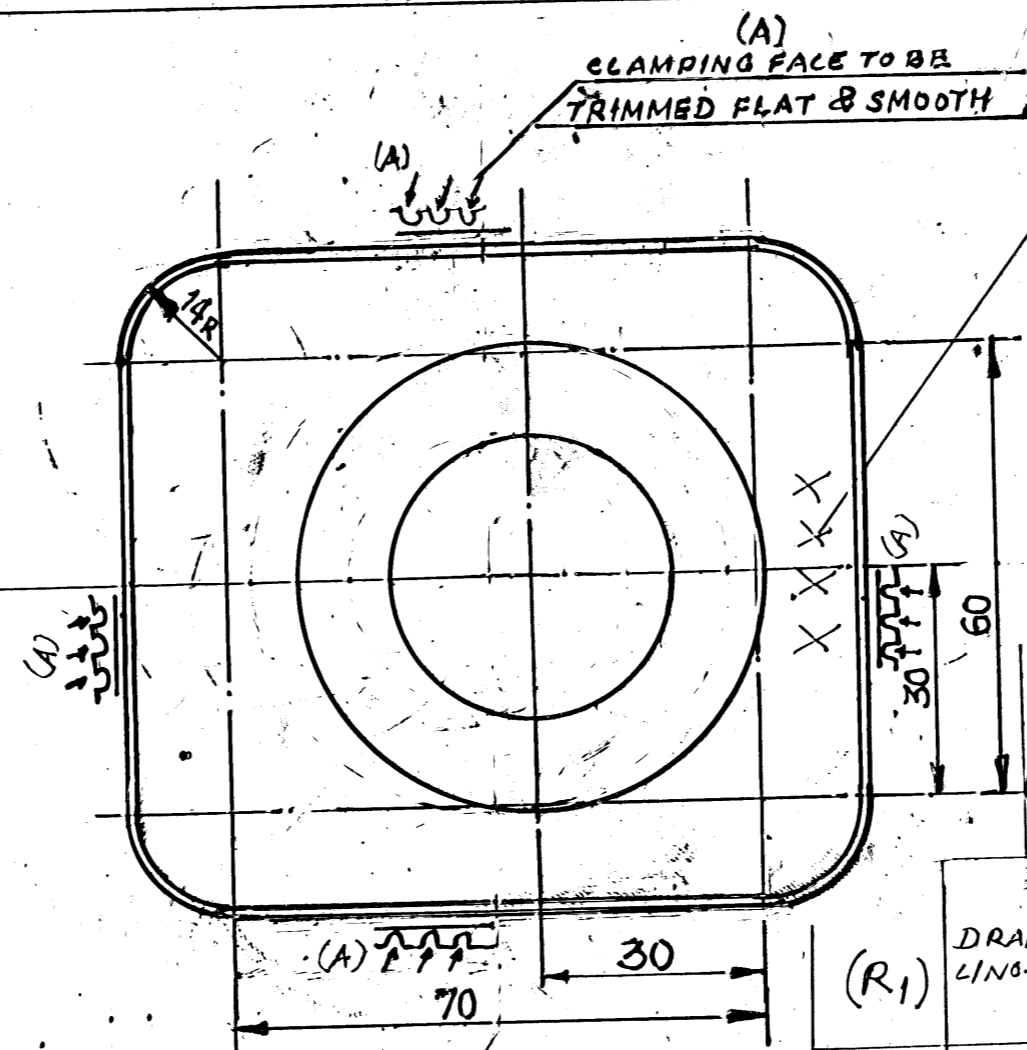
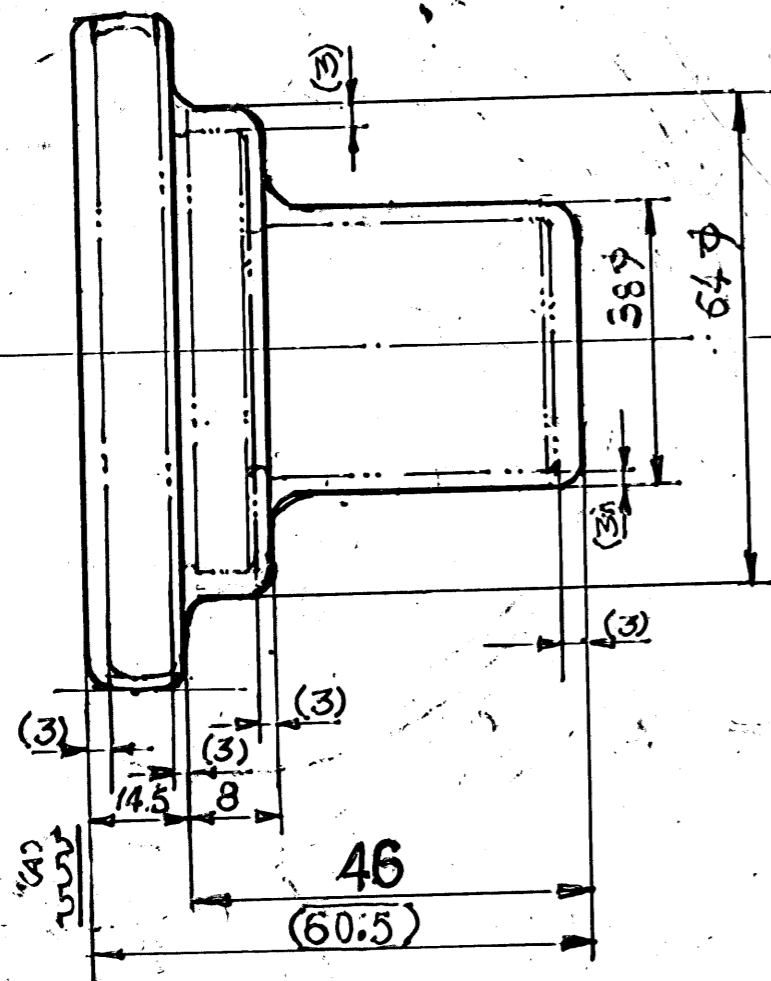


