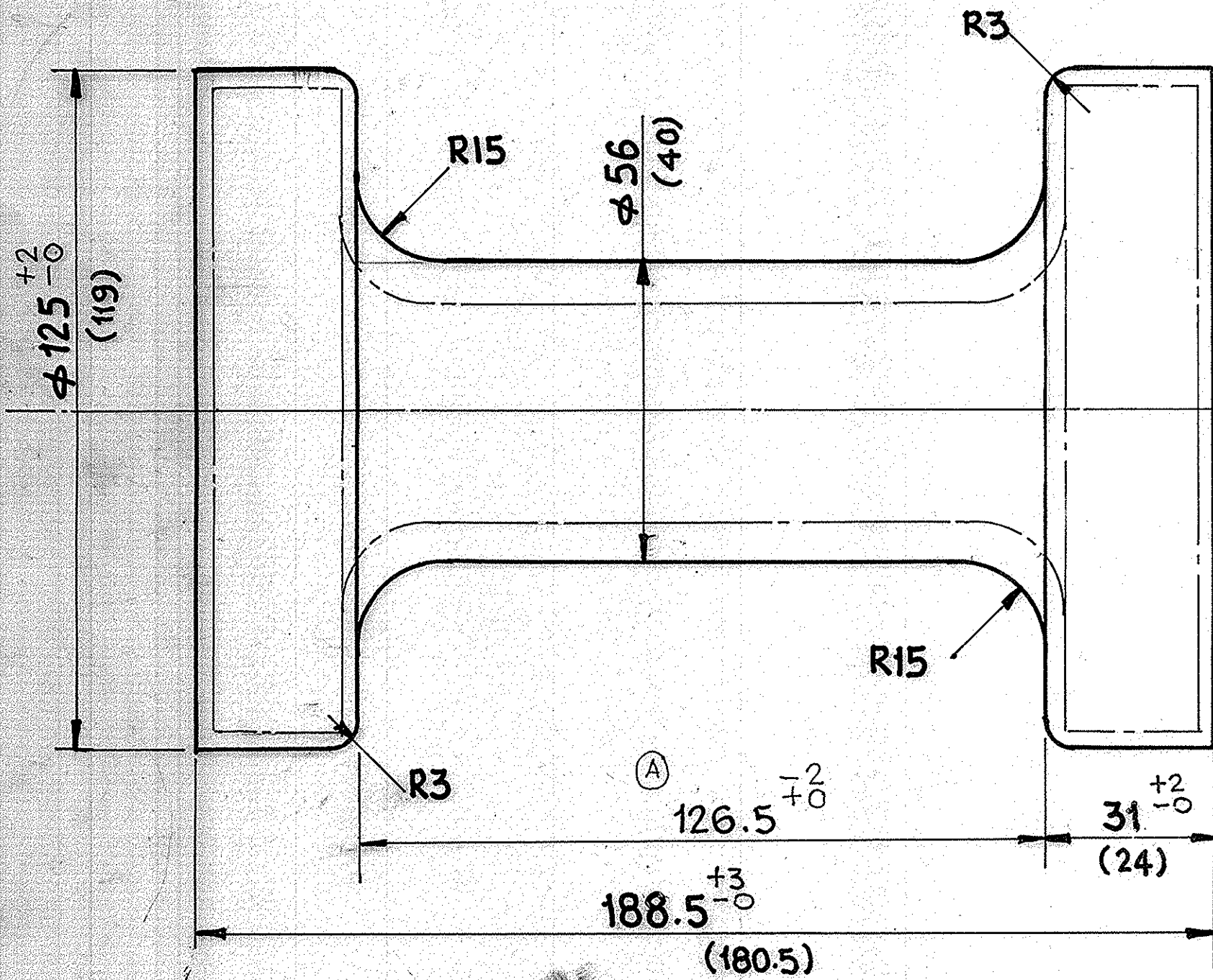


DRG. NO.  
172.45.344/F

TECHNICAL REQUIREMENT



HEAT TREATMENT :- NORMALISING  
DESCALE  
DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE ARE ALLOWED.  
ELLIPTICITY OF HEADS SHOULD NOT EXCEED TOLERANCE LIMITS.  
ONESIDE RADIAL SHIFT OF HEAD AXIS RELATIVE TO THE SHAFT SHOULD NOT EXCEED 2 mm. MAY BE CHECKED IF NECESSARY.  
FOLDING OF FIN SHOULD NOT EXCEED 2 mm.  
FIN ON FACE SHOULD NOT EXCEED 2 mm.  
UNSPECIFIED RADII = R3 mm  
ELLIPTICITY IN THE PLACE OF GRIPPING IS ALLOWED WITH MINIMUM DIMN. OF 48 mm.  
MARK PART NO. SUITABLY ON THE FACE, DEPTH SHOULD NOT EXCEED 1 mm.

