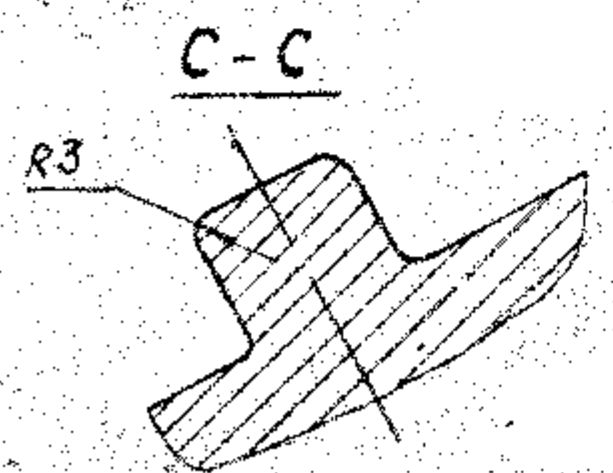
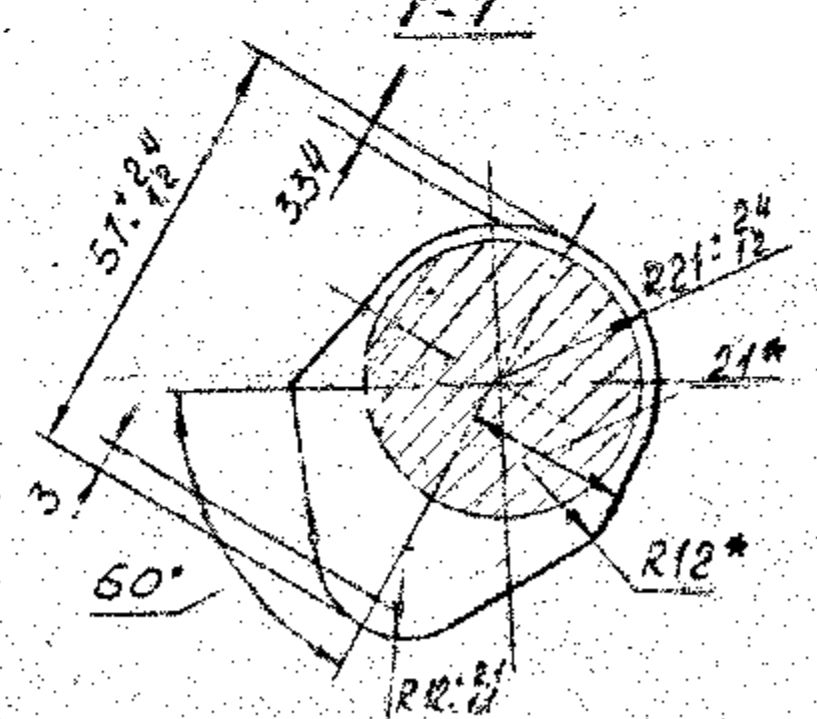
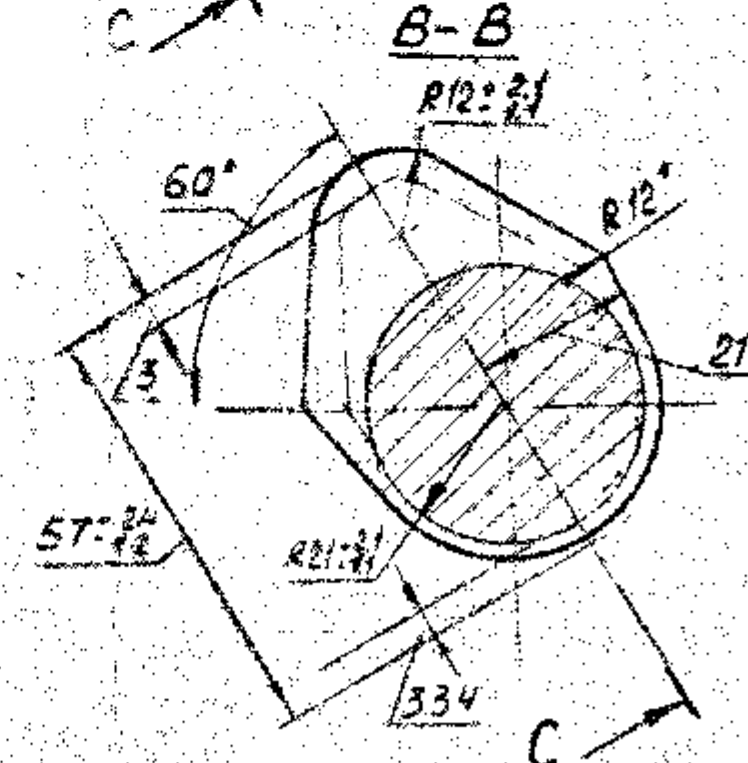
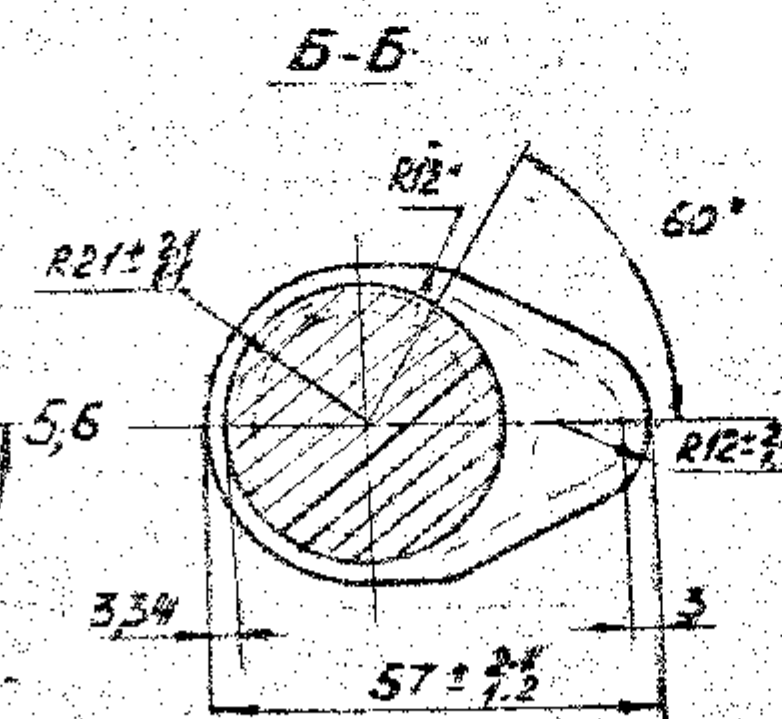
