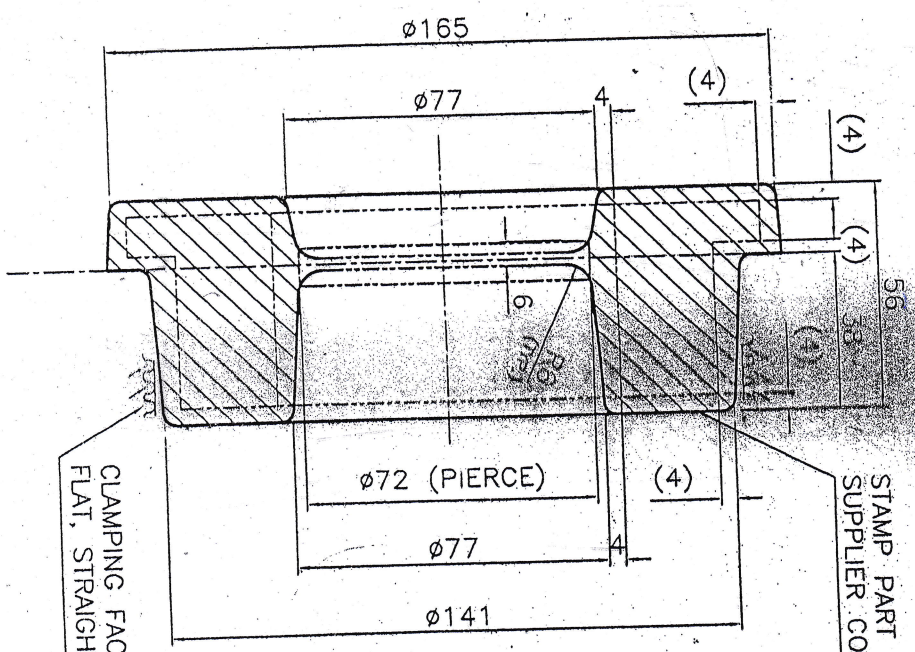


ALL DIMENSIONS ARE IN MM.



- NOTE:
1. FORGING RIDGES TO BE TRIMMED, CLEAN & SMOOTH FINISH ALL OVER.
 2. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS 3-47-13BY BRUSHING OR SPRAYING.
 3. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
 4. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION, PIPING, FLAKES ETC.
 5. DIMS IN BRACKETS INDICATE MACHINING ALLOWANCE.
 6. DRAFT ANGLE: INNER 7°, OUTER 5°.
 7. UNSPECIFIED RADII: CORNER 2R, FILLET-3R.
 8. VALVE CLAMPING FACE & VALVE STOP FACE OR 1ST MACHINING OPERATION.

MATERIAL: C-45 IS 2004
 COMP. OF CLASS-4: C 0.4-0.50, Si 0.35MAX, Mn 0.60-0.90, S 0.04MAX, P 0.04MAX.
 HEAT TREATMENT: NORMALISED
 HARDNESS: 150-210 BHN
 MICRO STRUCTURE: FINE FERRITE & PEARLITE
 GRAIN SIZE: ASTM 5 OR FINER
 INCLUSION RATING: 3 A B C D THIN OF IS 1463

KIND OF DIMS.	TOL
LENGTH / DIA	+1.2 -0.6
THICKNESS	+0.9 -0.5
MISMATCH	0.6
STRAIGHTNESS	0.6
RESIDUAL FLAT	+0.7
TRIMMED FLAT	-0.7
ANGULAR	+2 -1
RADI	+50% -25%

ALTERATION	SIGN	DATE	APPROVAL	REPLACEMENT FOR
FORGING BLANK FOR FRONT CASING FOR GUN PORT UPGRADED MPV 4X4			UPGRADED MPV 4X4	DRG NO. F-2705-57-31
VEHICLE FACTORY JAWALPUR				

FORGING WEIGHT :- 6.3 KG (APPROX)

TECHNICAL SERVICES SECTOR
 Vehicle Factory, Jabalpur
 CERTIFIED CORRECT COPY
 10/06/2022
 JMM/MPV-1

DRG. VCH = 12 NK

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