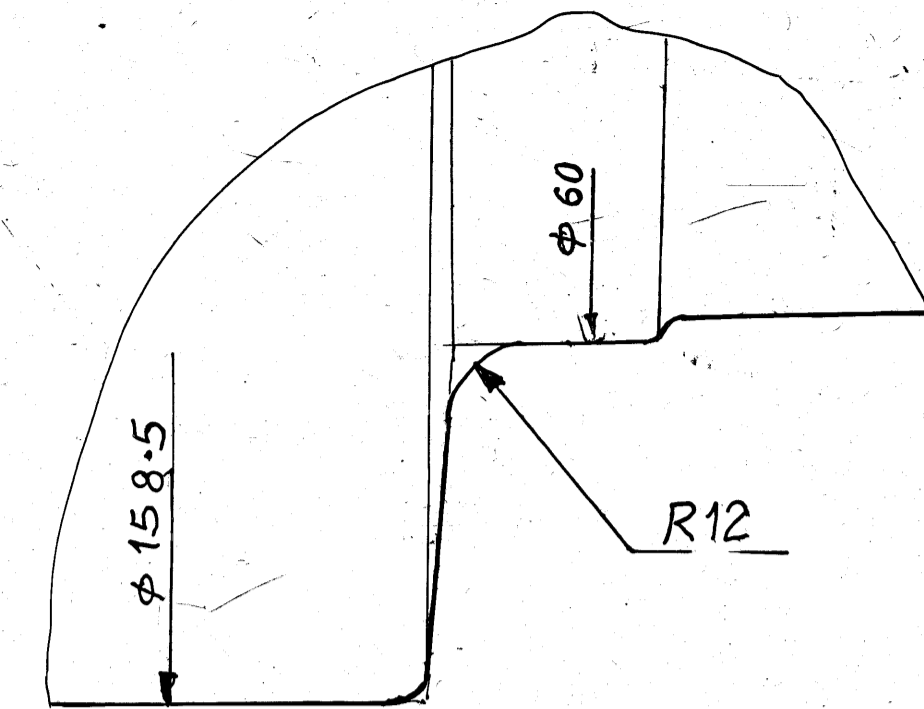
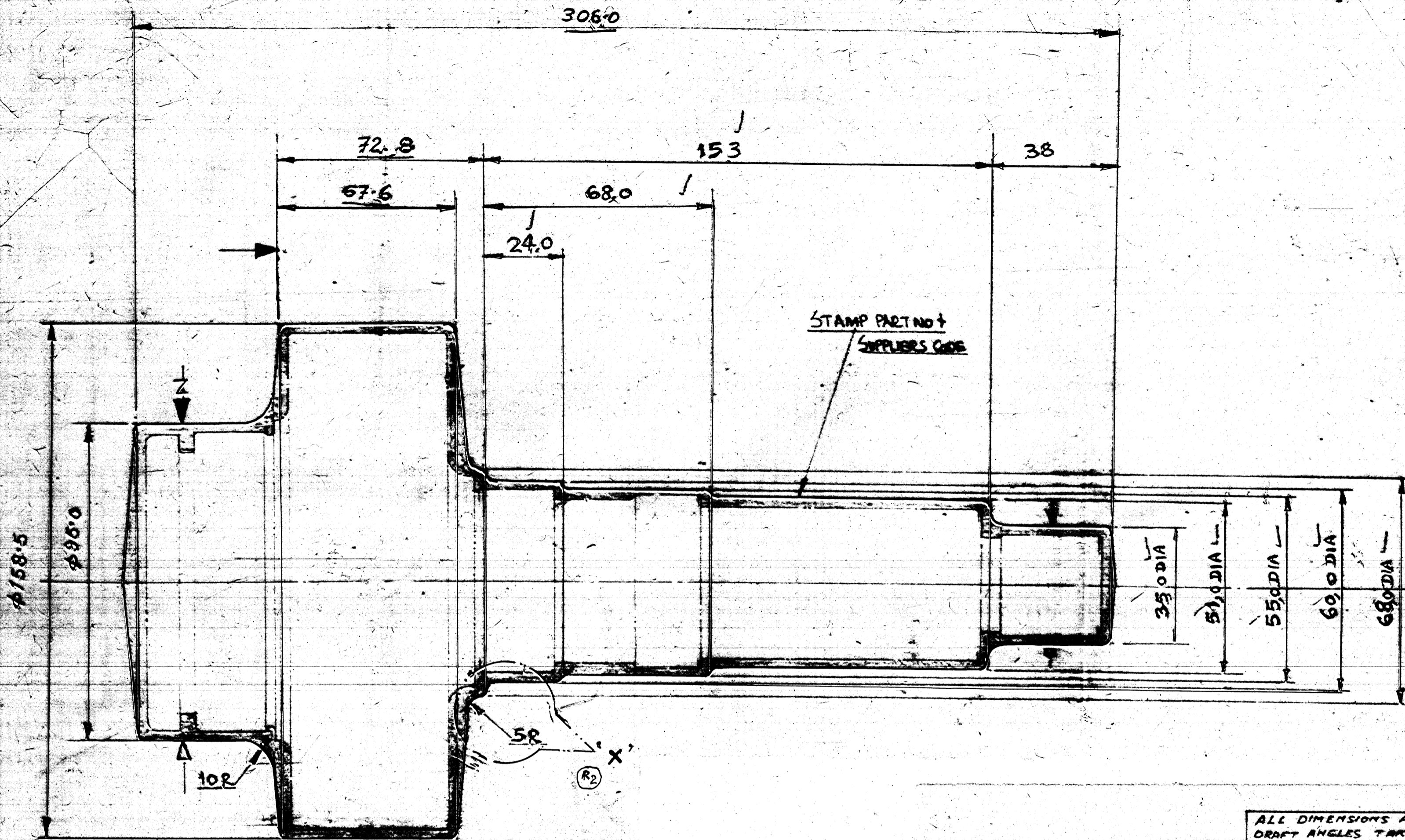


