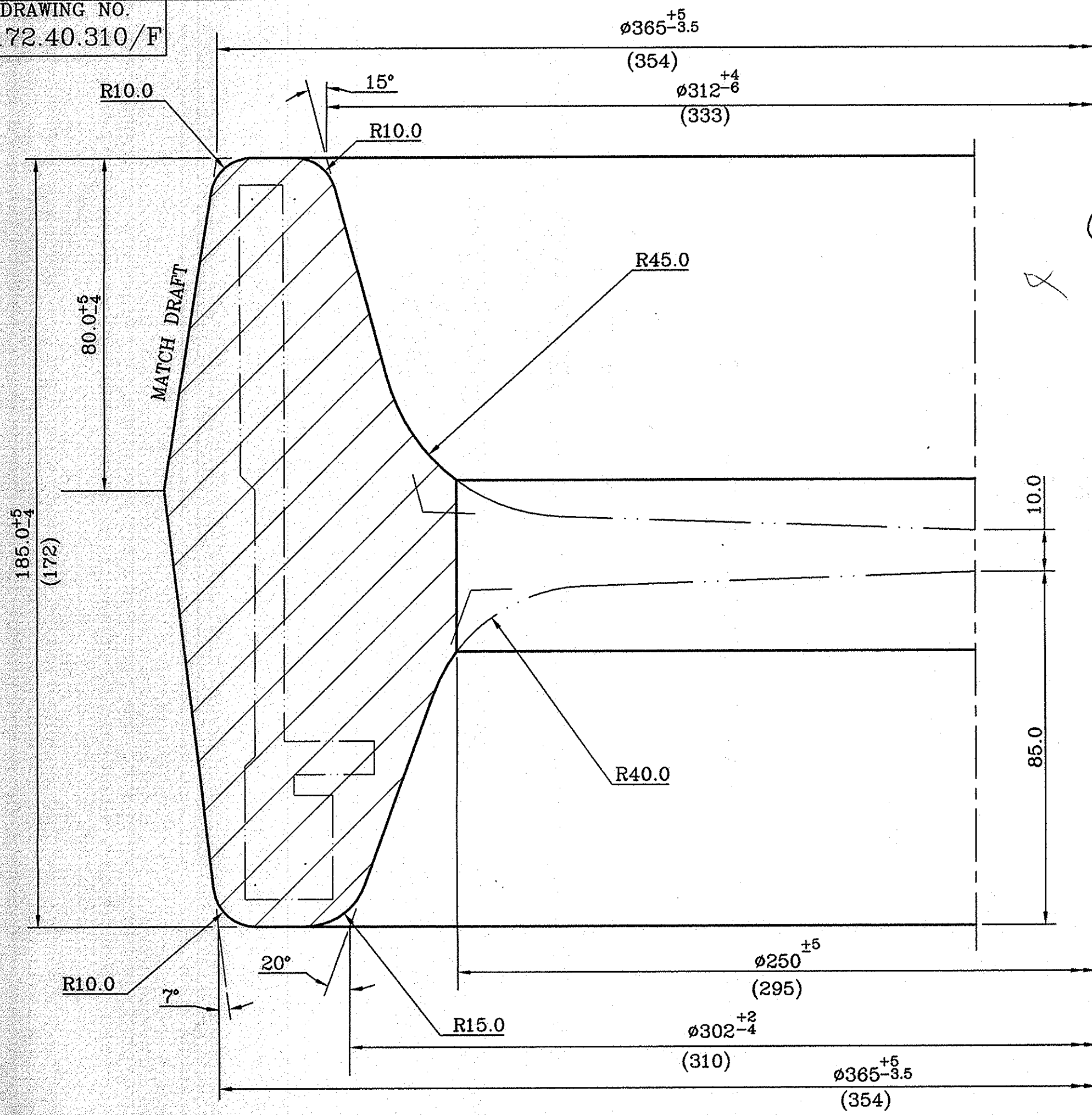


DRAWING NO.
172.40.310/F



ISS.	MODIFICATION	DATE
A	HEAT TREATMENT DIA. OF IND. ≥ 3.8 mm WAS 286-341 HB REF. Jwm/TRANS LETTER NO. 0727/ TRANS/FSP/06 Dt. 17-05-06	18/5/06

TECHNICAL REQUIREMENTS.

- (A) 01. DIA. OF INDENTATION ≥ 3.8
(EQUAL OR LESSER THAN 255 BHN)
- 02. DE-SCALES (SHOT BLASTINGS)
- 03. MARK THE CODE OF SHOP INCHARGE
- 04. SURFACE DEFECTS AND DEPRESSIONS DUE TO SCALES MAY BE ALLOWED UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE.
- 05. SHIFT OF AXES OF DIES MAY BE ALLOWED UPTO 2.0 MM.
- 06. DEVIATION FOR CONCENTRICITY OF BROACHED HOLE MAY BE UPTO 3.0MM
- 07. DIMENSIONS WITHOUT TOLERANCES NEED NOT BE CHECKED.
- 08. DIMENSIONS IN BRACKETS ARE GIVEN FOR MACHINING.
- 09. RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 2.0 MM.
- 10. PAINT RED OXIDE.

T-72 & T-90

MATERIAL	FORGING WT.	
38XC GOST 4543071	70.0 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-32	1:1
DRAWN	CHECKED	APPROVED
L. Ruff/m 10/9/03	MJ 10/9/03	S. D. J.
DRAWING NO.	172.40.310/F	
NOMENCLATURE:	CROWN GEAR OF THIRD PLANETARY GEAR SET	
HEAVY VEHICLES FACTORY AVADI, CHENNAI		