



CHEM. COMP. OF EN 24 IN % AS PER BS-970

FOR INTERNAL DIMENSIONS REVERSE + AND - SIGNS

$C = 0.35 - 0.45$ $S = 0.050 \text{ MAX}$
 $Si = 0.10 - 0.35$ $P = 0.050 \text{ MAX}$
 $Mn = 0.45 - 0.70$
 $Ni = 1.30 - 1.80$
 $Cr = 0.90 - 1.40$
 $Mo = 0.20 - 0.35$

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS.		MATERIAL	EN 24, BS: 970 (R1)	→ LOCATE
DRAFT	EXTERNAL 5°	HEAT TREATMENT	ISO THERMAL ANNEALING	→ REST
ANGLE	INTERNAL 10°	HARDNESS	241 BHN. MAX.	
CORNER RADIUS	3/32"	MICRO STRUCTURE	-	→ CLAMP
FILLET RADIUS	1/8"	WEIGHT	4.2 lbs (APPROX)	

TOLERANCES

DIE WEAR [TOTAL]	+0.015" -0.015"
DIE CLOSURE	+0.080" -0.009"
MISMATCH	0.025"
FLASH EXTENSION	CLOSE TRIM
STRAIGHTNESS	0.020"
CORNER & FILET RADII	+50% - 25%
DRAFT ANGLE	+2° - 1°
ECCENTRICITY OF PARTICLE	0.04" (0.02" TIR)
SURFACE	0.020"

ASHOK LEYLAND LTD ENNORE MADRAS-74

JIG & TOOL DESIGN OFFICE

19/19	SIGN	DATE	PART NAME	SLIDING DOG CLUTCH
DRN	Bb	11/31/77	PART NO.	F1631011 (53211AC)
CHD	<i>[Signature]</i>	26/4/79	PROJECT	COMPL
A+B	<i>[Signature]</i>	26/4/79	DRAWING NO	P-S1631011(R2)

CAB NO. 13/1-1058

AGB 1/1 Roll No (1) (19) (5) A-F 1-4 A3