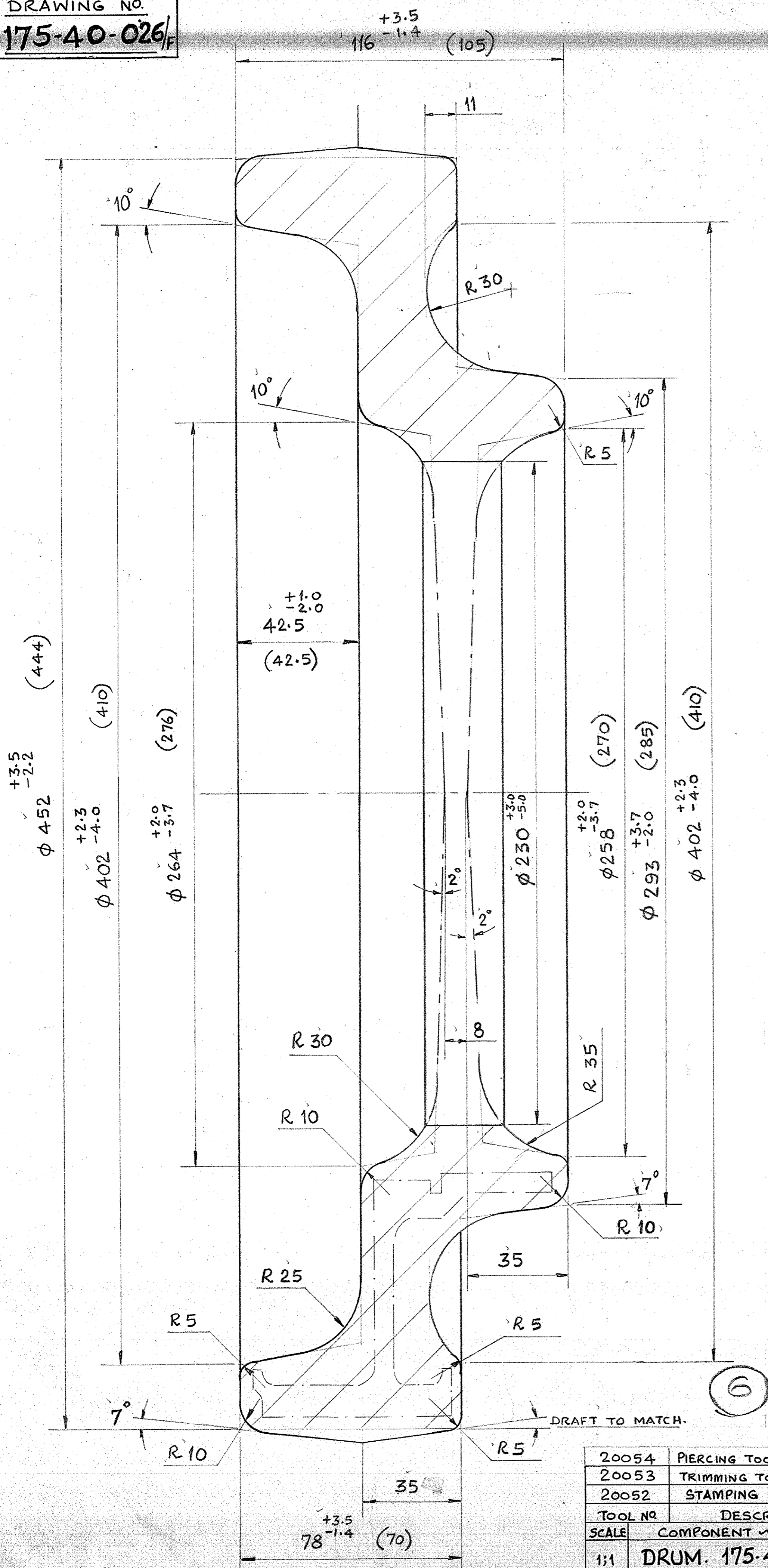


DRAWING NO.  
175-40-026/F

ISSUE	MODIFICATIONS	DATE.



TECHNICAL REQUIREMENT.

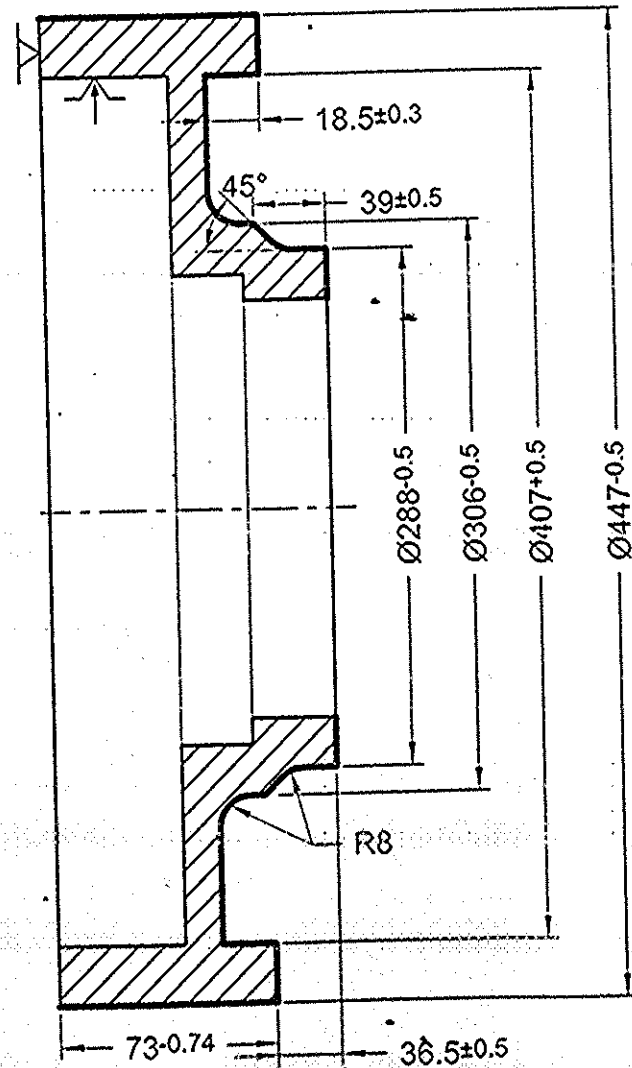
1. STAMP IDENTIFICATION MARK.
2. HEAT TREAT. DIA. OF IND.  $\geq 3.8$ .
3. DESCALE.
4. SURFACE DEFECTS AND PIT MARKS DUE TO SCALES. UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE IS ACCEPTABLE.
5. MISMATCH NOT TO EXCEED 1.8 mm.
6. RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 2.4 mm, IN PIERCED HOLE NOT TO BE MORE THAN 4 mm.
7. ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED 4 mm.
8. UNSPECIFIED DRAFTS TO BE 7°.
9. MACHINING DIMENSIONS ARE SHOWN IN BRACKET.
10. UNTOLERANCED DIMENSIONS ARE NOT TO BE CHECKED.
11. UNSPECIFIED RADII TO BE R.5mm.

