



1. Steel group M2 as per GOST 7505-74
2. Degree of complexity C 3 as per GOST 7505-74
3. Manufacture accuracy class II as per GOST 7505-74
4. Furnace heating for forging.
5. Normalization, high - temperature tempering
HB 341-293 ($\phi 3.3-3.55$)
6. *Dimensions are to be ensured by tool.
7. Unspecified drafts $5^\circ \dots 7^\circ$
8. Unspecified rounding-off radii R 2-4 mm
9. Nonfilling of corners should be within 0.5 of actual allowance
10. Non-flatness should not be more than 1.2 mm.
11. Curvature should not exceed 1.2 mm.
12. Misalignment of diameter B relative to the diameter A is 1.0 mm Max
13. Twisting of ribs should be within tolerance.
14. Mismatch along die parting line should not exceed 0.9 mm.
15. Flash along cutting perimeter should not be more than 1.2 mm; die mark on flash should be 3.0 mm Max.
16. Scale dents, nicks and same similar surface defects are allowed to a depth of 0.5 Max of actual allowance.
17. Die marks, hair line cracks and same similar defects, except the cracks are allowed to a depth of not exceeding 0.5 of actual allowance by the determination of depth/location with local grooves at random 0.5% from a batch. L of defect
18. Scales are to be dressed.
19. Inspection group II as per GOST 8479-70
20. Heat number or heat index is to be marked with type $\pi\alpha-B$. GOST 2930-62
21. Other technical requirements are as per GOST 7505-74, GOST 8479-70. TT 20-02

20-04-19-4	
ARTICULATED CONNECTING ROD (FORGING)	SHEET MASS 1 OF 1 5.66 Kg
18X2H4MA (18X2H4BA) TY-14/1-381-72	
ENGINE FACTORY AVADI	

2	20-04-71	DRG UP DATED BY USSR
ISSUE	DATE	AMENDMENTS
APPROVED	B. K. SAHA	
CHECKED	G. KALIAMURTY	
DRAWN	A. K. BURMAN	