



TECHNICAL REQUIREMENTS

01. ≤ 269 HB.
02. MARKING THE PART NUMBER IS ALLOWED.
03. BURRS ALONG THE PERIMETER OF CUTTING SHOULD NOT EXCEED 1.2 MM, ALONG CORE DIA 30 AND R 16 SHOULD NOT EXCEED 1.8 MM.
04. SHIFT ALONG THE PARTING LINE OF DIE SHOULD NOT EXCEED 1.0 MM.
05. WARPAGE SHOULD NOT EXCEED 1.0 MM.
06. SURFACE DEFECTS SUCH AS FOLDS DUE TO SCALES AND DENTS ARE ALLOWED, AND ALSO CLEANING WITH DEPTH NOT EXCEEDING 50% OF ACTUAL SINGLE SIDED MACHINING ALLOWANCE IS ALLOWED.
07. DRAFT ANGLE 7°
08. UN-SPECIFIED FILLET RADIUS R 3.0 MM.
09. DE-SCALES (SHOT BLASTING).
10. FORGING II CLASS, C2 GOST 7509-89.
11. PAINT RED OXIDE.

T 90

MATERIAL	FORGING WT.		
45XH2MØA-W TY 141-1725.76	2.2 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	MPM	NTS	
DRAWN	CHECKED	APPROVED	
<i>L. Dutt</i> 02/09/03	<i>M. Srinivas</i> 2/09/03	<i>S. D. S.</i>	
DRAWING NO.	179.47.001/F		
NOMENCLATURE:	TORSION BAR		
HEAVY VEHICLES FACTORY AVADI, CHENNAI			