

**TECHNICAL REQUIREMENTS.**

01. ACCURACY CLASS OF FORGING T5, STEEL GROUP M2, LEVEL OF ACCURACY C4, STARTING INDEX C 22 DIFFICULTY LEVEL C4, AS PER GOST 7505-89.
02. FORGING GROUP II AS PER GOST. 8479-70
03. MARK THE CODE OF CHEIF.
04. 217...269 HB.
05. DESCALES (SHOT BLASTING
06. ON THE MACHINING SURFACE OF FORGINGS, OCCASSIONAL DEFFECTS WITHOUT THEIR ELIMATION ARE ALLOWED, IF THEIR DEPTH IS DETERMINED BY CONTROL CUTTING AND DOESN'T INCREASE 0.5 OF ACTUAL MACHINING ALLOWANCE.
07. SHIFT THE AXIS OF DIE IS UPTO 3.0 MM.
08. PERMISSIBLE VALVE OF RESIDUAL FIN IS UPTO 4.0 MM.
09. PERMISSIBLE DEVIATION FROM FLATNESS IS UPTO 2.5 MM.
10. UN-SPECIFIED RADIUS R 12.
11. UN-SPECIFIED EXTERNAL DRAFT ANGLE 7°
12. PERMISSIBLE DEVIATION OF SHAPE AND POSITIONING OF SURFACES IS INDEPENDENT AND DOESN'T DEPEND UPON TOLERANCES AND PERMISSIBLE DEVIATION OF FORGING DIMENSIONS
13. PAINT RED OXIDE.

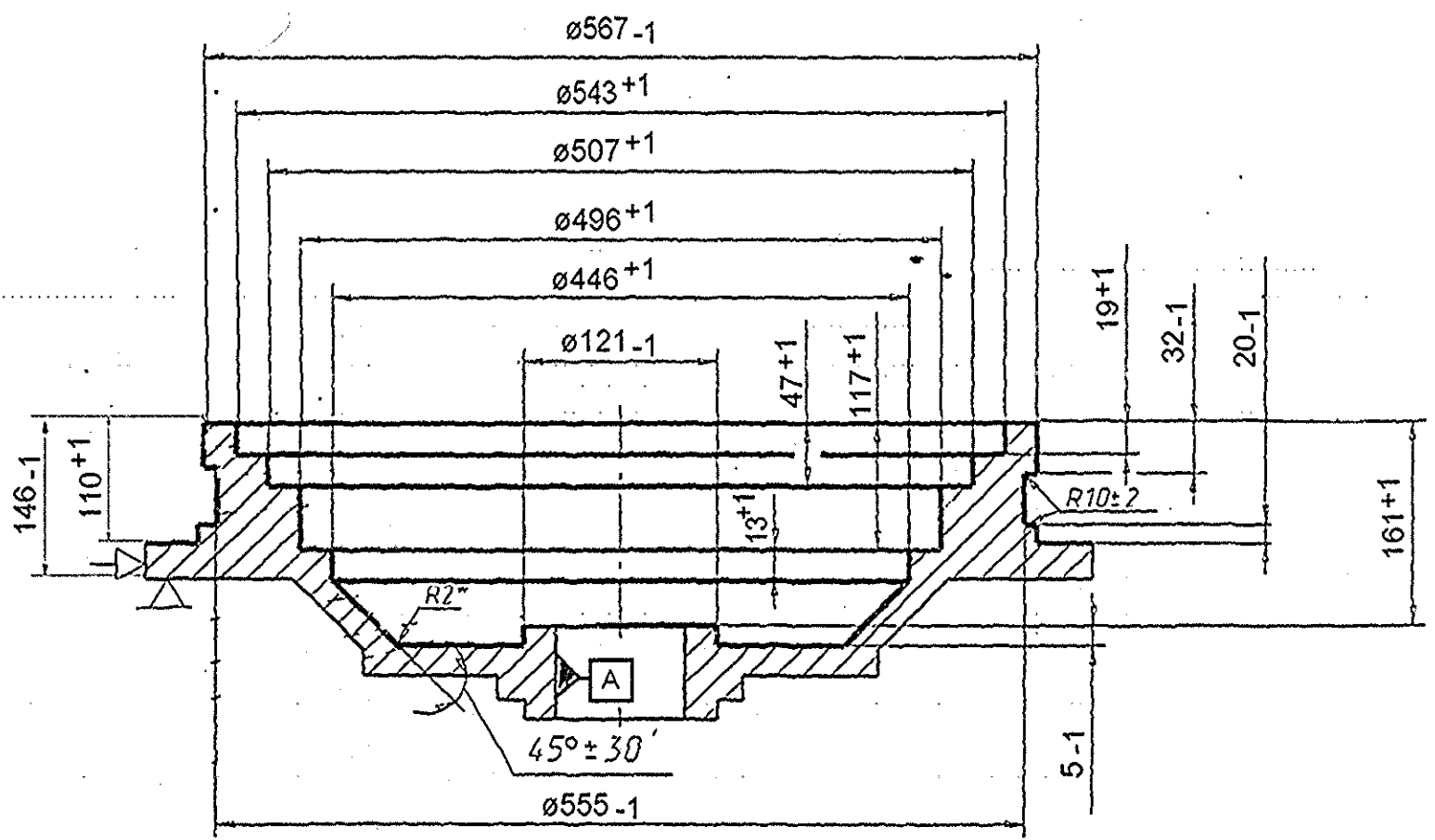
NOTE:-  
TRADE SUPPLIES IN NORMALISED CONDITION  
FORGING IS COMMON FOR COMPT.  
172.40.373/F

