

TECHNICAL REQUIREMENTS

- GROUP II, GOST 8479-70
- PARAMETERS OF FORGING: T5, M2, C2, 14 GOST 7505-89.
- HARDNESS 179..269 BHN (DIA. OF INDN. 3.7 TO 4.5 MM)
- UNSPECIFIED DRAFT 7°
- UNSPECIFIED RADIUS - 3.0 MM.
- TOLERANCE OF SHIFT ALONG THE SURFACE OF PARTING LINE OF DIE IS 0.6 MM.
- PERMISSIBLE LIMIT VALUE OF RESIDUAL FIN - 0.9 MM
- PERMISSIBLE LIMIT HEIGHT OF BURR ALONG CONTOUR OF CUTTING - 3.0 MM.
- TOLERANCE OF FLATNESS AND CURVATURE 0.8 MM.
- DIMENSION WITHOUT TOLERANCE NEED NOT BE CHECKED.
- FOLLOWING LOCAL DEFECTS ARE ALLOWED WITHOUT RECTIFICATION: DENTS, NICKS, SCALE AND TOOL MARKS IN AN AREA NOT MORE THAN 30% OF THE SURFACE AND DEPTH NOT MORE THAN 1 MM. WRINKLES, GRIPS, LAPS AND ROLLING DEFECTS OF INPUT MATERIAL WITH DEPTH NOT MORE THAN 1MM ANYWHERE IN THE AREA NOT LESS THAN 15 MM FROM THE FACES. TOTAL NUMBER OF ALL SURFACE DEFECTS WITHOUT DRESSING SHOULD NOT BE MORE THAN TWO PER COMPONENT. SLIGHT DRESSING OF DEFECTS WITHIN THE TOLERANCE LIMIT OF CORRESPONDING DIMENSION IS ALLOWED.
- TO BE DE-SCALE (SHOT BLASTED) ON MACHINED SURFACES TRACES OF SCALES NOT REMOVABLE BY DRESSING ARE ALLOWED.
- ACCEPTANCE STAMPS ON ALL COMPONENTS.
- EVERY BATCH QTY, 2 COMPONENTS TO BE LABELED WITH MARKING OF DRG. NO. AND BATCH NUMBER DETAILS.
- PAINT RED OXIDE.

T 90

MATERIAL	FORGING WT.	INSPECTION	
STEEL 38XC GOST:4543-71	1.9 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	MPM	NTS	
DRAWN	CHECKED	APPROVED	
L. Duff 3/19/04			
DRAWING NO.	219-35-126/F		
NOMENCLATURE:	SHOE		
HEAVY VEHICLES FACTORY AVADI, CHENNAI			

