



NOTE :

1. DRAFTS ARE TO BE 6°
2. UNSPECIFIED RADII ARE TO BE R3 mm
3. MISMATCH OF DIE AXES SHOULD NOT EXCEED 0.6 mm
4. RESIDUAL FIN ALONG THE PARTING LINE SHOULD NOT EXCEED 0.8 mm
5. LOCAL PIT MARKS SHOULD NOT EXCEED 0.5 OF THE ACTUAL ALLOWANCE
6. WHEN ALTERNATE MATERIAL IS USED GRADE OF STEEL IS TO BE MARKED
7. TO BE HEAT -TREATED HARDNESS BHN 217-156 (Ø4.1 TO Ø4.8)
8. FORGING SHOULD BE FREE OF SCALE
9. FORGINGS ARE TO BE NORMALIZED AT 900°C + 20°C AND TEMPERED AT 640°C+20°C
10. THIS FORGING IS COMMON FOR MACHINING THE COMPONENTS 3312-100-2 & 3312-101-5

MATERIAL : 12XH3A
TY14-1-381-72

FINISH DIMENSIONS ARE GIVEN IN SQUARE BRACKET

APPX. WEIGHT 1332 Kg

| ITEM | DESCRIPTION | QTY | MATERIAL | SPECN | SIZE | REMARKS | |
|--------|----------------|------------------------------------|----------|-----------|------|-----------------------------|--|
| | GEN.TOL. | COMPONENT NO. | OPN.NO | M./C. NO. | | SIGN. DATE | |
| 6 - | 30 ± 0.2 | V92S2 ENGINE | SPS | | | DRN.BY [Signature] 21/1/06 | |
| 30 - | 120 ± 0.3 | CIL PUMP | | | | CKD.BY [Signature] 1/9/06 | |
| 120 - | 400 ± 0.5 | TITLE:- GEAR (FORGING) | | | | APPD.BY [Signature] 1/1/06 | |
| 400 - | 1000 ± 0.8 | | | | | AUTHD.BY [Signature] 1/9/06 | |
| 1000 - | 2000 ± 1.2 | | | | | DRG.No. | |
| 2000 - | 4000 ± 2 | | | | | 3312-100-2 | |
| | | | | | | 3312-101-5 | |
| | SCALE:- 1:1 | ENGINE FACTORY, AVADI. | | | | SHEET 1 OF 1 SHEETS | |
| | | | | | | ISSUE | |

[Signature]
HOS/SPS
USER APPROVAL

