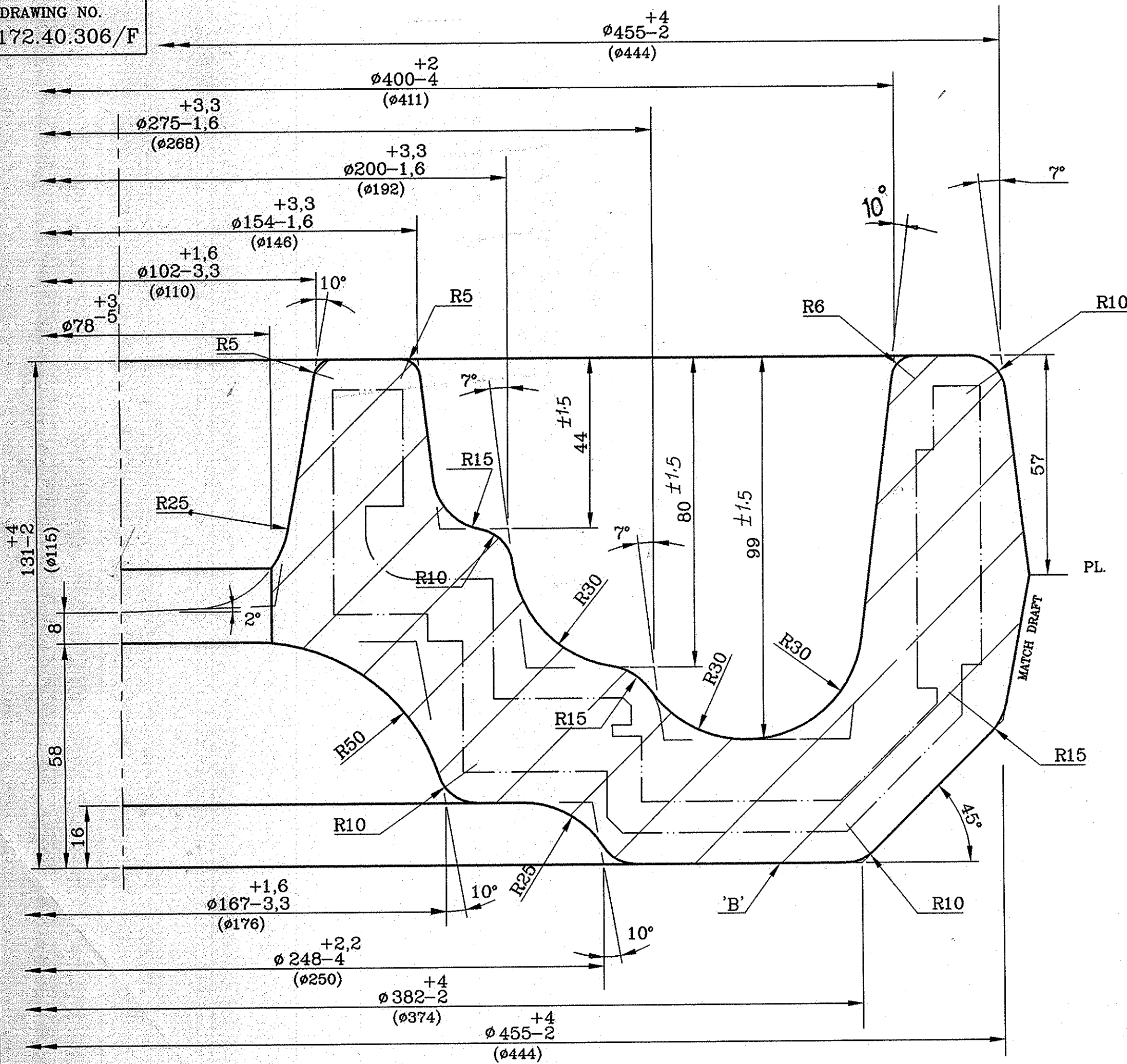


DRAWING NO.  
172.40.306/F



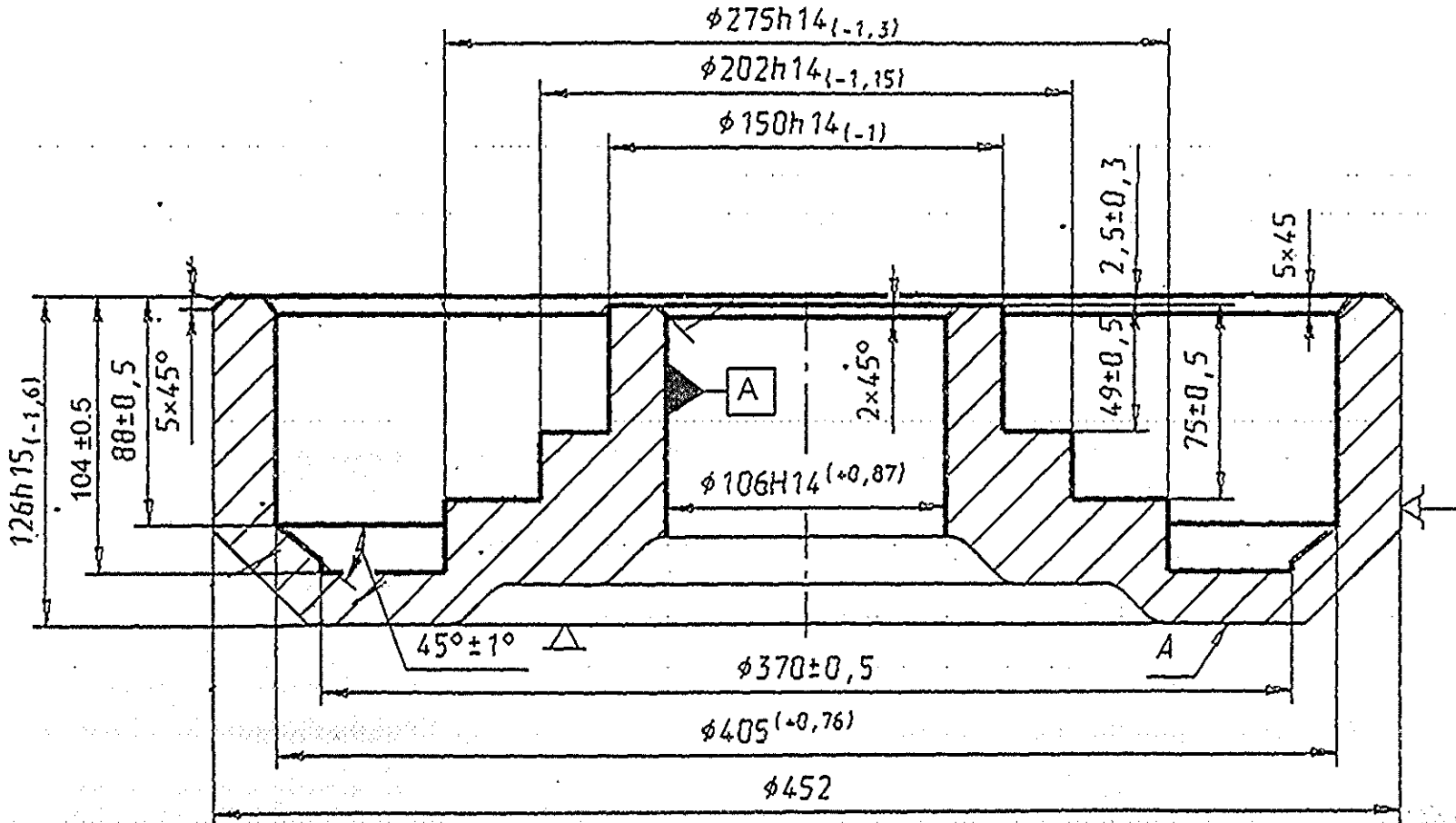
**TECHNICAL REQUIREMENTS.**

01.  $\leq 256$  HB
02. DE-SCALES(SHOT BLASTINGS)
03. MARK THE CODE OF SHOP INCHARGE
04. SURFACE DEFECTS AND DEPRESSIONS DUE TO SCALES MAY BE ALLOWED UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE.
05. SHIFT OF AXES OF DIES MAY BE ALLOWED UPTO 1.8 MM.
06. PROJECTION DUE TO DEBURRING MAY BE UPTO 2.5 MM.
07. CONTINUOUS BURR IN HOLE IS ALLOWED.
08. SHRINKAGE ON PLANE 'B' MAY BE UPTO 3.0MM.
09. DEVIATION FOR CONCENTRICITY OF BROACHED HOLE MAY BE UPTO 5.0MM
10. UNSPECIFIED DRAFTS TO BE 7°
11. UNSPECIFIED FILLET RADII R 10.0 MM.
12. DIMENSIONS WITHOUT TOLERANCE GIVEN FOR MAKING DIES-NOT TO BE CHECKED.
14. DIMENSIONS IN BRACKETS ARE GIVEN FOR MACHINING.
15. PAINT RED OXIDE.

		T72 & T90
MATERIAL	FORGING WT.	
20X2H4A GOST 4543071	78.0 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-32	1:1
DRAWN	CHECKED	APPROVED
<i>L. Puffa</i> 11/09/03	<i>[Signature]</i> 11/09/03	<i>[Signature]</i>
DRAWING NO.	172.40.306/F	
NOMENCLATURE:	SUN GEAR OF 4 th PLANETARY GEAR SET	
HEAVY VEHICLES FACTORY AVADI, CHENNAI		

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Rz80



RUN OUT OF ALL DIAMETER WITH REFERENCE TO 'A'  
SHOULD BE 0.3MM MAX

SUN GEAR OF 4TH

DRG. NO	: 172.40.306/SMF, PLANETARY GEAR SET
OPN. NO.	: 015 (TURNING)
MATERIAL	: STEEL 20X2H4A GOST 4543-71
HARDNESS	: 256 BHN

