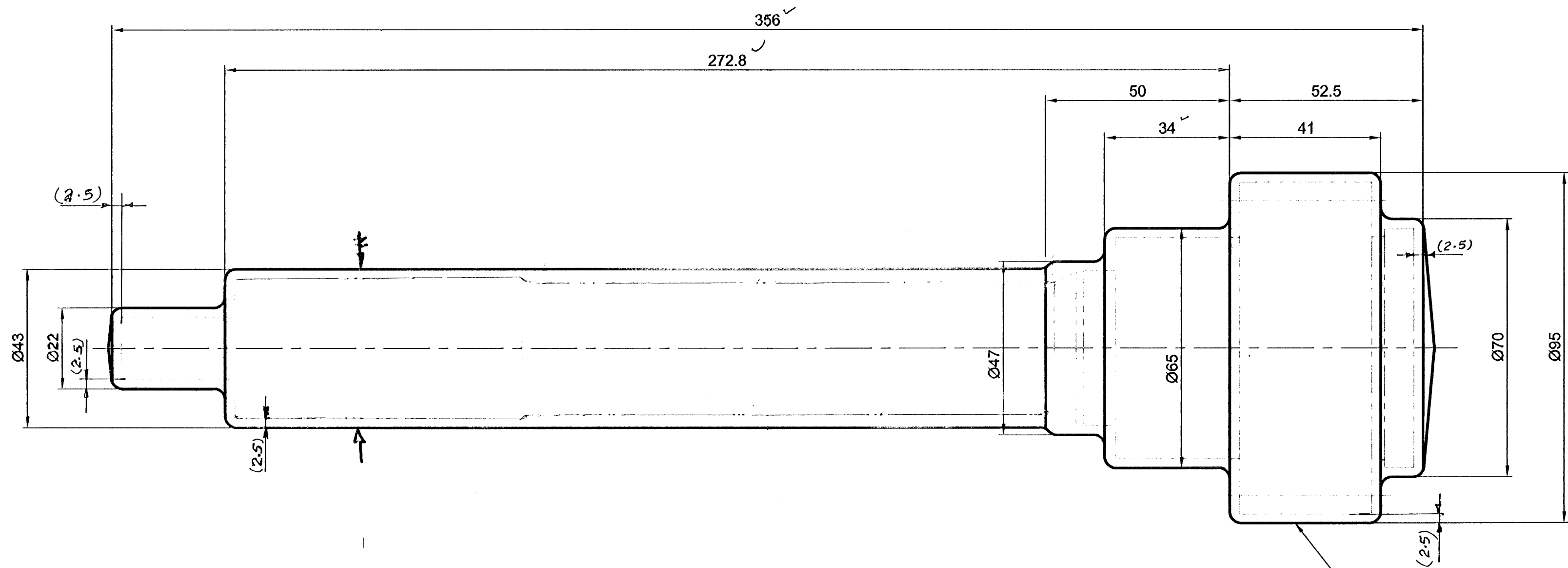


ALL DIMENSIONS ARE IN MM.



STAMP PART NO. SUPPLIERS CODE & HEAT CODE  
IN RAISED TYPE

NOTE:

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
2. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS:3 - 47-13 BY BRUSHING OR SPRAYING.
3. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
4. STEEL SHOULD BE FREE FROM CENTRE, SEGREGATION, PIPING, FLAKES ETC.
5. DIMS. IN BRACKET INDICATES MACHINING ALLOWANCE.
6. CLAMPING FACE FOR 1st MACHINING - STOP FACE OPERATION.
7. DRAFT ANGLE: INNER -  $1^\circ$ , OUTER -  $3^\circ$
8. UNSPECIFIED RADII: CORNER - 2R, FILLET - 3R

MATERIAL: 815 M17(En 353) OF BS-970

HARDENABILITY: JOMINY HARDENABILITY VALUE OF J 8/16" = 35 TO 39 HRC (FOR TEST PIECE)

COMP. OF En353:

C 0.14-0.20, Si 0.35 MAX., Mn 0.50-1.00, S 0.015-0.04, P 0.035 MAX, Ni 1.0-1.5, Cr 0.75-1.25, Mo 0.08-0.15  
PHYS. PROP.:

HEAT-TREATMENT: ISO THERMAL ANNEALING.

HARDNESS: 150 - 210 BHN

MICRO STRUCTURE:

UNIFORM LAMELLAR PEARLITE & FERRITE BAINITE & INTERMEDIATE STRUCTURE 10% MAXIMUM. EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS PRESENT, MINIMUM NUMBER OF BANDS/mm SHALL BE 14 (WHEN VIEWED AT 100X MAGNIFICATION)

GRAIN SIZE: ASTM 5 - 8

INCLUSION RATING: 3A, 3B, 3C, 3D MAX. OF IS 4163

FORGING TOLERANCE AS PER IS : 3469 - 1974

| FORGING WEIGHT (APPROX)             | ENVELOP WEIGHT | COMPLE- XITY   | INTRAC OF MATL. | FORGING GRADE                                                                                  |
|-------------------------------------|----------------|----------------|-----------------|------------------------------------------------------------------------------------------------|
| 6.5 KG                              |                |                |                 | NORMAL                                                                                         |
| KIND OF DIMS.                       | TOL.           | KIND OF DIMS.  | TOL.            | FORGING DRAWING<br>FOR<br>INPUT SHAFT<br>GEAR BOX, STLN. MK-IV<br><br>VEHICLE FACTORY JABALPUR |
| LENGTH<br>( <i>DISEMBAR TOTAL</i> ) | +2.0<br>-0.6   | RESIDUAL FLASH | —               |                                                                                                |
| THICKNESS/ <i>DIA.</i>              | +1.6<br>-0.4   | TRIMMED FLAT   | TRIM            |                                                                                                |
| MISMATCH                            | 0.8            | DRAFT ANGLE    | +2°<br>-1°      |                                                                                                |
| STRAIGHTNESS                        | 0.9            | RADII          | +50%<br>-25%    |                                                                                                |
| INTERNAL DIMS. REVERSE SIGN + & -   |                |                |                 |                                                                                                |

FORGING DRAWING  
FOR  
INPUT SHAFT  
GEAR BOX, STLN. MK-IV

VEHICLE FACTORY JABALPUR

|                           |                |                   |         |
|---------------------------|----------------|-------------------|---------|
| R.C.R. KOLTE<br>JWM / DDO |                | JWM/GS            | APPD.   |
| S. GUPTA<br>DRN.          | TCD.           | DGM/GS            |         |
| REF. DRG.                 | 1:1<br>SCALE   |                   |         |
| M/C.                      | DDO<br>SECTION | 1/04/2014<br>DATE |         |
| DEMANDED BY               | W M/VMM        | 1/1               | SHT. A2 |
| DRG. NO.                  | F3311611-3     |                   |         |