MATERIAL :- 45XH2MΦA-W  
FORGING WEIGHT :- 8.5 kg

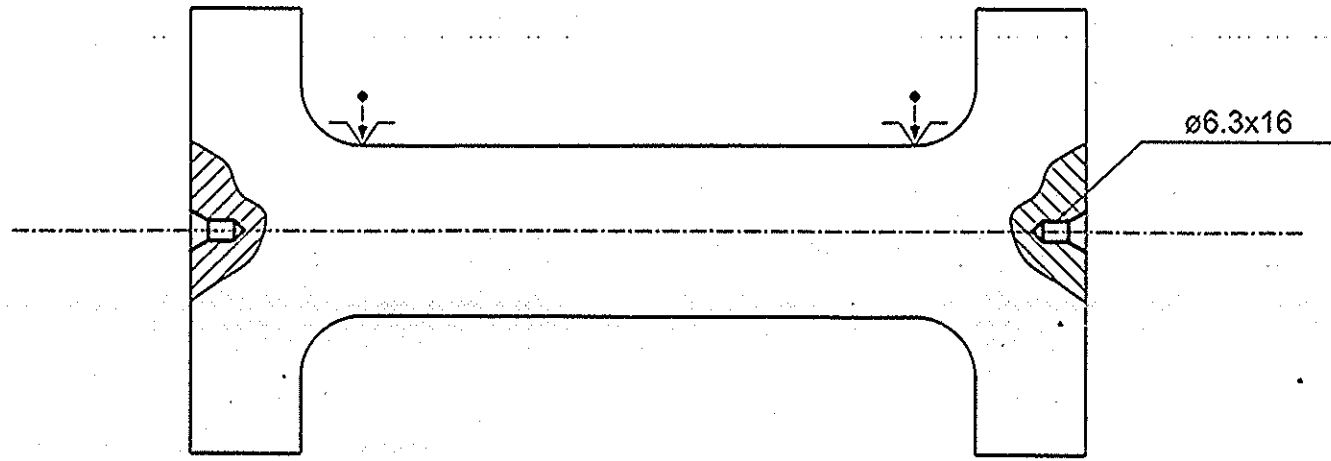
CHD. <i>M/S</i> 13/11/98	APPD. <i>S. D. S.</i> 16.11.98
DRG. NO. 172.45.344/F (UPSET)	
TITLE TORSION BAR	
HEAVY VEHICLES FACTORY, AVADI	

A	126.5 <sup>+2</sup> <sub>0</sub> DIMN. INCLUDED REF. TRANS LET. NO. 07271/ TRANS/TC/02/FSP/99 DT 16/11/99	26/11/99
ISS.	MODIFICATION	DATE

3 ✓

TORSION SHAFT

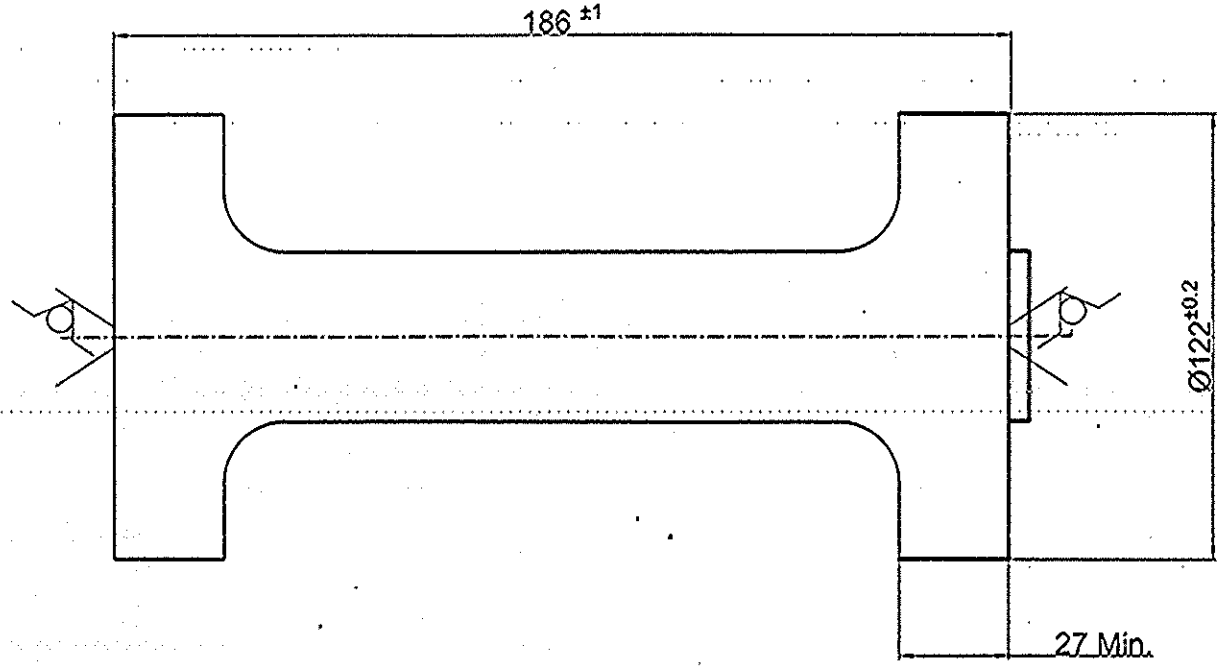
Rz40 ✓



DRG NO.	: 172.45.344/SMF, TORSION SHAFT
OPN NO.	: 10 FACING AND CENTERING
MATERIAL	: STEEL 45XH2 M $\phi$ A - Q2
HARDNESS	: BHN 255-285
SHEETNO.	: NOT TO SCALE




