

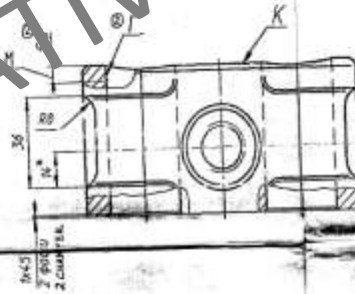
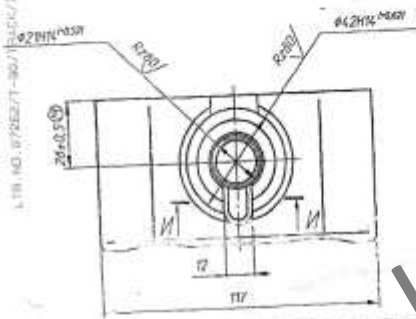
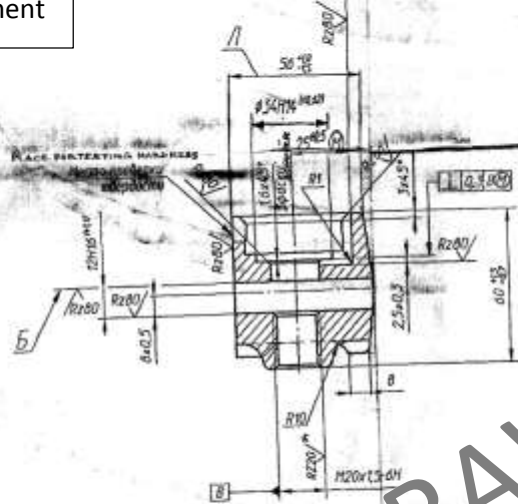
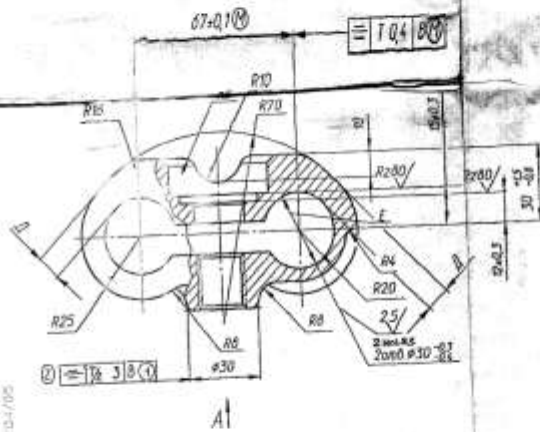
DRAWING NUMBER
172.55.025

SHEET No. 1 OF 1

Note :- These Drawings are only for reference. Actual Drawings may be different and shall be issued at the time of procurement

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1. Material: 341.444 isothermal hardening. Surface of checking...
2. On the manufactured surfaces the following are allowed without dressing:
 - Nicks, cuts due to scale and tool in the area not more than 30% of the surface with depth 1 mm.
 - Labels, rolling up and defects of rolling with depth 1 mm of optional position at a distance 12.5 mm from face.
 - Total quantity of all surface defects without dressing not more than specified in the component.
3. Unspecified limit deviation of dimension should be as per GOST 7505-88 Accuracy class T3.
4. Dimension E should be checked before cutting slot E.
5. Dimensions are for reference.
6. Surface finish should be ensured by tool.
7. Difference in dimension E should not exceed 0.05 mm. Measuring error ±0.01 mm.
8. Machining of surface K in dimension J with surface finish Rz = 80 microns is allowed.
9. Difference in dimension J should not exceed 1.5 mm, measuring error to be ±0.1 mm.
10. Other requirements should be as per specifications 520.Ty1.
11. On surfaces F tool marks with a depth 1.6 mm along the dimension M over a width of slot E are permitted.

INDICATIVE DRAWINGS

PILOT SAMPLE SHOULD BE APPROVED BY A R & F BEFORE MASS PRODUCTION
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R. OUT-SETS & THEIR EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DATE	DESIGNED BY	MATERIAL	USED OR IN D. SET.
17-03-04	[Signature]	STEEL 341.444	172.55.010 cb-1Cb
SCALE	1:1	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS: ±0.15		ANAD	
ALL THERMALS TO CONFORM TO	D-3 CAT NUMBER	TITLE	CLAMP
DATE	NATURE OF AMENDMENTS	DRAWING NUMBER	172.55.025