



NOTE:-

- (1) ALL LOCATING, RESTING AND CLAMPING SURFACES TO BE CLEAN, SMOOTH, FLAT AND CYLINDRICAL.
- (2) ALL THE TOLERANCES TO BE AS PER IS: 34-69 (PART I TO III) - 1974
- (3) SUPPLY CONDITION:

IF AS FORGED	IF ISO ANNEALED
PART NO. S3344611	PART NO. S3344619

(R2)	NOTE NO. 3 FOR SUPPLY CONDITION DELETED AS PER JEGM/T'S LINO. AHSP/9556/FUR-VEH/AL/AGB/CDO, DT-01-12-04	3-12-04	DGM/TMS JWM/TDO
(R1)	MAT SPEC BS: 970 added as per JE-GM/T'S LINO. 9556/FUR-VEH/AL/AGB/CDO-III, DT. 13-11-2003 & JWM/RAT LINO. 461/RAT/POLICY/03, DT. 15-11-03	22-11-03	DGM/TMS JWM/TDO
(B)	MICRO UNIFORM LAMELLER PEARLITE & FERRITE ADDED AS PER INSTRUCTION GIVEN BY JE-GM/T. REF. AL FORGING DRG. LAY SHAFT 46324.00 P-3344611	2-8-01	JWM/TMS JWM/TDO
(a)	NOTE (2) & (3) ADDED DIMENSION 300.8 WAS 301.8, 38 WAS 38.5 12.0 WAS 12.5 AND 52.0 WAS 52.5		

ALT. CODE	DESCRIPTION	REF	SIGN + DATE
	BS: 970 (R1)		
	MATERIAL	EJ353 FINE GRAIN 1/2% NICKEL CHROMIUM CASE HARDENING STEEL	> LOCATE
	HEAT TREATMENT	ISO THERMAL ANNEALING	
	HARDNESS	170 160 - 210 BHN	> REST
	MICRO STRUCTURE	UNIFORM LAMELLER PEARLITE & FERRITE	> CLAMP
	WEIGHT		
TOLERANCES			
DIE WEAR (TOTAL)	+2.2, -0.0		
DIE THICKNESS	+1.6, -0.0		
MIS MATCH	0.6		
FLASH EXTENSION	CLOSE TRIM		
STRAIGHTNESS	0.8 /		
CORNER & FILLET RADI	+50%, -25%		
DRAFT ANGLE	+2°, -1°		
ECCENTRICITY	-		
SURFACE	0.5		

ASHOK LEYLAND LTD ENNORE MADRAS-57			
JIG + TOOL DESIGN OFFICE			
1986	SIGN	DATE	PART NAME
DN	BY	6/4	OUTPUT SHAFT FRONT
CHD	BY	1/2	PART NO
APD			F3344611 3-A
			1-2-86
			PROJECT
			4X4
			DRAWING NO
			P-53344611 (R2)