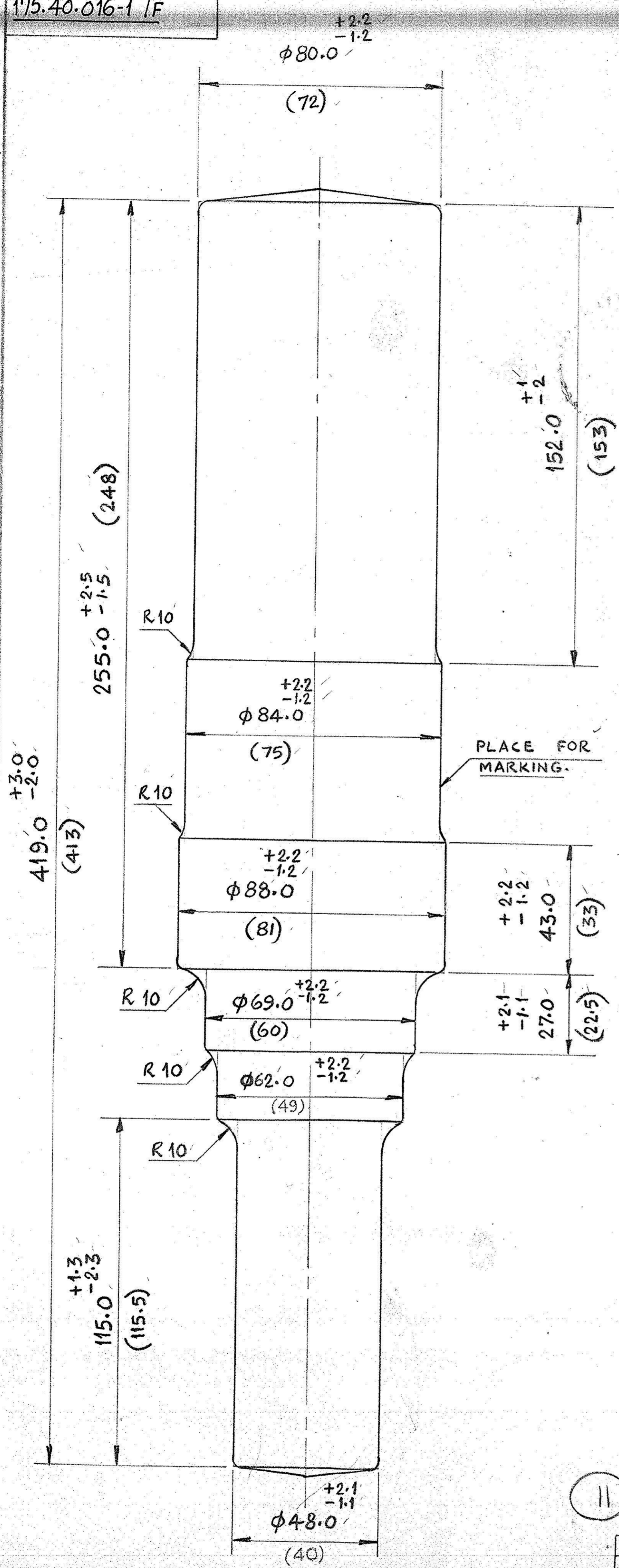


DRAWING NO.  
175.40.016-1 / F

MODIFICATIONS.		
ISSUE	N of A	DATE & SIG.
A	<del>POINT NO. 4. MATERIAL STEEL 18X2H4BA WAS</del> <del>STEEL 18X2H4MA. POINT NO. 6 ALTERNATIVE MATERIAL ADDED IN 'NOTE' TO BE IN CONFIRMITY WITH MACHING DRAWING.</del>	<i>[Signature]</i> 28/01/07
B	NOTE ADDED, FORGING IS COMMON FOR T-90 COMPT. NO. 172.40.314/F PRIMARY SHAFT. REF. DGM (TRANS & SMS) NO. 07291/TRANS/T905/03-04 DT 26.12.03	<i>[Signature]</i> 27/1/06



TECHNICAL REQUIREMENTS.