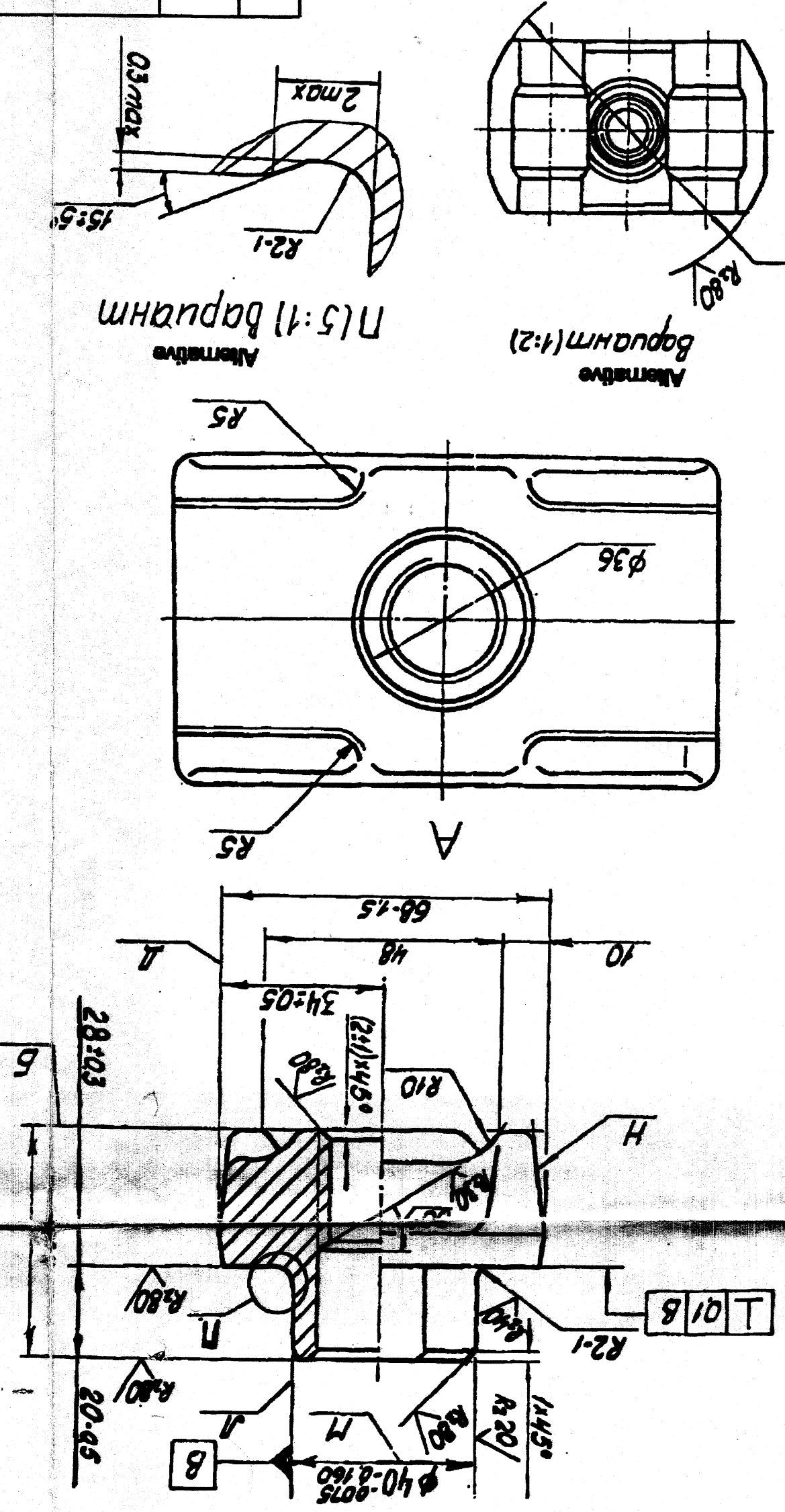
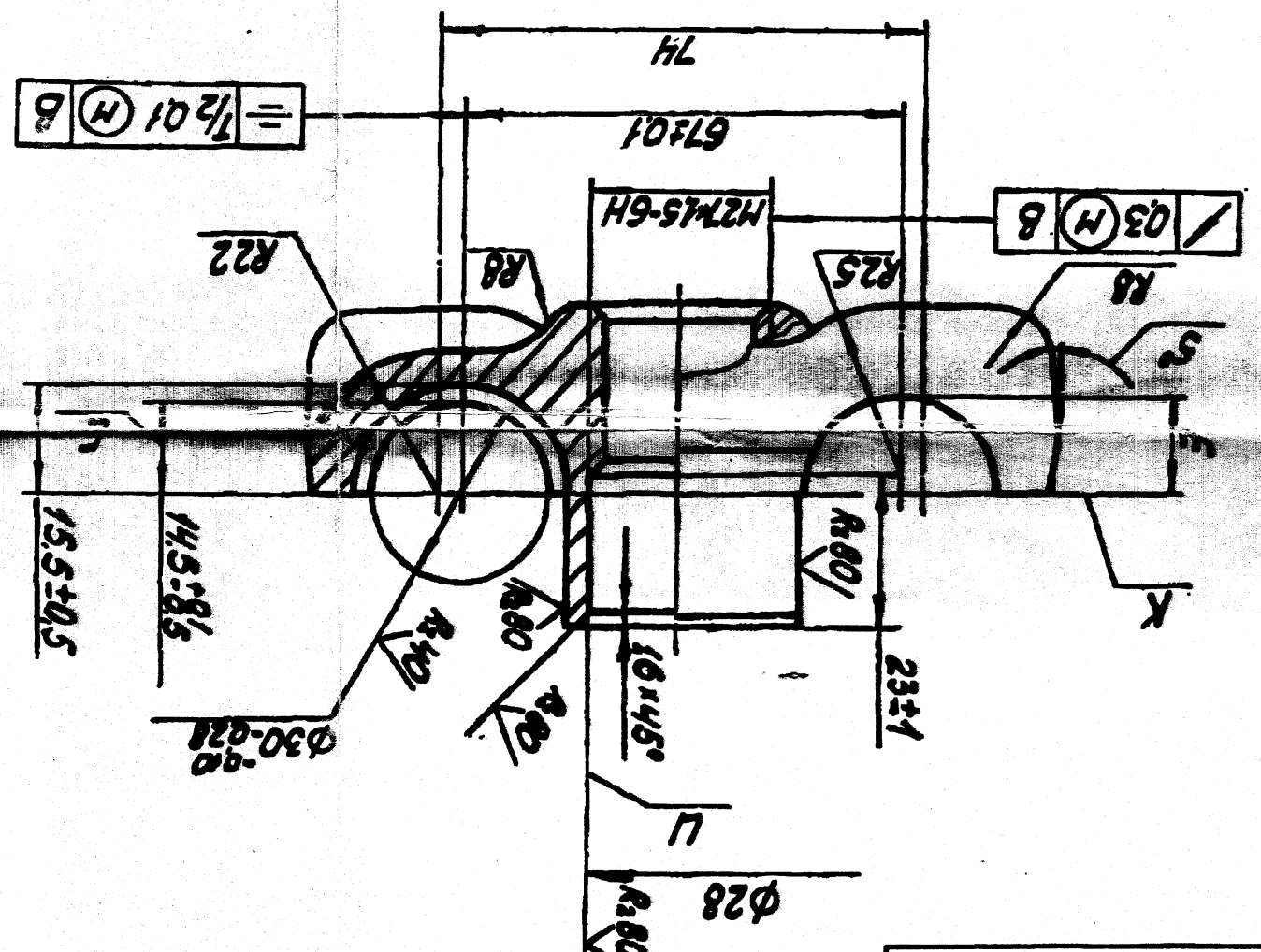
