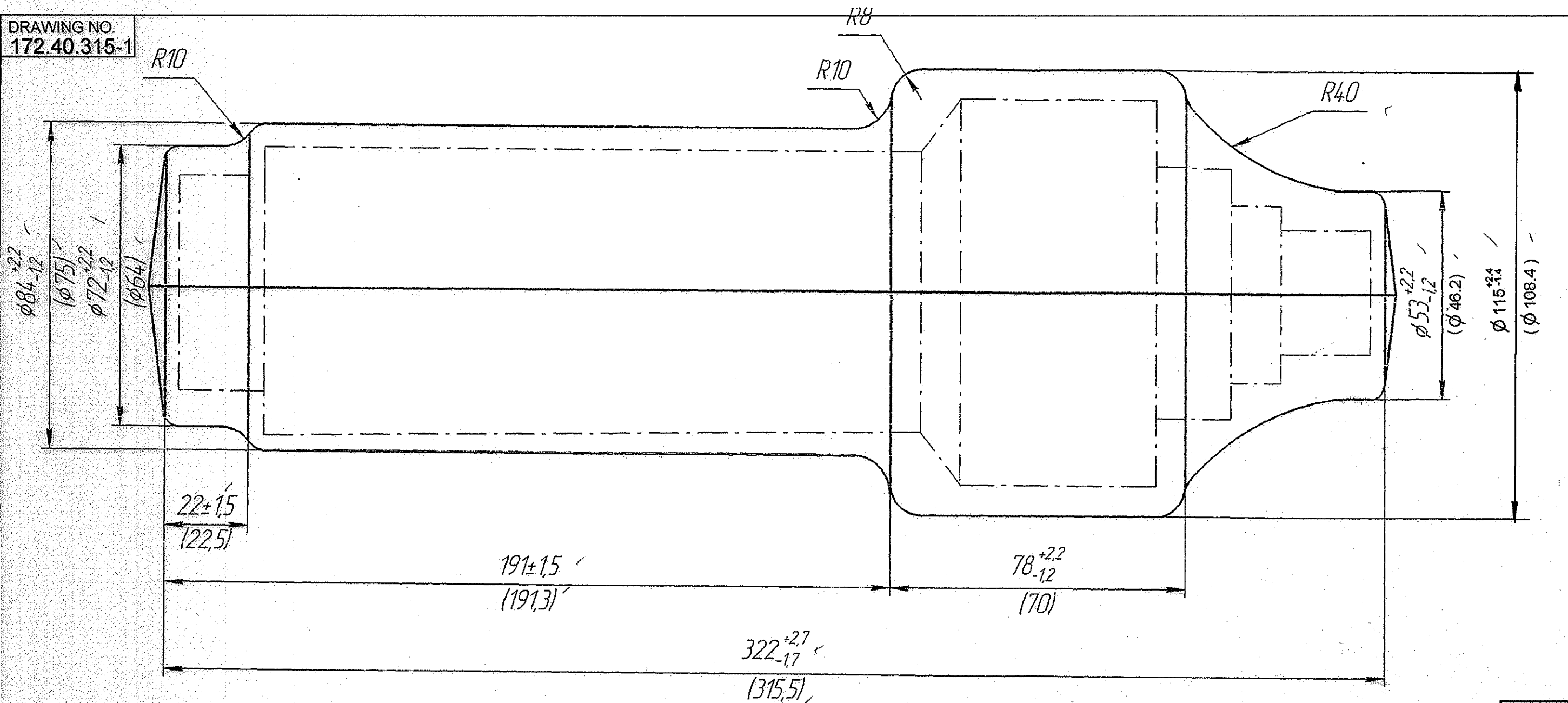


DRAWING NO.
172.40.315-1



T 90

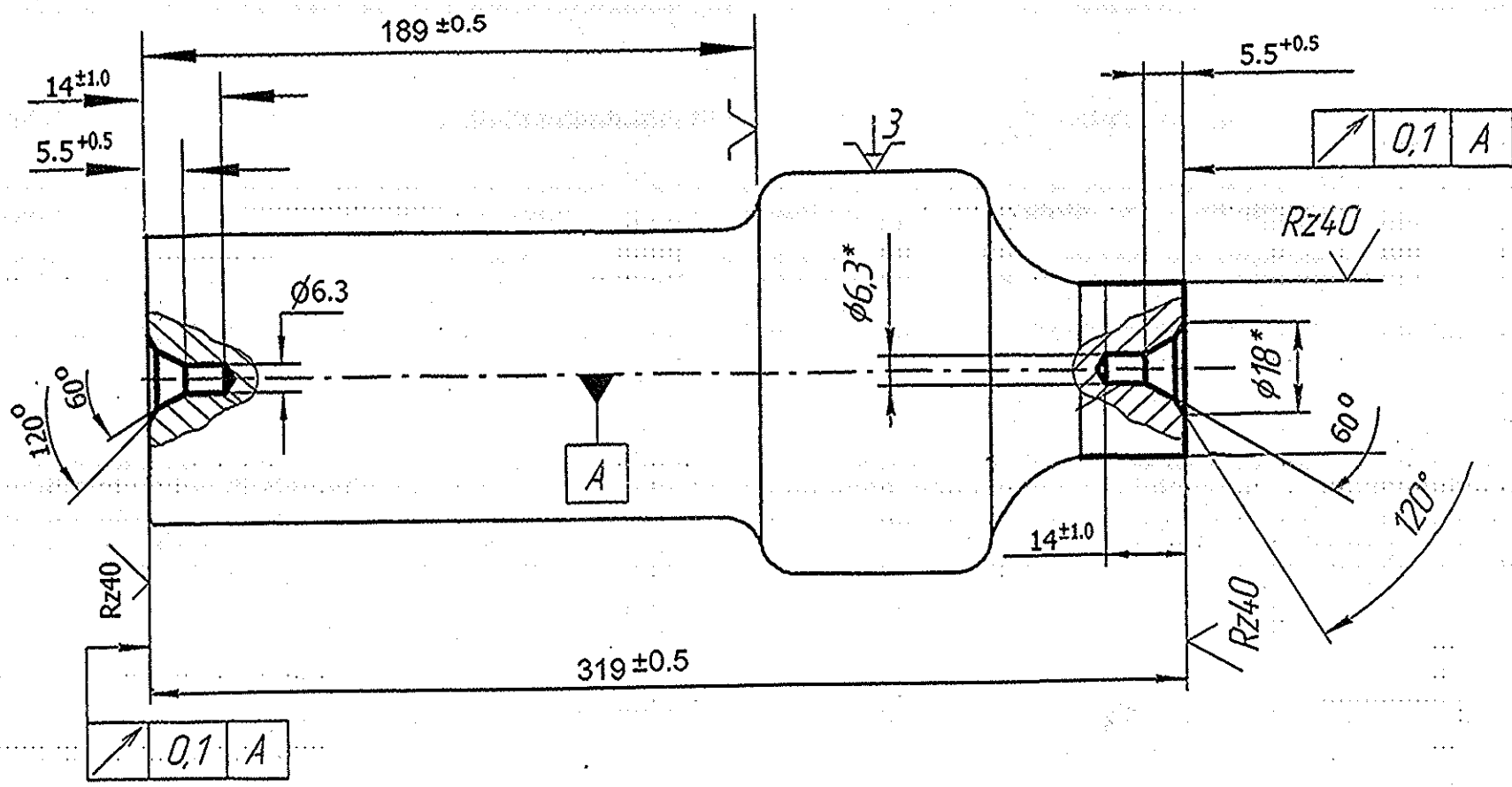
TECHNICAL REQUIREMENTS

- | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p>01. 207.....268 HB.</p> <p>02. BURRS MAY BE ALLOWED ON THE PERIMETER OF CUT UPTO MAX. 1.7 MM.</p> <p>03. DISPLACEMENT ALONG PARTING OF DIE UPTO MAX. 1.2 MM IS ALLOWED.</p> <p>04. BENDING UPTO MAX. 1.2 MM MAY BE ALLOWED.</p> <p>05. UN-SPECIFIED STAMPING DRAFTS - 7° /</p> <p>06. UN-SPECIFIED FILLET RADII - R 4 MM.</p> <p>07. DIMENSIONS IN BRACKETS ARE FOR MACHINING. /</p> | <p>08. DIMENSIONS WITHOUT TOLERANCES ARE FOR MAKING DIE. /</p> <p>09. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS AS WELL AS SLANTED CHIPPING OR FINISHING OF, DEFECTS IN DEPTH UPTO 50% OF ACTUAL ONE SIDE MACHINING ALLOWANCE MAY BE ALLOWED.</p> <p>10. DE-SCALES (SHOT BLASTING) /</p> <p>11. IT IS ALLOWED TO MARK MELT NO. /</p> <p>12. FORGING ACCURACY CLASS II, GROUP OF FORGING M2, CATAGORY OF COMPLEXICITY C1 GOST 7505-89.</p> <p>13. PAINT RED OXIDE. /</p> |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