T 90

MATERIAL	FORGING WT.	
30XGCA GOST 4543-71	220 KGS Ⓐ	
ALT. MATERIAL	HAMMER	SCALE
		NTS
DRAWN	CHECKED	APPROVED
<i>L. Duff</i> 11/10/03	<i>M. J.</i> 11/10/03	<i>S. M. L.</i>
DRAWING NO.	172.40.372/F	
NOMENCLATURE:	R.H REAR FLANGE	
<b>HEAVY VEHICLES FACTORY</b> AVADI, CHENNAI		

REV	A	FORGING WEIGHT IS 220 Kg WAS 190 Kgs. REF. JWM/FS Lt NO: 05610/FS/78/2009-10 of 01.7.09	<i>M. J.</i> <i>L. Duff</i> 4.7.09
REV		MODIFICATION & NO OF A	<i>S. S. IGM</i>

Rz80  
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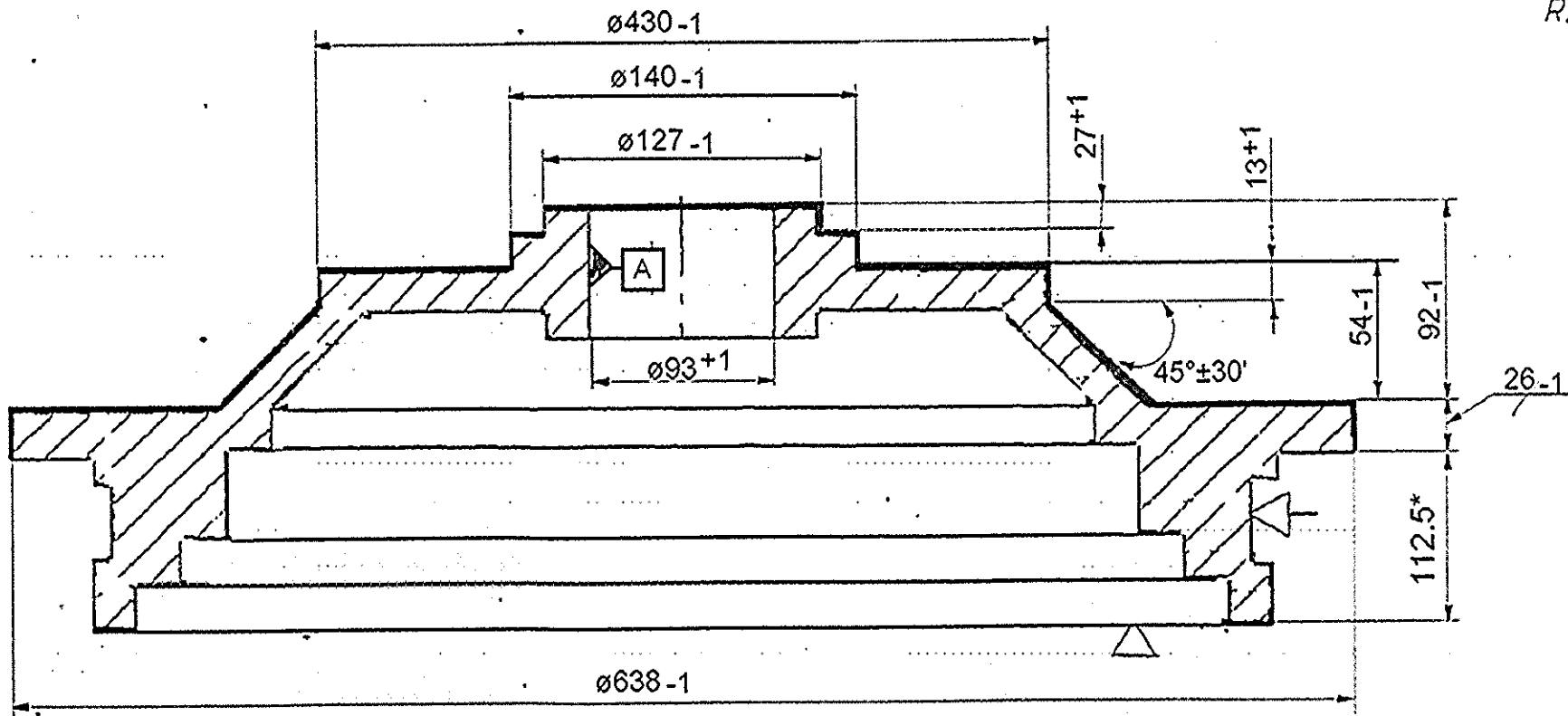
NOTE:

1) RUN OUT OF ALL INSIDE & OUTSIDE DIAMETER WITH REFERENCE TO 'A' SHOULD BE WITH IN 0.5mm

DRG. NO	: 172.40.372/SMF, RH/REAR FLANGE
OPN. NO.	: 010 TURNING
MATERIAL	: STEEL FORGING 30X7C
HARDNESS	: 280 BHN Max.
SHEET NO.	NOT TO SCALE

 PREPARED [V. JAYARAMAN] JWM/TRG	 CHECKED [D. YUVARAJ] CM/TRG	 APPROVED [K. DURAJ RAJ] JWM/TRG (MS)
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NOTE:

- 1) RUN OUT OF ALL INSIDE & OUT SIDE DIAMETER WITH REFERENCE TO 'A' SHOULD BE WITHIN 0.5 mm
- 2) \* - DIMENSION FOR REFERENCE

DRG. NO	: 172.40.372/SMF, RH-REAR-FLANGE
OPN. NO.	: 020 TURNING
MATERIAL	: STEEL FORGING 30X7C
HARDNESS	: 280 BHN Max.
SHEET NO.	
	NOT TO SCALE

 PREPARED M. S. V. Jmm/TRG	 CHECKED D. YUYARAJ CM/TRG	 APPROVED K. DURAIRAJ Jmm/TRG (HOS)
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