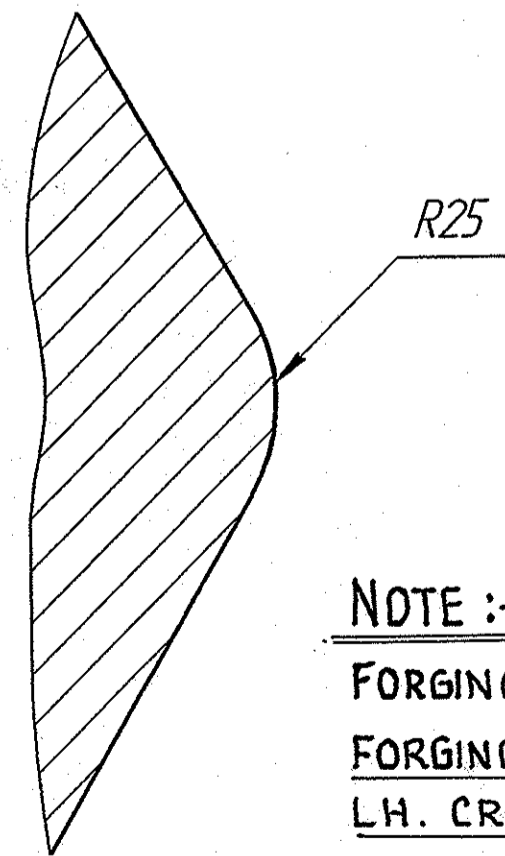
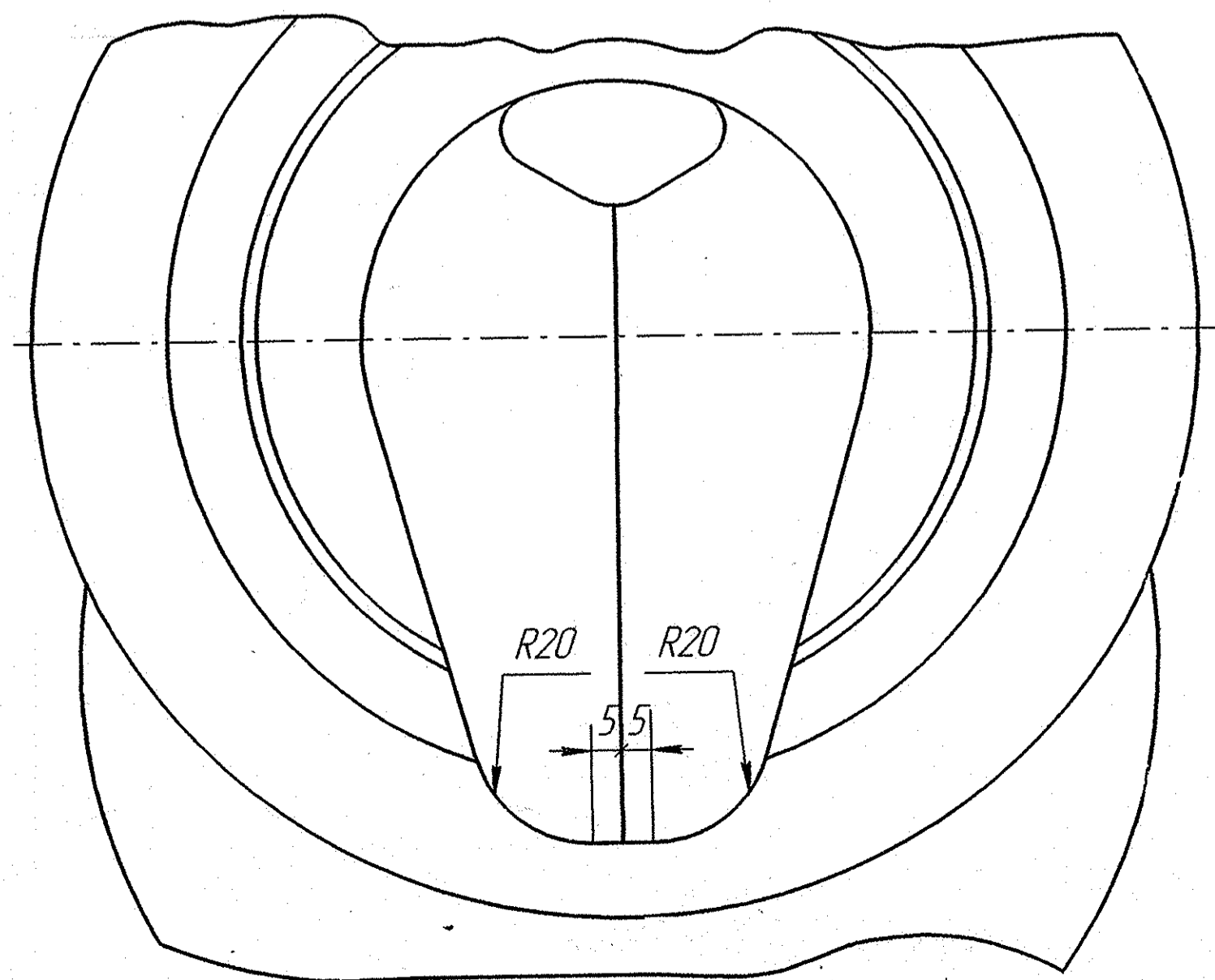


