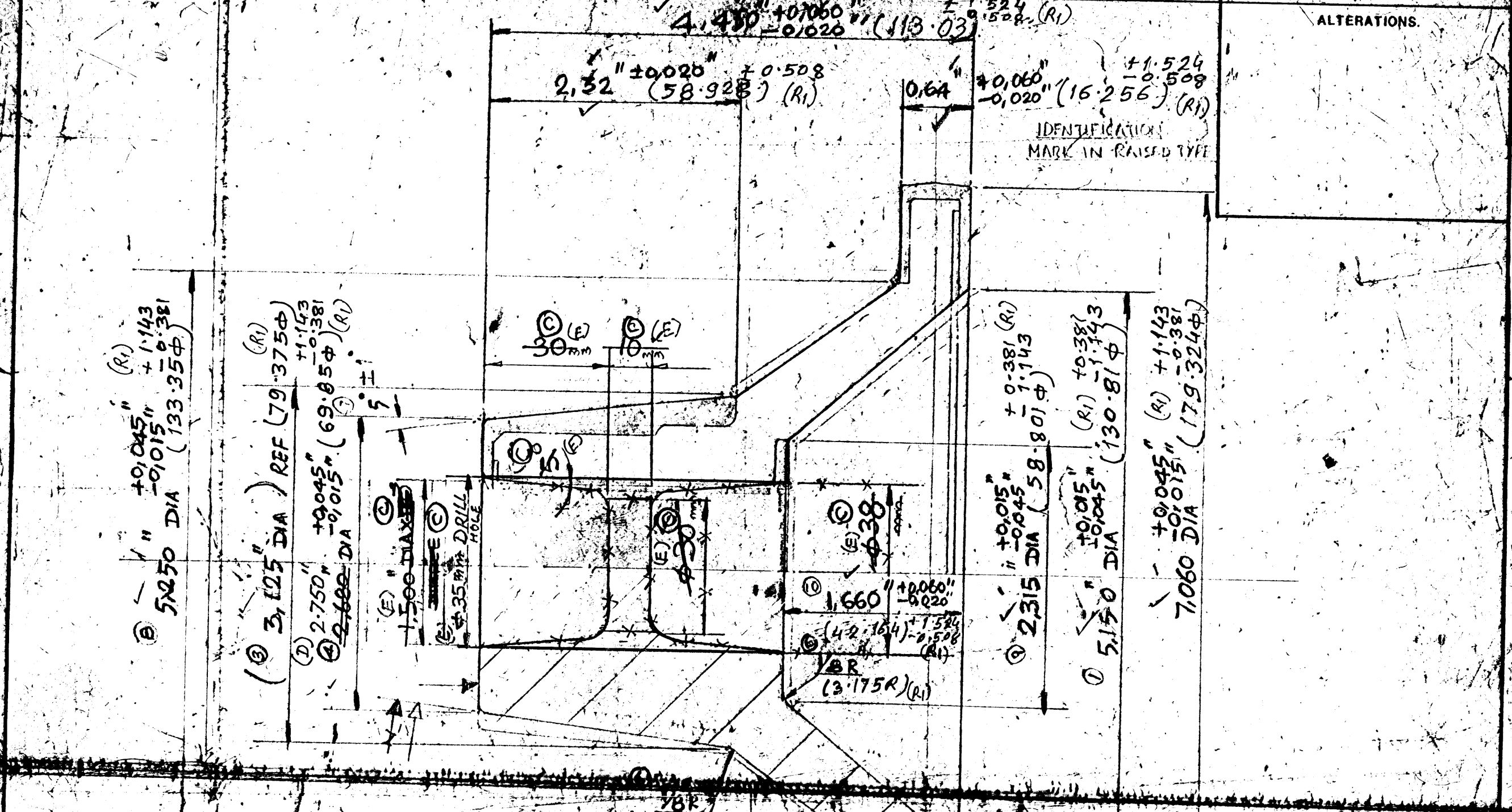


TITLE: STAMPING DRAWING		PART NO: F143311 (1681259)	DRAWN BY: 186	TOOL NO: 15-1143
FOR: DRIVING FLANGE		OPN: 1	CHECKED BY: 1	
ASHOK LEYLAND LTD. JIGS & TOOLS DRAWING OFFICE, ENNORE			DATE: 8/3/79	PROJECT: 1BT
ALTERATIONS:				



DIMNS. SHOWN IN BRACKET () ARE IN MILLIMETER.