1. MARK MELT NO
2. TO BE HEAT TREATED. DIA. OF IND. 3.7 TO 4.2
3. DESCALE.
4. SURFACE DEFECTS AND PIT MARKS FROM SCALES UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE IS ACCEPTABLE.
5. MISMATCH SHOULD NOT EXCEED 1.3 mm.
6. RESIDUAL FIN AFTER TRIMMING SHOULD NOT EXCEED 1.7 mm ALONG PARTING LINE.
7. BUCKLING SHOULD NOT EXCEED 1.5 mm.
8. MARK PART NO
9. MAY BE MANUFACTURED FROM STEEL 18X2H4MA-W, 18X2H4BA AND 18X2H4MA GOST 4543-71

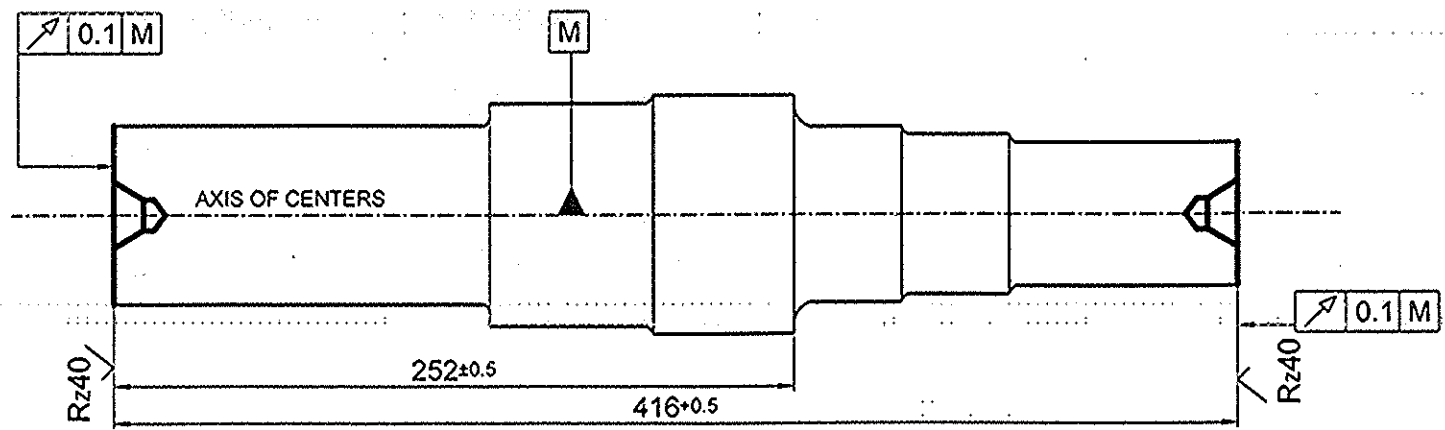
NOTE.

1. DRAFTS : 7°
  2. UNSPECIFIED ROUNDING OFF RADII TO BE R3.5mm MAX.
  3. MACHINING DIMENSIONS ARE SHOWN IN BRACKET.
  4. MATERIAL : STEEL 18X2H4BA. GOST 4543-71
  5. WEIGHT OF FORGING : 14.2 kg.
  6. ALTERNATE MATERIAL : 18X2H4MA GOST 4543-71
- B. FORGING DRG. IS COMMON FOR T-90 COMPT. NO. 172.40.314 / F.

11

20006	TRIMMING TOOL	600T	T-72 & T-90
20005	STAMPING DIES.	DG 13.	
TOOL NO.	DESCRIPTION.	MACHINE	EQUIPT. TO BE USED.
SCALE	COMPONENT		COMPNT./FORGING
1:1	SHAFT PRIMARY. 175.40.016-1	DG 13	1.
DGN.	CHD.	APPD.	AUTHD.
<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
FORGING DRAWING.			175.40.016-1 / F

Rz80 ✓(✓)

