



- NOTES:-
1. ALL DIMENSIONS ARE IN MM.
 2. DRAFT ANGLE : 5°
 3. CORNER RADII- 2 & FILLET RADII- 3 (UNLESS OTHERWISE STATED)
 3. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP FITS, LAPS, CRACKS, UNFILLINGS ETC. (MAX. DEPTH DEFECT ALLOWED 0.5MM.)
 4. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLITE WITHOUT HARMFUL CONTINUOUS BANDING.
 5. GRAIN SIZE : ASTM NO. 5 - 8 AS PER 'MC' QUAD- BHN TEST (FILED GRADE AL KILLED CONDITION)
 6. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
 7. HARDNESS 150 - 200 BHN
 8. MATL : 20Mn5Cr5 55: No28 713
 9. FORGING ARE TO BE SHOT BLASTED
 10. HEAT TREATMENT - ISOTHERMAL ANNEALING
 11. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
 12. FORGING TO BE COATED WITH RUST PREVENTIVE RED OXIDE PRIMER
 13. FORGING RIDGES TO BE TRIMMED, CLEANED & SMOOTH FINISHED ALL OVER.
 14. CLAMPING FACE - ∇ RESTING FACE - ∇ FOR MACHINING 1ST OPERATION.

SUPPLY CONDITION:
TRACES OF PARTING-LINE NOT PERMITTED

THICKNESS	+2.4, -0.0
DIE WEAR	+3, -0.0
FLASH PROJECTION	1.4
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
STRAIGHTNESS	1.0
MISMATCH	0.7
TOLERANCES UNLESS OTHERWISE SPECIFIED	
INT. DIMS. REVERSE SIGN + & -	

ITEM	DESCRIPTION	NO OFF	IS MAT	IS MAT	SIZE/WT	REMARK
					F/TDO	F/PR
					DRN	TCB
					CKD	C/CKD
INDEX	ALTERATION	DATE	SGN		REFERENCE DRG	N.T.S.
DIN	TOL				MACHINE	SCALE
0-30	± 0.1					28.9.10
30-50	± 0.2					DATE
50-80	± 0.3					
80-100	± 0.4					
> 100	± 0.5					
					DEMANDED BY	1/1
						SHEET
					DRG NO	CHANGE NO
					VEHICLE FACTORY JABALPUR	269126207911-3

DIM. CHANGED VIDE L.Nº 035/JWM/GS/FRG./10 Dt: 13-10-10 46.2-04 5