THIS FORGING DRG. IS TO BE USED FOR THE COMPONENT DRIVING FLANGE (DRG. NO. F1434411) AND DRIVING FLANGE (DRG. NO. F1436211) AGB STALL ION

CHEM. COMP. OF EN16 IN %
 C = 0.30-0.40
 Si = 0.10-0.35
 Mn = 1.30-1.80
 Mo = 0.20-0.35
 S = 0.050 MAX
 P = 0.050 MAX

(R1)	CHEM. COMP. OF EN16 & CONVERSION OF INCH DIMS TO MM DIMS ADDED AS PER JE. GM/QT 4ND. 468/QT DRG. DT. 06-05-04. Per DL	12/04	JWM/TDO	2015/11/2 0169 HndJani	FOR INTERNAL DIMENSIONS REVERSE + AND - SIGNS
(E)	Hardness 248-302 BHN was 248-270 BHN, MICRO-TEMPERED MARTENSITE & 35° DRILL HOLE ADDED. PIERCE HOLE 30mm WITH RELETED DIM. DELETED AS PER HIS ASHOK LEYLAND LND. D&SV. VET. & LTY. TOT. 725 241502.01. & DISCUSSION WITH JE. GM/QT. Per DL	27/01	JWM/TDO	2015/11/2 0169 HndJani	
(D)	Dim 2.750" was 2.680" H.T. Hard. & Temp. to T' condition was Normalised & Hardness 248-270 BHN was 170-229 BHN change based on his ASHOK LEYLAND LND. Forging drg. modification (a) & (e) as per instruction. JE. GM/QT. Per DL	6/2000	JWM/TDO	2015/11/2 0169 HndJani	
C	DIM Ø38, Ø30, Ø10 & ANGLE 5° ADDED.	8/01	JWM/TDO	2015/11/2 0169 HndJani	
B	DIM 1.5" X 110° DIMPLE DELETED	15/01	JWM/TDO	2015/11/2 0169 HndJani	
A	(4) 2.315" DIA WAS 2.500" DIA (10) 1.660" WAS 1.555" (1) 170-229 WAS 241-281 BHN (1) 5.150" DIA WAS 4.890" DIA (2) 2.500" DIA WAS 2.240" DIA (2) 3.125" DIA WAS 3.370" DIA (2) 2.680" DIA ADDED (5) M/C ALLOWANCE REMOVED (6) 1/8" R WAS 1/4" R (7) 5° ± WAS 7° ±	28/2/80	JWM/TDO	2015/11/2 0169 HndJani	

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS	MATERIAL	EN 16	LOCATE
DRAFT EXTERNAL 5°	HEAT TREATMENT	NORMALISED (D) HARDENED & TEMP'D TO T' CONDITION	REST
ANGLE INTERNAL 10°	HARDNESS	248-270 BHN (D) 248-302 (E) BHN	CLAMP
CORNER RADIUS 1/8"	MICRO STRUCTURE	TEMPERED MARTENSITE	
FILLET RADIUS 1/8"	WEIGHT	(11.8 lbs) (APPROX)	

TOLERANCES		ASHOK LEYLAND LTD ENNORE MADRAS 57	
DIE WEAR TOTAL	+0.045 -0.015	JIG & TOOL DESIGN OFFICE	
DIE CLOSURE	+0.050 -0.020		
MIS MATCH	0.032		
FLASH EXTENSION	0.005		
STRAIGHTNESS	0.000		
CORNER RADIUS RADIUS	100% R/R		
DRAFT ANGLE	12/1/1		

DRN	BGN	DATE	PART NAME	DRIVING FLANGE
END	18/03/79	8/3/79	PART NO.	F143311 (1681259)
PROJ	18/03/79	18/03/79	PROJECT	1BT