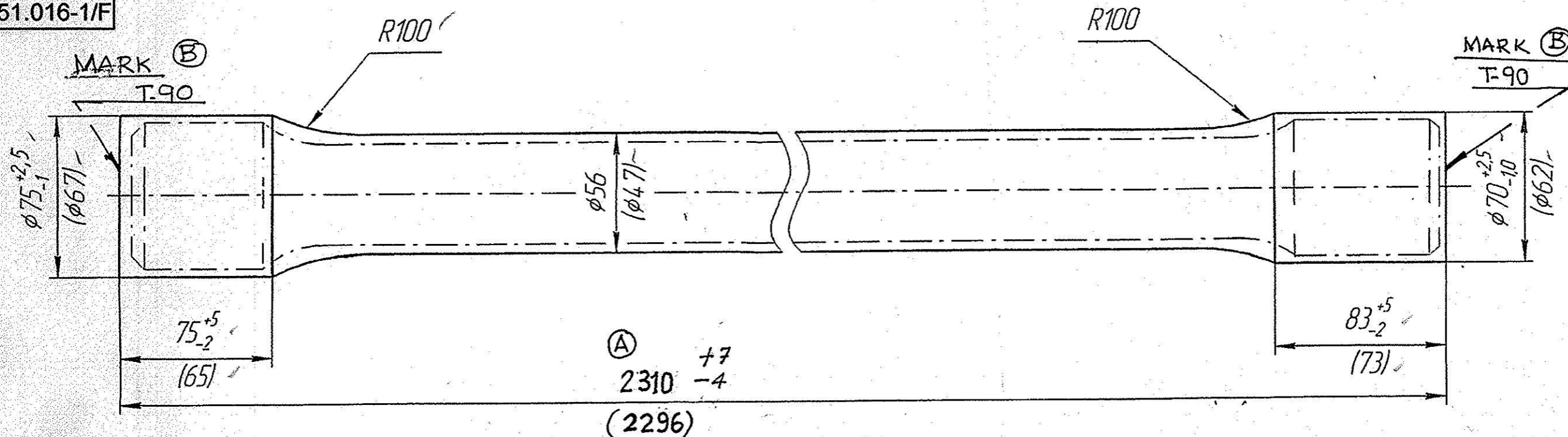


DRAWING NO.
172.51.016-1/F



TECHNICAL REQUIREMENTS

01. ≤ 256 HB. (ISOTHERMAL ANNEALING)
02. CURVATURE SHOULD NOT EXCEED 1.5 MM ALONG THE ENTIRE LENGTH OF ROD DIA 56.
03. CLEANING THE SURFACE DEFECTS AND RECESSES DUE TO SCALES NOT EXCEEDING 50% OF ACTUAL ALLOWANCE IS ALLOWED.
04. FORGED BURRS WITH DEPTH NOT EXCEEDING 2.0MM IS ALLOWED.
05. ELLIPTICITY OF HEAD SHOULD NOT EXCEED 2.5 MM.
06. RUN-OUT OF HEADS RELATIVE TO ROD SHOULD NOT EXCEED 3.0 MM, CHECKING OF RUN-OUT IS CARRIED FOR LENGTH 200 MM FROM END FACE OF HEAD. RUN-OUT OF HEAD IS CHECKED FOR LENGTH 50MM FROM END FACE
07. END FACE BURRS SHOULD NOT EXCEED 6.0MM.
08. BURRS ALONG THE PARTING LINE OF DIES SHOULD NOT EXCEED 2.0 MM.
09. SHIFT OF AXIS OF DIES ALONG THE PARTING LINE OF FEMALE (LOWER) DIE SHOULD NOT EXCEED 1.0 MM.
10. ELLIPTICITY IN PLACES OF PRESSINGS DUE TO DIE WITH MIN DIMENSION 54 MM IS ALLOWED.
11. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
12. DIMENSIONS WITHOUT TOLERANCES NEED NOT BE CHECKED.
13. MARKING THE CODE OF CHIEF, SERIAL NO. OF BATCH AND HEAT NO. IS ALLOWED (IN FRONT OF HEAT NO. STAMP WORD "W").

(B) 14. PAINT RED OXIDE. WITH YELLOW BAND

B IDENTIFICATION MARK - T-90 AND PAINT RED OXIDE WITH YELLOW BAND ADDED.

A TOTAL LENGTH DIMNS. 2310⁺⁷ WAS 2324⁺⁷. REF. JE.GM/RG LTR No. 07271/VP/RG/TORSION BAR/2003-04 Dt. 27.11.2003

FORGING ADDED IN NOMENCLATURE
 ≤ 256 HB ISOTHERMAL ANNEALING ADDED
 REF. RG ITR NO. 07271/RG/1
 T-90/TORSION BAR Dt. 04.02.10

ISSUE	MODIFICATION	DATE	ISS.	MODIFICATION	DATE

T 90

MATERIAL	FORGING WT.	T 90	
45XH2MΦAW GOST 4543-71	47.2 KGS		
ALT. MATERIAL	HAMMER	SCALE	
		NTS	
DRAWN	CHECKED	APPROVED	
1. 20/8/03			
DRAWING NO.	172.51.016-1/F		
NOMENCLATURE:	TORSION BAR FORGING		
HEAVY VEHICLES FACTORY			
AVADI, CHENNAI			