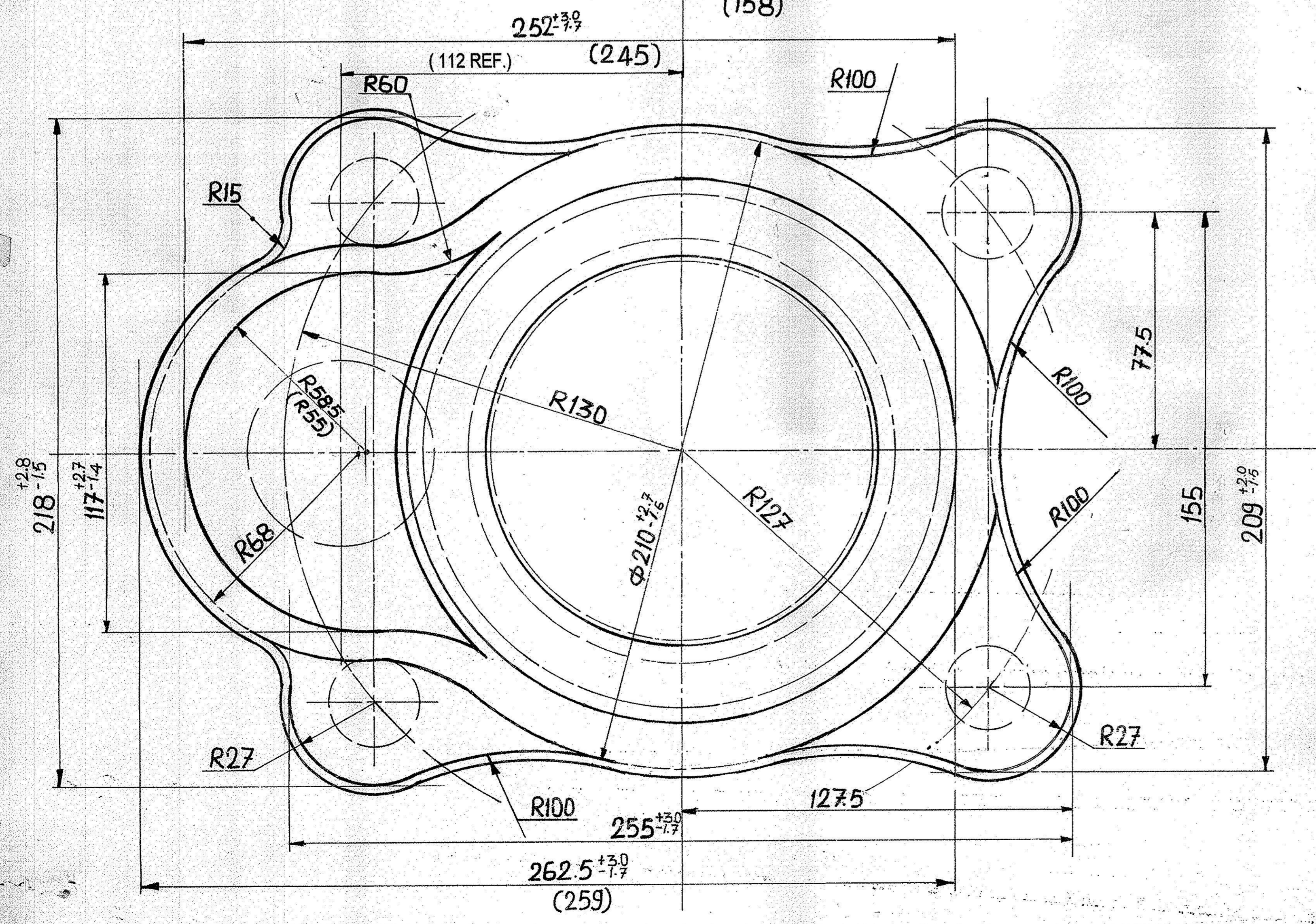
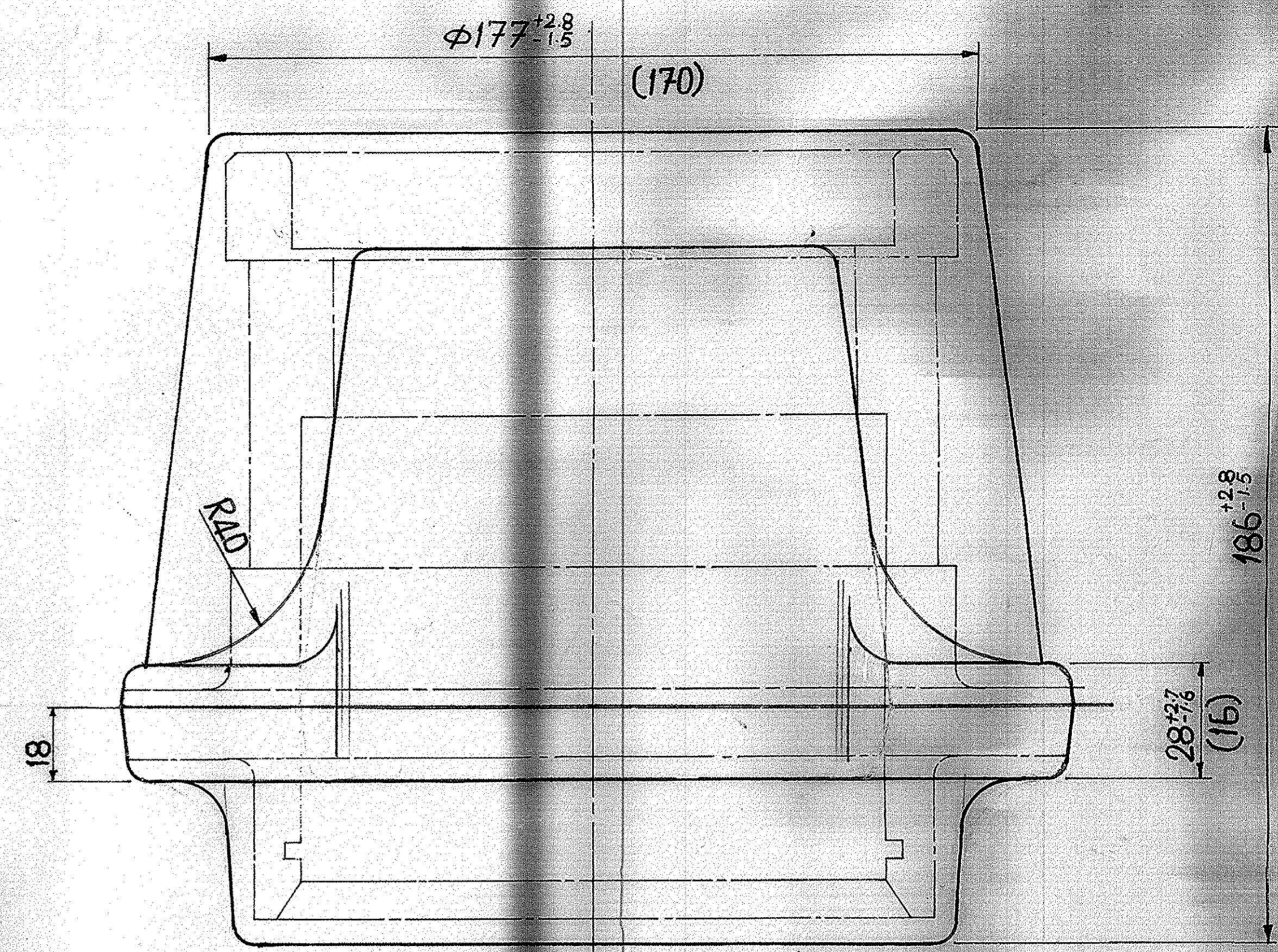
