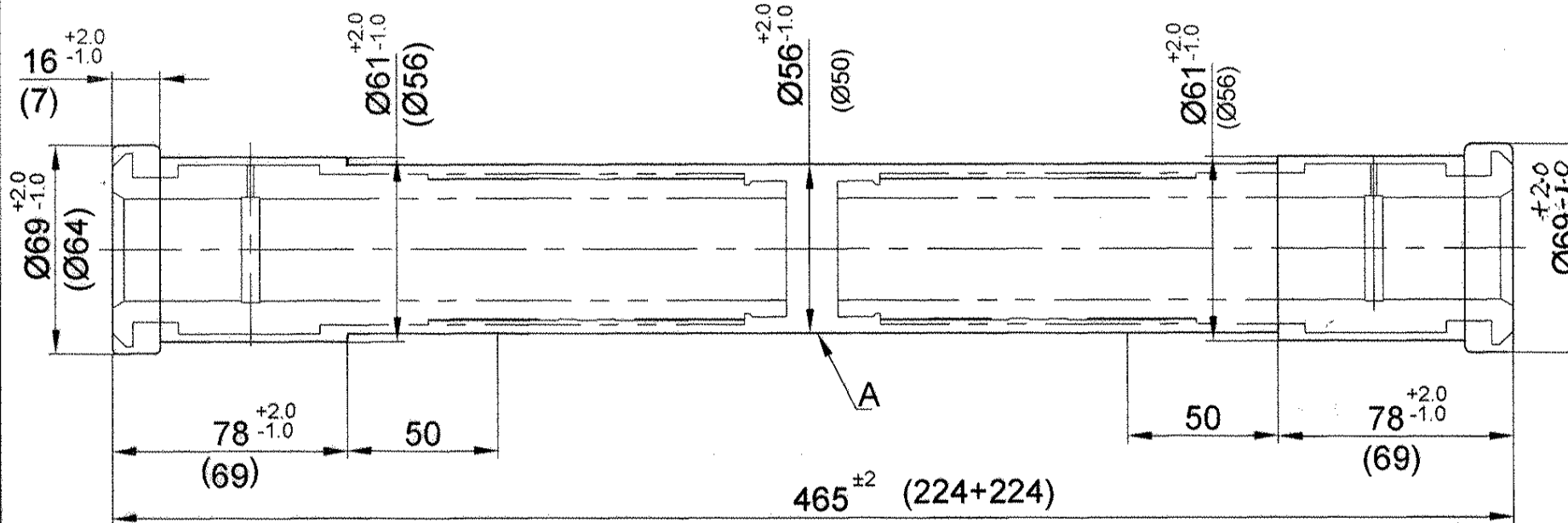


TECHNICAL REQUIREMENTS



- HEAT TREAT. DIA. OF IND 3.7 - 4.2 mm.
- DESCALE.
- DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING.
- MISMATCH SHOULD NOT EXCEED 0.1 mm.
- RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 1.2 mm. ALONG Ø69 mm-UPTO 4 mm.
- BEND ALLOWED IS MAX 1.2 mm., TO BE CHECKED IN SECTION 'A' (BULGING OF MAX. Ø58 mm IS ALLOWED OVER A LENGTH 50 mm.)
- SHAFT OF Ø69 HEAD RELATIVE TO AXIS SHOULD NOT EXCEED 1.0 mm.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UNTOLERANCED DIMENSIONS ARE FOR CONSTRUCTION.
- ELLIPTICITY WITHIN THE LIMITS OF TOLERANCE IS ALLOWED.
- MAY BE MANUFACTURED FROM STEEL 18X2H4MA GOST 4543-71.
- MARK PART NO.
- PAINT RED OXIDE.
- PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

CHEMICAL COMPOSITION (%)			MECHANICAL PROPERTIES		
ELEMENT	STEEL 18 x 2 H4 BA GOST 4543-71	STEEL 835M15 (EN-39 B) BS: 970-83	DESCRIPTION	STEEL 18 x 2 H4 BA GOST 4543-71	STEEL 835M15 (EN-39 B) BS: 970-83
C	0.14 - 0.20	0.12 - 0.18	TEST BAR DIA.	-----	19 mm
Si	0.17 - 0.37	-----	ULTIMATE STRENGTH	105 Kgf/mm ² MIN.	1310 MPa MIN
Mn	0.25 - 0.55	0.25 - 0.50	YIELD STRENGTH	80 Kgf/mm ² MIN.	-----
Cr	1.35 - 1.65	1.00 - 1.40	RELATIVE ELONGATION	12 % MIN.	8 % MIN.
Ni	4.00 - 4.40	3.90 - 4.30	REDUCTION OF AREA	50 % MIN.	-----
Mo	0.30 - 0.40	0.15 - 0.30	HARDNESS BHN	207-269	207-269
S	0.025 MAX	0.025-0.050	IMPACT STRENGTH	12 Kgf.m/cm ² MIN.	-----
P	0.025 MAX	0.035 MAX.	IZOD	-----	25 MIN.
Cu	0.30 MAX	-----	KCV (CHARPY)	-----	28 MIN.

ALTERNATE MATERIAL : STEEL 835M15 (EN-39 B) TO BS: 970-83
 AUTHORITY : CQA(HV) LETTER No. 091/IFD/IND-V/MTPF/OE DATED 17-03-2005



DRIVING SHAFT		STEEL 18x2H4BA	GOST 4543-71	MASS = 10.1 Kg.			
संख्या NO.OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाणु DIMENSIONS	अभ्यक्ति REMARKS	
सामान्य सहिष्णुता GENERAL TOLERANCE							
रेखिक परिमाणु LINEAR DIMENSION							
0-6	±0.1						
6-30	±0.2						
30-120	±0.3						
120-315	±0.5						
315-1000	±0.8						
1000-2000	±1.2						
कोणिक परिमाणु ANGULAR DIMENSION		संख्या NO.OFF	संबंधित पुर्जा क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2006 दिनांक DATE	नाम NAME
1-10	±1'						
10-50	±30'						
50-100	±20'						
>100	±10'						
मापोंक 'म्यू एम' में VALUE IN 'μm'							
-	>25						
▽	8-25						
▽▽	1.6-8						
▽▽▽	0.025-1.6						
▽▽▽▽	<0.025						
DRIVING SHAFT (FORGING) (FOR 2 COMPONENTS) FOR COMP DRG NO.172-47-148 TRANSMISSION GEAR UNIT CODE-45 / T-72 & T-90				मापमान SCALE	आरेखित DRAWN	16-06	VML
				1:2	जाँचा CHECKED	29.06	A
					अनुमोदित APPROVED	21/06	F
				द्वारा बदला BY	REPLACED FOR		
मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				कार्यालय OFFICE	हेतु बदला FOR		
				D.O.	आरेखण क्र. DRAWING NO.		
					172 - 47 - 148 / F		

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मूलमाप व अन्वयोजन NOMINAL SIZE & FIT
 विचलन DEVIATION