



TECHNICAL REQUIREMENTS

01. UN-SPECIFIED FILLET RADII - R 5.
02. UN-SPECIFIED STAMPING DRAFTS - 7°
03. DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING.
04. DIMENSIONS WITHOUT TOLERANCES ARE GIVEN FOR MAKING DIES - NEED NOT BE CHECKED.
05. MARK CODE OF SHOP - INCHARGE.
- Ⓐ 06. HEAT TREATMENT ≤ 255 HB
07. DE-SCALES (SHOT BLASTING)
08. SURFACE DEFECTS AND DEPRESSIONS DUE TO SCALES IN DEPTH MAY BE NOT MORE THAN 0.5 OF ACTUAL MACHINING ALLOWANCE.
09. SHIFT (MISALIGNMENT OF AXES OF DIES) MAY BE UPTO 1.5 MM.
10. PROJECTION DUE TO REMOVAL OF BURR ALONG THE PARTING LINE OF DIES SHOULD NOT BE MORE THAN 1.5 MM, CONTINUOUS BURR IN HOLE AND AT PLACE "A" MAY BE UPTO 4.0 MM.
11. WARPAGE MAY BE UPTO 1.5 MM.
12. ECCENTRICITY OF BROACHED HOLE MAY BE UPTO 3.5 MM.
13. PAINT RED OXIDE.

T 90

Ⓑ NOTE: FORGING IS COMMON FOR T-90 AND T-72 COMPT, 172.40.270/F.

B	NOTE ADDED DIA. 254 WAS DIA. 260. MODIFIED AS PER JWM/TRANS LIR NO. 07271/TRANS/MATH PLG/ T-90 DT 14.3.08	24/3/08
A	HEAT TREATMENT ≤ 255 HB EQUAL OR LESSER THAN 255 HB WAS ≤ 268 HB. MODIFIED IN LINE WITH T-72. AS PER JWM/FS REQUIREMENT DT. SEP 2007.	24/3/08
ISS.	MODIFICATION	DATE

MATERIAL	FORGING WT.	
38XC GOST 4543-71	31.0 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-32	NTS
DRAWN	CHECKED	APPROVED
<i>A. Suf</i> 27/8/03	<i>M. S.</i> 23/10/03	<i>S. S.</i>
DRAWING NO. 172.40.270-1/F		
NOMENCLATURE: BOOSTER		

HEAVY VEHICLES FACTORY
AVADI, CHENNAI