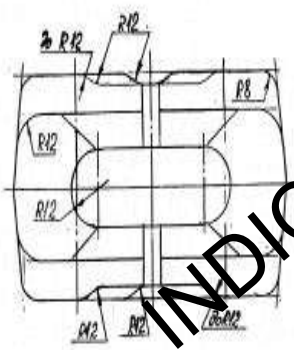
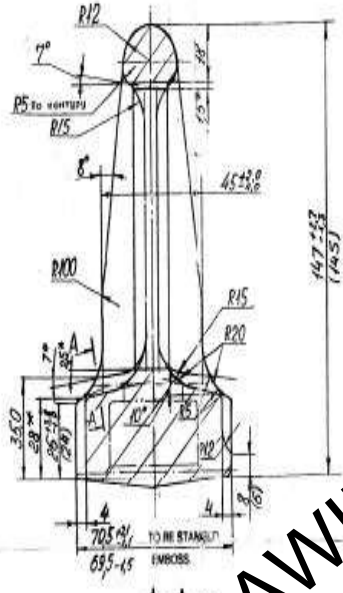
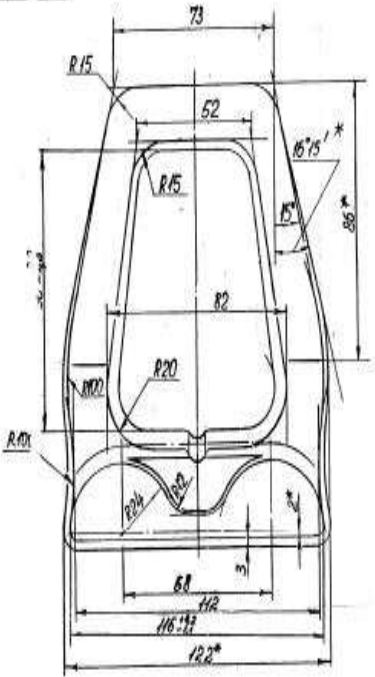


DRG NO
172.55.013/F

MODIFICATIONS & ADDITIONS	
SR	DESCRIPTION



These drawings are only for reference. Actual drawings may be different and shall be issued at the time for procurement.

TECHNICAL REQUIREMENTS

- GROUP 8, 8057 8470-70
- FORGING PARAMETERS 15, 16, 17, 18 CODE 7003-80
- HARDNESS 170-200 HBW (DIA. OF INDENT. 1.0-4.5 MM)
- * DIMENSION FOR REFERENCE
- UNFINISHED DRAFT ANGLE 5°
- UNFINISHED DIA. 3.0 MM
- TOLERANCE OF SURFACE FINISH ALONG SURFACE OF PARTING LINE OF DIM - 1.0 MM. PERMISSIBLE LIMIT VALUE OF RESIDUAL FIN 1.3 MM.
- PERMISSIBLE LIMIT OF WARP ALONG CONTOUR OF CUTTING - 0.15 MM IN HOLES - 0.15 MM
- TOLERANCE OF FLATNESS AND CURVATURE = 1.0 MM
- DIMENSIONS WITH UNSPECIFIED LIMIT DEVIATION NEED NOT BE CHECKED
- TOLERANCE OF CONCENTRICITY OF PIERCED HOLE 0.5 MM
- FOLLOWING LOCAL DEFECTS ARE ALLOWED ON UNMACHINED SURFACES WITHOUT RECTIFICATION: DENT, HOLE, SCALE AND TOOL MARKS IN AN AREA NOT MORE THAN 50% OF THE SURFACE AND DEPTH NOT MORE THAN 1MM. WHEEL GRIND LAPS AND ROLLING DEFECTS OF SUPPLY MATERIAL WITH DEPTH NOT MORE THAN 1MM. ANYWHERE IN AREA NOT LESS THAN 10 MM FROM THE BASE OF THE TRACK GUIDE WHEN THE LENGTH OF ONE DEFECT IS NOT MORE THAN 40 MM. TOTAL NUMBER OF ALL SURFACE DEFECTS WITHOUT DRESSING SHOULD NOT BE MORE THAN TWO PER COMPONENT. SLIGHT DRESSING OF DEFECTS WITHIN THE TOLERANCE LIMIT OF THE CORRESPONDING DIMENSION IS ALLOWED.
- ON THE MACHINED SURFACES DEFECTS WITHOUT RECTIFICATION ARE ALLOWED IF THEIR DEPTH AFTER DRESSING DOES NOT EXCEED 50% OF THE ACTUAL MACHINING ALLOWANCE.
- DE-SCALE (SHOT BLASTING)
- ACCEPTANCE STAMP ON ALL COMPONENTS
- MARK THE DRG NO AND BATCH NO. ON LABEL ON TWO COMPONENTS FROM THE EVERY BATCH OF PRODUCTION
- PAINT RED-OXIDE

INDICATIVE DRAWING

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FOR REFERENCE ONLY

OFM 32850

MATERIAL		FORGING WT.	
STEEL 38XC	4.0 KGS		
8057 4043-71			
ALT. MATERIAL	HARDNESS	SCALE	
	DC-8	NTS	
DRAWN	CHECKED	APPROVED	
DRAWING NO. 172.55.013/F			
NOMENCLATURE: TRACK GUIDE			
HEAVY VEHICLES FACTORY			
APAC, CHENNAI			