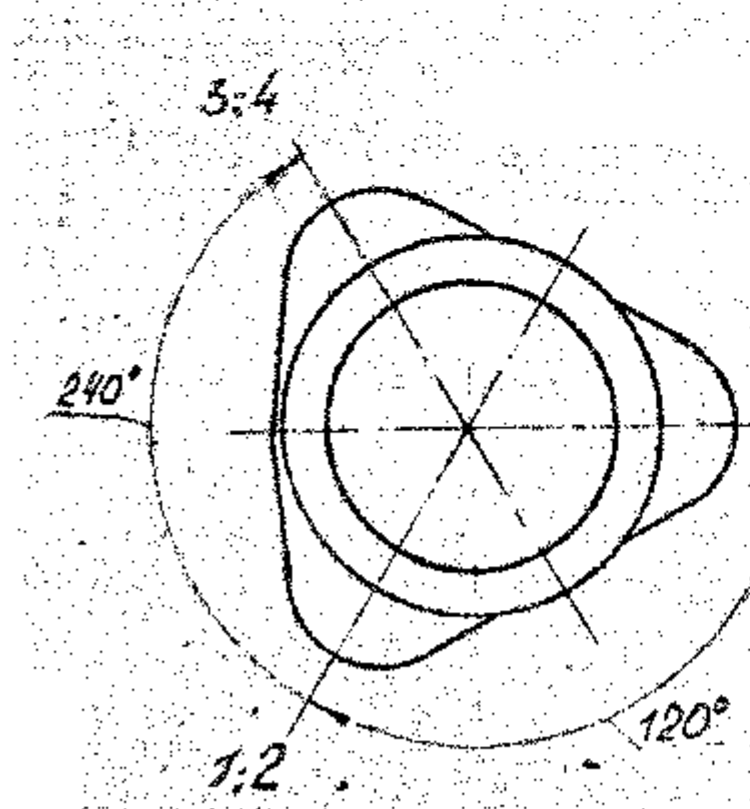
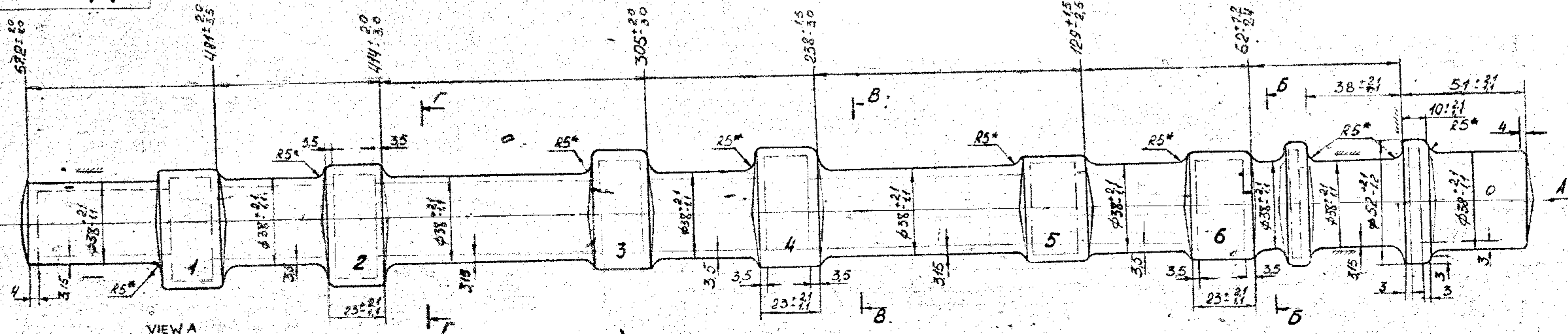


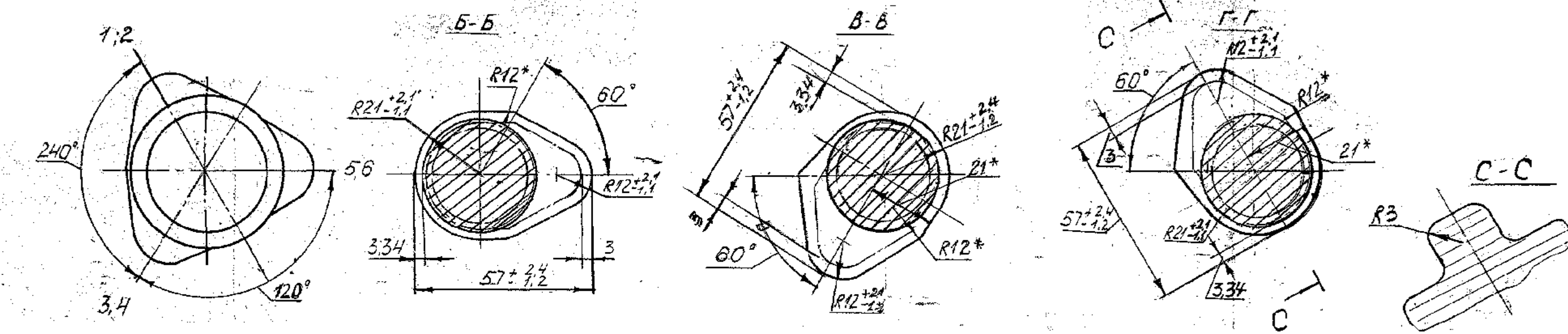