*for reference only use
T72 dog 175 40-028/F*

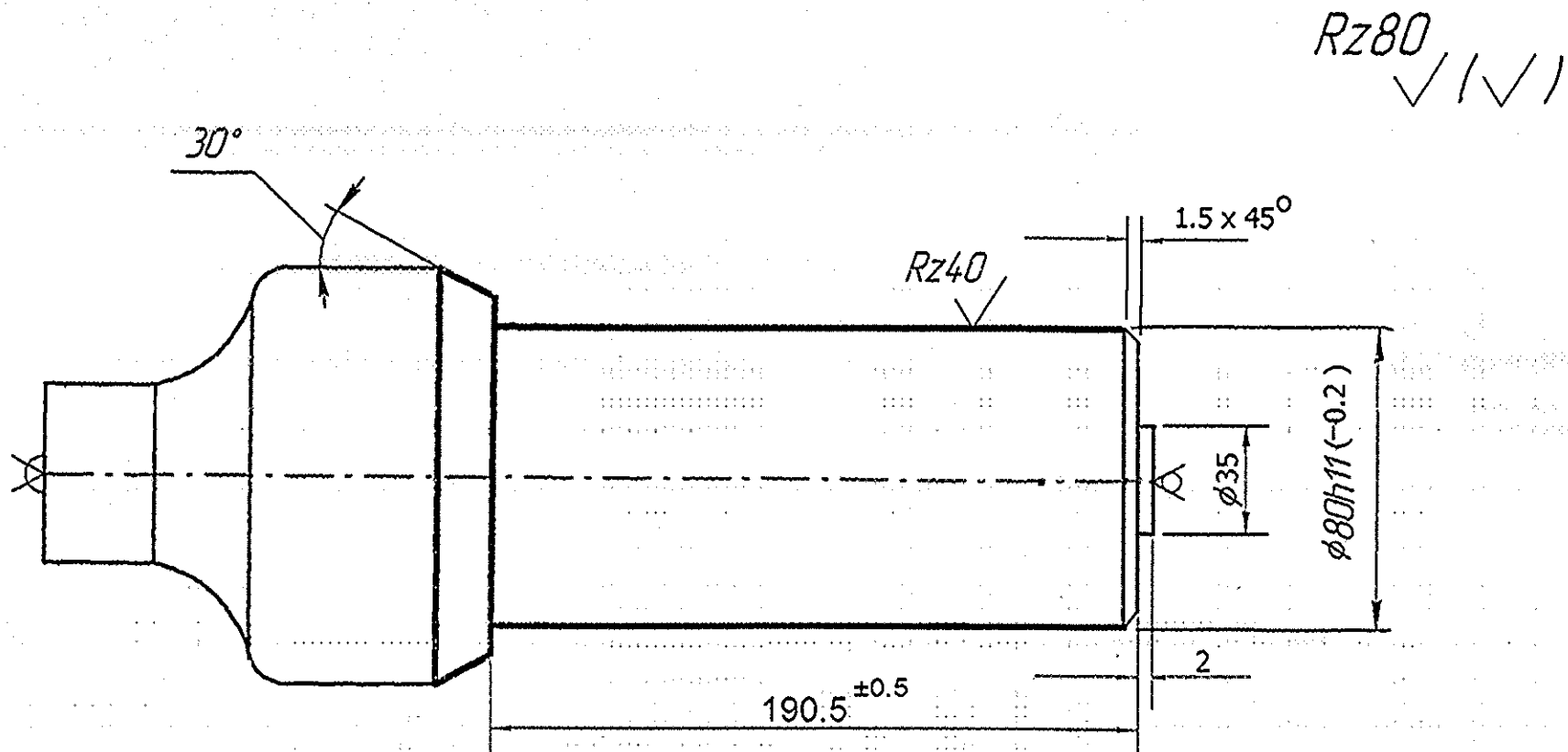
MATERIAL	FORGING WT.	
18X2H4BA GOST 4543-71	16.36 KGS	
ALT. MATERIAL	HAMMER	SCALE
18 X 2H4MA GOST 4543-71	DG-13	NTS
DRAWN	CHECKED	APPROVED
<i>L. Suf/02 02/09/23</i>	<i>M. S. 21/03</i>	<i>S. J. 21/03</i>
DRAWING NO.	172.40.315-1/F	
NOMENCLATURE:	SECONDARY SHAFT	
HEAVY VEHICLES FACTORY		
AVADI, CHENNAI		

Rz80
 ✓(✓)



DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 010 FACING AND CENTERING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