B-B

VIEW 'A'



NOTE :-

FORGING IS COMMON FOR T-72 & T-90.
FORGING IS COMMON FOR COMPT. 172.56.010
L.H. CRANK ALSO.

TECHNICAL REQUIREMENTS

01. MARK HEAT NO., CODE OF SHOP IN-CHARGE.
02. 269..321 HB.
03. DE-SCALES (SHOT BLASTING)
04. OCCASSIONAL DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS ARE ALLOWED ON UN-MACHINED SURFACES.
05. OCCASSIONAL DEFECTS WITHOUT RECTIFYING THEM ARE ALLOWED ON UN-MACHINED SURFACES, IF THEIR DEPTH DETERMINED BY CONTROL FINISHING, DOES NOT EXCEED 0.5 OF ACTUAL ONE SIDE MACHINING ALLOWANCE.
06. PROJECTION DUE TO DEBURRING ALONG THE PARTING OF DIE UPTO 2.5 MM MAY BE ALLOWED. WIDTH OF PROJECTION NEED NOT BE CHECKED.
07. DISPLACEMENT (MISALIGNMENT AXES OF DIES) UPTO 2.5 MM.
08. DEVIATION FOR CYLINDRICITY AND ROUNDNESS SHOULD BE WITHIN THE TOLERANCE LIMITS.
09. NON-PARALLELISM OF AXES ON DIMENSION 575 MAY BE UPTO 2.5 MM.
10. ON THE SURFACES WITH TECHNOLOGICAL ALLOWANCES BUILDING UP OF DEFECTS SHOULD BE AS PER INSTRUCTIONS ADK 25090-00016.
11. DIMENSIONS IN BRACKETS ARE MEANT FOR MACHINING.
12. UN-SPECIFIED STAMPING DRAFTS - 10°
13. UN-SPECIFIED FILLET RADII - R 6
14. THE PART CAN BE MADE OUT OF STEEL GRADE 40X2H2MA. IN THIS CASE MARK GRADE OF STEEL CONVENTIONALLY "M".
15. PAINT RED OXIDE.

T-72 & T-90

MATERIAL	FORGING WT.	SYMBOLS	
45XH GOST 4543-71	86.00 KGS		
ALT. MATERIAL	HAMMER	SCALE	
40X2H2MA GOST 4543-71	EK-32	NTS	
DRAWN	CHECKED	APPROVED	
<i>A. B. ...</i>	<i>M. ...</i>	<i>S. ...</i>	
DRAWING NO. 175.56.001/F		NOMENCLATURE: R.H. CRANK.	
HEAVY VEHICLES FACTORY AVADI, CHENNAI			