



1. Shift of axes of dies should be 1 mm maximum
2. Bending of core should not be more than 1.25mm
3. Non flatness of surfaces "E" should be 1.2mm maximum
4. Holes and recess of defects are to a depth maximum half of actual allowance
5. Remaining burr along die flash line should not be more than 1.0mm
6. Non-filling of corners of upper head in the section 120° on "C" side is not allowed
7. It is allowed to manufacture from steel 18X2H4BA as per TY 14-1-381-72
8. Component No. and type ROB to be marked.
9. Heat No and grade of steel in case of replacing material, type ROB to be marked.
10. * Dimensions are to be ensured by foot
11. Forging is used for the manufacture of component 304 - 12 - 7

1. TO BE NORMALISED
2. SCALES TO BE DRESSED
3. HIGH TEMPERATURE TEMPERING: HB-255 196 (43-B 4-3) /

ISSUE	DATE	REFERENCE	304-12-7		
A	21.06.72	DIMENSIONALISED			
APPROVED			FORGING FOR		
CHECKED			MAIN CONNECTING ROD		
DRAWN			MATERIAL:-		
			STEEL 18X2H4MA		
			TY 14-1-381-72		
			SHEETS	MASS	SCALE
			- ENGINE FACTORY AVADI.		

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22/01/07

AS per WORKS advised to send for Trade Action No. 7A.