



TECHNICAL REQUIREMENTS

- 01. 286...341 HB.
- 02. BURRS ALONG THE PERIMETER OF CUT NOT EXCEEDING 1.5 MM MAY BE ALLOWED, CONTINUOUS OR STAMPED BURR ALONG THE CONTOUR AND IN HOLE IS ALLOWED.
- 03. DISPLACEMENT ALONG THE PARTING LINE OF DIE IS ALLOWED UPTO MAX. 1.2 MM.
- 04. NON-FLATNESS UPTO MAX. 1.0 MM IS ALLOWED.
- 05. MISALIGNMENT OF DIA 80 WITH RESPECT TO DIA 89 IS ALLOWED UPTO 2.0 MM.
- 06. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS AND ALSO SLANTED CUTTING AS FINISHING OF DEFECTS IN DEPTH NOT MORE THAN 50% OF ACTUAL ONE SIDE MACHINING ALLOWANCE MAY BE ALLOWED.
- 07. MARKING OF PART NUMBER IS ALLOWED.
- 08. UN-SPECIFIED FILLET RADII - 3.0 MM.
- 09. STAMPING DRAFTS : OUTER 7°, INNER 10°.
- 10. DIMENSIONS IN BRACKETS ARE MEANT FOR MACHINING.
- 11. DIMENSIONS WITHOUT TOLERANCES ARE FOR DIE.
- 12. DE-SCALES (SHOT BLASTING).
- 13. FORGING ACCURACY CLASS II, GRADE OF STEEL M2, CATAGORY OF COMPLEXCITY C4 GOST 7505-89.
- 14. PAINT RED OXIDE.

T 90

MATERIAL	FORGING WT.	
38XC GOST 4543-71	13.30 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-13	NTS
DRAWN	CHECKED	APPROVED
<i>L. Duffa</i> 27/8/03	<i>M. S.</i> 28/8/03	<i>S. D.</i>
DRAWING NO. 172.40.317/F		
NOMENCLATURE: CARRIER CHEEK		
HEAVY VEHICLES FACTORY AVADI, CHENNAI		