<i>MJ</i>	<i>Me</i>	<i>df</i>
PREPARED	CHECKED	APPROVED

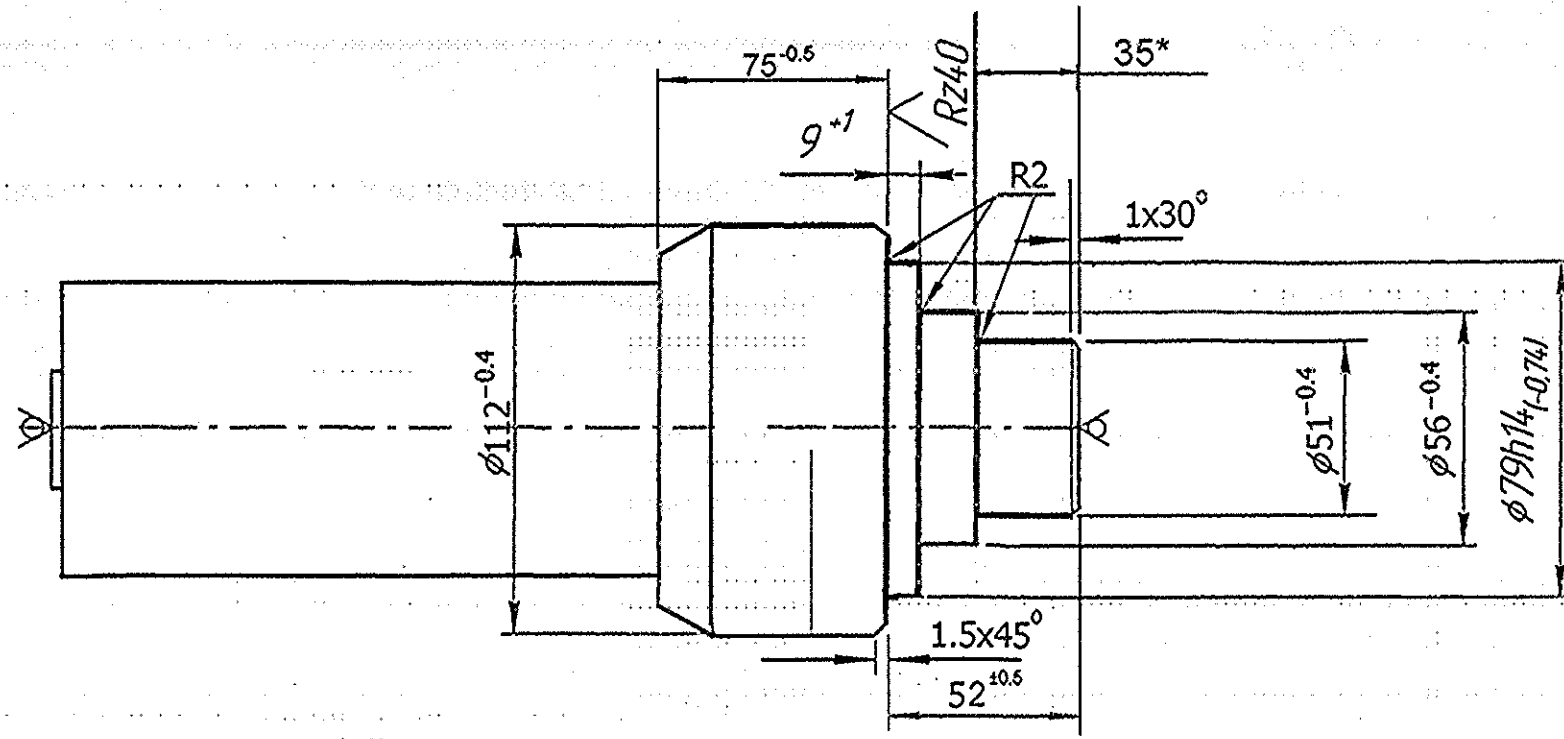


1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS
OF CENTER HOLES SHOULD BE 0.3mm MAX

DRG. NO	: 172.40.315-1 /SMF DRIVEN SHAFT
OPN. NO.	: 030 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	: NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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Rz80
✓(✓)

