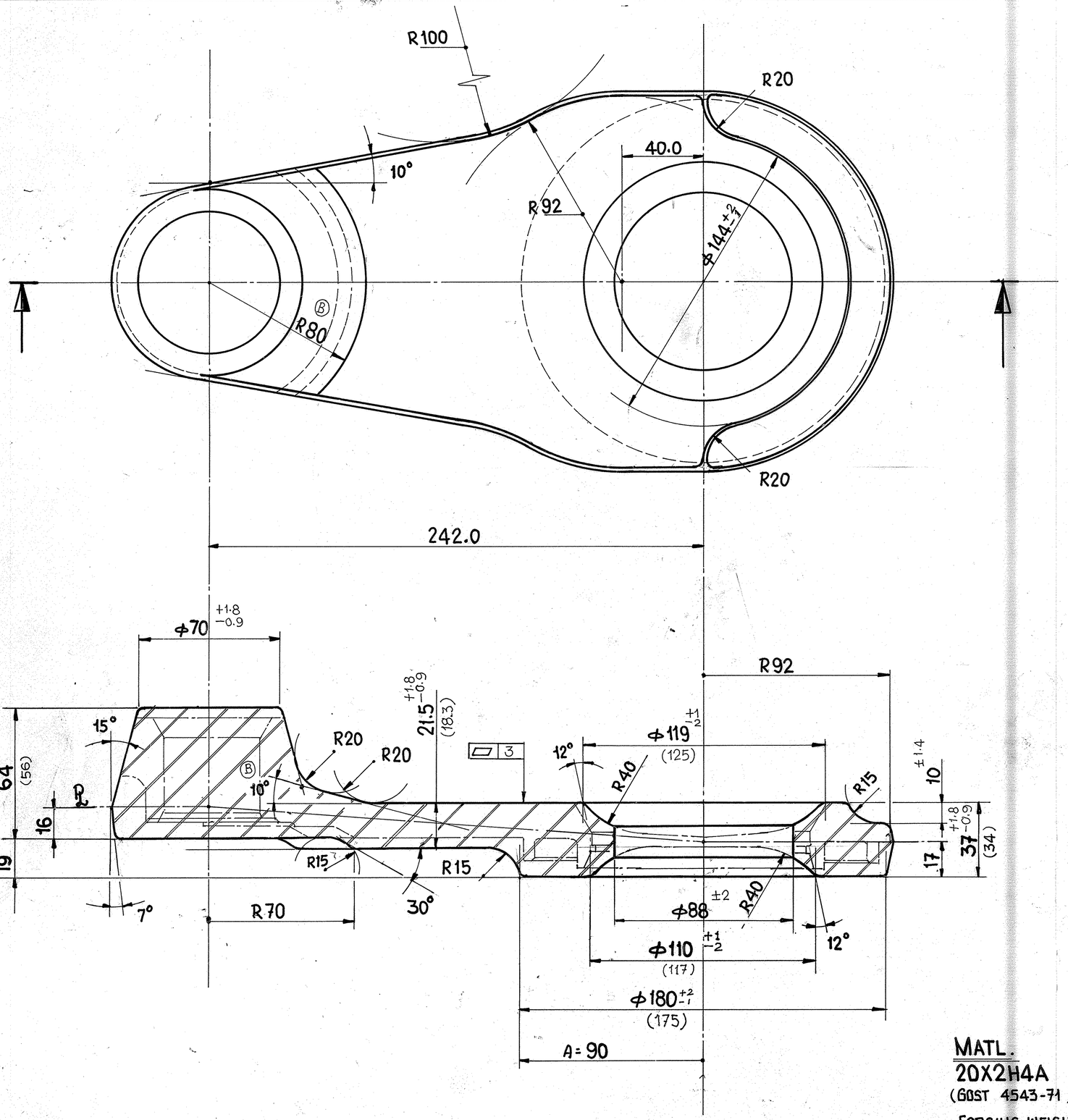
DRG. NO.
172-52-124/F

ISS.	MODIFICATION	DATE
A	HEAT TREATMENT DETAILS ADDED.	SD 3/6.
B	REDRAWN R 80 WAS R 76 10° ANGLE WAS 15° REF. NO. 7 DE. 26.3.90 FROM LIST OF NOFA 172 M 46'A' 88 CAL 10/1 FROM COMPT DRG.	13/12/99
C	TECH. REQUIREMENTS 1) MISMATCH NOT TO EXCEED 1.5 mm WAS 0.5 mm. 2) FOLDING OF FIN 5mm WAS 0.5mm AMENDMENT ISSUED TO CORRECT D.O. ERROR.	16/03/04



TECHNICAL REQUIREMENTS

Ⓐ HARDEN AND TEMPER 321 - 269 BHN
DIA. OF INDN. 3.4 mm TO 3.7 mm

DESCALE (PICKLE)

IN MACHINING SURFACES SURFACE DEFECTS AND SCALE PITS ARE ALLOWED UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE. IN UNMACHINED SURFACES WITHIN TOLERANCE LIMITS.

MISMATCH SHOULD NOT EXCEED 1.5 mm. ©

RESIDUAL FIN ALONG THE PARTING LINE SHOULD NOT EXCEED 1.5 mm. FOLDING OF FIN ALONG SECTION AND IN THE HOLE UPTO © 5 mm.

BUCKLING SHOULD NOT EXCEED 2.0 mm.

UNSPECIFIED DRAFTS 7°

UNSPECIFIED RADII 3 mm.

MACHINING DIMN'S ARE SHOWN IN BRACKETS.

UNTOLERANCED DIMN'S ARE FOR CONSTRUCTION.

FOLDING OF FIN IN PIERCED HOLE IS ALLOWED UPTO 0.5 mm.

ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED 2.5 mm.

MARK PART NO. & SUPPLIERS MARK.

PAINT REDOXIDE

MATL.
20X2H4A
(GOST 4543-71)

FORGING WEIGHT - 11.8 kg

SL. NO	DESCRIPTION	TOOL NO.	MACHINE		REMARKS
SCALE	COMPONENT ~ T-72 AJEYA			FG. WT	MATL.
1:1	172-52-124/F LEVER			11.8 kg	20X2H4A GOST 4543-71
THIS DRG. IS TO BE USED WITH J&T SPECN. II/J&T 155:NIL					H.V. FACTORY, AVADI
DRN.	CHD.	APPD.	AUTH'D	STAMPING DRG.	DRG. NO.
					172-52-124/F