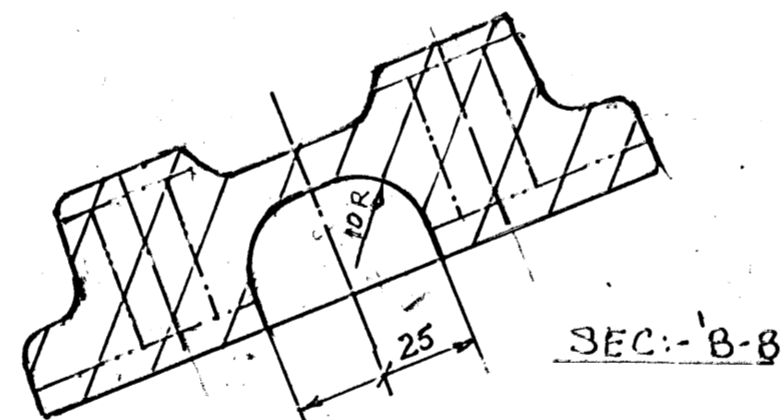
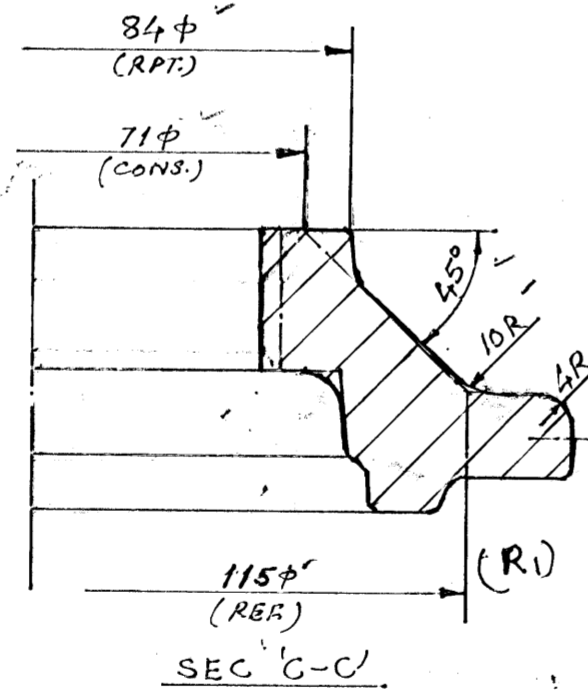