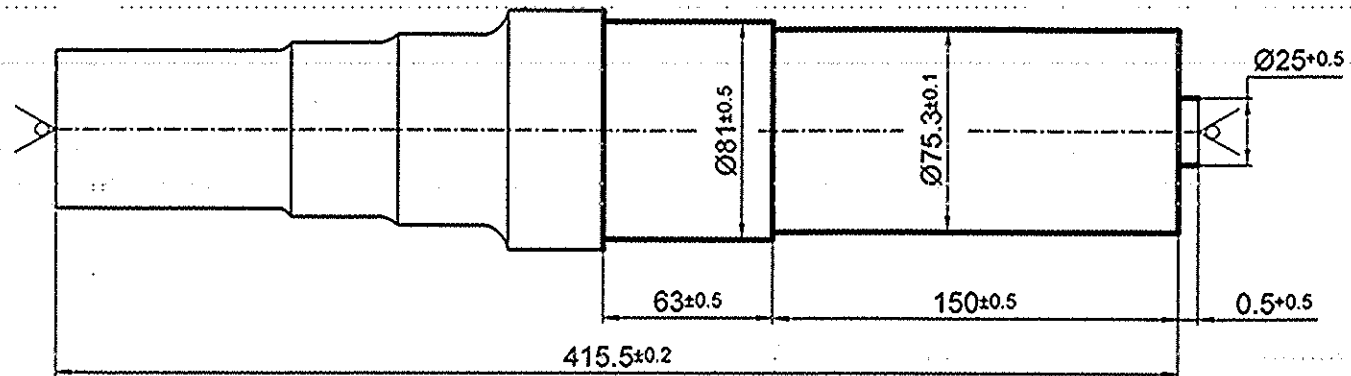


USE A5 X 16' CENTRE DRILL

DRG NO. : 175.40.016-1/SMF, SHAFT PRIMARY
OPN NO. : 10 FACING AND CENTERING
MATERIAL : STEEL 18X2H4,BA
HARDNESS : 269-207 BHN
SHEETNO. : NOT TO SCALE

PREPARED	CHECKED	APPROVED

Rz80  
√(√)



1. RUN OUT OF MACHINED SURFACES WITH RESPECT TO AXIS OF CENTERS NOT TO BE MORE THAN 0.3mm
2. CHAMFER 1X45° AT ALL EDGES.

DRG NO. : 175.40.016-1/SMF, SHAFT PRIMARY

OPN NO. : 20 TURNING

MATERIAL : STEEL 18X2H4, BA

HARDNESS : 269-207 BHN

SHEETNO. :

NOT TO SCALE

*MJN*

PREPARED

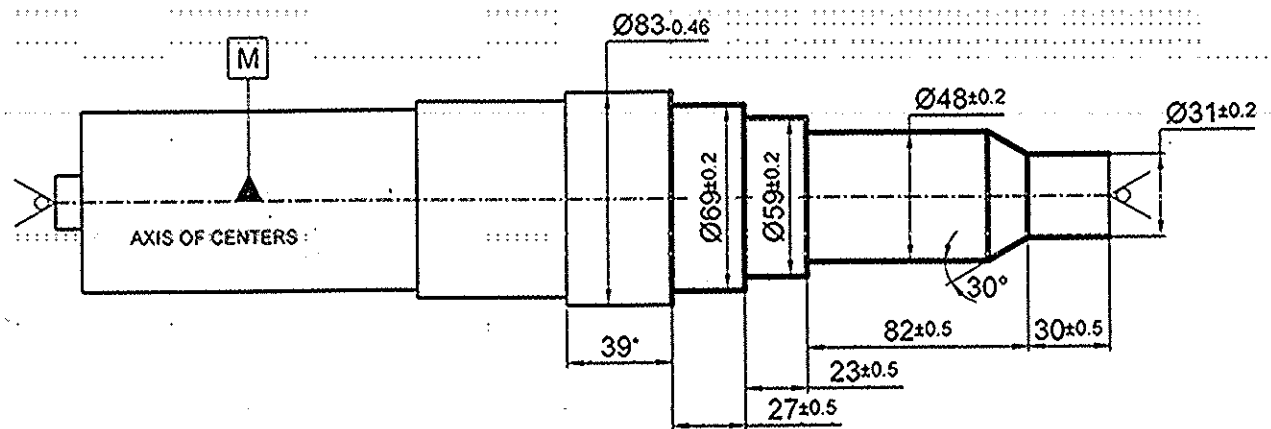
*[Signature]*

CHECKED

*[Signature]*

APPROVED

Rz80 ✓(✓)

