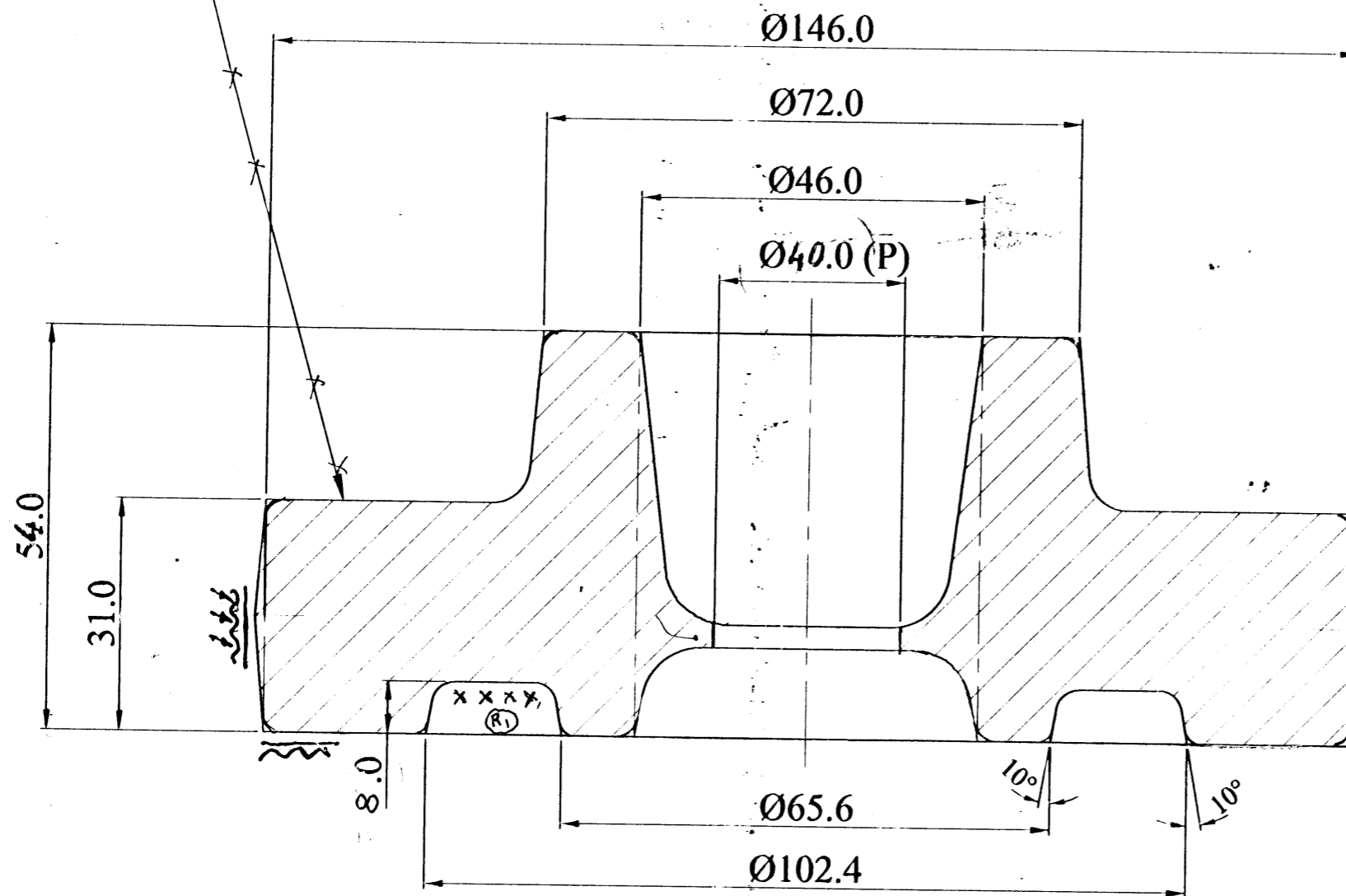


STAMP PART NO., FIRM'S INITIAL, MONTH & YEAR (5 x 1 RAISED TYPE) (R1) (x x x x) HERE



- NOTES:-
1. ALL DIMENSIONS ARE IN MM.
 2. DRAFT ANGLE : OUTER-5°, INNER-7°
CORNER RADII- 2 & FILLET RADII- 5
(UNLESS OTHERWISE STATED)
 3. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PITS, LAPS, CRACKS, UNFILLINGS ETC (MAX. DEPTH DEFECT ALLOWED 0.3 MM.)
 4. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLIT WITHOUT HARMFUL CONTINUOUS BANDING.
 5. GRAIN SIZE : ASTM NO. 5 - 8 AS PER 'MC' QUAI-EHN TEST (FILED GRADE AL KILLED CONDITION)
 6. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
 7. HARDNESS : 150 - 200 BHN
 8. MATL. : 815 M17 BS 970 - 1 T13 SS: A027
 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: PRE-MACHINED

OUTSIDE DIA. - 146.0/146.5
INSIDE DIA. - 46.0/46.5

ECCENTRICITY OF PIERCING	0.6
THICKNESS	+1.2, -0.0
DIE WEAR	+1.7, -0.0
FLASH PROJECTION	0.8
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
FLATNESS	0.8
MISMATCH	0.6

TOLERANCES UNLESS OTHERWISE SPECIFIED
INT. DIMS. REVERSE SIGN + & -

ITEM	DESCRIPTION	NO OFF	10 F MAT	IS MAT	SIZE/WT	REMARK	
(R1)	STAMPING POSITION OF FIRM'S MONO CHANGED AS PER AWM/RS L.N. 035/AWM/GS/AUD/01 DT. 22.07.15					JWM/TOD JWM/TOD APPD	
INDEX	ALTERATION					DRN TCD CKD C/CKD	
DIM	TOL	FORGING DRAWING FOR 4TH SPEED GEAR, C/S. GB/LPTA - 715, BS- III				REFERENCE DRG	
0-30	± 0.1					2691 2630 5428	NTS SCALE
30-250	± 0.2					MACHINE	24.9.10 DATE
250-800	± 0.3					DEMANDED BY	1/1 SHEET
800-2000	± 0.3						
> 2000	± 0.8						
T.D.O.	VEHICLEFACTORY JABALPUR	DRG NO	269126305428-3(R1) CHANGE NO				

13/3-2008 462-08

13/3-2008