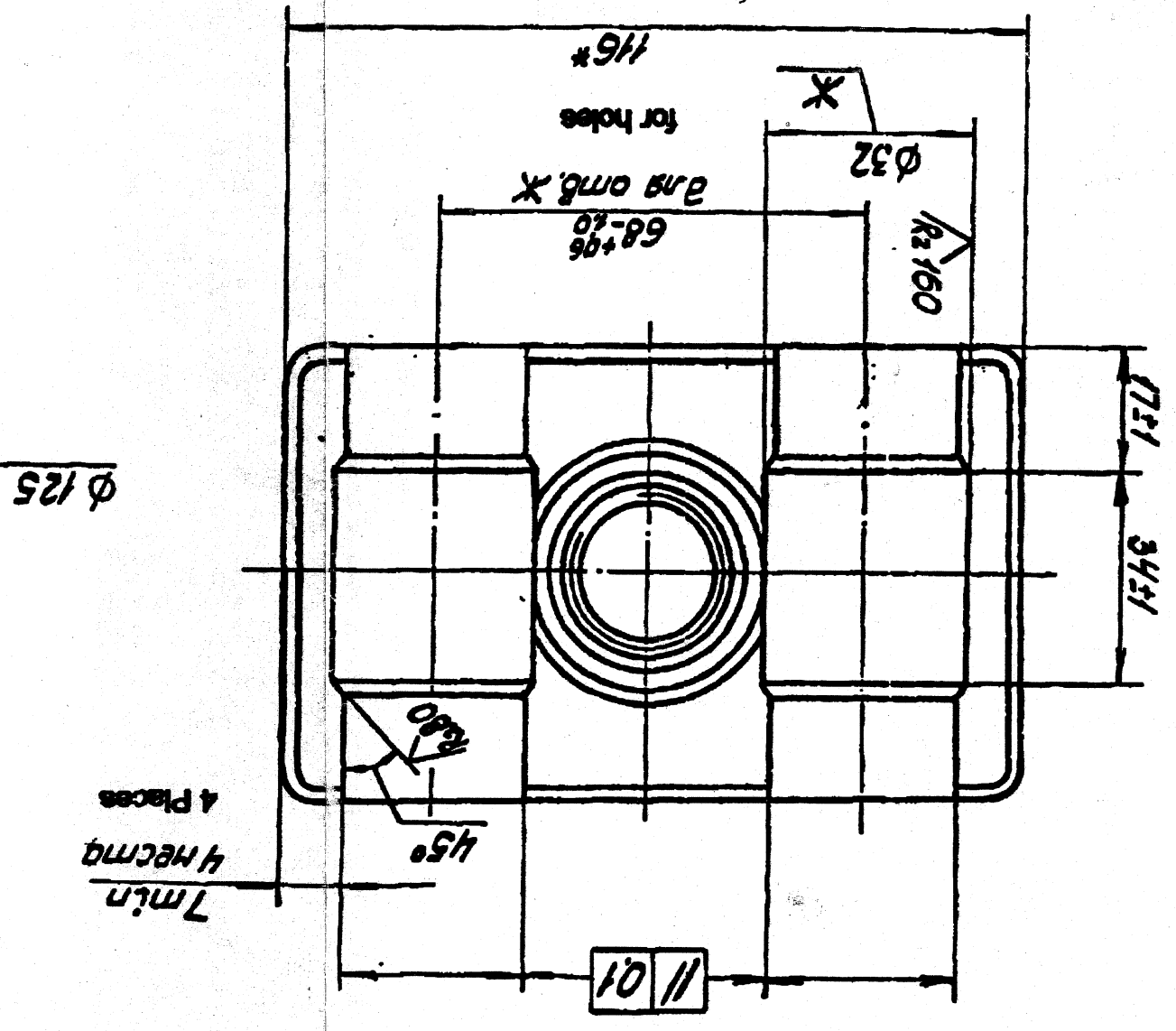
FOR REFERENCE ONLY