ALL DIMS. ARE IN MM.



(R2) ALTERNATE PROFILE VIEW - 'X'

SUPPLY CONDITION -
TRACES OF PARTING LINE NOT PERMITTED

NOTE: 1) ALL LOCATING, RESTING AND CLAMPING SURFACES TO BE CLEAN, SMOOTH, FLAT AND CYLINDRICAL

2) ALL THE TOLERANCES AS PER IS: 3469 (PART I TO III) - 1974

3) SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.

4) FORGINGS TO BE SUPPLIED AFTER APPLYING RED OXIDE PRIMER FOR RUST PREVENTION

5) GRAIN SIZE: ASTM 5 OR FINER.

6) INCLUSION RATING: - 3 ABCD THIN SERIES OR FINER AS PER IS: 4163-1967.

MATERIAL CONSTITUENTS

S.N.	DETAILS	MARK IV
1	MATERIAL	EN 355
2	IS EQUIVALENT	822 M 17
3	TYPE OF STEEL	2% Ni Cr Mo CH Steel (Low C)
4	C	0.2 Max
5	Si	0.35 Max
6	Mn	0.4-0.7
7	Ni	1.8-2.2
8	Cr	1.4-1.7
9	Mo	0.15-0.25
	Phosphorus %	12
	Sulfur %	25

TOLERANCES	
DIE WEAR (TOTAL)	+2.5, -0.0
DIE THICKNESS	+2.5, -0.0
MIS MATCH	0.9
FLUSH EXTENSION	CLOSE TRIM
STRAIGHTNESS	0.9
CORNER + FILLET RADII	+50%, -25%
DRAFT ANGLE	+2°, -1°
ECCENTRICITY TO THE BUNCH HOLE	-
SURFACE	0.5

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS	MATERIAL	EN 355, FINE GRAIN	LOCATE
DRAFT ANGLE	EXT. 5° INT. 7°	HEAT-TREATMENT	ISOTHERMAL ANNEALING FORGING TO BE SUPPLIED IN SHOT-BLASTED COND.
CORNER RADII	2	HARDNESS	160-210 BHN
FILLET RADII	3	MICRO STRUCTURE	FINE FERRITE & PEARLITE
WEIGHT			CLAMP

ALT. PROFILE VIEW AT 'X' ADDED
REF. DRG. IS: L. NO. 467/15-18/1974
9/14/8 DT 30.3.16, TSSL. NO. EVEN DT 11/4/16 18.4.16 D/R/000

NOTE AT S.N. 10, 11 & 12 UNDER MATL. CONT. HEADING DELETED
REF. JWM/QAT L. NO. 467/

QAT/RBR II/T.S. & DUE. DT 12.13
5.2.13

FORGING DRAWING
SHAFT OUT PUT
AQB/STLN.
MARK - IV

VEHICLE FACTORY JABALPUR

DRG. NO. X-3303311-3 (R2)