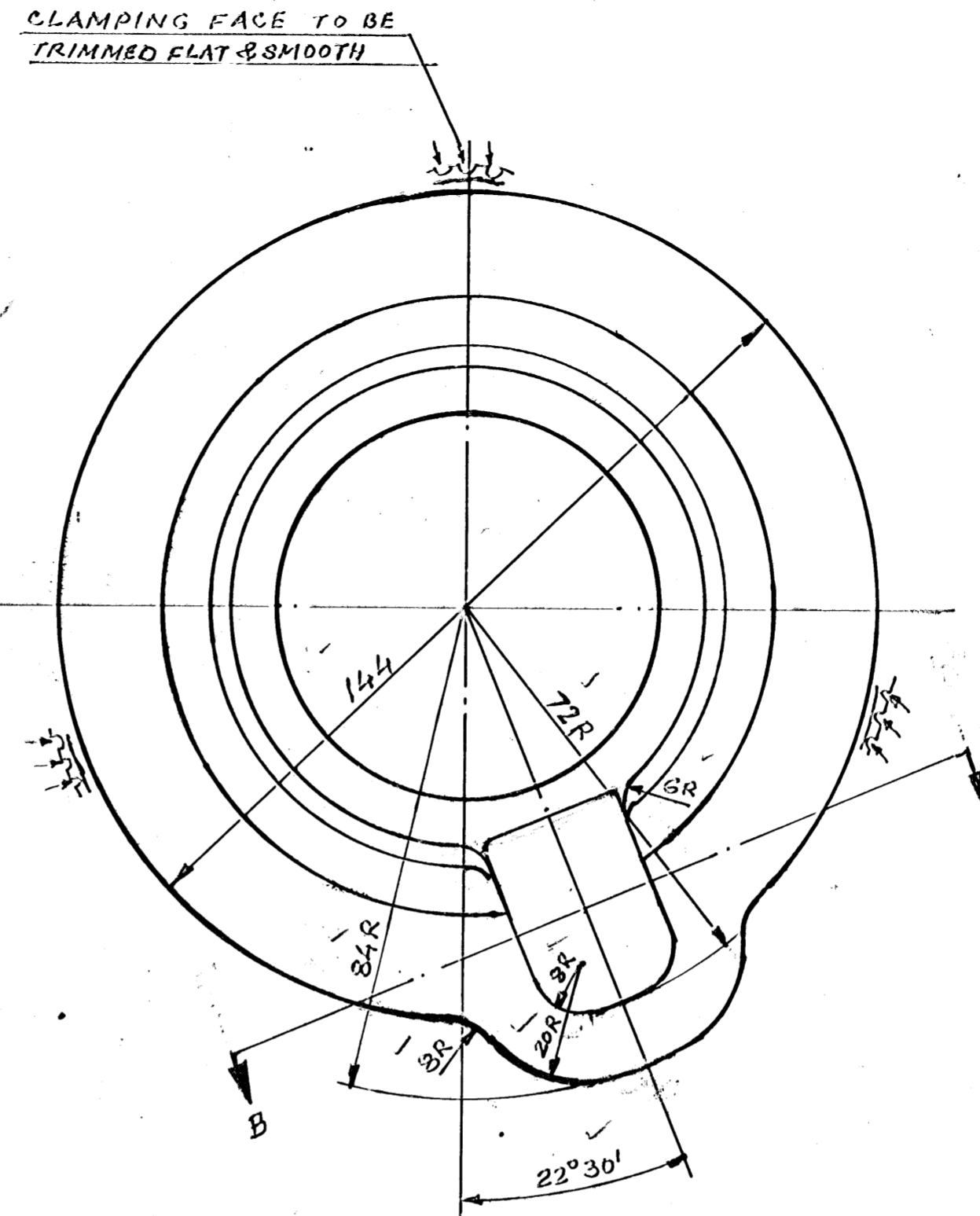
