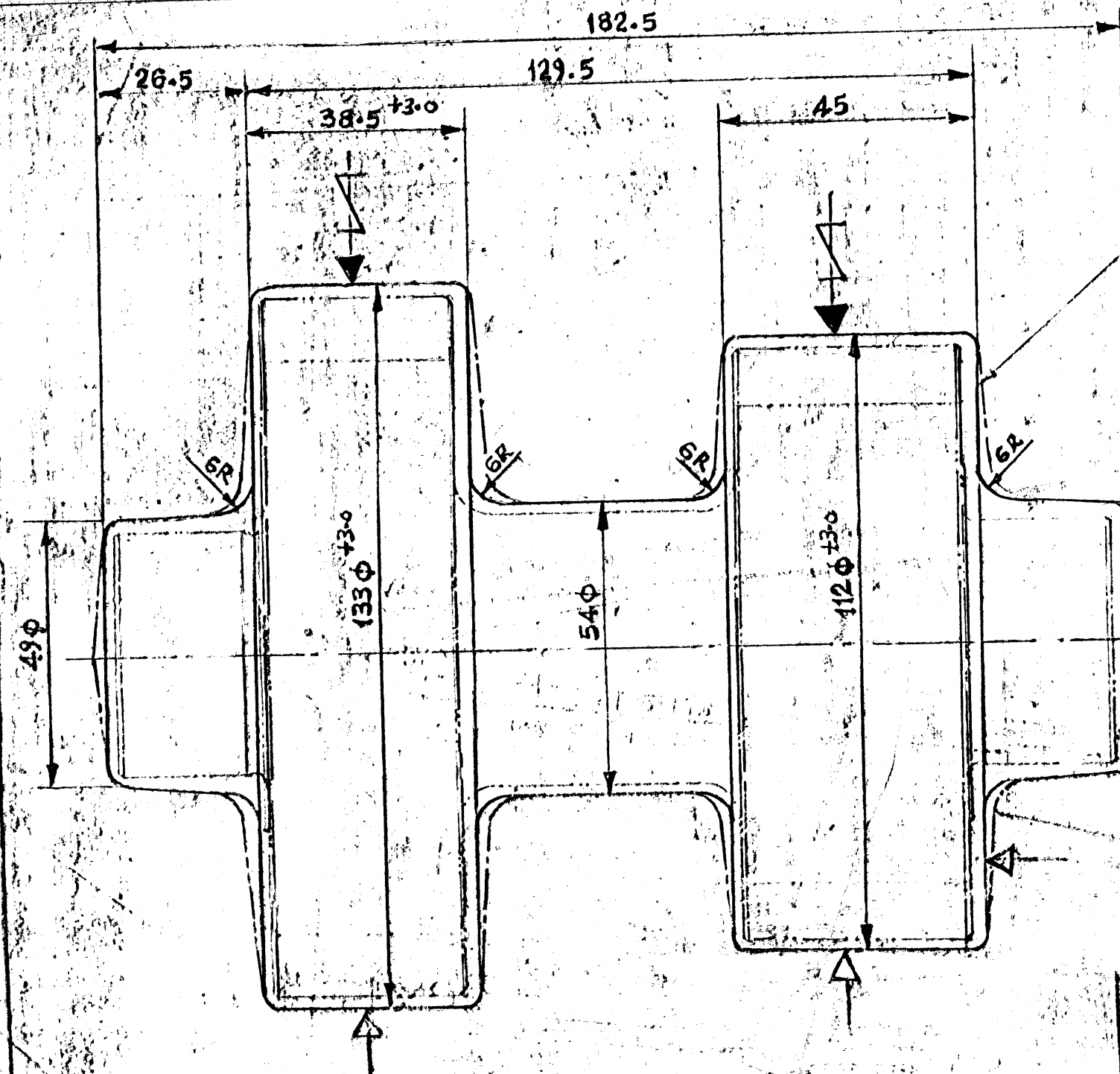


All Dimensions are in mm. unless otherwise specified.
 If in doubt, Ask. Drawing drawn to 1:1 Scale. Angle Projection.



TELCO PART NO. AND SUPPLIER'S
 CODE NO. TO BE IN 4mm. RAISED
 LETTERS AS PER MEDIUM LETTER
 8 DIN 1451 (TS: 11231).

UPSET FORGING

NOTES:-

1. FORGING SHOULD BE SUPPLIED AS PER SS:10,000.
2. LOCATING AND CLAMPING SURFACES SHOULD BE SMOOTH.
3. SURFACE COATING T.C.P.F IS: 1154 (174 TS: 25205).
4. LOCATION, CLAMPING
5. CORNER RADIUS - 3R
6. MISMATCH 0.8mm.
7. DRAFT ANGLE ON 49φ 3° ± 1°
8. STRAIGHTNESS WITHIN 0.8mm (1.6 T.I.R)
9. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS LAPS, CRACKS UNFILLING PIT ETC.
10. HEAT TREATMENT AS PER TELCO'S INSTRUCTIONS
11. TOLERANCE FOR FILLET & EDGE RADIUS, TRIM BURRS AND DRAFT ANGLES TO BE AS PER IS: 3469

DESIGN & DEV. FORGE	CENTRAL PLG.	G.A. FORGE
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ALTERNATE FORGING PROFILE

TOLERANCES WHEREVER NOT MENTIONED.
 1. ON THICKNESS +2.00
 0.00 INCLUSIVE OF
 2. ON DIAMETERS +2.00
 0.00 DIE WEAR & SHRINKAGES.

Material Description: 20 Mn Cr 5 SS: 4027.T3 (50-65)		NEW RELEASE	
This drawing is the property of Telco. It should not be copied or communicated to any person without the written approval of the proprietor.		Modification	
DATE	23.5	Product/Group No.	AUX. GEAR. BOX.
Scale	1:1	Drg./Part Designation	RAW PART FOR COUNTER SHAFT.
TATA ENGINEERING & LOCOMOTIVE CO. LTD.		Drg./Part No.	00322. 283 01 02 50

Machining Deviation as per										class to IS 2102									
M/cg Deviation for open Dims (Metric IS 2102)										Surface Finish Symbols									
Dim.	Over	6	30	120	315	1000	2000	>1000	Symbol	Symbol	Symbol	Symbol	Symbol	Symbol					
Ups & Inc.	6	30	120	315	1000	2000	4000		0.8	1.6	3.2	6.3	12.5	25.0					
Tolerance	± 0.1	± 0.1	± 0.2	± 0.3	± 0.5	± 1.2	± 2	± 3	For Symbols Values See IS 11303										

cab. 13/3-2065 13 R. NO. 1