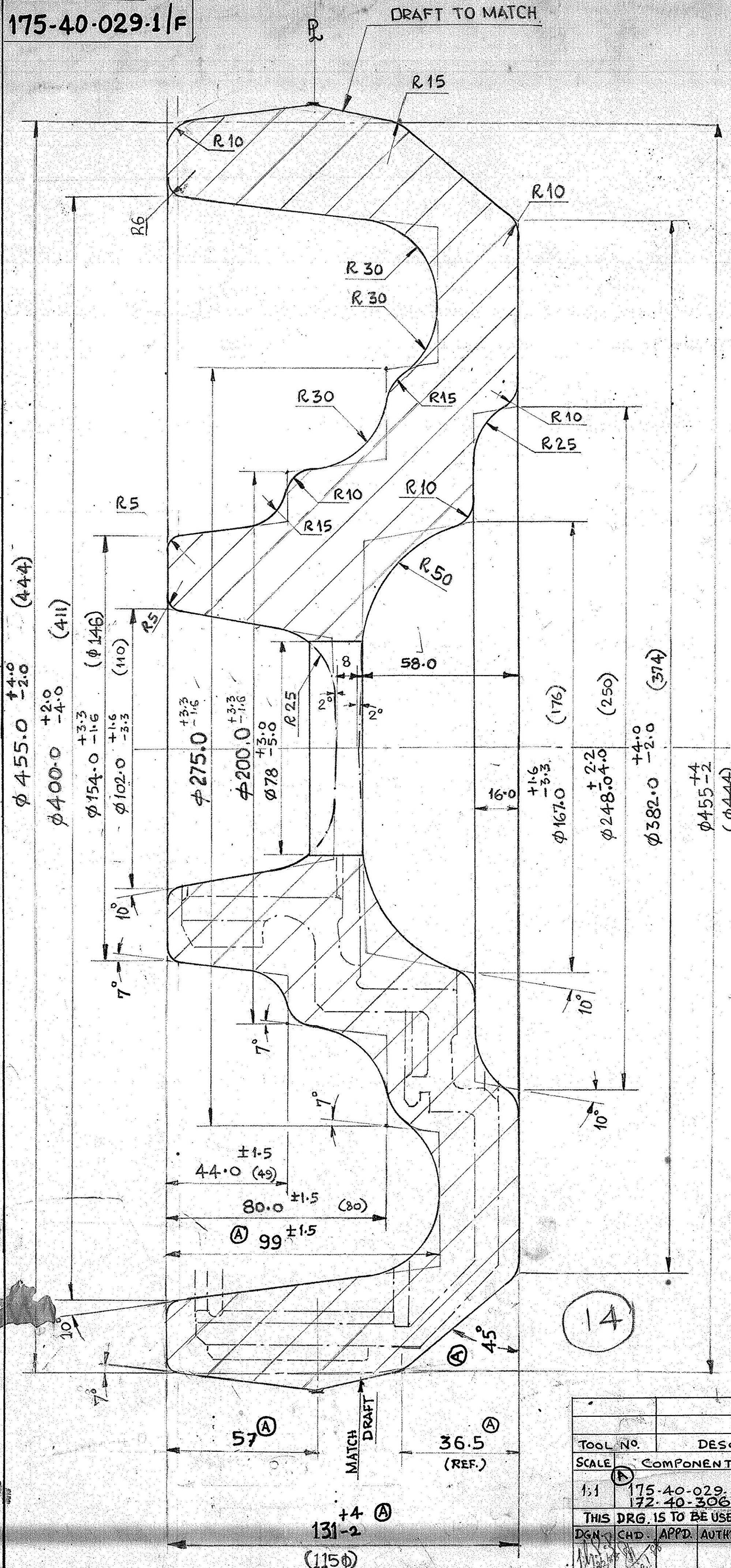


DRAWING NO.  
175-40-029-1/F

DRAFT TO MATCH

ISSUE	MODIFICATION	DATE
A	TO ACCOMODATE T-90 FORGING REQUIREMENT THE FOLLOWING DIMNS. ARE MODIFIED. 131 DIMNS. WAS 124 57 DIMNS. WAS 50 99 DIMNS. WAS 90 45° ANGLE ADDED. 36.5 REF. DIMNS ADDED NOTE ADDED.	27/3/04



TECHNICAL REQUIREMENTS.