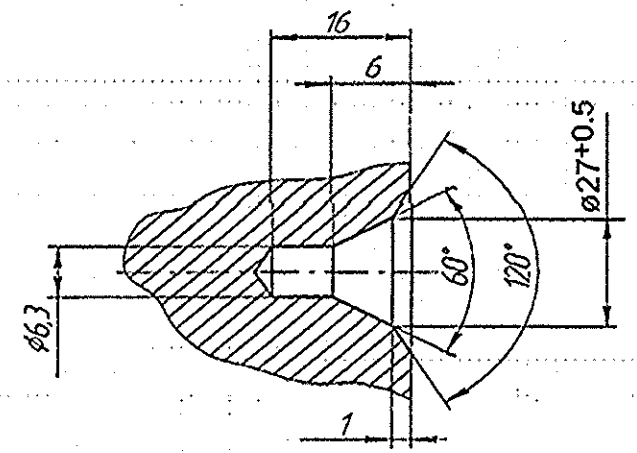
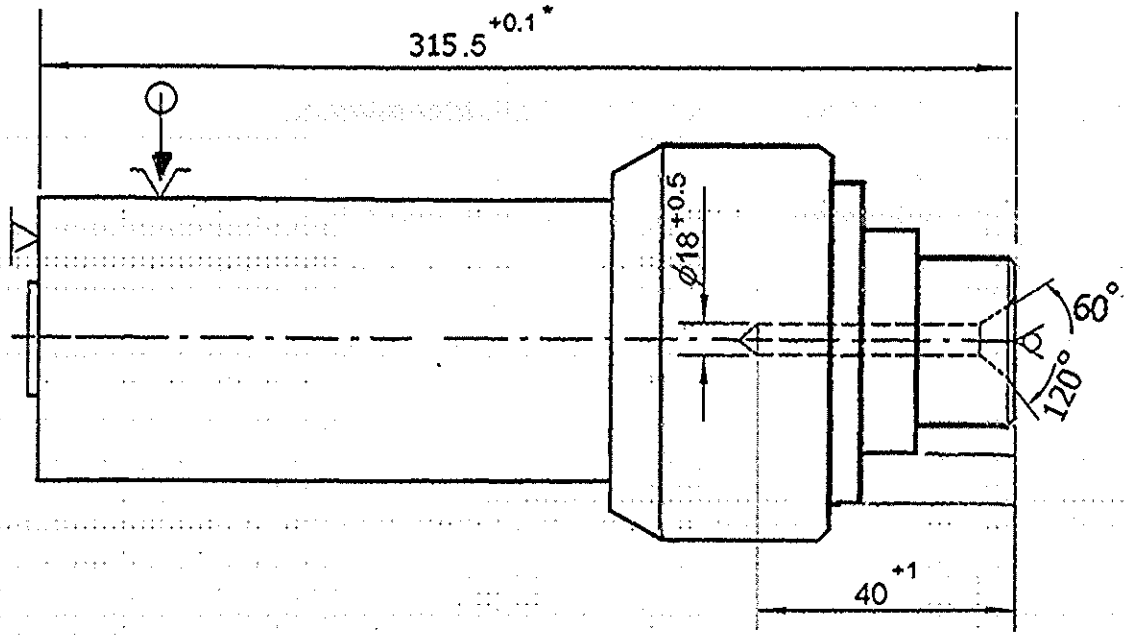


1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS OF CENTER HOLES SHOULD BE 0.3mm MAX

DRG. NO	: 172.40.315-1/SMF. DRIVEN SHAFT
CPN. NO.	: 040 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

PREPARED	CHECKED	APPROVED

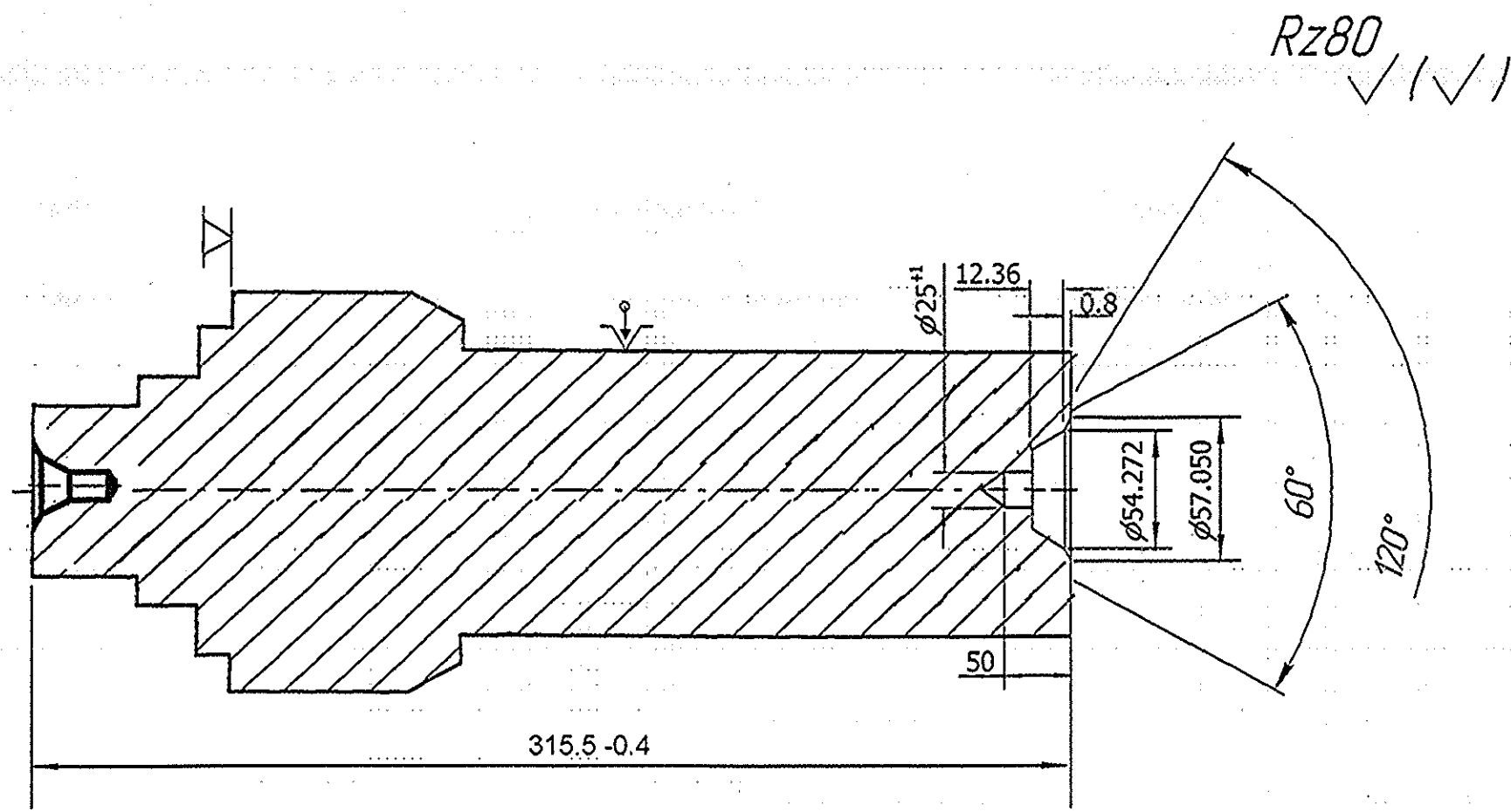
Rz80
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1. RUNOUT OF MACHINED SURFACE WITH RESPECT TO AXIS OF CENTER HOLES MAY BE UPTO 0.3mm MAX

DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 045 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

PREPARED		CHECKED		APPROVED	
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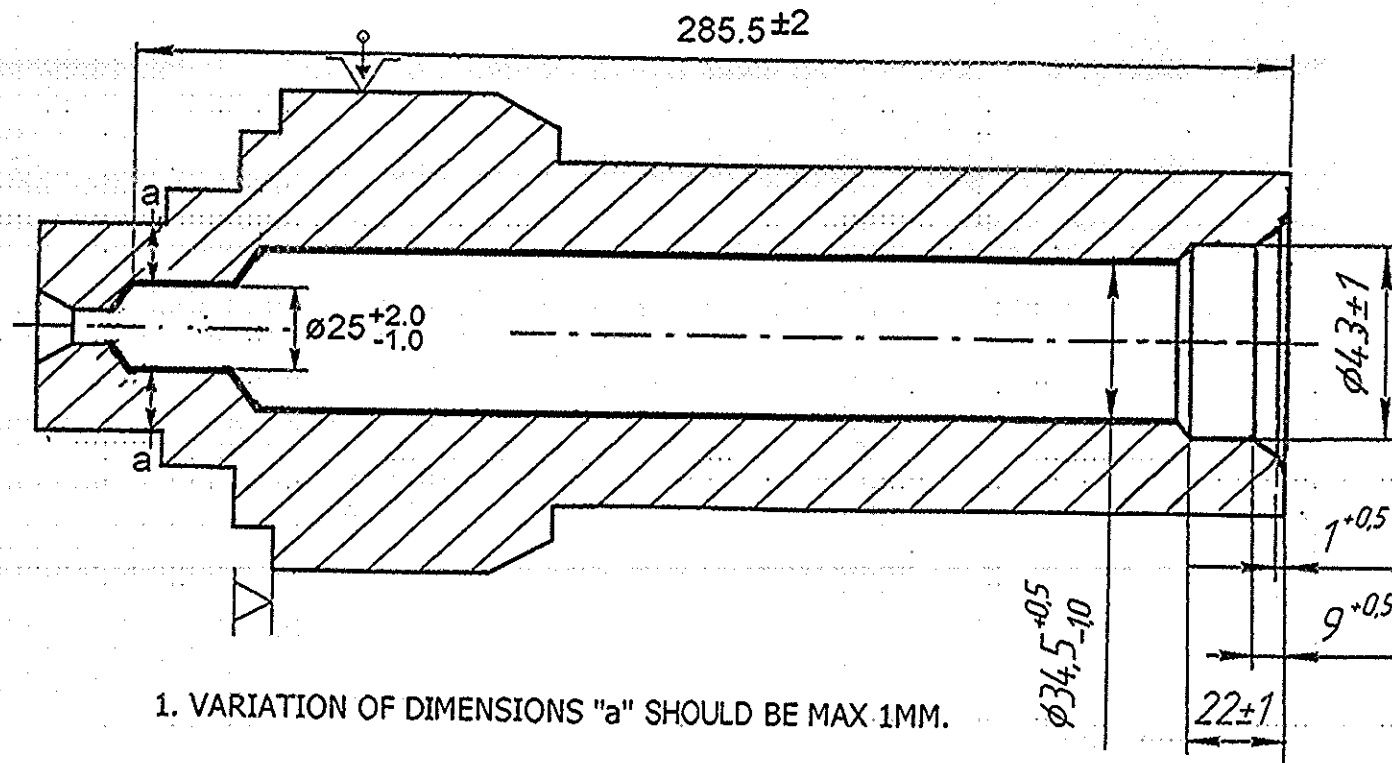


