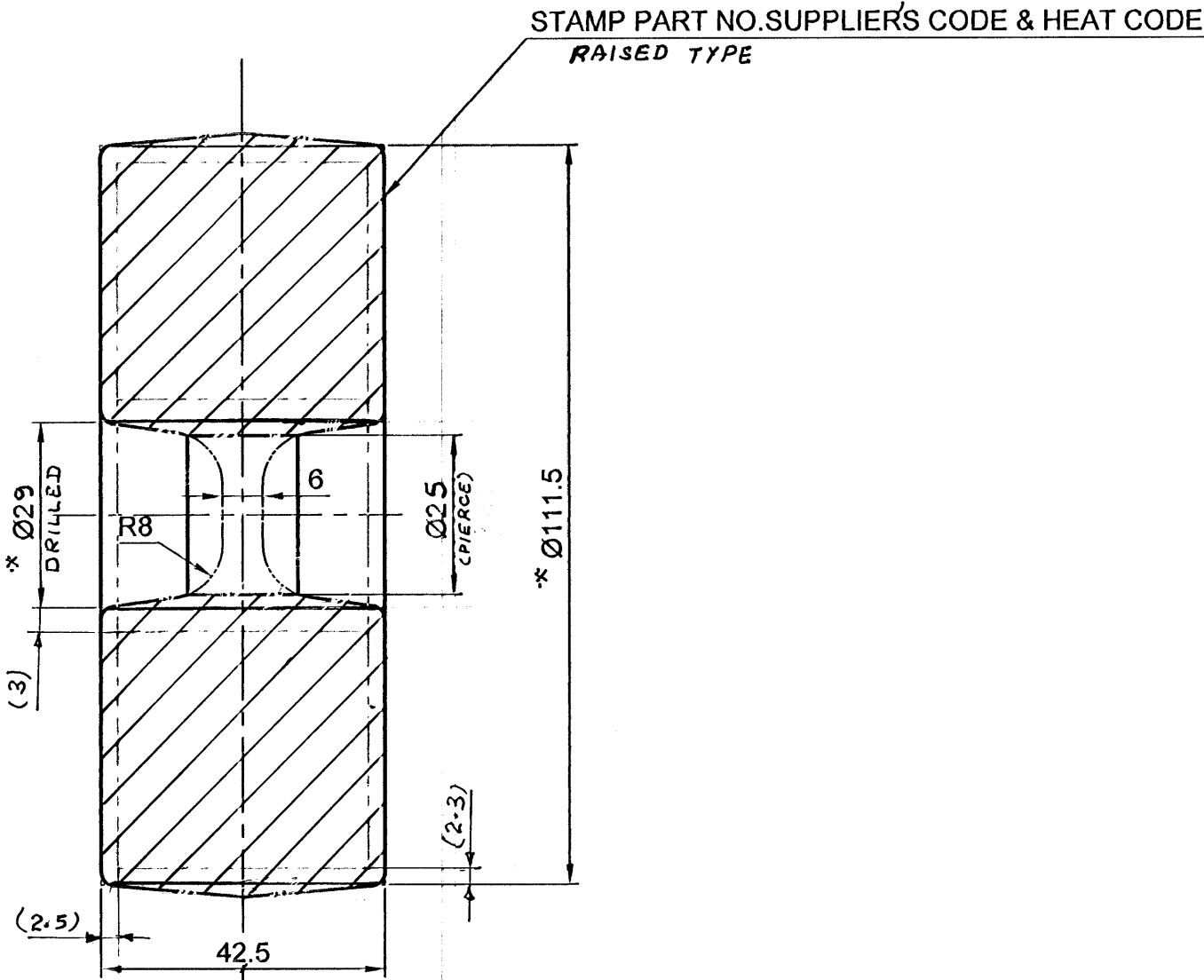


ALL DIMENSIONS ARE IN MM.

IF IN DOUBT PLEASE ASK

NOTE:

- *SUPPLY CONDITION PRE-MACHINED
(1) O/S DIA. 111.5/112.0
(2) I/S DIA. 29/29.5



NOTE:

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

MATERIAL: 822 H17(En 355)OF BS-970

HARDENABILITY: JOMINY HARDENABILITY VALUE OF J 8/16"=35 TO 39 HRC (FOR TEST-PIECE)

COMP.OF En355: (% OF wt.)
C 0.14-0.20, Si 0.35MAX, Mn 0.40-0.70, S: 0.05 MAX, P 0.05 MAX, Ni 1.75-2.225, Cr: 1.30-1.70 Mo 0.15-0.25
PHYS.PROP.:

HEAT-TREATMENT: ISO THERMAL ANNEALING.

HARDNESS: 150 - 210 BHN

MICRO STRUCTURE:

UNIFORM LAMELLER PEARLITE & FERRITE BAINITE & INTERMEDIATE STRUCTURE 10% MAXIMUM.
EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS PRESENT,MINIMUM NUMBER OF BANDS/mm SHALL BE 14 (WHEN VIEWED AT 100X MAGNIFICATION)
GRAIN SIZE: ASTM 5 - 8

INCLUSION RATING: 3A,3B,3C,3D MAX. OF IS 4163

FORGING TOLERANCE AS PER IS : 3469 - 1974

FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE
3.2KG				NORMAL

KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.
LENGTH/DIA	+1.1 -0.4	RESIDUAL FLASH	—
THICKNESS	+1.5 -0.0	TRIMMED FLAT	CLOSE TRIM
MISMATCH	0.6	DRAFT ANGLE	+2° -1°
STRAIGHTNESS	0.6	RADII	+50% -25%

INTERNAL DIMS. REVERSE SIGN + & -

INDEX

ALTERATION

DATE

SIGN

FORGING DRAWING

FOR

REVERSE IDLER GEAR

STLN.MK-IV

VEHICLE FACTORY JABALPUR

R.C.R. KOLTE
JWM / DDO
JWM/GS
APPD.

RAJEEV
DRN.
TCD.
DGM/GS
DO/PROD.

REF. DRG. 15/2/14
A/L D & S V/AKs
EDM / 431.d.1.1.2/14
1:1
SCALE

M/C.
DDO
SECTION
03/02/2014
DATE

DEMANDED BY WJM/VMM
1/1
SHT. A3

DRG. NO.
F8A02611-3