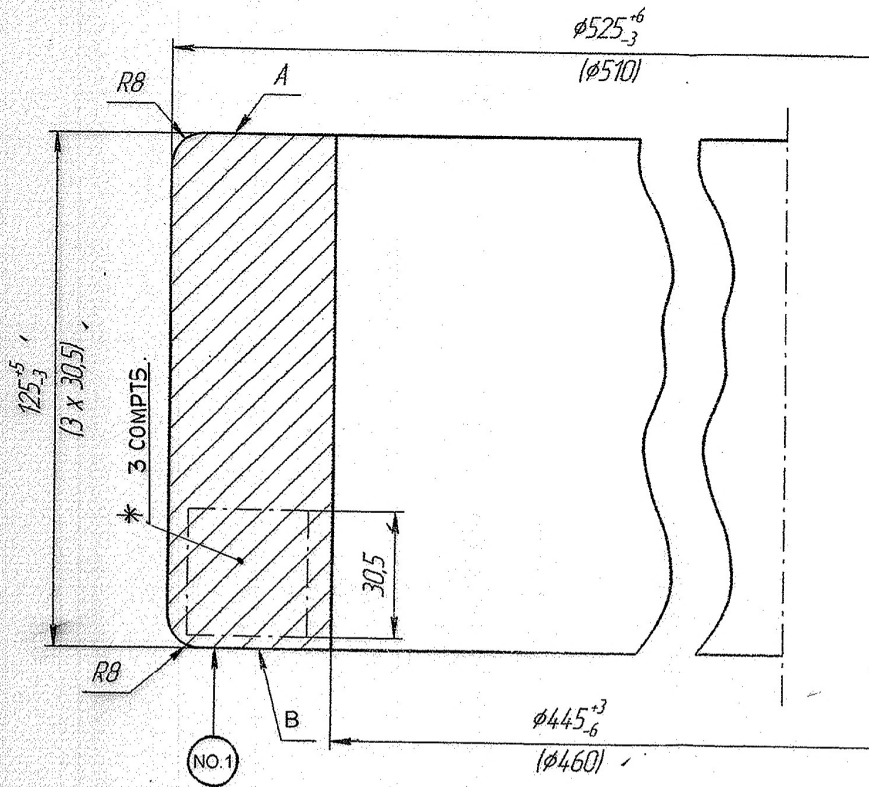


DRAWING NO.
172.40.329/F

ROLLING



TECHNICAL REQUIREMENTS

01. MARK THE PART NO. AND CODE OF CHIEF.
02. <256 HB.
03. DE-SCALES (SHOT BLASTING)
04. ON SURFACE OF FORGING OCCASSIONAL DEFECTS WITHOUT THEIR REMOVAL ARE ALLOWED, IF THEIR DEPTH IS DETERMINED BY CONTROL CUTTING, AND SHOULD NOT EXCEED 0.5 ACTUAL MACHINING ALLOWANCE.
05. ON SURFACES A AND B DRAFT ANGLE 3° IS ALLOWED.
06. ALONG THE PARTING LINE OF GAUGE, BURRS ARE ALLOWED.
07. DEVIATION FROM CIRCLE AND CYLINDERICITY SHOULD BE WITHIN TOLERANCE LIMITS.
08. IN-COMPLETNESS IN PARTING LINE OF GAUGE UPTO R 15 IS ALLOWED.
09. PAINT RED OXIDE.

SECOND OPERATION(ROLLING)
(SHEET 2 OFF 2)

FORGING IS COMMON FOR COMPT.NO.
172.40.331/F

T 90

NOTE:-
THE FORGING TECH. REQUIREMENTS CALLS FOR DIE FORGING OPERATION AS WELL AS ROLLING OPERATION. INSPECTION IS REQUIRED AT EVERY STAGE.

* EACH FORGING Caters FOR THREE COMPTS.

MATERIAL	FORGING WT.	TOLERANCE	
20X2H4A GOST 4543-71		⊕	⊖
ALT. MATERIAL	HAMMER	SCALE	
		NTS	
DRAWN	CHECKED	APPROVED	
<i>A. Ruff</i> 01/09/03	<i>[Signature]</i>	<i>[Signature]</i>	
DRAWING NO. 172.40.329/F		FORGING	
NOMENCLATURE: R.H MIDDLE ENGAGING RING			
HEAVY VEHICLES FACTORY			
AVADI, CHENNAI			