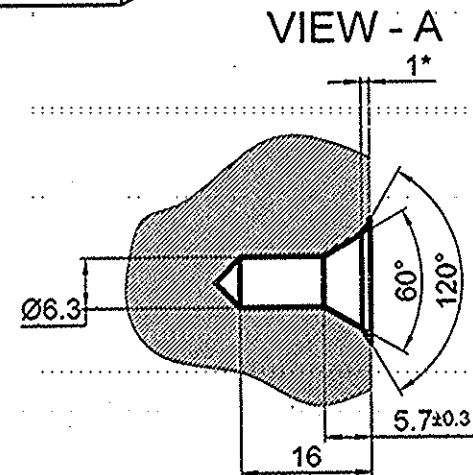
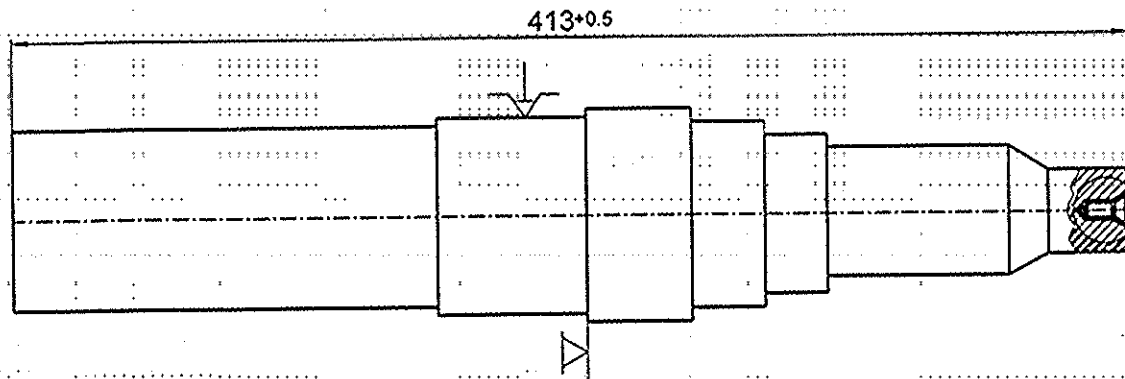


1. RUN OUT OF MACHINED SURFACES WITH RESPECT TO AXIS OF CENTERS NOT TO BE MORE THAN 0.3mm.
2. CHAMFER 1X45° AT ALL EDGES.
3. \* DIMENSION FOR REFERENCE

DRG NO.	: 175.40.016-1/SMF, SHAFT PRIMARY
OPN NO.	: 30 TURNING
MATERIAL	: STEEL 18X2H4,BA
HARDNESS	: 269-207 BHN
SHEETNO.	: NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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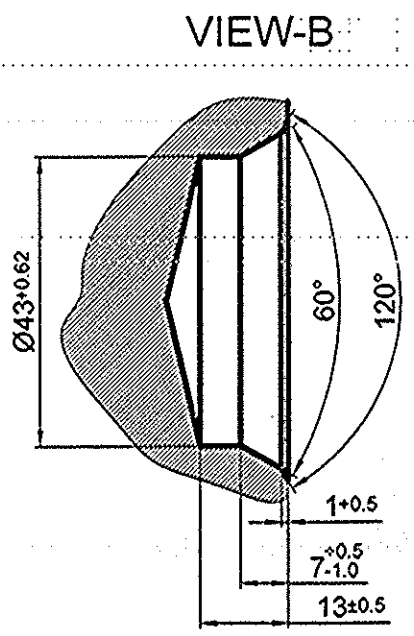
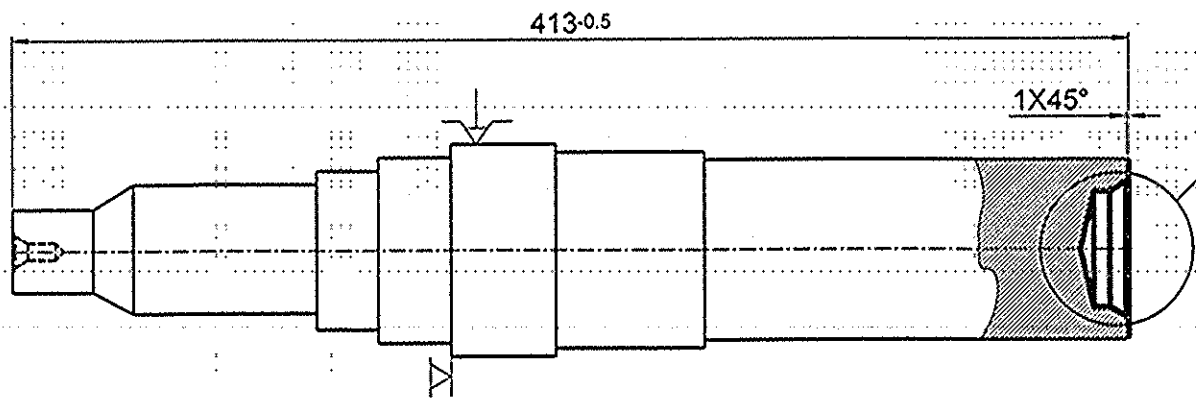
Rz20 ✓(✓)



