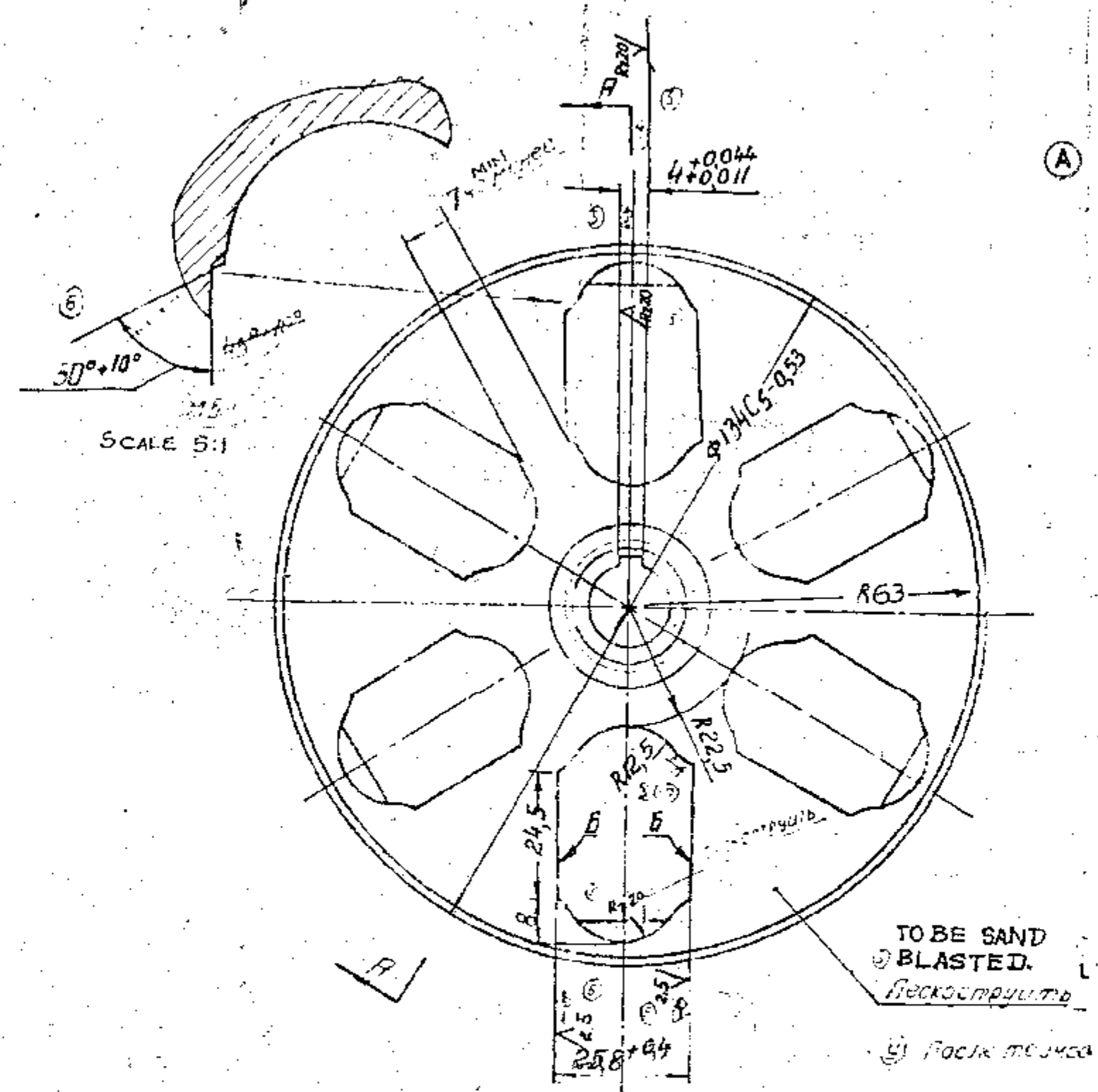
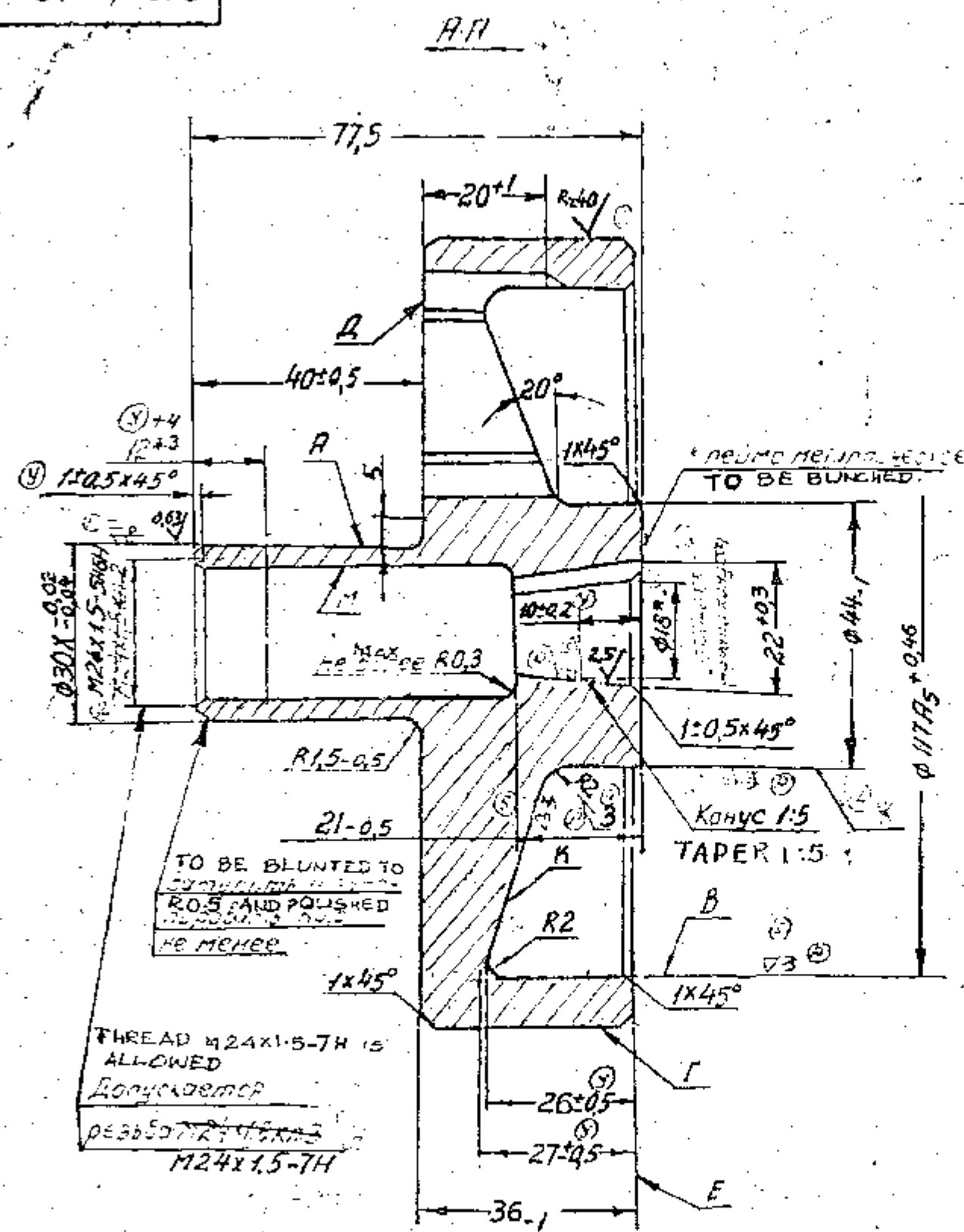