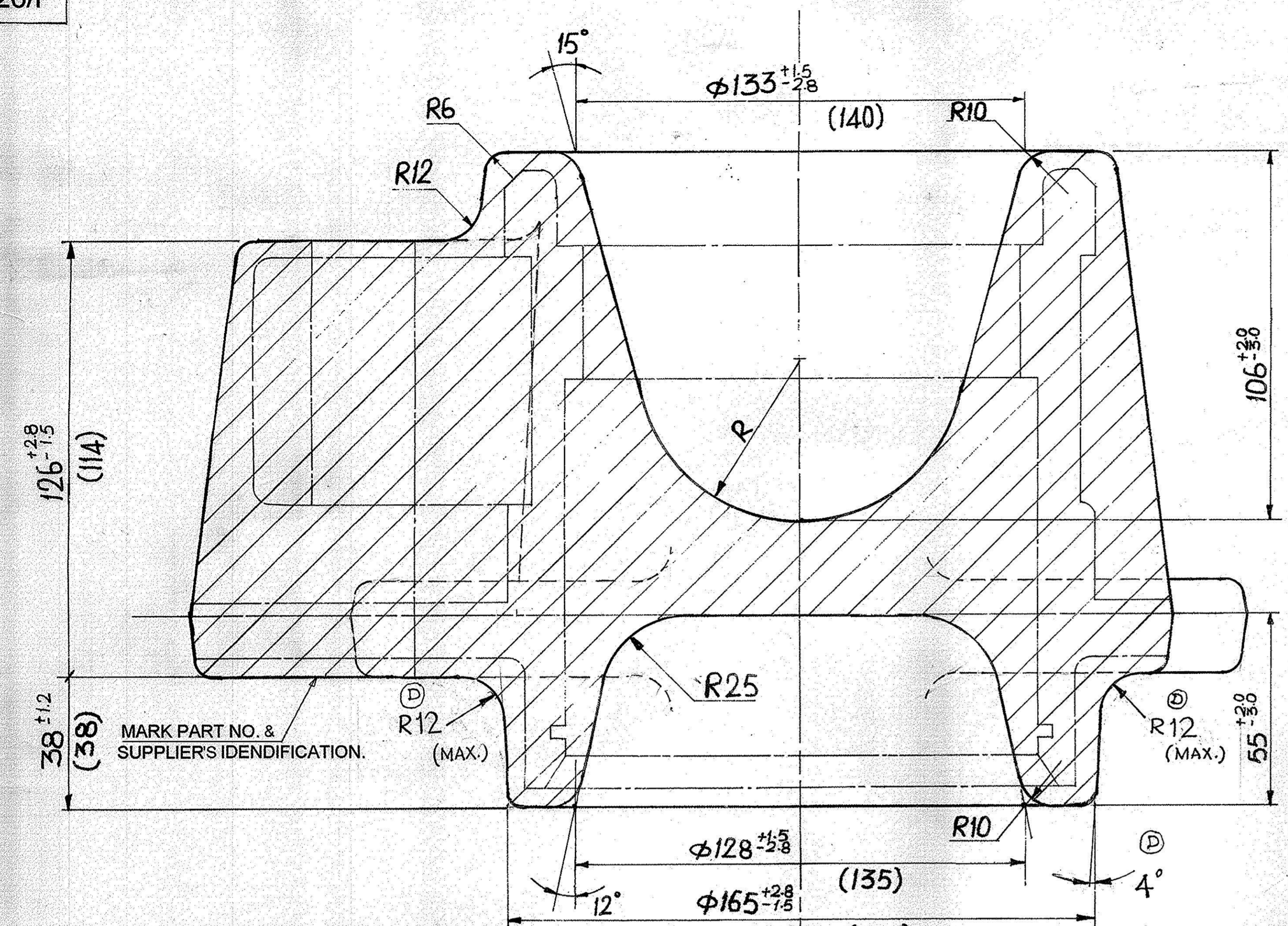