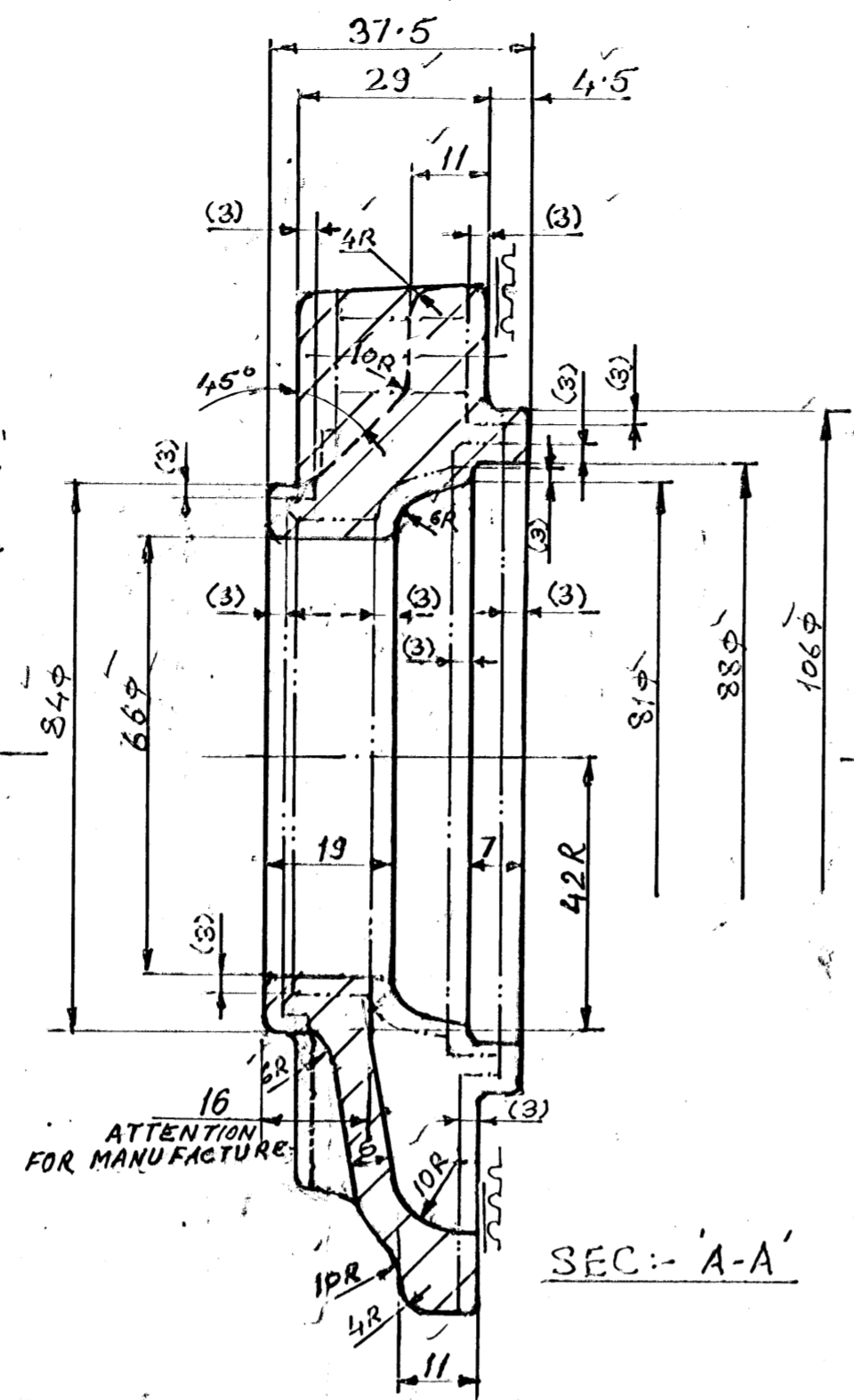
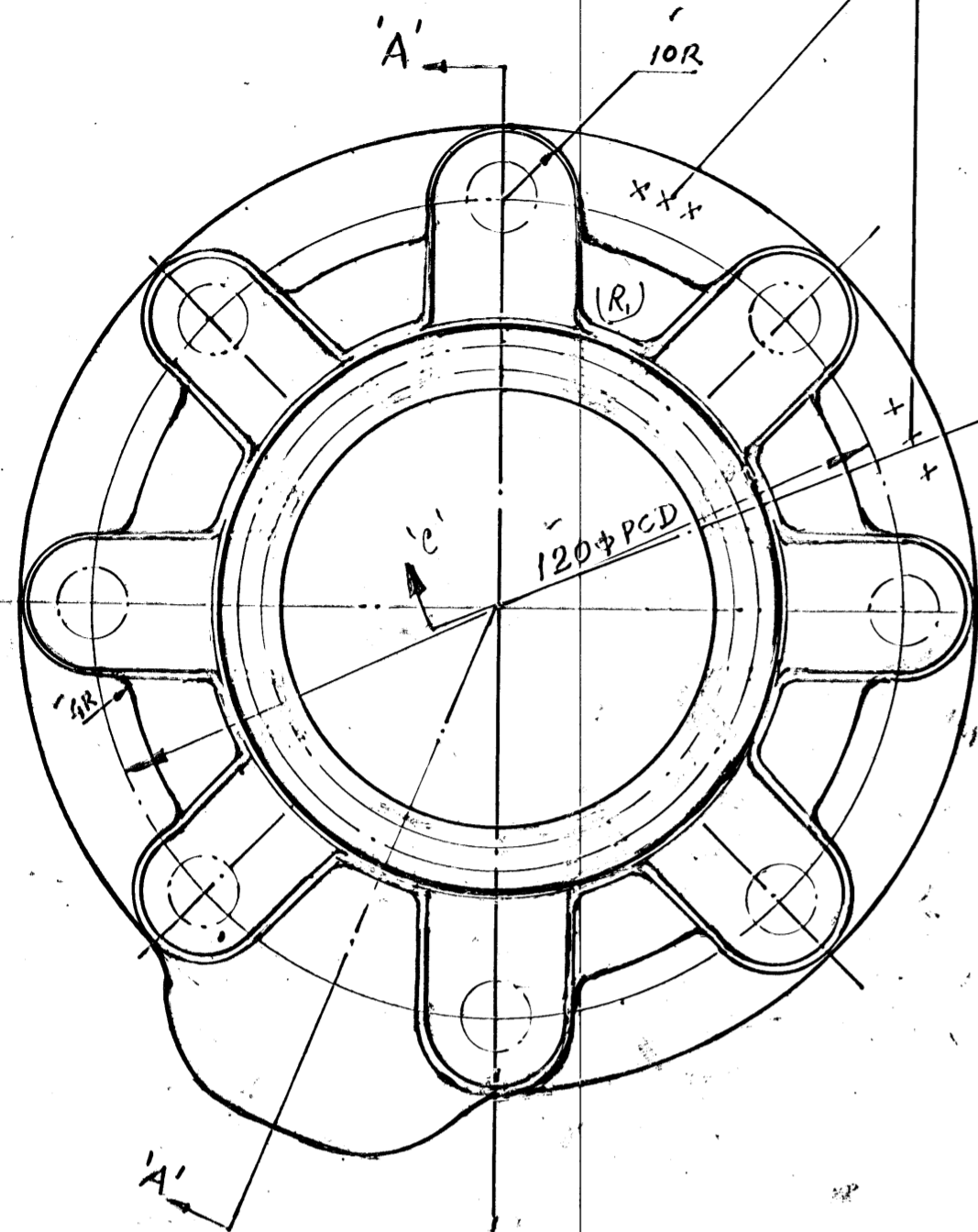