315 611-2



1. Inspection group III, TT-11.
2. Surfaces A and B should be carburized to a depth of not less than 0.5 mm.
3. It is permitted to case-harden all over to a depth  $\leq 1.3$  mm except surface M. HRC 51
4. HRC 56 on surface B and HRC 50 on surface A. HRC 57
5. Dimensions with unspecified tolerances should be obtained as per standard 82050-07.
6. Technical requirements for thread as per standard 82021-00.
7. Run-out of end portion of surface A relative to the taper should not exceed 0.1 mm.
8. Run-out of surfaces B and Γ relative to the taper should not exceed 0.5 mm.
9. Run-out of surfaces D and E relative to the taper should not exceed 0.3 mm on dia. 130 mm.
10. Run-out surface K relative to the taper should not exceed 0.5 mm on dia 100 mm.
11. Shift of key-way axis relative to the taper axis should not exceed 0.04 mm. (MMC)
12. Shift of axis of symmetry of slots B from taper diametrical plane should not exceed 0.2 mm.
13. On surface A grinding wheel mark is allowed at a distance of 5 mm; min, from the shank.
14. Taper 1: 5 is to be checked by blueing. fitting should be uniform and should cover not less than 80% of the entire area.
15. Finally finished component should be balanced. For this purpose it is allowed to remove excessive metal in any place at dia 117 A5.
16. Unbalance upto 6 gr is allowed at R 67 mm.
17. Sharp edges should be blunted.
18. Coating:- Chemical oxidizing, oil finishing.
19. May be manufactured from steel 20 X Gost 4543-71.

20. After heat-treatment buckling of surfaces B and Γ by upto 0.5 mm, beyond the limit diameters is allowed.
21. After heat-treatment, roughness Rz 20 is allowed on surfaces B.
22. \*Dimension is to be ensured with tool.
23. Cutting-in along radius 3 to 0.5 mm., max is allowed on surface \*

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THIS #.	
1.762 Kg		LETTERS)	
B	15.2.88 AUTHY BK 83-672	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
A	23.11.87 AUTHY BK 82-394		
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN	SCALE - 1 : 1	MATERIAL - STEEL 20	USED ON: 15 327 00 45
CHD		GOST 1050-74	
TCDD		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPO		TITLE - GOVERNOR SLOTTED DISC	
DATE		D S CAT NUMBER	DRAWING NUMBER
11.5.86			315 611 2

