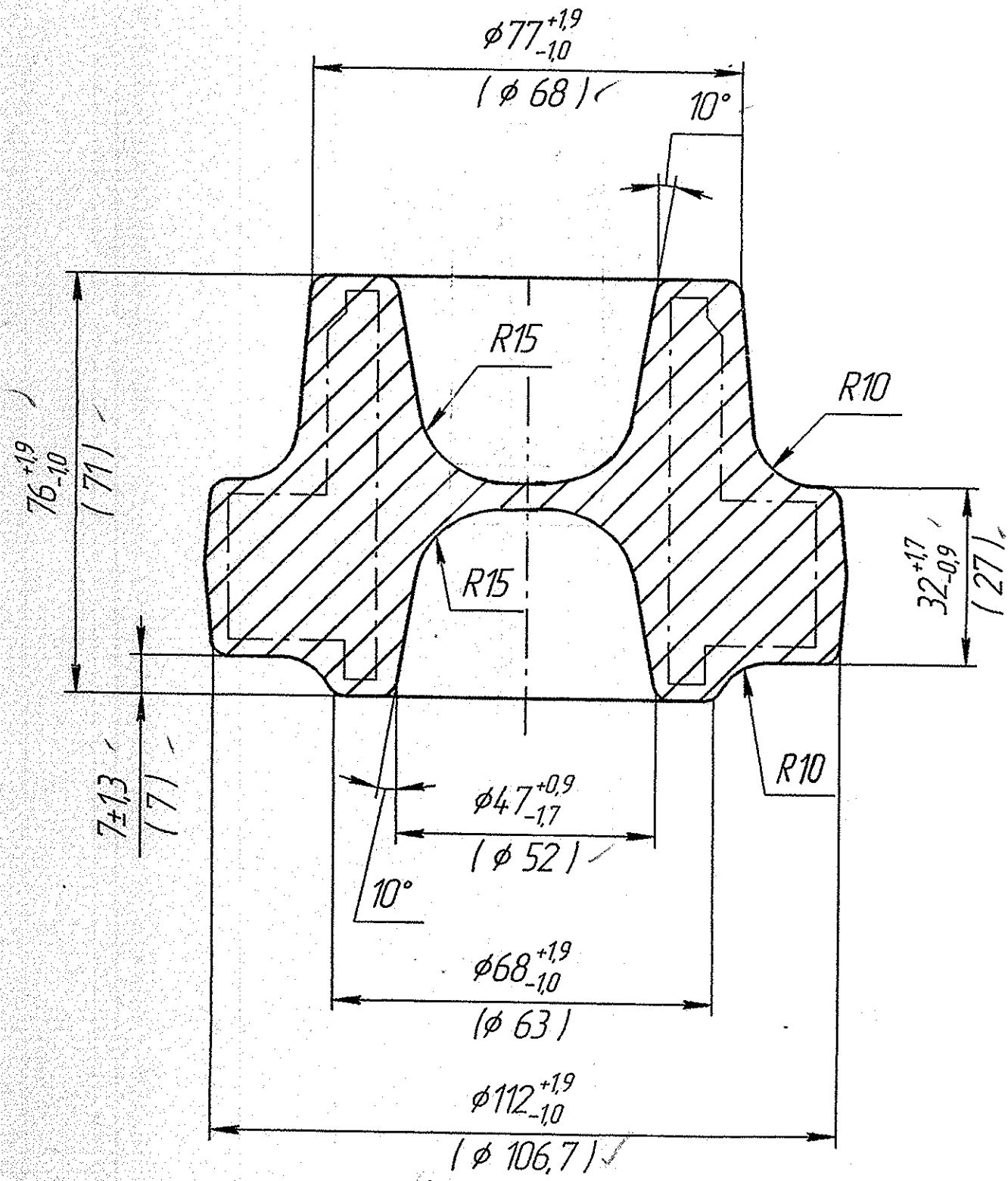


TECHNICAL REQUIREMENTS



01. 207...268 HB.
02. ALTERNATE MATERIAL : STEEL 20X2H4A - W GOST 4543-71.
03. BURRS ON PERIMETER OF CUT IS ALLOWED UPTO MAX. 1.2 MM.
04. SHIFT ON PARTING OF DIE IS ALLOWED UPTO MAX. 1.0 MM.
05. NON-FLATNESS IS ALLOWED UPTO MAX. 0.8 MM.
06. UN-SPECIFIED STAMPING DRAFTS - 5°
07. FILLET RADII - R 3.0 MM.
08. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
09. DIMENSIONS WITHOUT TOLERANCES ARE FOR MAKING DIES.
10. MISALIGNMENT OF DIA 30 WITH RESPECT TO DIA 47 - MAX. 1.5 MM.
11. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS, AS WELL AS CHIPPING OR FINISHING OF DEFECTS IN DEPTH UPTO 50% OF ACTUAL ONE SIDE MACHINING ALLOWANCE MAY BE ALLOWED.
12. DE-SCALES (SHOT BLASTING)
13. IT IS ALLOWED TO MARK PART NUMBER.
14. FORGING II ACCURACY CLASS, GROUP OF STEEL M2, CATAGORY OF COMPLEXITY C3 GOST 7505-89.
15. PAINT RED OXIDE.

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MATERIAL	FORGING WT.		
20X2H4A GOST 4543-71	3.80 KGS		
ALT. MATERIAL	HAMMER	SCALE	
20X2H4A-W GOST 4543-71	MPM	NTS	
DRAWN	CHECKED	APPROVED	
L. Ruffin 27/8/03		S. S. S. 0	

DRAWING NO. 172.40.313/F
NOMENCLATURE: PLANET PINION Z-18

HEAVY VEHICLES FACTORY
AVADI, CHENNAI

A	PIERCING DIA. 30 mm. DELETED	
ISS.	MODIFICATION	DATE