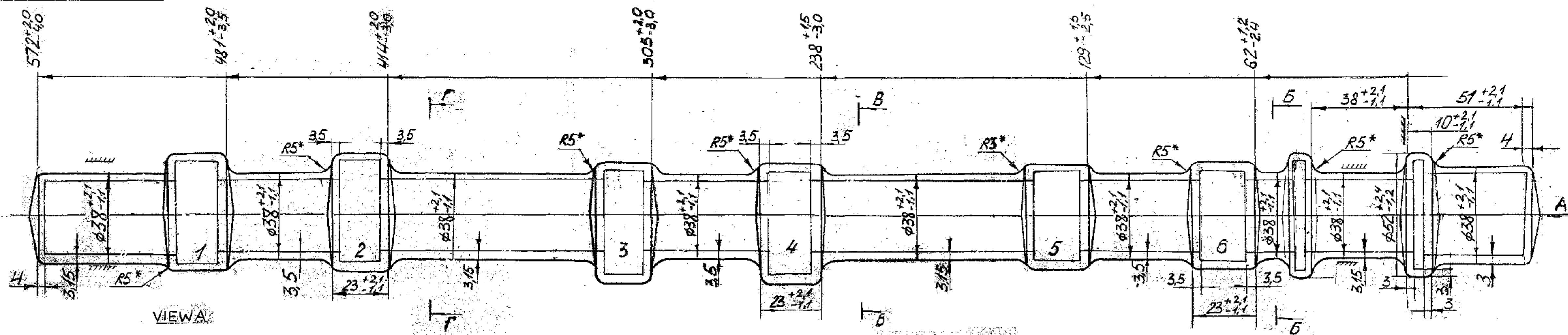
SK/U/0700600A



- 1 STEEL GRADE M2 AS PER GOST 7505-74.
- 2 COMPLEXITY GRADE C5 AS PER GOST 7505-74.
