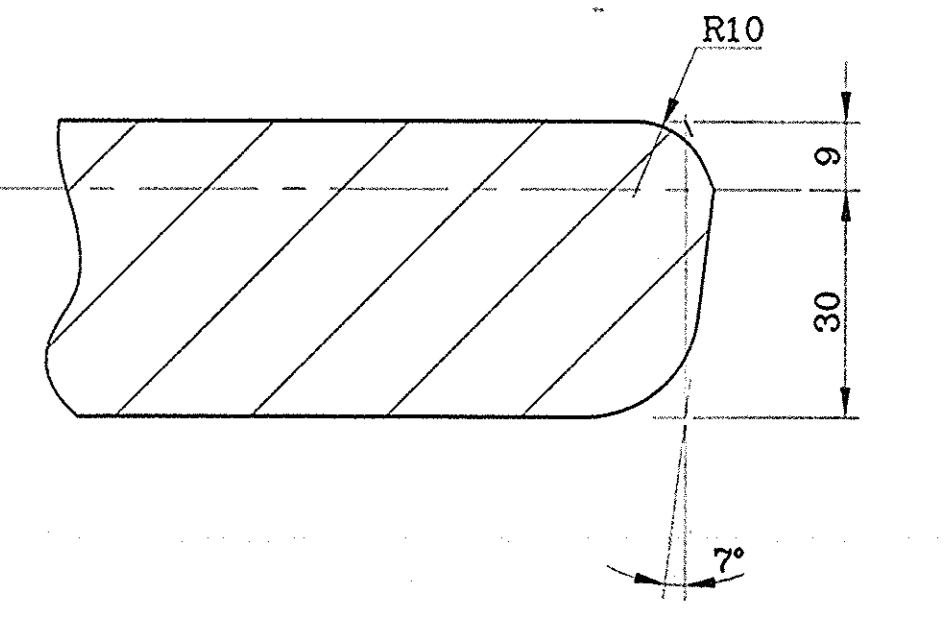
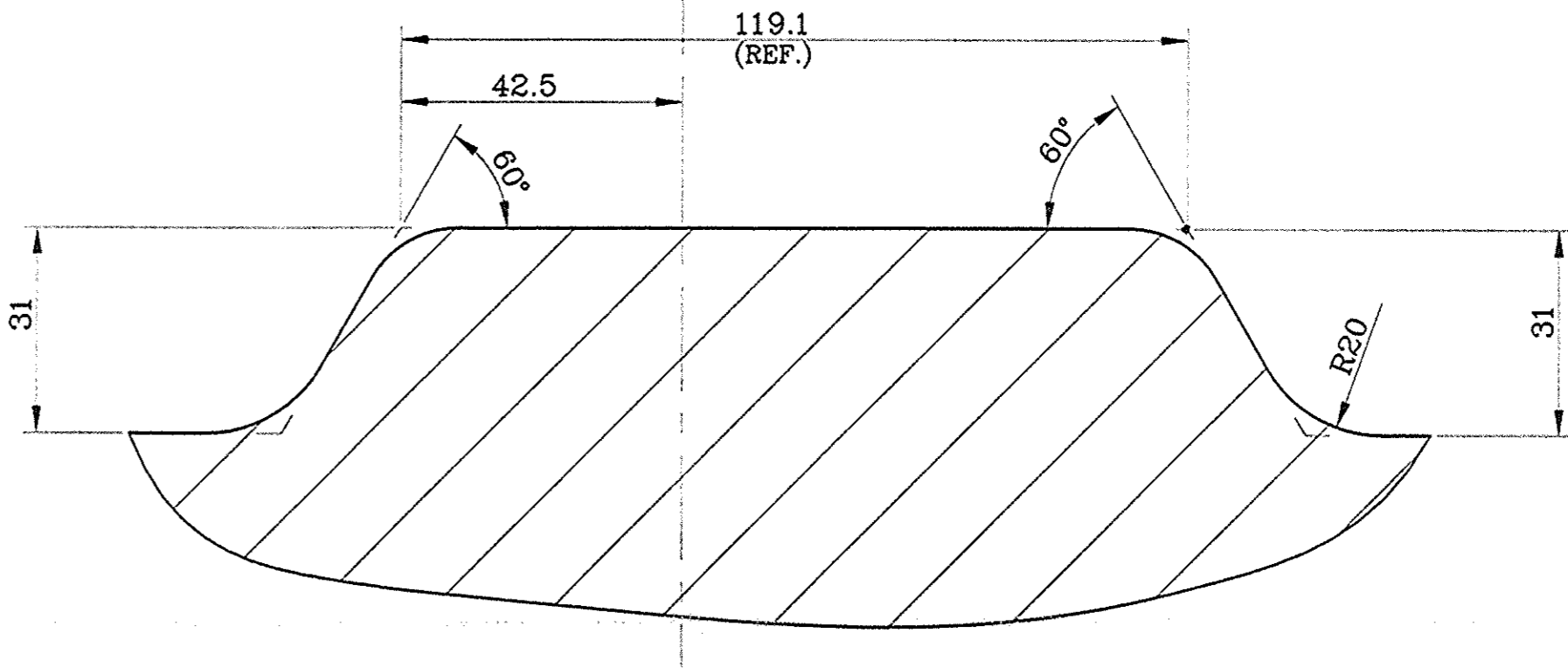
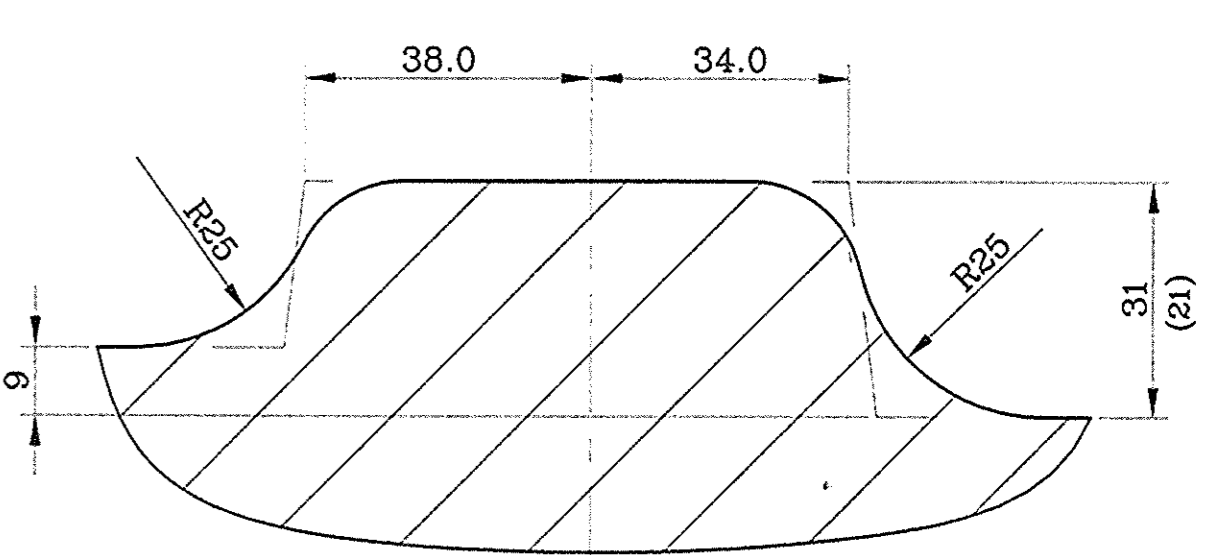
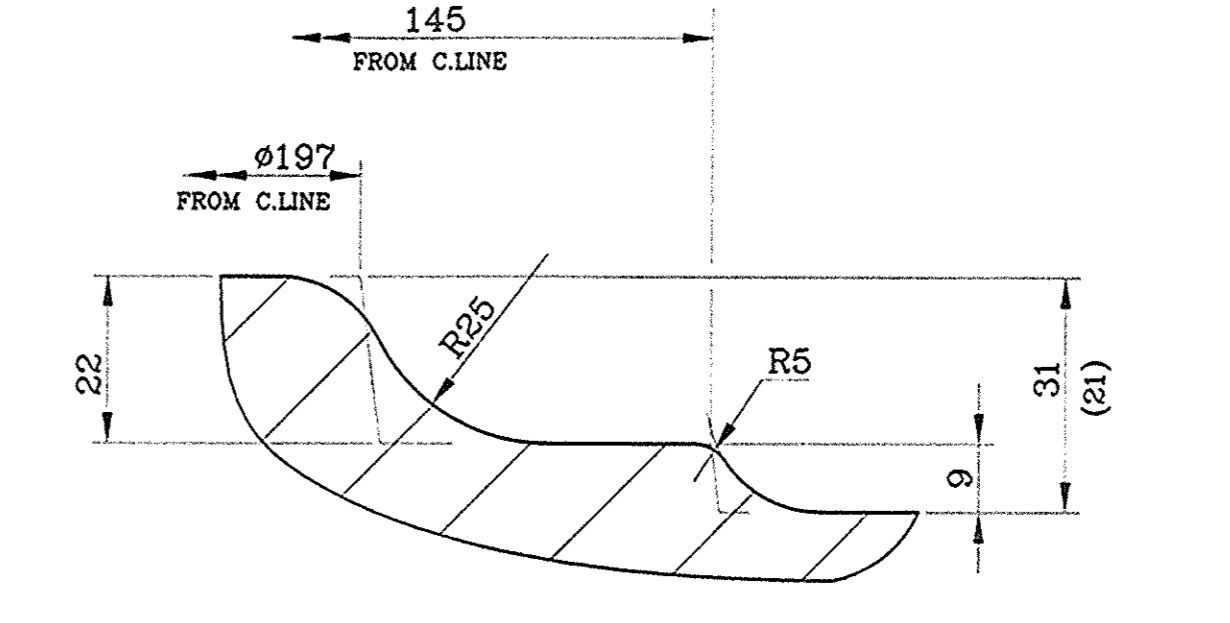
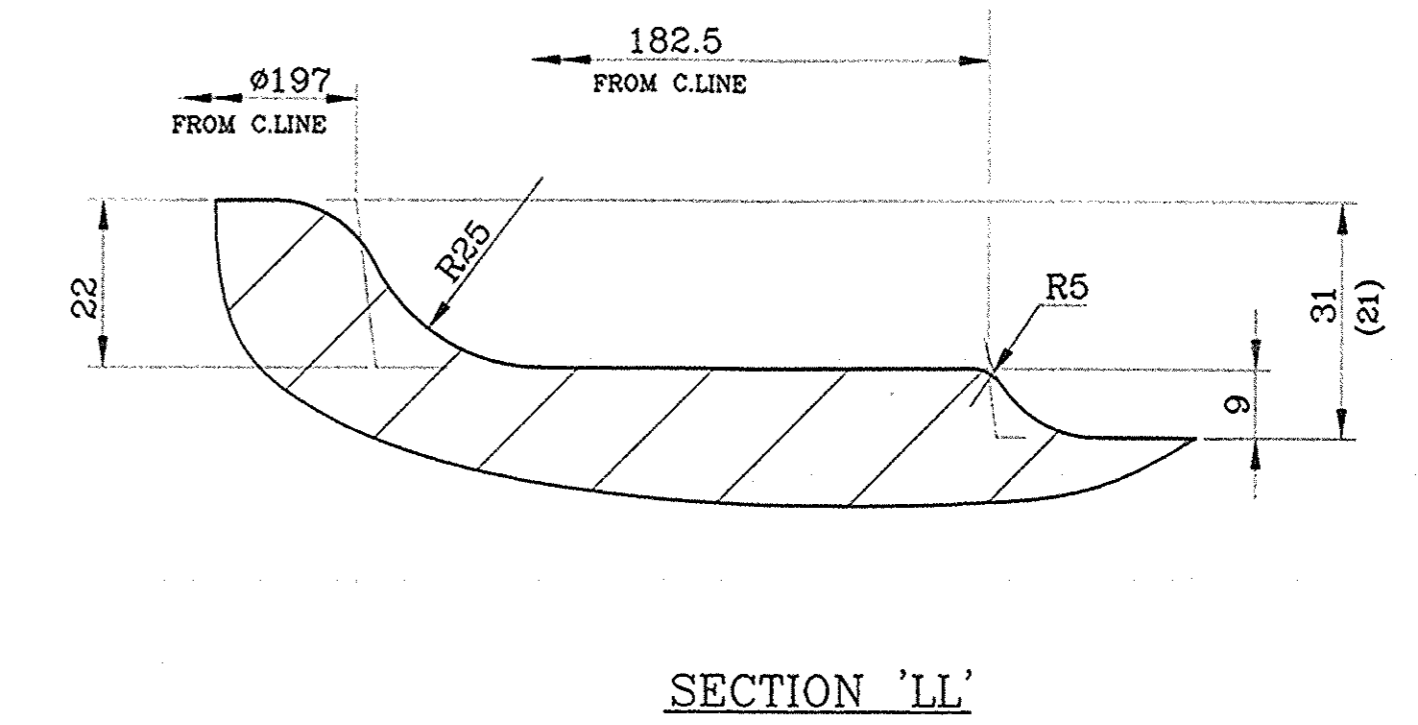