1. RUN-OUT BASE SURFACES WITH RESPECT TO CENTERS IS ALLOWED UPTO 0.3MM MAX.

DRG. NO	: 172.40.315-1 / SMF DRIVEN SHAFT
OPN. NO.	: 050 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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Rz80
 ✓(✓)

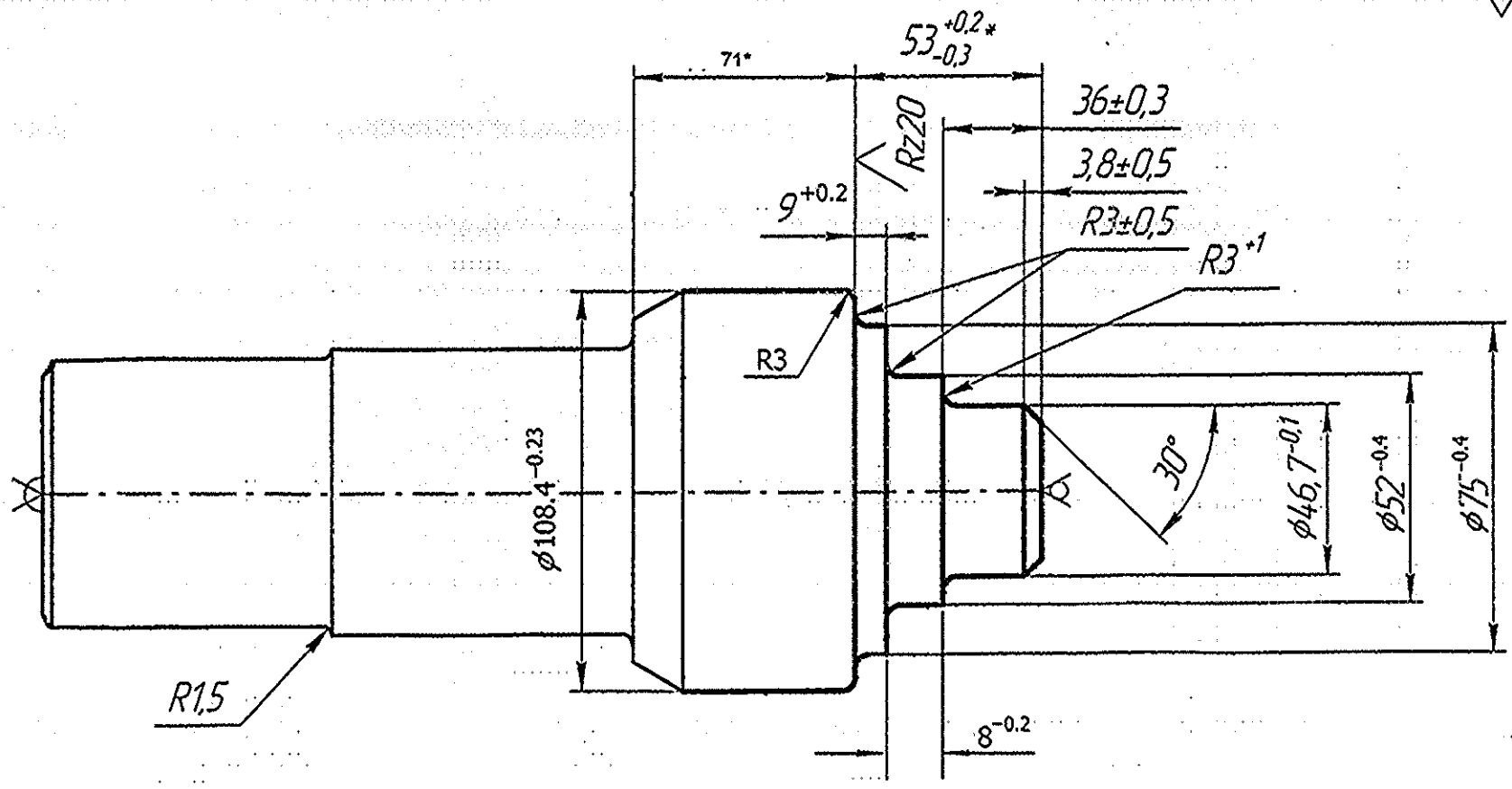


1. VARIATION OF DIMENSIONS "a" SHOULD BE MAX. 1MM.

DRG. NO	: 172.40.315-1	DRIVEN SHAFT
OPN. NO.	: 055	DRILLING
MATERIAL	: STEEL	18X2H4BA
HARDNESS	: 207-268	BHN
SHEET NO.		NOT TO SCALE

