

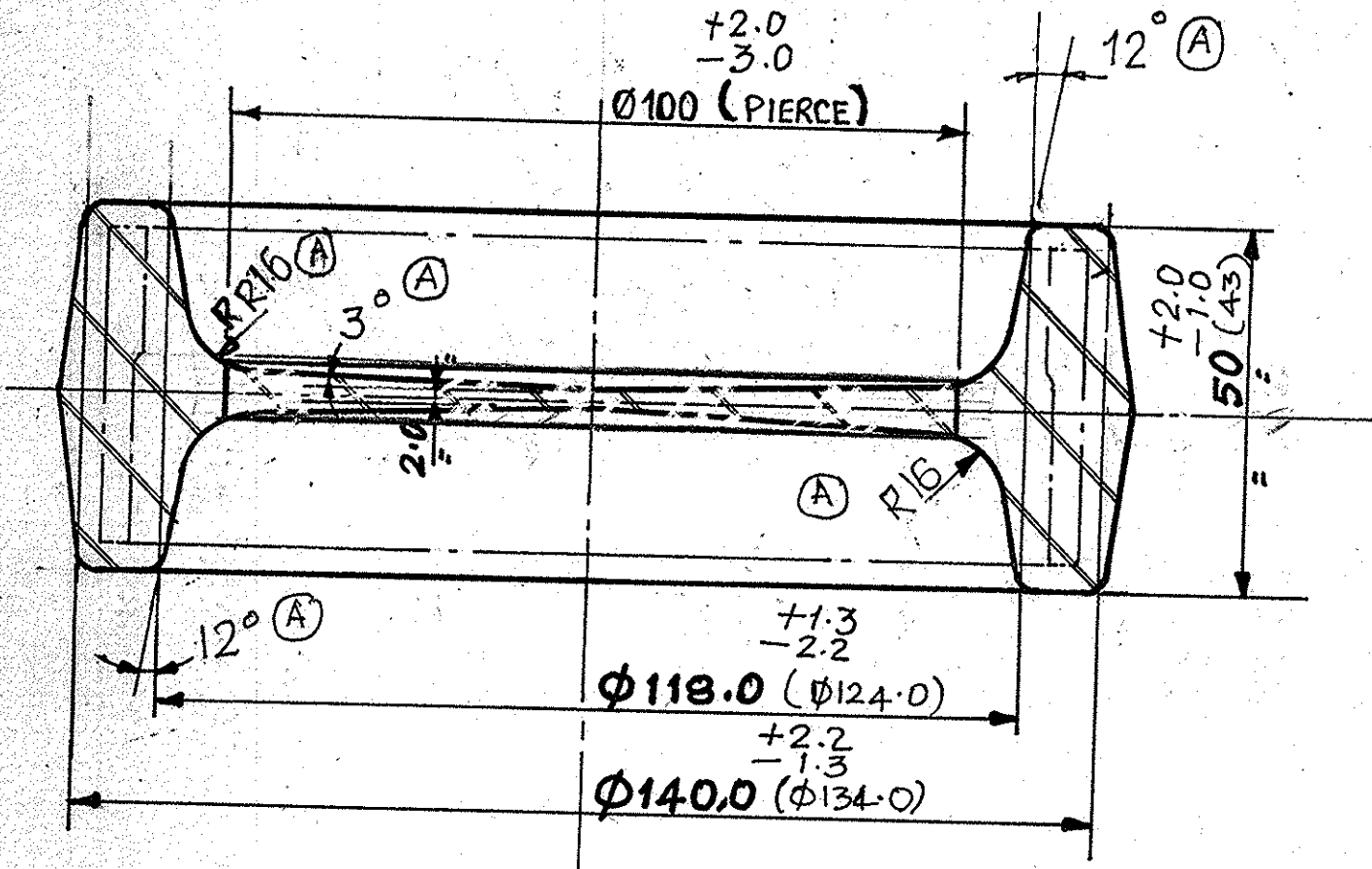
DRG. No.

172-52-126

UNSPECIFIED TOLERANCE ON DIMENSIONS
 UNMACHINED ±0.8 MACHINED ±0.25 ANGULAR 30°-15°

SURFACE FINISH
 ▽ R_a 1.6 TO 3.2
 ▽ R_a 0.4 TO 1.6
 ▽ R_a 0.1 TO 0.25
 ▽ R_a < 0.1

MODIFICATIONS & ADDITIONS
 ISSUE MODIFICATION & N OF A SIGN. DT.
 A INT. DRAFT 12° WAS 10°, RADIUS 16mm VAR 12mm. 3° TAPPER WAS 2° AVOIDING PRODUCTION PROBLEM. REQUEST BY FS. 19/8/66



TECHNICAL REQUIREMENTS

- HEAT TREAT. DIA OF IND. 3.4 To 3.7
- DESCALE
- SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL ALLOWANCE ARE ALLOWED
- MISMATCH SHOULD NOT EXCEED 0.5
- RESIDUAL FIN SHOULD NOT EXCEED 0.5
- BUCKLING SHOULD NOT EXCEED 0.7
- UNSPECIFIED DRAFTS 7°
- UNSPECIFIED RADIUS 3.0mm
- MARK PART No.
- MACHINING DIMS ARE SHOWN IN BRACKETS
- UNTOLERANCED DIMS ARE FOR CONSTRUCTION

MATL : 38 XC . (GOST-4543-71)

ITEM No	DESCRIPTION	QTY	MATERIAL	TREATMENT	SIZE EACH/	REMARKS
SCALE	COMPONENT NOS.	7-72				
1:1	172-52-126/(HOLDER)	2.40 kg	M.P.M			
DIMENSIONS ARE IN MM. WELMENTS TO BE STRESS RELIEVD. GAUGING MEMBERS TO BE STABILISED. TOOLS TO BE TRIED AND PROVED BEFORE ISSUE. BURRS AND UNWANTED SHARP EDGES TO BE REMOVED						FORGE SHOP PLANNING AYADI, MADRAS-600 011
DGN डिजा.	CHD ऑन	APPRD अनु.	AUTH'D प्रावि			
FORGING DRG				DRG. No. 172-52-126/F		
				ISSUE		

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Haleem
6-11-92