PREPARED	CHECKED	APPROVED

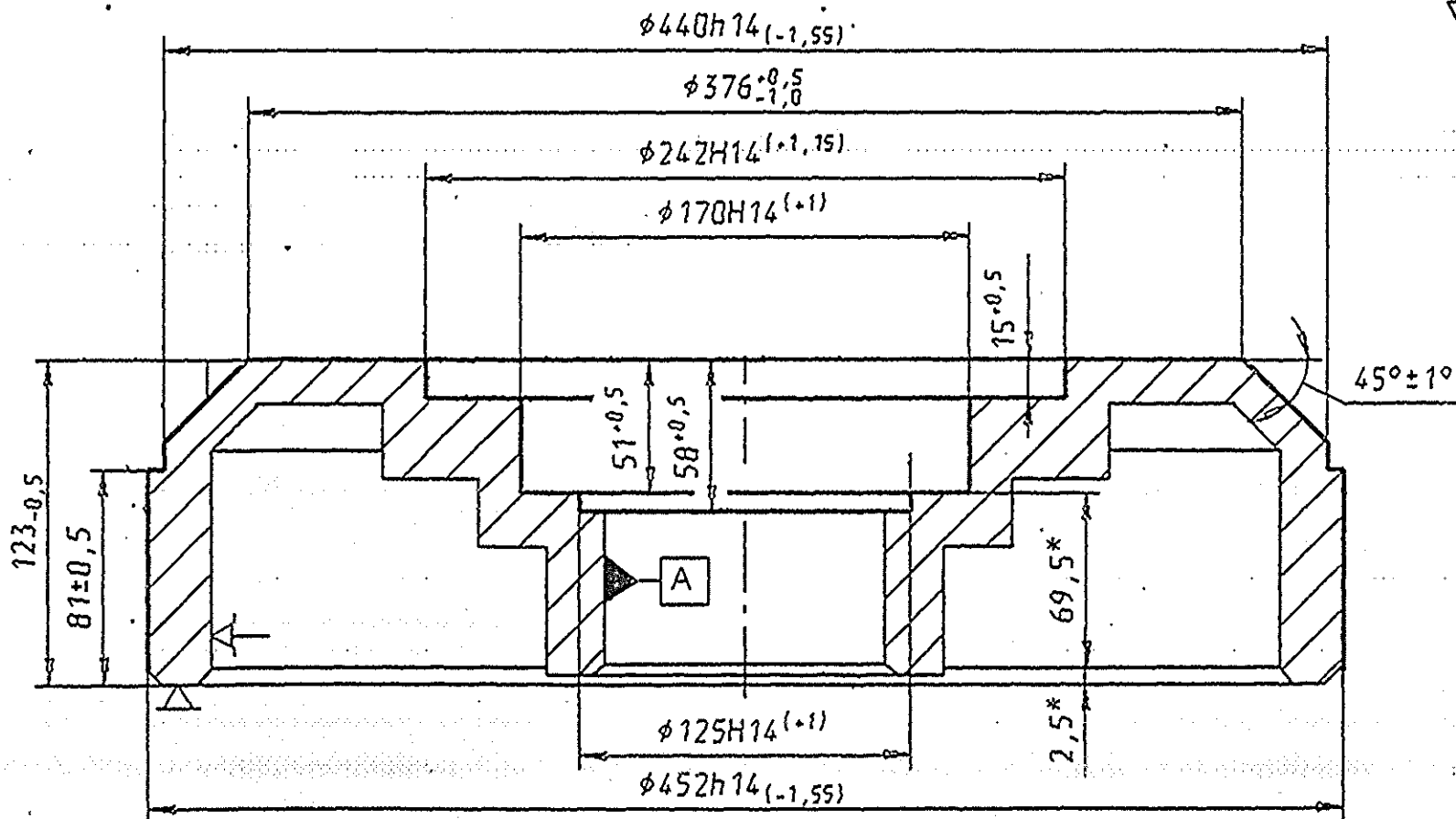
VIJAYANAND. A  
JWM / TRG.

S. SARAVANAN.  
JNM / TRG.

K. DURAJ RAJ  
JWM / TRG (HOS)

SHEET NO.	NOT TO SCALE
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Rz80



RUN OUT OF ALL DIAMETER WITH REFERENCE TO 'A'  
SHOULD BE 0.3MM MAX

SUNGEAR OF 4TH

DRG. NO : 172.40.306/SMF , PLANETARY GEAR SET




OPN. NO. : 020 (TURNING)

MATERIAL : STEEL 20X2H4A GOST 4543-71

HARDNESS : 256BHN

SHEET NO.

NOT TO SCALE

 PREPARED VIJAYANAND. A JWM/TRG	 CHECKED S. SARAVANAN. JWM/TRG.	 APPROVED K. DURAIRAJ. JWM/TRG (CHAS).
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