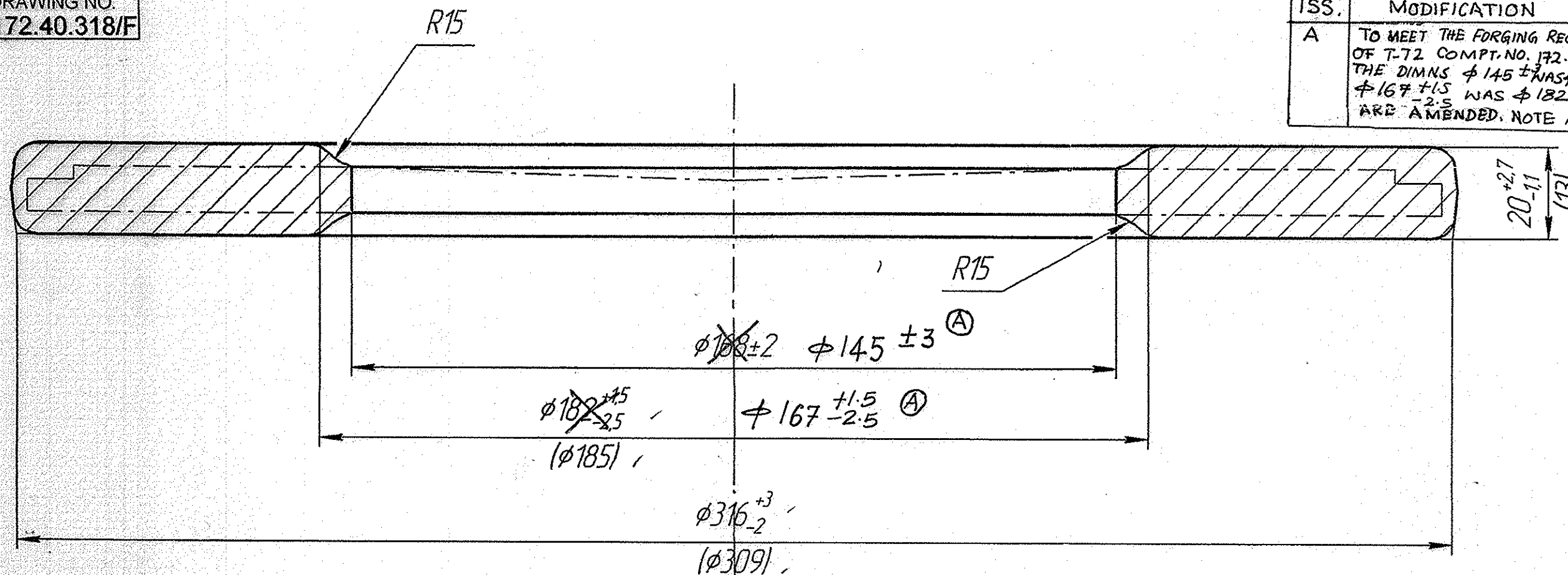


DRAWING NO.
172.40.318/F

ISS.	MODIFICATION	DATE
A	TO MEET THE FORGING REQUIREMENT OF T-72 COMPT. NO. 172.40.239/F THE DIMNS $\phi 145 \pm 3$ WAS $\phi 168 \pm 3$ $\phi 167 \pm 1.5$ WAS $\phi 182 \pm 1.5$ ARE AMENDED. NOTE ADDED.	04/10/04



TECHNICAL REQUIREMENTS

01. < 256 HB.
02. BURRS ALONG THE PERIMETER OF CUT NOT EXCEEDING 2.0 MM ARE ALLOWED.
03. DISPLACEMENT ALONG PARTING LINE OF DIE NOT MORE THAN 1.4 MM MAY BE ALLOWED.
04. NON-FLATNESS NOT MORE THAN 1.5 MM IS ALLOWED.
05. MISALIGNMENT OF DIA 168 WITH RESPECT TO DIA 182 MAY BE UPTO 2.0 MM.
06. SURFACE DEFECTS SUCH AS DENTS DUE TO SCALES AND NICKS AS WELL AS STARTED CUTTING OR FINISHING OF DEFECTS IN DEPTH NOT MORE THAN 50% OF ACTUAL ONE-SIDE MACHINING ALLOWANCE MAY BE ALLOWED.

07. IT IS ALLOWED TO MARK PART NUMBER.
08. STAMPING DRAFTS - 7°
09. UN-SPECIFIED FILLET RADII - NOT MORE THAN R 5.0 MM.
10. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
11. DIMENSIONS WITHOUT TOLERANCES ARE FOR DIES.
12. DE-SCALES (SHOT BLASTING).
13. FORGING II ACCURACY CLASS. GRADE OF STEEL ,M2, CATAGORY OF COMPLEXICITY C4 GOST 7505-89.
14. PAINT RED OXIDE.

(A) NOTE :- FORGING IS COMMON FOR T-72 COMP. No. 172.40.239/F AND T-90 COMPT. NO. 172.40.318/F

T 90

MATERIAL	FORGING WT.		
38XC GOST 4543-71	8.80 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	DG-13	NTS	
DRAWN	CHECKED	APPROVED	
<i>2. Suf/02/09/03</i>	<i>M Suf/03</i>	<i>Suf/03</i>	
DRAWING NO. 172.40.318/F		NOMENCLATURE: CARRIER CHEEK	
HEAVY VEHICLES FACTORY AVADI, CHENNAI			