- HEAT TREAT. DIA. OF IND. 3.7 TO 4.2
- DESCALE.
- MARK MELT NO. AT ANY PLACE.
- DEPTH OF SURFACE DEFECTS AND PIT MARKS FROM SCALES SHOULD NOT EXCEED 0.5 OF ACTUAL MACHINING ALLOWANCE.
- MISMATCH SHOULD NOT EXCEED 1.8mm.
- RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 2.5 mm.
- BUCKLING SHOULD NOT EXCEED 15mm.
- FOLDING OF FINS IN PIERCED HOLE IS ALLOWED.
- MARK PART NO.
- PIERCED HOLE MAY BE OFFSET UPTO 5mm.
- UNSPECIFIED DRAFTS TO BE 7°.
- UNSPECIFIED RADII TO BE R6mm.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UNTOLERANCED DIMENSIONS ARE NOT TO BE CHECKED.

MATERIAL :- 20X2H4A

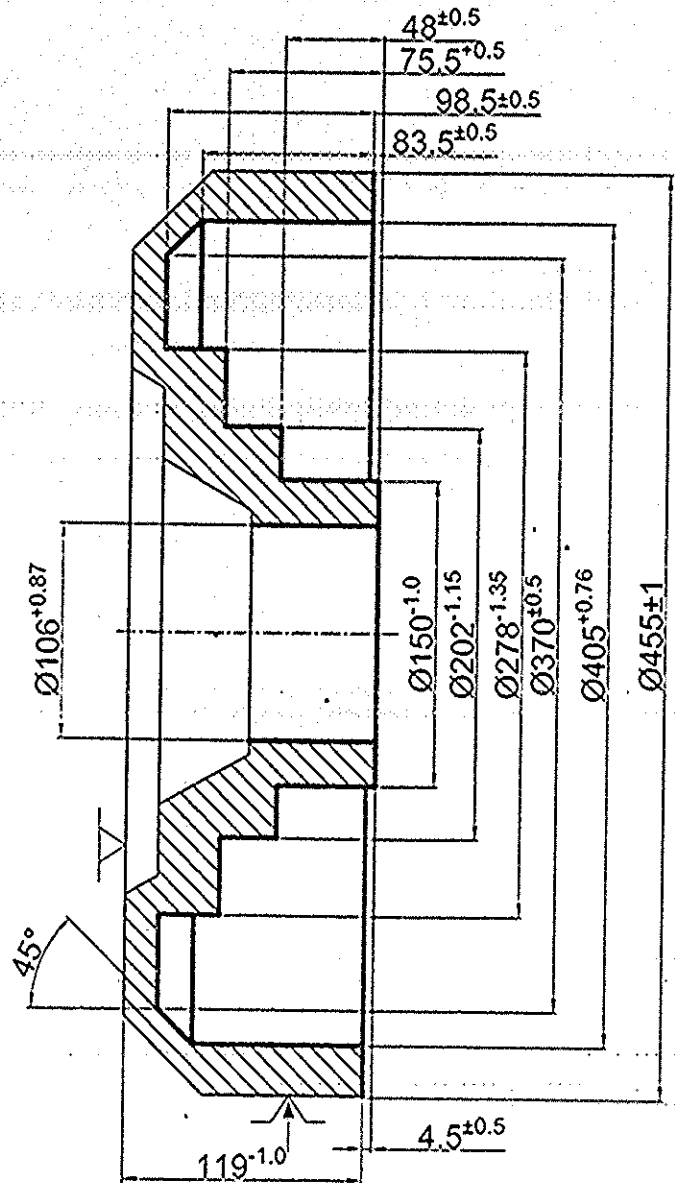
WEIGHT OF FORGING :-

78 KGS

(A) NOTE :-

FORGING IS COMMON FOR COMPTS.  
175.40-029-1/F - T-72 AND  
172.40-306/F - T-90.