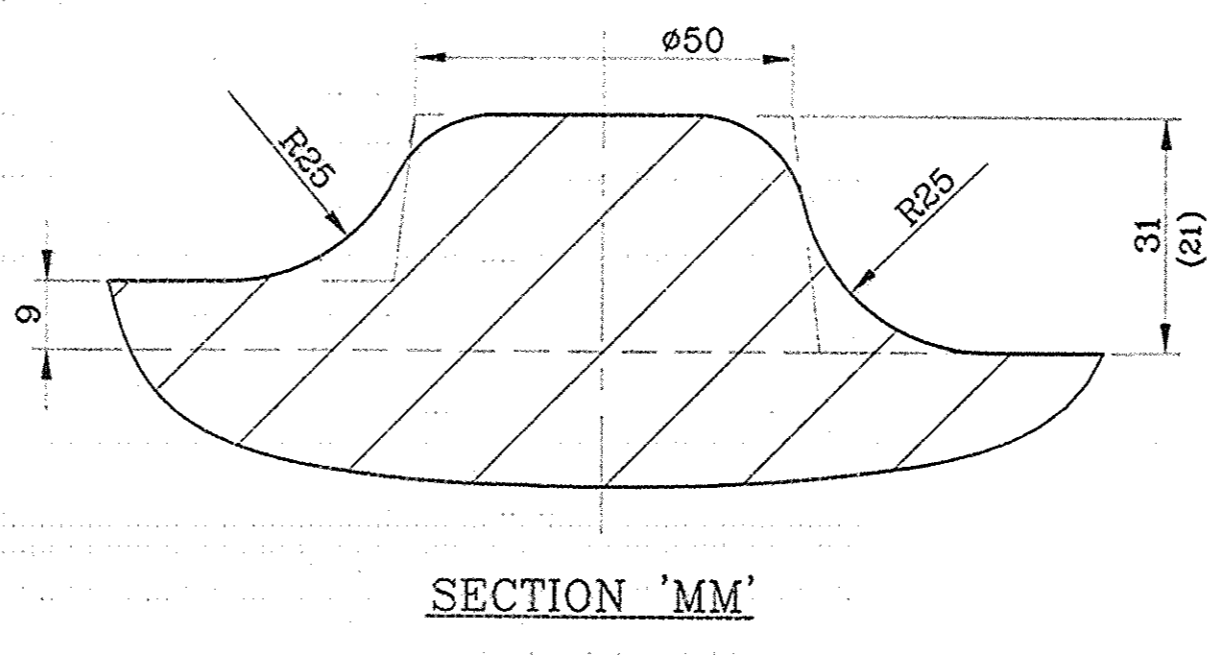
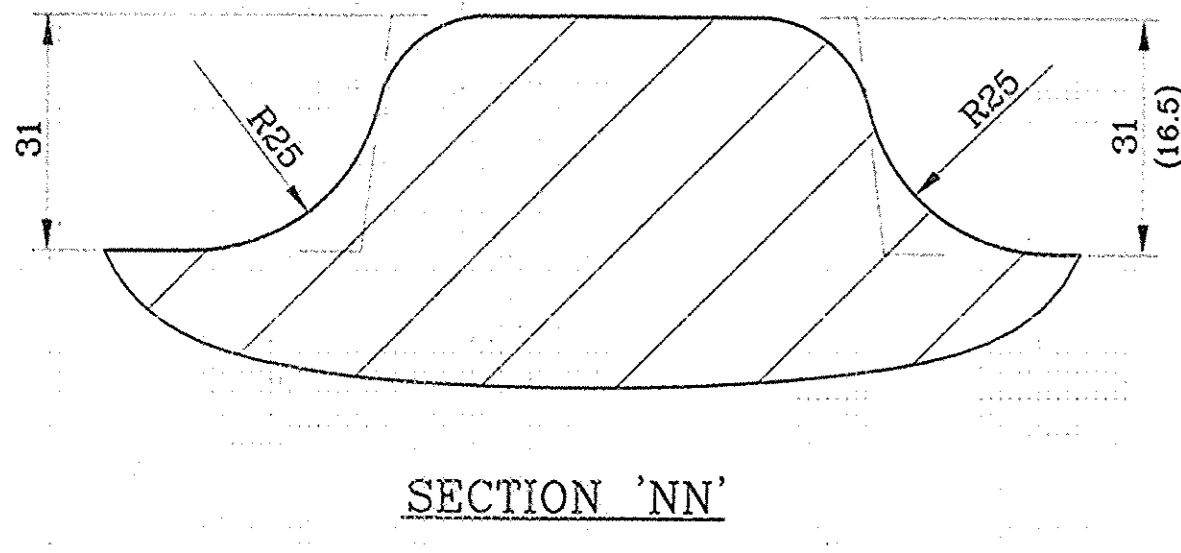
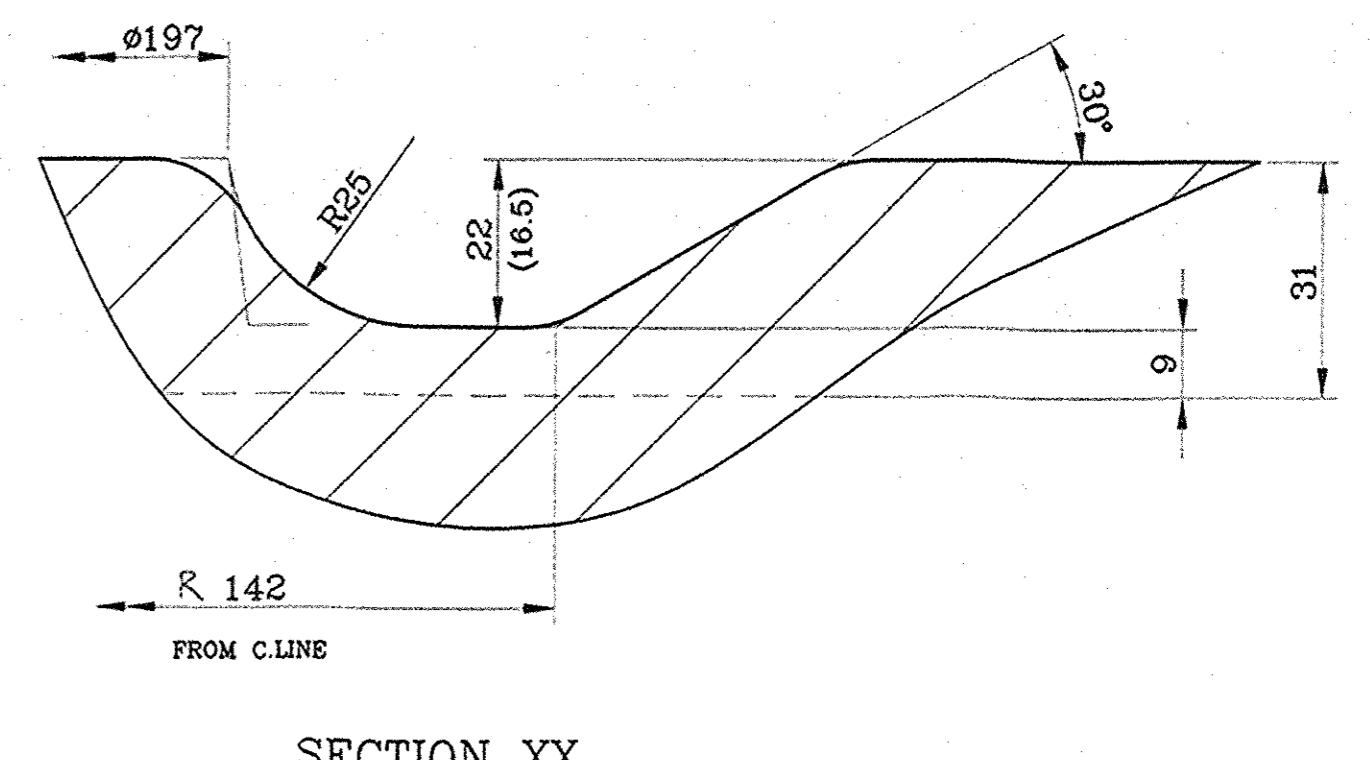
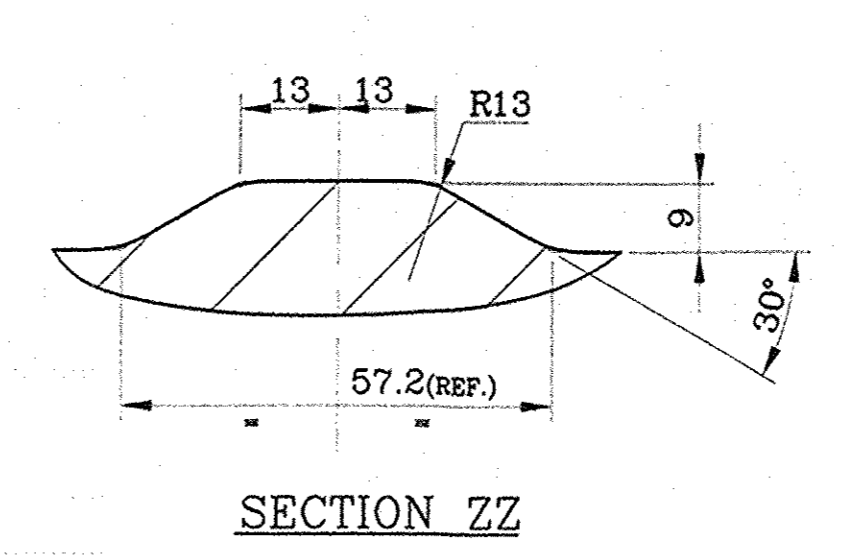
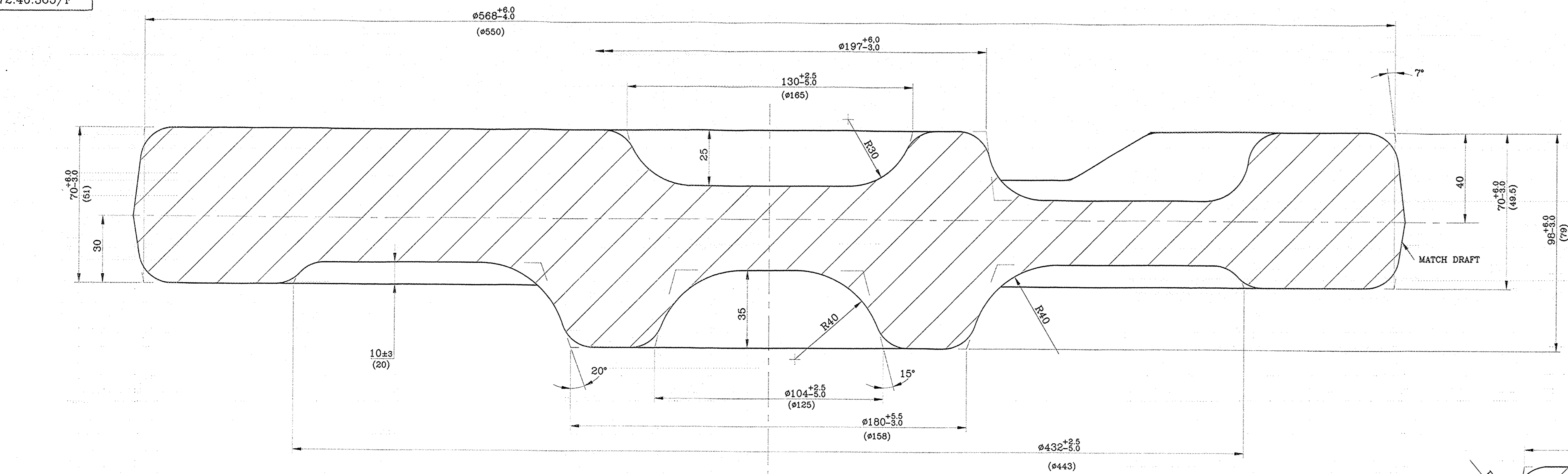


MODIFICATIONS & ADDITIONS		
