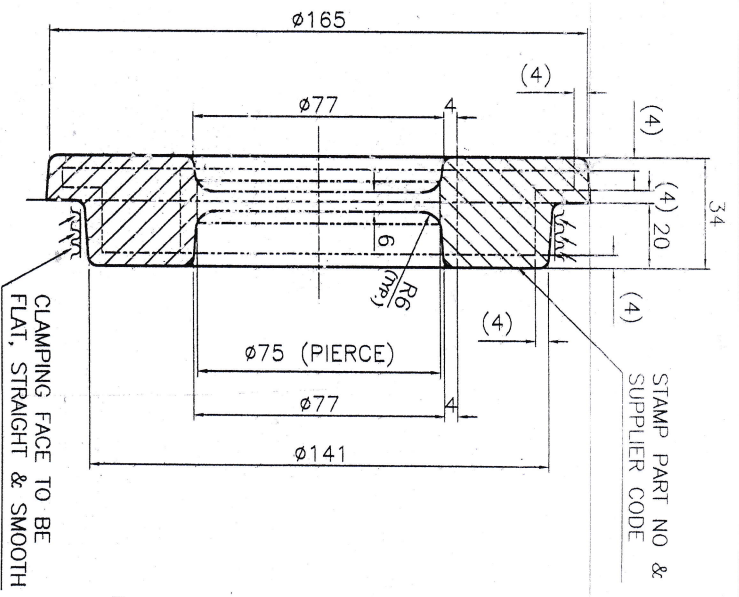


ALL DIMENSIONS ARE IN MM.



STAMP PART NO & SUPPLIER CODE

CLAMPING FACE TO BE FLAT, STRAIGHT & SMOOTH

TECHNICAL SERVICES SECTOR  
 Vehicle Factory, Jabalpur  
 CERTIFIED CORRECT COPY  
 10/06/2022  
 JMM/MM-1

AMENDMENT 'A':- DETAILS FOR MICRO STRUCTURE, GRAIN SIZE & INCLUSION RATING ADDED.

FORGING WEIGHT :- 3.9 KG (APPROX)  
 NOTE: SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

QTY/VEH = 12 NOS.

NOTE:	1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.	MATERIAL: C-45IS20M	KIND OF DIMS.	TOL	ALTERATION	SIGN	DATE	ALTERNATE MODEL REF. DRG. NO.	DIR/ODC	REPLACED BY	REPLACEMENT FOR	DRG. NO. F-2706-57-31/A	SHT.
	2. FORGING TO BE SHOT BLENDED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO ISS 3-47-13BY BRUSHING OR SPRAYING.												
	COMP. OF CLASS-4 C 0.44-0.50, SI 0.35MAX, Mn 0.60-0.90, S 0.004MAX, P 0.004MAX.		LENGTH / DIA	+1.2 -0.6				UPGRADED MPV 4X4					
	HEAT TREATMENT: NORMALIZED		THICKNESS	+0.9 -0.5									
	HARDNESS: 150-210 BHN		MISMATCH	0.6									
	MICRO STRUCTURE: FINE PEARLITE & BAINITE		STRAIGHTNESS	0.6									
	GRAIN SIZE: ASTM 5 OR FINER		RESIDUAL FLAT	+0.7									
	INCLUSION RATING: 3 A B C/D THIN OF IS 4163.		TRIMMED FLAT	-0.7									
	FORGING TOLERANCE AS PER IS 3469-1974		ANGULAR	+2° -1°									
			RADI	+50% -25%									
			INTERNAL DIMS.										
			REVERSE SIGN + & -										

ODC VEHICLE FACTORY JABALPUR

FORGING BLANK FOR REAR CASING FOR GUN PORT UPGRADED MPV 4X4

1/1