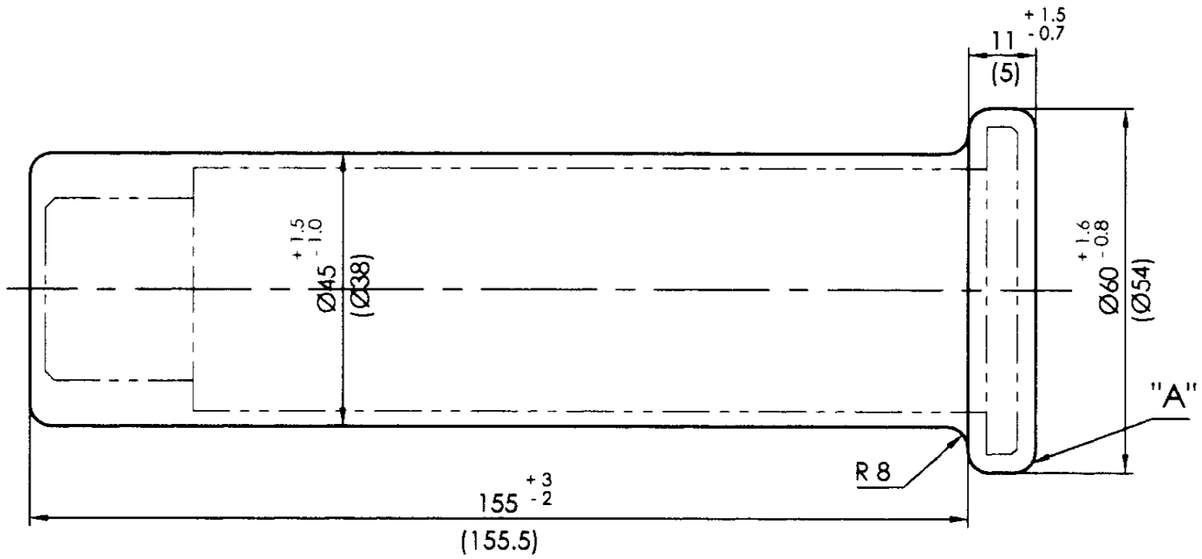

CHEMICAL COMPOSITION (%)			MECHANICAL PROPERTIES		
ELEMENT	STEEL 20X2H4A GOST 4543-71	STEEL 835M 15 (EN-39B) BS: 970-83	DESCRIPTION	STEEL 20X2H4A GOST 4543-71	STEEL 835M 15 (EN-39B) BS: 970-83
C	0.16 - 0.22	0.12 - 0.18	TEST BAR DIA.	------	19 mm
Si	0.17 - 0.37	----------	TENSILE STRENGTH	130 Kgf/mm² MIN.	1310 MPa MIN.
Mn	0.30 - 0.60	0.25 - 0.50	YIELD STRENGTH	110 Kgf/mm² MIN.	----------
Cr	1.25 1.65	1.00 - 1.40	RELATIVE ELONGATION	9 % MIN.	8 % MIN.
Ni	3.25 - 3.65	3.90 - 4.30	REDUCTION OF AREA	45 % MIN.	------
Mo	----------	0.15 - 0.30	IMPACT STRENGTH	8 Kgf.m/cm² MIN.	------
Cu	0.30 MAX.	----------	IZOD	------	25 MIN.
S	0.025 MAX.	0.025 - 0.050	KCV (CHARPY)	------	28 MIN.
P	0.025 MAX.	0.035 MAX.			

NOTES.

1. HEAT TREAT. DIA OF INDN : 3.7 - 4.2 mm, HARDNESS : BHN 269 MAX.
2. DESCALE
3. DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE ARE ALLOWED.
4. ELLIPTICITY OF HEAD SHOULD BE WITHIN LIMITS OF TOLERANCE
5. HOLDING MARKS, ELLIPTICITY AND FIN ALONG PARTING LINE ARE ALLOWED,
6. FIN ALONG PARTING LINE UPTO 1 mm, ALONG CIRCUMFERENCE "A" UPTO 3.5 mm.
7. MISMATCH MAX. 1.0 mm.
8. FACE DRAFT 6° MAX., CUT MARKS UPTO 4 mm ON A LENGTH OF 30 mm ALLOWED.
9. BUCKLING MAX. 2 mm.
10. THICKNESS INCREASE NEAR THE HEAD IS ALLOWED UPTO 48Ø ON A LENGTH OF 100 mm.
11. UNSPECIFIED RADII UPTO R 3.0 mm.
12. MACHINING DIMENSIONS ARE SHOWN IN BRACKET.
13. PAINT RED OXIDE,
14. PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY

ALTERNATE MATERIAL: STEEL 835M15 (EN39B) TO BS: 970 - 83

AUTHORITY: CQA(HV) LETTER NO. 091/IFD/IND-V/MTPF/OE DATED : 17.03.2005

VETTED
9 JUN 2006
JWM/STD-CELL

	AXLE		20X2H4A GOST 4543-71		MASS 2.22 Kg.
संख्या NO OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO	पदार्थ MATERIAL	मानक STANDARD	परिमाप DIMENSIONS	अभ्यक्ति REMARKS

			@	forging for AXLE (SPINDLE) was AXLE (AMBUNA)		26.01.10	

सामान्य सहिष्णुता GENERAL TOLERANCE

रेखिक परिमाप LINEAR DIMENSION

0-6	±0.1
6-30	±0.2
30-120	±0.3
120-315	±0.5
315-1000	±0.8
1000-2000	±1.2

कोणिक परिमाप ANGULAR DIMENSION

1-10	±1°
10-50	±30'
50-100	±20'
>100	±10'

मापांक 'म्यू एम' में VALUE IN "um"

~	>25
▽	8-25
▽▽	1.6-8
▽▽▽	0.025-1.6
▽▽▽▽	<0.025

संख्या NO.OFF	संबंधित पुर्जाका आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2006	दिनांक DATE	नाम NAME

FORGING FOR AXLE (SPINDLE)

FOR COMP. DRG NO. 175-45-025

TRANSMISSION GEAR UNIT

CODE - 45 / T-72 & T 90

मापमान SCALE	आरेखित DRAWN	01/06/06	Vishal
1:1	जाँचा CHECKED	29.06	
	अनुमोदित APPROVED	29/06	

द्वारा बदला REPLACED BY

हेतु बदला REPLACED FOR

मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ

MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH

कार्यालय OFFICE: D.O.

आरेखण क्र. DRAWING NO. 175 - 45 - 025 / F

इन आरेखणो तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नही कराई जानी चाहिए ।

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मूलमाप व अन्वायोजन NOMINAL SIZE & FIT | विचलन DEVIATION

FILE PATH : D:\Vishal\DATABANK\Codes\Code-45\175-45-025/F.DWG

DRG. DEVELOPED FROM HVF, AVADI ORIGINAL PRINT DATED 29/07/1985