ISSUE	MODIFICATIONS & 'N' OF 'A'	SIGN.
A	REDRAWN COLLABORATOR FORGING DRO HAS BEEN MODIFIED IN LINE WITH COMPONENT DRG. 172.40.0634/SSB.	
B	IN LINE WITH H7/D7 BOOK, MBE Trade Supplies in Normalised Condition in selected HANDS AND TENSILE MARKS RE SUMITRACAS JIN. NO. HVF/07/072074 & 64/Steel/Forge d 13.11/15	



**TECHNICAL REQUIREMENTS:**

- STEEL GRADE. 30XGCA GOST 4543-71
- 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
- 228...269 HB (HARDEN & TEMPER) ⑤
- 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 CONTROL CUTTING) IS ALLOWED ON NON-MACHINING SURFACES. OCCASIONAL FOLDERS AND DENTS WITH DEPTH UP TO 3.0MM IS ALLOWED IF THE DEPTH OF SURFACE DEFECTS EXCEEDS THE MACHINING ALLOWANCE. REMOVAL OF THEM IS CARRIED OUT BY CONTROL CUTTING WITH SUBSEQUENT WELDING AS PER INSTRUCTIONS ADK 25090.00016
- 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.

MATERIAL	FORGING WT.	SCALE
30XGCA GOST 4543-71	110 KGS	1:1
ALT. MATERIAL	HAMMER	
DRAWN	CHECKED	APPROVED
DRAWING NO. 172.40.365/F NOMENCLATURE: L.H. FRONT FLANGE HEAVY VEHICLES FACTORY AVADI, CHENNAI		