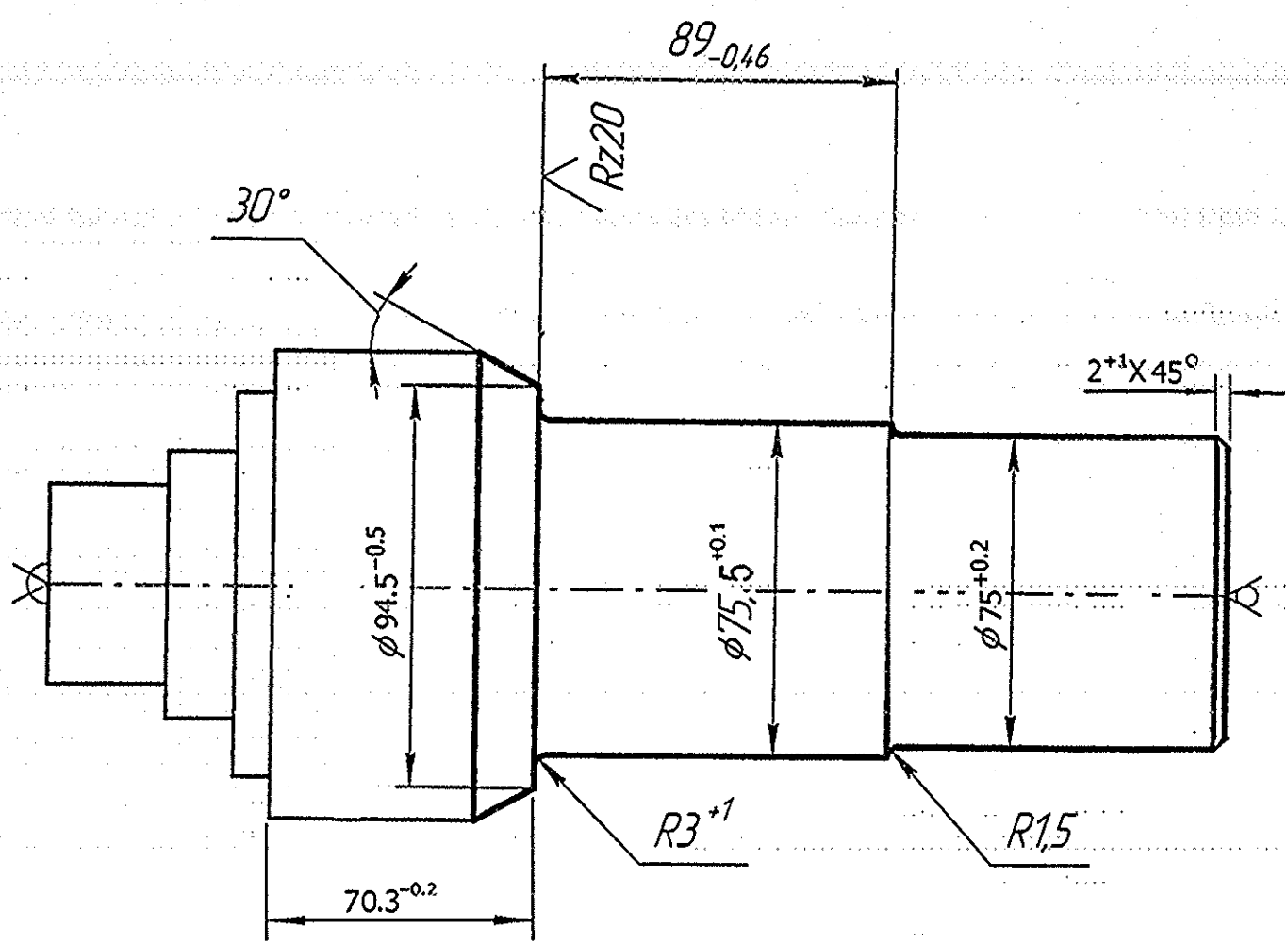
PREPARED	CHECKED	APPROVED

Rz40
 ✓ (✓)



DRG. NO	: 172.40.315-1 /SMF DEIVEN SHAFT
OPN. NO.	: 060TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.	NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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DRG. NO	: 172.40.315-1/SMF DRIVEN SHAFT
OPN. NO.	: 070 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207-268 BHN
SHEET NO.
NOT TO SCALE	

<i>Mj</i>	<i>De</i>	<i>ok</i>
PREPARED	CHECKED	APPROVED