



1. STEEL GRADE, HEAT TREATMENT, METHOD OF ACCEPTANCE AND TESTING AS PER LIST FOR COMPONENTS FROM SPECIAL MEDIUM HARDNESS.
2. REQUIREMENT FOR CASTING AS PER 172 TY5
3. ACCURACY OF CASTING AS PER 111 - 0 - 0 - 10 GOST 28545 - 85
4. CHAMBER MAY BE CUTTING OF FLAME RULES FOR CHECKING OF QUALITY AND ACCEPTANCE FLAMES OF EDGE AS PER OST BJ - 4302 - 88
5. OTHER REQUIREMENTS AS PER 520 TY1
6. ON MACHINING SURFACES OF CASTING DEFECTS WITHIN LIMIT TOLERANCE FOR MACHINING NOT TO BE RECTIFIED. IN CASE PASSING OF DEFECTS BEYOND LIMIT OF TOLERANCE CARRY OUT THE RECTIFICATION WITH SUBSEQUENT HEAT TREATMENT.
7. BASE SURFACE SHOULD BE SMOOTH & CLEAN.
8. WEIGHT OF BLANK 125KG.
9. ON OUTER NON-MACHINING SURFACE CARRY OUT ASDIE MARK OF HEIGHT SHOULD NOT EXCEED 6MM AND WIDTH SHOULD NOT EXCEED 8MM.
10. DIMENSIONS WITH SIGN * ARE FOR REFERENCE.

APPROVED
 [Signature]
 Chief Engineer (Casting)
 (TECH. CELL)

MATERIAL	CASTING WT.	SCALE
172 TY5	125Kg	1:1
ALT. MATERIAL	HAMMER	SCALE
DRAWN	CHECKED	APPROVED

DRAWING NO. 188.10.220
 NOMENCLATURE: BASE R.H. HATCH
 HEAVY VEHICLES FACTORY
 AVADI, CHENNAI