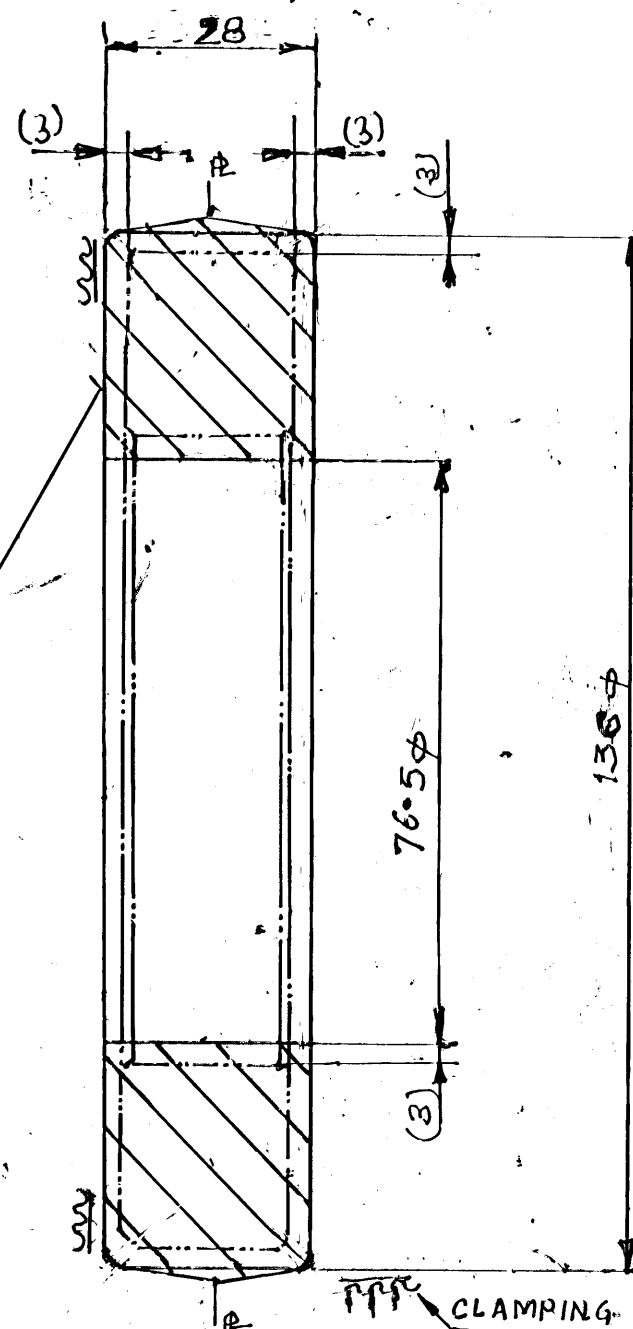


ALL DIMENSIONS ARE IN M.M.

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



NOTE:-

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALLOVER
2. FORGING TO BE SHOT BLASTED.
3. FORGING TO BE COATED WITH RED OXIDE PRIMER TO ISS: 3-47-13 BY BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
5. DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
6. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
7. DRAFT ANGLE - 3°
8. UNSPECIFIED RADII - 2.5R
9. CLAMPING FACE & STOP FACE FOR 1ST MACHINING OPERATION.

MATL. BS-970
EN 8 STEEL STAMP

EQT. MATL.

CHEMICAL COMPOSITION IN % OF EN8
C = 0.35-0.45
Si = 0.05-0.35
Mn = 0.6-1.0
S = 0.06 MAX.
P = 0.06 MAX.

PHYSICAL PROPERTIES
T.S. = 35 T/Sq. in. Min.
Y.S. = 18 T/Sq. in. Min.
ELONG. = 17% Min.

HEAT-TREATMENT:- NORMALISED

HARDNESS:- 152-207 BHN

MICRO-STRUCTURE:- FINE FERRITE AND PEARLITE

GRAIN SIZE:- ASTM 5 OR FINER

INCLUSION RATING: 3A B C D THIN

SERIES OR FINER AS PER IS: 4163

1967. STEEL SHOULD NOT HAVE ANY

LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION

FORGING TOL. AS PER IS: 3469-74

FORGING WEIGHT	ENVELOP WEIGHT	COMPLE. XITY.	INTRAC. OF MATL.	FORGING GRADE
2.28 kg	3.28 kg	S ₁	M ₁	NORMAL

KIND OF DIM.	TOL.	KIND OF DIM.	TOL.
THICK.	+0.9 -0.5	RESIDUAL FLAT	+0.8
DIA	+1.3 -0.7	TRIMMED FLAT	-0.8
MISMATCH	0.7	ANGULAR	+2° -1°
STRAIGHTNESS	0.8	RADII.	+50% -25%
INTERNAL DIMS. REVERSE SIGN. + & -			

INDEX	ALTERATION						DATE	SIGN
DRN	TCD	CKD	JWM/TDO	JWM/PR	WM/HT	APPD/DRG	APPD	
FORGING DRAWING FOR:- RING FOR OIL SEAL OUTER FOR M/S. ASHOK LEYLAND LTD.							REF. DRG. No.	1:1 SCALE
ASSY - XL							M/C.	T.D.O
VEHICLE FACTORY JBP.							SECTION	DATE
							DEMANDED BY 138/TPE/ MATL./FT.XL/RXL/13. DATED:- 5/12/98	1/1 SHEET
							DRG. No.	
							F0741011 - 3	

13/1-1126

31.3.037

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