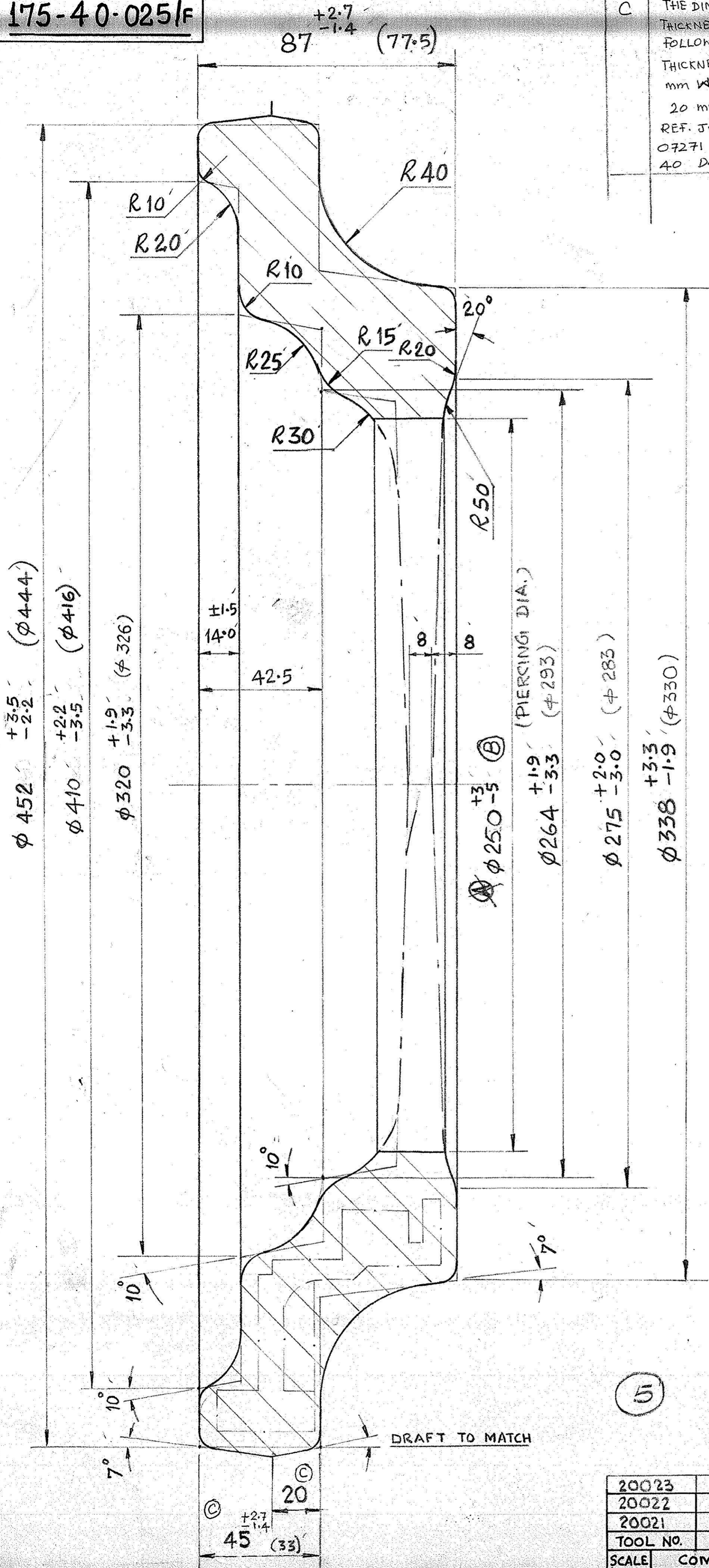


DRAWING NO.
175-40-025/F

ISS.	MODIFICATION	DATE	ISSUE	MODIFICATION	DATE
C	THE DIMNS. AT FLANGE THICKNESS MODIFIED AS FOLLOWS. THICKNESS DIMN. $4.5^{+2.7}_{-1.4}$ mm WAS $4.1^{+2.7}_{-1.4}$ mm. 20 mm WAS 16 mm. REF. JWM/TRANS IIT NO. 07271/TRANS/MATL.PLG/40 DATED 13.01.2006.	17/1/06	A	PIERCING DIA. 220^{+3}_{-5} WAS 250^{+3}_{-5} (AVOIDING PIERCING PROBLEM, SUGGESTED BY JWM/FS DT.24.4.2K	26/4/2K
			B	PIERCING DIA 250^{+3}_{-5} WAS 220^{+3}_{-5} CORRECTED AS PER JWM/FS INSTRUCTION ON 22.09.2005	22/9 22/9



TECHNICAL REQUIREMENTS

1. STAMP IDENTIFICATION MARK.
2. HEAT TREAT. DIA. OF IND. ≥ 3.8
3. DESCALE.
4. DEPTH OF SURFACE DEFECTS AND PIT MARKS DUE TO SCALES UP TO 0.5 OF ACTUAL MACHINING IS ACCEPTABLE.
5. RESIDUAL FIN ALONG PARTING LINE UP TO 2.1mm IS ACCEPTABLE.
6. FOLDING OF FIN IN PIERCED HOLE IS ALLOWED.
7. BUCKLING SHOULD NOT EXCEED 1.0 mm.
8. MISMATCH SHOULD NOT EXCEED 1.6 mm.
9. ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED 3.0 mm.
10. UNSPECIFIED DRAFTS TO BE 7°.
11. UNSPECIFIED RADII TO BE R5mm.
12. MACHINING DIMENSIONS ARE GIVEN IN BRACKETS.
13. UNTOLERANCED DIMENSIONS ARE NOT TO BE CHECKED.

MATERIAL:- STEEL 38XC
GOST 4543-71.

WEIGHT OF FORGING:- 40.0 Kg.

20023	PIERCING TOOL	1500T	
20022	TRIMMING TOOL	1500T	
20021	STAMPING DIES.	DG-32	
TOOL NO.	DESCRIPTION	MACHINE	EQUIPMNT. TO BE USED.
SCALE	COMPONENT ~ T-72.	MACHINE	COMPONENT / FORGING.
1:1	175-40-025 GEAR	DG32	1.
DGN.	CHD.	APPD.	AUTHD.
FORGING DRAWING.			H.V.F. AVADI. DRAWING NO. 175-40-025/F