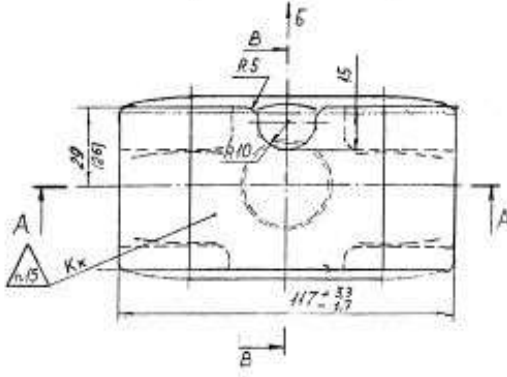
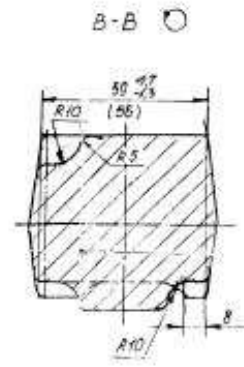
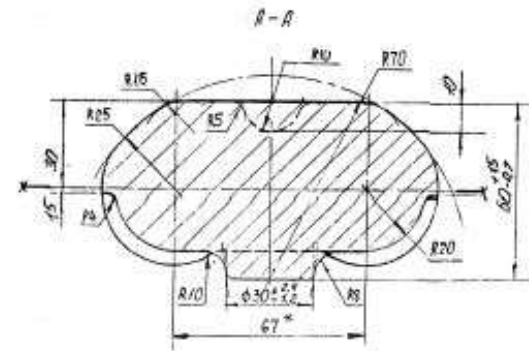
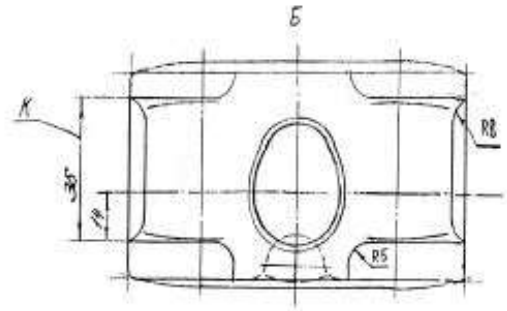


DRAWING NO.
172.55.025/F

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These drawings are only for reference actual drawings may be different and shall be issued at the time for procurement.



TECHNICAL REQUIREMENTS

01. GROUP K, GOST 8479-70
02. FORGING PARAMETERS: T5, M2, C3, 17 GOST 7805-89
03. HARDNESS 178 ... 209 BHN (DIA OF INDENTATION: 3.7 ... 4.6MM)
04. *DIMENSION FOR REFERENCE
05. UNSPECIFIED DRAFT ANGLE 7°
06. UNSPECIFIED RADE 3.0 MM
07. TOLERANCE OF SHFT ALONG SURFACE OF PARTING LINE OF DIE 1MM
08. PERMISSIBLE LIMIT VALUE OF RESIDUAL FIN 1.0MM AS PER DIMENSION X
09. PERMISSIBLE LIMIT OF BURR HEIGHT ALONG CONTOUR OF CUTTING 3MM
10. TOLERANCE OF FLATNESS AND CURVATURE - 1.0 MM
11. DIMENSIONS WITHOUT TOLERANCE NEED NOT BE CHECKED
12. THE FOLLOWING LOCAL DEFECTS ARE ALLOWED ON UNMACHINED SURFACES WITHOUT RECTIFICATION: DENTS, NICKS, SCALERS AND TOOL MARKS IN AN AREA NOT MORE THAN 30% OF THE SURFACE AND DEPTH NOT MORE THAN 2 MM. WRINKLES, GRIPS, LAPS AND ROLLING DEFECTS OF INPUT MATERIAL WITH DEPTH NOT MORE THAN 2 MM ANYWHERE IN THE AREA NOT LESS THAN 12 MM FROM THE FACES. TOTAL NUMBER OF ALL SURFACE DEFECTS WITHOUT DRESSING SHOULD NOT BE MORE THAN TWO PER COMPONENT
13. ON UNMACHINED SURFACES SEPARATE DEFECTS WITHOUT RECTIFICATION ARE ALLOWED IF THE DEPTH DOES NOT EXCEED 80% OF THE ACTUAL MACHINING ALLOWANCE
14. DE-SCALE (SHOT BLASTING)
15. ACCEPTANCE STAMPING ON ALL COMPONENTS
16. EVERY BATCH QTY 3 COMPONENTS TO BE LABELED WITH MARKING OF DRAWING NO. AND BATCH NO. DETAILS.
17. PAINT RED-OXIDE

INDICATIVE DRAWING

FOR REFERENCE ONLY

MATERIAL		FORGING WT.	T 90
STEEL 50Cr (GOST 8479-70)	2.7 KGS.		
ALT. MATERIAL	GRADE	SCALE	
	MPa	NTS	
MARK	CHECKED	APPROVED	
DRAWING NO.	172.55.025/F		
DESCRIPTION	CLAMP		
HEAVY VEHICLES FACTORY			
AVUL, CHENNAI			