ALL DIMS ARE IN MM

DRG. NO., SUPPLIER'S INITIAL,  
MFG. MONTH & YEAR TO BE RAISED.



HARDNESS 140-187 BHN WAS 170-217  
BHN CHANGE AS PER COMMENTS GIVEN  
BY JE.GM/SAT ON DGM/TMM LINO.  
740/TMM/TELCO/ENTT 0082, DT. 19.7.03.  
K.P. [Signature]

INDEX	ALTERATION	DATE	SIGN
(R <sub>2</sub> )	HARDNESS 140-187 BHN WAS 170-217 BHN CHANGE AS PER COMMENTS GIVEN BY JE.GM/SAT ON DGM/TMM LINO. 740/TMM/TELCO/ENTT 0082, DT. 19.7.03. K.P. [Signature]	24.7.03	DGM/TM JWM/TDO
(R <sub>1</sub> )	DRAFT ANGLE 3° ADDED AS PER JE.GM/TMM LINO. 740/TMM/TELCO/ENQ, DT. 11.3.03. K.P. [Signature]	12.3.03	DGM/TM JWM/TDO
(B)	H.T. 150-THERMAL ANNEALED WAS NORMALISED CHANGE AS PER DIN STANDARD & INSTRUCTION OF JE.GM/T. K.P. [Signature]	25.3.01	JWM/TM JWM/TDO
(A)	CLAMPING FACE & STOP FACE SHOWN & NOTE ADDED AS PER P/SCHEDULE. K.P. [Signature]	22.8.99	AWM/D JWM/TDO

- NOTE:-**
- FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALLOVER
  - FORGING TO BE SHOT BLASTED.
  - FORGING TO BE COATED WITH RED OXIDE PRIMER TO JSS: 3-47-13 BY BRUSHING OR SPRAYING.
  - SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
  - DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
  - STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
  - DRAFT ANGLE - 3° (R<sub>1</sub>)
  - UNSPECIFIED RADII - 2.5R
  - CLAMPING FACE & STOP FACE FOR 1<sup>ST</sup> MACHINING OPERATION.

MATL. 20 MnCr16	EQVT. MATL.	FORGING TOL. AS PER IS: 3469-74
SS4027		FORGING WEIGHT 1.6 Kg
CHEMICAL COMPOSITION IN %		ENVELOP WEIGHT 4.1 Kg
150-THERMAL ANNEALED		COMPLE. XITY. S2: M1
HEAT-TREATMENT:- NORMALISED (R <sub>2</sub> )		INTRAC. OF MATL. NORMAL
HARDNESS:- (R <sub>2</sub> ) 140-187 BHN		FORGING GRADE
MICRO-STRUCTURE:- FINE FERRITE & PEARLITE		
GRAIN SIZE:- ASTM 5 OR FINER		
INCLUSION RATING: 3 ABCD THIN		
SERIES OR FINER AS PER IS: 4163		
1987. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.		

DRN	TCD	CKD	JWM/TDO	JWM/PR	WM/HT	/MC	APPD
[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]
FORGING DRAWING							REF. DRG. No.
KING PIN LOWER							1:1 SCALE
FRONT AXLE							M/C
LPTA 713							T.D.O
M/S TELCO							14.99 DATE
VEHICLE FACTORY JBP.							DEMANDED BY I/CTPE NO. 138/TPE/LPTA/AGB-FA-RA 1 DRG/10 DT. 6.3.99
13/3-2104							1/1 SHEET
30-6-022							DRG. NO. 340.3321306-3
A-3							CHANGE NO. (R <sub>2</sub> )