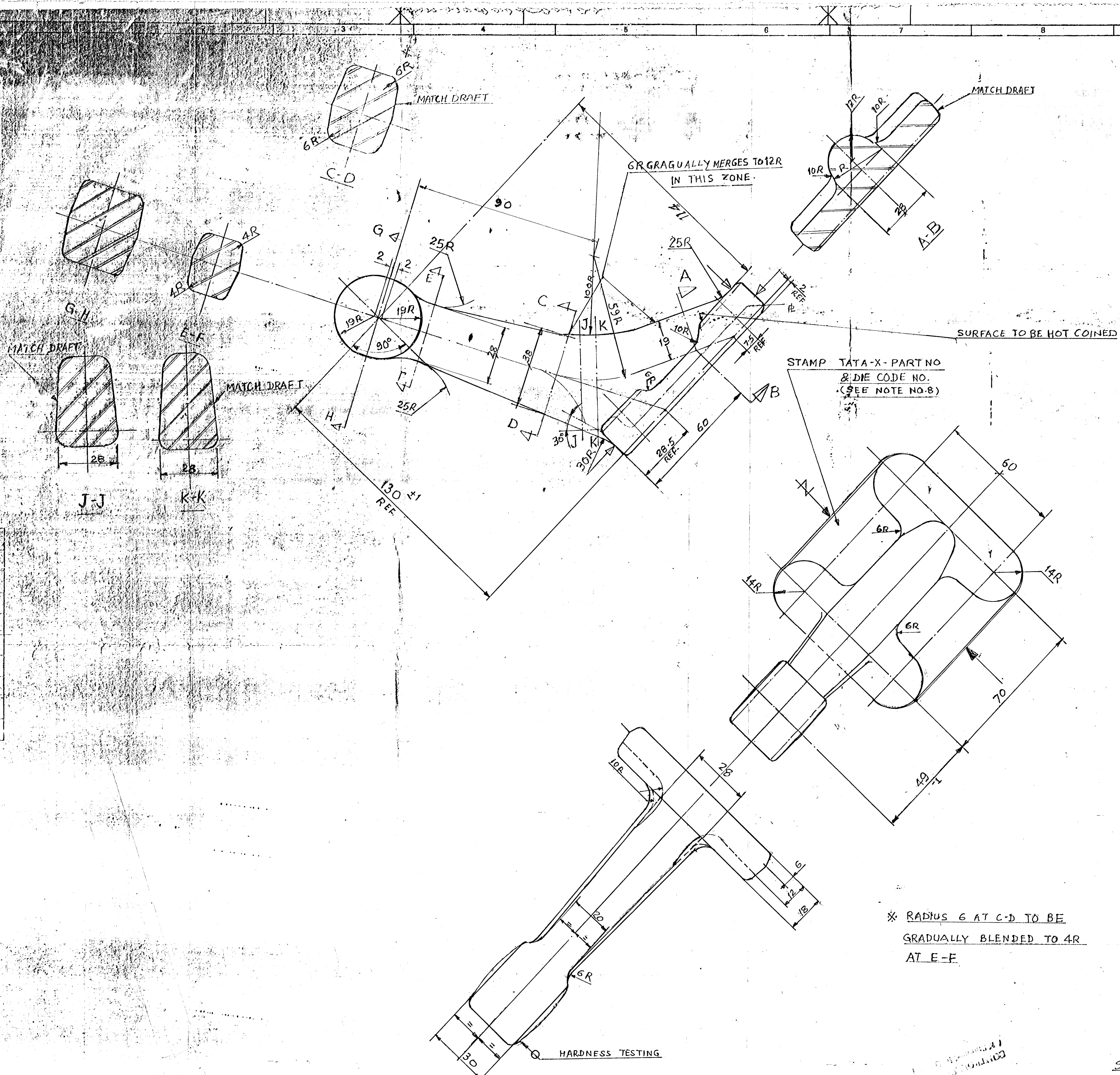


Do not Scale the drawing Unless otherwise stated
If in doubt, Ask. ©Org. drawn to first angle

THIS DRAWING IS TRACED FROM:-
DRAWING No: 00312338100550.
MOD. No. 8



NOTES:-

1. FORGING SHOULD BE CLEAN & TRIMMED.
NORMAL.
2. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS PITS, LAPS, UNFILLINGS & CRACKS ETC.
3. TOLERANCE FOR SCALE PITS:-
i) FOR UNMACHINED SURFACE:- ONE THIRD OF THE THICKNESS TOLERANCE.
ii) FOR MACHINED SURFACE:- HALF OF THE MACHINING ALLOWANCE.
4. HEAT TREATMENT AS PER TELCO'S (AUTO) INSTRUCTIONS.
5. FORGING SHOULD BE SUPPLIED AS PER SS: 10,000.
6. SURFACE COATING TRC.S. IS: 1154 (174 TS 26205).
7. RAW MATERIAL SHOULD BE AS PER SS: 4027.
8. X (C)-SUPPLIERS' CODE LETTER.
TATA SIZE TO BE 4MM (h) AND PROPORTION FOR THIS 'h' AS PER TS-11238 SHEET NO. 1 OF B.
9. MAGNETIC CRACK TESTING 100%.
10. TOLERANCE FOR FILLET & EDGE RADII, TRIM BURRS & DRAFT ANGLE TO BE AS PER IS: 3469.

* RADIUS 6 AT C-D TO BE GRADUALLY BLENDED TO 4R AT E-E

APPROVED
JRM/NTM

STOP
REST
CLAMP

Design & Devt. Forge
Date: 04/05/2000
Rev. No. Mod. No. S. No. in ROMAN
For. No. Mod. No. S. No. in ROMAN
is equivalent ARABIC numeral

Machining Deviations as per ISO 2768 m										Surface Roughness Symbols / VALUES IN $\mu m Ra$									
Customer	Die Wear (Burrs)	Mis Match Thickness	Flash Thickness	Clp	Pierce	Res Spike	Drift	Contraction	Min Rad	Over	Under	6	30	120	400	1000	2000	4000	8000
AUTO	2.5	0.6	±0.5	HOT		HOT	5°	1 IN 64	2.5	Tolerance	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±1.7	±2.5	±4.0

Symbol	Value	Symbol	Value	Symbol	Value	Symbol	Value	Symbol	Value
Ra	1.2	Rz	6.3	Ry	12.5	Rq	1.6	Rt	10.0
Ra	2.5	Rz	12.5	Ry	25.0	Rq	3.2	Rt	20.0
Ra	5.0	Rz	25.0	Ry	50.0	Rq	6.3	Rt	40.0
Ra	10.0	Rz	50.0	Ry	100.0	Rq	12.5	Rt	80.0
Ra	20.0	Rz	100.0	Ry	200.0	Rq	25.0	Rt	160.0
Ra	40.0	Rz	200.0	Ry	400.0	Rq	50.0	Rt	320.0
Ra	80.0	Rz	400.0	Ry	800.0	Rq	100.0	Rt	640.0
Ra	160.0	Rz	800.0	Ry	1600.0	Rq	200.0	Rt	1280.0

Material Description Size, Spec. Std. No.		40C4 TYPE-B SS: 4027 T14(30-105)	
DESIGN. & DEV. FORGE		MJC UNIT - 2 TON D/S HAMMER	
Product/Group No. 1210 SA		Replaces Drg. Reference Drg. No.	
Scale: 1:1		Opp. Hand Drg./Prt. No.	
Drg./Part Description STEERING LEVER (RAW PART)		Drg./Part No. 00312 338 100550	
Sheet No.		of	