ALL DIMS. ARE IN M.M.

DRG. NO., SUPPLIER'S INITIAL, MFG. MONTH & YEAR TO BE RAISED.



NOTES:-

- FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
- FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO ISS: 3-47-13 BY BRUSHING OR SPRAYING.
- SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
- STEEL SHOULD BE FREE FROM CENTRE SEGREGATION, PIPING, FLAKES ETC.
- DIMS. IN BRACKET INDICATES MACHINING ALLOWANCE.
- CLAMPING FACE FOR 1st MACHINING OPERATION. UUV STOP FACE
- DRAFT ANGLE:- INNER-10°, OUTER-5°
- UNSPECIFIED RADII:- 3R.

MATL:- 45CB  
T3, 60-75  
SS 4027  
CHEM. COMP.

ALT. MATL:-  
PHYSICAL PROP.

HEAT TREATMENT:- NORMALISED  
HARDNESS:- 169 - 211 BHN  
MICRO-STRUCTURE:- FINE FERRITE & PEARLITE  
GRAIN SIZE:- ASTM 5 OR FINER  
INCLUSION RATING:- 3ABCD THIN SERIES OR FINER AS PER IS: 4763-1967. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION

FORGING TOL. AS PER IS 3463-1974					INDEX		ALTERATION					DATE	SIGN.
FORGING WT. (APPROX)	ENVELOP WT.	COMPLE XITY	INTRAC OF MATL.	FORGING GRADE	K <sub>PR</sub>	DRN	TCD	CKD	C/MAN	JWM/TDO	JWM/PR	AWM/TYPE	APPD.
1.5KJ	5.6KJ	S3	M1	NORMAL									
KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.										
HEIGHT	+1.1 -0.5	RASIDUAL FLASH	+0.7										
DIA.	+1.3 -0.7	TRIMMED FLAT	-0.7										
MISMATCH	0.6	ANGULAR	+2° -1°										
STRAIGHTNESS	0.8	RADII	+50% -25%										
INTERNAL DIMS. REVERSE ± & - SIGN.													

(R1)	DRG. MODIFIED & ACCORDINGLY SEC 'C-C' ADDED, AS PER FINISH DRG.		14.6.03	JUN/00
(B)	DRG. MODIFIED & REDRAWN.			
<b>FORGING DRAWING</b>				
<b>FOR:- FLANGE (AXLE HOUSING)</b>				
<b>FRONT AXLE, LPTA-713</b>				
<b>M/S TELCO.</b>				
R.E.F. DRG. NO.			1:1 SCALE	
M/C		T.D.O. SECTION		13-11-2000 DATE
DEMANDED BY			1/1 SHEET	
DRG. NO.			2604.3510.51.02-3(R)	

13/3-2105 A-2 30.6.026