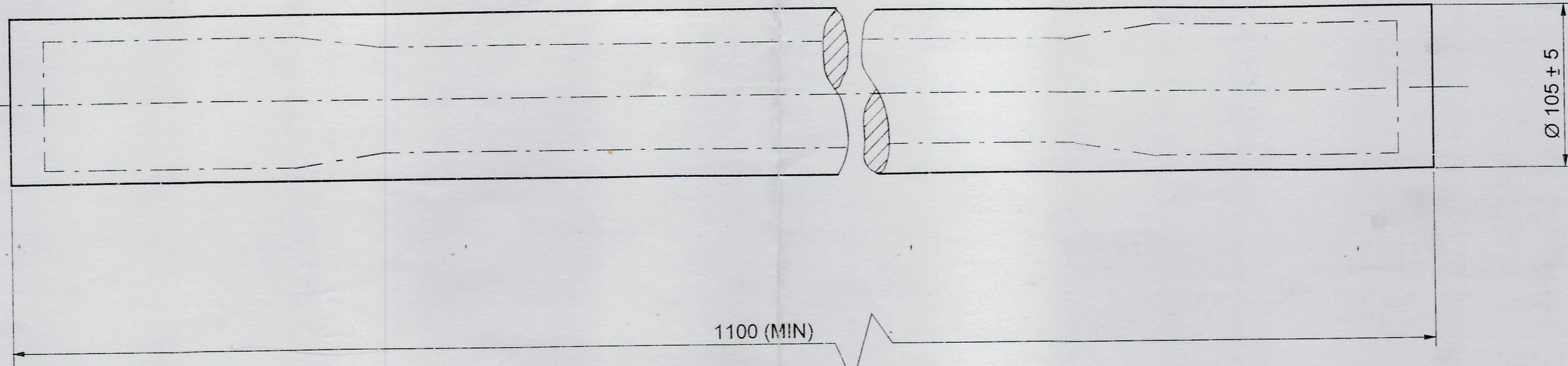


PART No.
**M46-18-180 &
M46-18-181**

DRG CONVENTIONS CONFORM TO IS : 696
DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED
TOLERANCE FOR UNTOLERANCED LINEAR DIMNS FOLLOWS IS:2102 (MED CL)

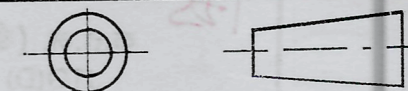


MATERIAL :- IS:4367-1991 GRADE 40Ni10Cr3Mo6 (HEAT TREATED TO RULING SEC 150mm) WITH PHYSICAL PROPERTIES AS UNDER:-
YIELD STRENGTH - 800 MPa (min)
UTS - 1000 TO 1150 MPa
ELONGATION - 12% (min)
IZOD IMPACT - 48 (min)

NOTE :-

1. ALL THE FORGING SHOULD BE ULTRASONICALLY TESTED ALL THE FORGING SHOULD BE CONCENTRIC i.e. FREE FROM DISTORTION OR BEND (BEND NOT TO BE EXCEED 0.02 mm ONE SAMPLE TO BE TRIED BEFORE BULK SUPPLY
2. DRG IS PROVISIONAL AND FOR REFERENCE PURPOSE ONLY
3. STORE BE MANUFACTURED AND ACCEPTED AS PER SEALED SAMPLE AFTER SATISFACTORY FITMENT / FUNCTIONAL TRIAL
4. ANY CHANGE IN DRG DURING MANUFACTURING OF STORE MANUFACTURER SHOULD INTIMATE THE SAME TO AHSP i.e. CQA(W)
5. FOR MACHINING PLEASE REFER DRG TO PART No M46-18-32

BASED ON SKETCH FH - 101

10-10-17			19617-W	NOTE SL No. 5 ADDED & MATERIAL AMENDED.	SIG. AHSP	SIG. DO	DRAWN:-	CHD:-	ASSY DRG:- M46-ASSY-18	CQA(W), JABALPUR 	
25-7-15			19436-W	DRG. PROV. SEALED.	SIG. AHSP	SIG. DO	SCANNED:- PKA	CHD:- <i>Prisham</i>	DATE:-		
10-7-15				SCANNED & PRINTED WITHOUT CHANGE	SIG. AHSP	SIG. DO	H.C.S	DO	SCALE:- NTS		
DATE	AUTHORITY	ZONE	AMENDMENTS			SIG. AHSP	SIG. DO	MATERIAL:- AS ABOVE	FOR CQA(W)	ESTD mass:-	DESIGN No. CQA / WPN / 2709
PREV DC Nos:-							PROTECTIVE FINISH:-				PART No. M46-18-180 & M46-18-181
DRG SEALED PROV:- 19436-W DATE:- 25-7-15							DO COA(W)				DS CAT No.
FOR - TORSION SHAFT RH / LH (FORGING)											