DRG NO. : 175.40.016-1/SMF, SHAFT PRIMARY
OPN NO. : 40TURNING
MATERIAL : STEEL 18X2H4,BA
HARDNESS : 269-207 BHN
SHEETNO. : NOT TO SCALE

PREPARED	CHECKED	APPROVED

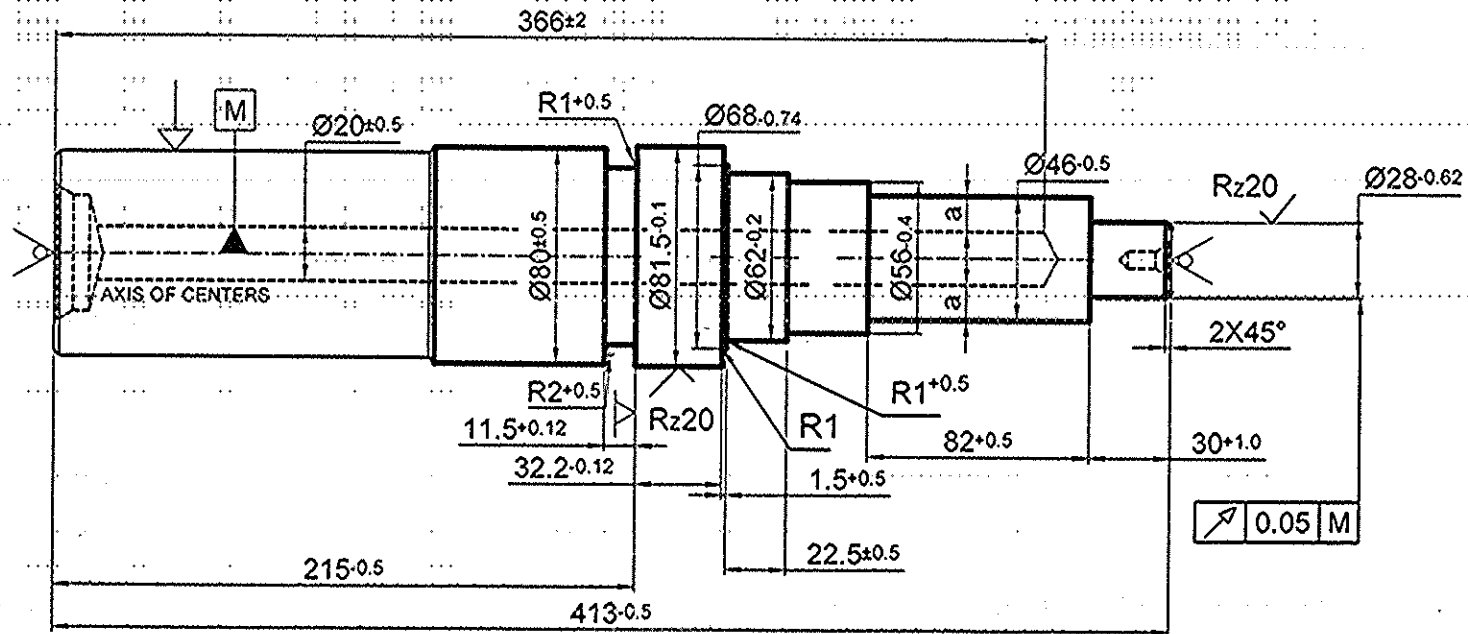
Rz20  
✓(✓)



DRG NO. : 175.40.016-1/SMF, SHAFT PRIMARY
OPN NO. : 50 TURNING
MATERIAL : STEEL 18X2H4, BA
HARDNESS : 269-207 BHN
SHEETNO. : NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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Rz40 ✓(✓)



1. RUNOUT WITH RESPECT TO AXIS OF CENTERS  
NOT TO BE MORE THAN 0.1MM
2. CHAMFER 1X45° AT ALL THE EDGES.
3. 'a' SHOULD NOT VARY MORE THAN 1MM.

DRG NO. : 175.40.016-1/SMF, SHAFT PRIMARY

OPN NO. : 60 TURNING

MATERIAL : STEEL 18X2H4, BA

HARDNESS : 269-207 BHN

SHEET NO. :

NOT TO SCALE

PREPARED

CHECKED

APPROVED