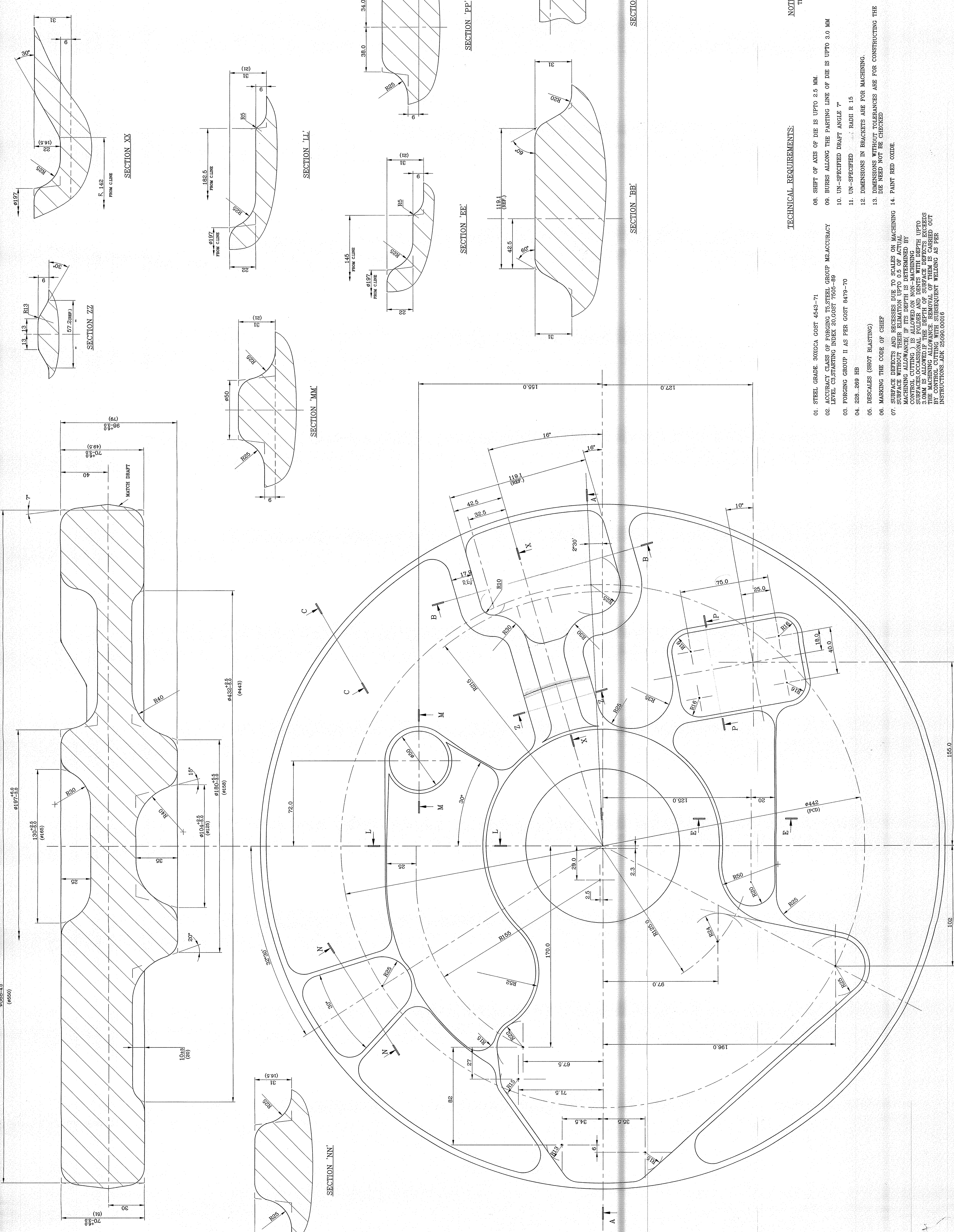


ISSUE	MODIFICATIONS & ADDITIONS
A	FORGING CALCULATOR FORGING DIE HAS BEEN MODIFIED IN ACCORDANCE WITH FORGING DIE. 172.40.365.152



TECHNICAL REQUIREMENTS:

- STEEL GRADE: 30XGCA GOST 4549-71
- ACCURACY CLASS OF FORGING: TS STEEL GROUP M2 ACCURACY LEVEL C3 STARTING INDEX 20, GOST 7505-89
- FORGING GROUP II AS PER GOST 8479-70
- 225...289 HB
- DESCALES (SHOT BLASTING)
- MARKING THE CODE OF CHIEF
- SURFACE DEFECTS AND RECESSES DUE TO SCALES ON MACHINING SURFACE WITHOUT THEIR ELIMINATION UP TO 0.5 OF ACTUAL MACHINING ALLOWANCE IF ITS DEPTH IS DETERMINED BY SURFACE MEASUREMENTS. SURFACE DEFECTS WITH DEPTH UP TO 3.0MM IS ALLOWED IF THE DEPTH OF SURFACE DEFECTS EXCEEDS THE MACHINING ALLOWANCE. REMOVAL OF THEM IS CARRIED OUT IN ACCORDANCE WITH SUBSEQUENT WELDING AS PER INSTRUCTIONS ADK 25090.00010
- SHIFT OF AXIS OF DIE IS UP TO 2.5 MM.
- BURRS ALONG THE PARTING LINE OF DIE IS UP TO 3.0 MM
- UN-SPECIFIED DRAFT ANGLE 7°
- UN-SPECIFIED RADI R 15
- DIMENSIONS IN BRACKETS ARE FOR MACHINING.
- DIMENSIONS WITHOUT TOLERANCES ARE FOR CONSTRUCTING THE DIE NEED NOT BE CHECKED
- PAINT RED OXIDE

NOTE
TRADE SUPPLIES IN NORMALISED CONDITION.

MATERIAL	FORGING WT	SCALE
30XGCA	110 KGS	1:1
GOST 4549-71		
AUT. MATERIAL	HAMMER	
DRAWN	CHECKED	APPROVED
DATE		
DRAWING NO. 172.40.365/F		
NOMENCLATURE: L.H. FRONT FLANGE		
HEAVY VEHICLES FACTORY		
ANDREYEV		