PREPARED	CHECKED	APPROVED
VIJAYANAND. A.	Y. SIVAKUMAR.	K. DURAIRAJ.
JWM/TRG.	CM/TRG.	JWM/TRG (HOS).

Rz40/

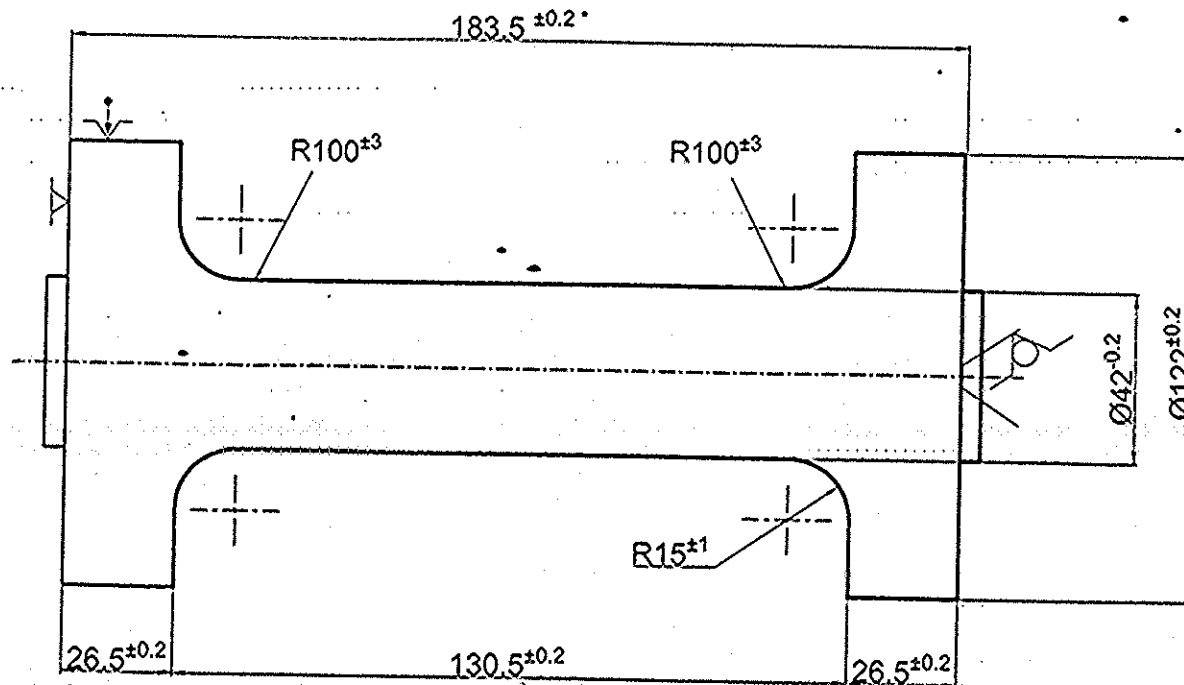


NOTE:  
1) RUN OUT OF ALL DIAMETERS WITH REFERENCE TO CENTRE SHOULD BE 0.3MM MAX.

DRG NO. : 172.45.344/SMF, TORSION SHAFT
OPN NO. : 20 TURNING
MATERIAL : STEEL 45XH2 M <sup>0</sup> A-3H
HARDNESS : BHN 255-285
SHEETNO. : NOT TO SCALE

		
PREPARED	CHECKED 2/17	APPROVED
VIJAYANAND.A JWM/TRG	V. SIVAKUMAR. CM/TRG	K. DURAIRAJ JWM/TRG (HOS)

Rz40



NOTE:

1) RUN OUT OF ALL DIAMETERS WITH REFERENCE TO CENTRE SHOULD BE 0.3MM MAX.

DRG NO. : 172.45.344/SMF, TORSION SHAFT

OPN NO. : 30 TURNING

MATERIAL : STEEL 45XH2 MPA C 45

HARDNESS : BHN 255-285

SHEETNO. :

NOT TO SCALE

PREPARED

CHECKED

APPROVED

VIJAYANAND . A  
JWM / TRG,

V. SIVAKUMAR  
CM / TRG.

K. DURAIRAJ  
JWM / TRG (HOS)