OFA 32848

H.S. Prinj
= 0507 Per
Forging Per = 750 T.

Injection Level = 250-450°C
Shaping Per = 400 T.

Forging Temp = 1100-1200°C
Heating time = 45 Sec.



EST. WT. (Kg) 0.9 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.			
DRN	APPD	DATE	ISSUE
CD			
MATERIAL: 112.55.010CB-1C7		SCALE: 1:1	
CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI		DIMENSIONS IN mm	
TITLE: SHOE		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69	
D S CAT NUMBER		ALL THREADS TO CONFORM TO	
DRAWING NUMBER 219.35.126		NATURE OF AMENDMENTS	

DRAWING ENGINEERS ARE CONFIDENTIAL
 UNAUTHORIZED REPRODUCTION IS PROHIBITED
 BY ORDER
 SR. GM. HVE

LTR.NO.07262790/TRACK/ID/DT: 11/04/05

- Group 1 341... 44B GOST 8478-70, Accuracy class 12 Gost 7805-80.
- Isometric hardening. Scope of check to be as per group 1 with 4 of OST 3-4704-80. Ingress strength KCL5 Kgf/cm². Pass for hardness test - surface H finished to a depth of 0.1 mm.
- The following is permitted on un-machined surfaces without removal:
 Burns, dents due to sooting and tool on an area and not exceeding 30% of total surface to a depth of 0.1 mm.
- Top edge, creases, lines and other defects due to rolling process to extent of 0.1 mm located randomly at a distance 100 mm from both ends / faces. Total number of all surface defects, without removal, should not be more than 2 per part. Formed covering height of defects is permitted, provided the dimensions remain within the tolerance limits.
- Variation in dimensions should be upto E 0.02.
- Machining of surfaces B & J with surface finish Rz=0.163µm is allowed.
- Tool marks are permitted to a depth 0.03 mm and width:
 a) On surface I - 0.05 mm.
 b) On surface H and K - 0.2 mm.
- Stacking/Weathering of bread is allowed up to M27X1.5 - 7H after heat treatment.
- Change of dimension H to (h0.07) mm above the allowance is permitted after heat treatment.
- Dimensions for reference.
- Other requirements are as per S20 TY 1.

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