MATERIAL :- 38 XC GOST 4543-71

WEIGHT OF FORGING :- 53.7 Kg

20054	PIERCING TOOL	1500T	
20053	TRIMMING TOOL	1500T	
20052	STAMPING DIES.	DG 32	
TOOL NO	DESCRIPTION	MACHINE	EQUIPT. TO BE USED.
SCALE	COMPONENT v T-72.	MACHINE	COMPONENT /FORGING
1:1	DRUM. 175-40-026	DG 32	1.
			H.V.F. AVADI.
			DRAWING NO.
FORGING DRAWING.			175-40-026/F

DGN.	CHD.	APPD.	AUTHD.



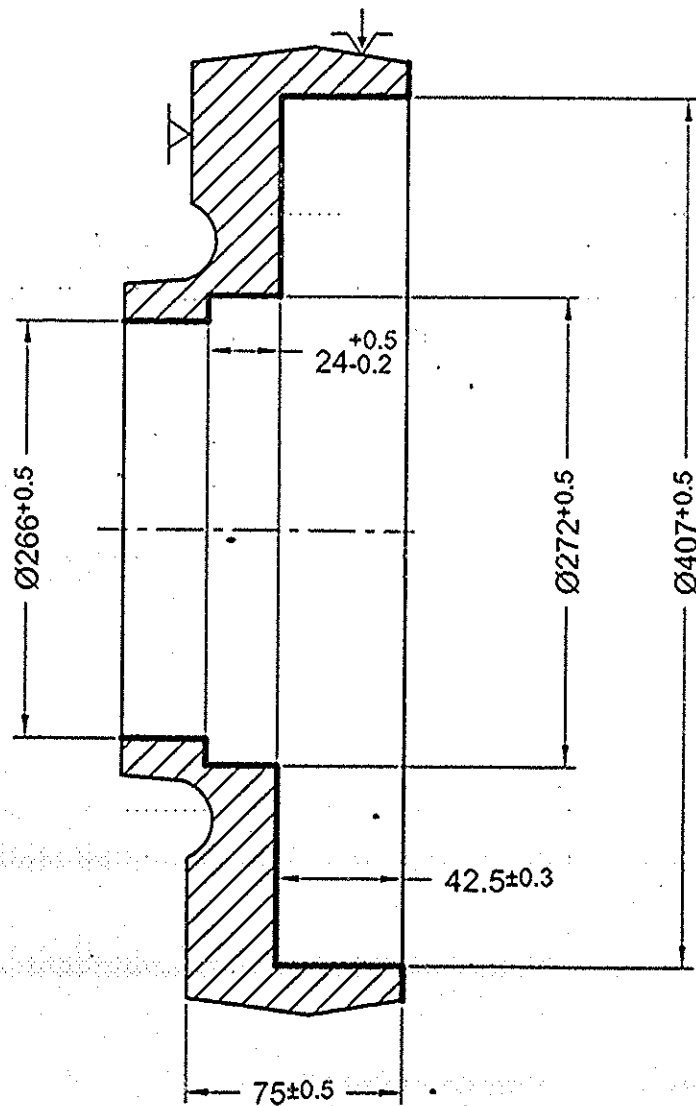
DRG NO.	: 175.40.026/SMF, DRUM
OPN NO.	: 20 TURNING
MATERIAL	: STEEL 38xC GOST 4543-71
HARDNESS	: 255 BHN
SHEETNO.	: NOT TO SCALE

PREPARED	CHECKED	APPROVED

VIJAYANAND. A  
JWM/TRG.

S. SARAYANAN.  
JWM/TRG.

K. DURAIRAJ.  
JWM/TRG (HOS)



DRG NO. :	175.40.026/SMF, DRUM
OPN NO. :	10 TURNING
MATERIAL :	STEEL 38xC GOST 4543-71
HARDNESS :	255 BHN
SHEETNO. :	NOT TO SCALE

*[Signature]*  
 PREPARED

*[Signature]*  
 CHECKED

*[Signature]*  
 APPROVED

VIJAYANAND.A  
 JWM/TRG.

S. SARAYANAN  
 JWM/TRG.

K. DURAIRAJ.  
 JWM/TRG (HOS).