DRAWING NO
172.51.026/F



ISSUE	MODIFICATION	DATE
A	HEAT TREATMENT DETAILS ADDED 2 3.8mm (255BHN) WAS 3.4 - 3.6mm	25.8.91
B	Drawing NO 172.51.026/F was 175.51.004.2/F (Ref. Amdt List NO-6/II Book-8)	19.8.95
C	REDRAWN	29.6.05
D	R 12 MAX. ON DIAMETRICALLY GIVEN WITH REFERENCE TO DIA. 165mm. AND R-30 AND R-20 DELETED. 4° MAX. ANGLE PROVIDED. 7° DELETED IN THE DIA. 165mm. REF. AREA NOTE ADDED FOR COMMON FORGING. REF. JWM/RG LTR NO. 07271/VP/RG/PROOF - MACH/06 DT 13.02.06	13/2/06

TECHNICAL REQUIREMENT

- HEAT TREATMENT :- NORMALISE . DIA OF IND. ≥ 3.8 MM(255 BHN)
- DESCALE.
- DEPTH OF SURFACE DEFECTS AND PITS FROM SCALE UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE IS ALLOWED, ON NOT TO BE MACHINED SURFACES ,IT SHOULD BE WITHIN THE LIMITS OF TOLERANCES.
- MISMATCH SHOULD NOT EXCEED 2.0 MM.
- BUCKLING SHOULD NOT EXCEED 1.5 MM.
- RESIDUAL FIN ALONG WITH PARTING LINE SHOULD NOT EXCEED 2.0 MM.
- UNSPECIFIED DRAFT ANGLE ARE TO BE 7°
- UNSPECIFIED RADII ARE TO BE 5.0 MM
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UNTOLERANCED DIMENSIONS ARE NOT TO BE CHECKED.
- PAINT RED OXIDE

NOTE :- FORGING IS COMMON FOR T-72 & T-90 COMPT.NO.172.51.026/F

MATERIAL	FORGING WT.	T-72&T-90
40X2H2MA GOST:4543-71	42.4KG	
ALT. MATERIAL	HAMMER	SCALE
		NTS
DRAWN	CHECKED	APPROVED
2.2/1/05		
DRAWING NO.	BUSHING	
NOMENCLATURE:	172.51.026/F	
HEAVY VEHICLES FACTORY AVADI,CHENNAI		