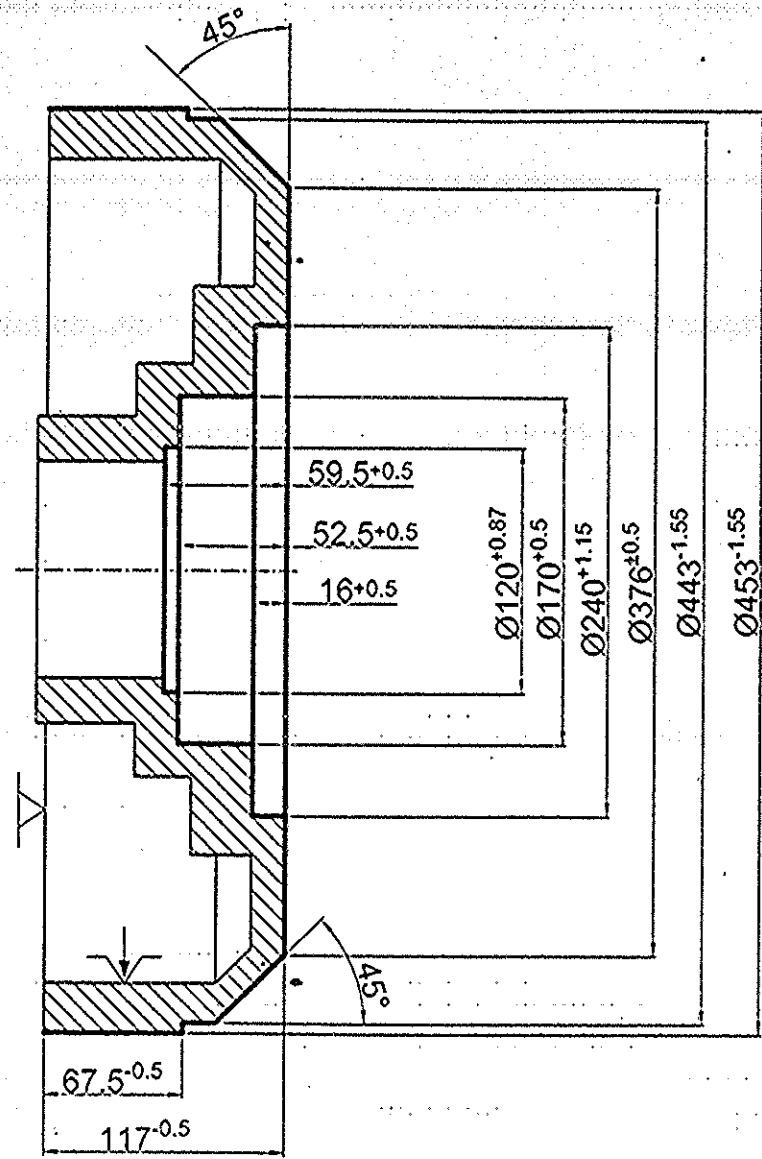
TOOL NO.	DESCRIPTION	MACHINE	EQUIPT. TO BE USED.
	COMPONENT ~ T-72 / T-90	MACHINE	COMPNT. / FORGING.
1:1	175-40-029-1/F SUN GEAR 172.40-306/F SUN GEAR	DG 32	1.
THIS DRG. IS TO BE USED WITH J&T SPECN. II/T ISS. NIL			H.V.F. AVADI.
DGN	CHD	APPD	AUTHD.
FORGING DRAWING			175-40-029-1/F



19

DRG NO.	: 175.40.029-1/SME <sub>2</sub> GEAR SUN-IV TRAI
OPN NO.	: 15-TURNING
MATERIAL	: STEEL 20X2H4A GOST 4543-71
HARDNESS	: 269-207 BHN
SHEETNO.	: NOT TO SCALE

 PREPARED VIJAYANAND. A	 CHECKED S. SARAVANAN.	 APPROVED K. DURAIRAJ
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DRG NO.	: 175.40.029-1/SMF, GEAR SUN IV TRAIN
OPN NO.	: 20-TURNING
MATERIAL	: STEEL 20X2H4A GOST 4543-71
HARDNESS	: 269-207 BHN.
SHEETNO.	: NOT TO SCALE

  
 PREPARED  
 VIJAYANAND A  
 TWIN / TDC

  
 CHECKED  
 S. SARAYANAN  
 TWIN / TDC

  
 APPROVED  
 K. DURAJ RAJ  
 TWIN / TDC (HOD)