- 3 ACCURACY OF FORGING MANUFACTURE CLASS 3 AS PER GOST 7505-74.
- 4 HOT STAMPING.
- 5 NORMALIZATION HARDNESS BRINNEL 207-163 (DIA OF INDENTATION 4.2-6.3).
- * 6 DIMENSIONS TO BE ENSURED BY TOOL.
- 7 UNSPECIFIED DRAFTS 5°-7°.
- 8 UNSPECIFIED RADIUS OF ROUNDING OFF R 3MM.
- 9 UNFILLING OF CORNERS WITHIN THE LIMIT OF 0.5 OF ACTUAL ALLOWANCE.
- 10 BEND NOT TO EXCEED 2 M.M. ON SHAFT LENGTH ON POSITIONS OF OTHER.
- 11 TOLERANCE CAMS IN RELATION TO FIRST CAM IS MAXIMUM 22°.
- 12 SHIFT OF PARTING LINE NOT TO EXCEED 1.0 M.M.
- 13 FLASH ALONG THE PARTING LINE NOT TO EXCEED 1.4 M.M. FOLDING OF FLASH MAXIMUM 5 M.M. FLASHES MAY BE GROUND.
- 14 SCALE DEPRESSIONS AND OTHER SURFACE DEFECTS TO A DEPTH OF NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE.
- 15 CRACK, HAIRLINE CRACK AND OTHER SURFACE DEFECTS TO A DEPTH NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE IS ALLOWED DEFECT DEPTH IS TO BE DETERMINED BY MACHINING 0.5 FROM A BATCH.
- 16 DRESS THE SCALES.
- 17 INSPECTION GROUP 3 AS PER GOST 2479-70.
- 18 REST OF THE TECHNICAL REQUIREMENT GOST 2479-70 AND GOST 7505-74.

ISSUE	DATE	REFERENCE	SK/U/0700600A		
			LETTERS	MASS	SCALE
APPROVED	K.R.S.	<i>[Signature]</i>		6.6	1:1
CHECKED	G.K.M.	<i>[Signature]</i>			
DRAWN	P.R.K.R.O.	<i>[Signature]</i>			
			INTAKE CAM SHAFT (FORGING)		
			45 SELECT (C=0.42-0.47)		
			TY 6-1-381-72		
			20-07-06		

20-07-15A



1. STEEL GRADE M2 AS PER GOST 7505-74.
2. COMPLEXITY GRADE C5 AS PER GOST 7505-74.
3. ACCURACY OF FORGING MANUFACTURE CLASS II AS PER GOST 7505-74.
4. HOT STAMPING.
5. NORMALIZATION HARDNESS BRINNEL 207-163 (DIA OF INDENTATION 4.2-4.7).
- * 6. DIMENSIONS TO BE ENSURED BY TOOL.
7. UNSPECIFIED DRAFTS 5...7.
8. UNSPECIFIED RADI OF ROUNDING OFF R 3MM.
9. UNFILLING OF CORNERS WITHIN THE LIMIT OF 0.5 OF ACTUAL ALLOWANCE.
10. BEND NOT TO EXCEED 2 M-M ON SHAFT LENGTH ON POSITIONS OF OTHER.
11. TOLERANCE CAMS IN RELATION TO FIRST CAM IS MAXIMUM ± 2°.
12. SHIFT OF PARTING LINE NOT TO EXCEED 1.0 M-M.
13. FLASH ALONG THE PARTING LINE NOT TO EXCEED 1.2 M-M. FOLDING OF FLASH MAXIMUM 3 M-M. FLASHES MAY BE GROUND.
14. SCALE DEPRESSIONS AND OTHER SURFACE DEFECTS TO A DEPTH OF NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE.
15. CRAMP, HAIRLINE CRACK AND OTHER SURFACE DEFECTS TO A DEPTH NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE IS ALLOWED. DEFECT DEPTH IS TO BE DETERMINED BY MACHINING 0.5% FROM A BATCH.
16. DRESS THE SCALES.
17. INSPECTION GROUP II AS PER GOST 8479-70.
18. REST OF THE TECHNICAL REQUIREMENT GOST 8479-70 AND GOST 7505-74.

ISSUE	DATE	REFERENCE	20-07-15A		
APPROVED	K.R.S.	<i>[Signature]</i>	LETTERS	MASS	SCALE
CHECKED	S.RONIN			66	1:1
DRAWN	PRK.RAO	<i>[Signature]</i>	SHEET	SHEETS 1	
EXHAUST CAM-SHAFT (FORGING)			ENGINE FACTORY AVADI		
45 SELECT (C-0-42.047)			TY 14-1-381-72		