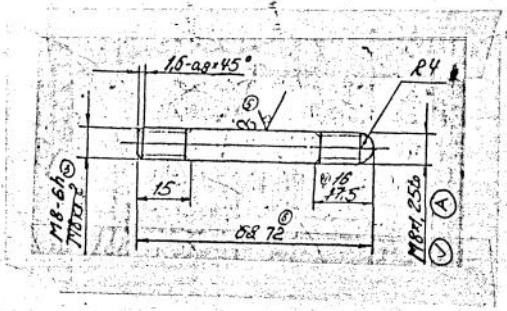


Rz 80J (V)

DRAWING NUMBER
350-122



1. Inspection group IV TT-11.
2. HRC 26..... 33.
3. Technical requirements for threads as per standard 82021-00.
4. Dimensions with unspecified tolerances and the rest of technical requirements as per standard 82052-00.
5. Coating: cadmium 3, chromating as per 431-104 with the elimination of hydrogen embrittlement.
6. The thread may be made by rolling with the diameter of unthread portion within the pitch diameter of thread.
7. Mechanical damages of cadmium coating such as scratches, nicks and dents are allowed on assembly units, provided the steel is not exposed.
9. Repair size dimensions are added where indicated thus (A) based on overhaul specification part III repair drawings. **

8. EXPLANATORY NOTE :

MATERIAL QUOTED : ROUND BAR GOST 7417-75
38XA GOST 1051-73

PERTAINS TO SIZED, COLD ROLLED OR COLD DRAWN STEEL WITH ROUND SECTION AS PER GOST 7417-75.

38XA = GRADE OF STEEL AS PER GOST 4543-71.

CHEMICAL COMPOSITION : (As per gost 4543-71)

C = 0.35 - 0.42	P = 0.025 max
Si = 0.17 - 0.37	S = 0.025 max
Mn = 0.50 - 0.80	Cu = 0.30 max
Cr = 0.80 - 1.10	Ni = 0.30 max

MECHANICAL PROPERTIES (AS PER GOST 4543-71)

ULTIMATE TENSILE STRENGTH Kgf/mm ²	= 95 (min)
YIELD POINT Kgf/mm ²	= 80 (min)
% ELONGATION	= 12 (min)
% REDUCTION IN AREA	= 50 (min)
IMPACT STRENGTH Kgf/cm ²	= 9 (min)

HEAT TREATMENT :

(a) HARDENING OR NORMALIZING TEMPERATURE °C = 860
COOLING MEDIUM = OIL

(b) TEMPERING TEMPERATURE °C = 550

COOLING MEDIUM = WATER OR OIL

S.No	R	REMARKS
1	M10x1.5 to	ALL OTHER CONDITIONS
2	PCD = 9.026 +0.170 +0.095	AS PER STD DRG.

(C) EQUIVALENT MATERIAL
STEEL 709M40 (EN19) TO BS: 970-
105-4 Mo3 TO 13-1570

(D) EQUIVALENT MATERIAL-
STEEL 709M40 (EN-19) COLD DRAWN
TO BS970-Pt-1-1983/AISI -6140

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.02 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	Prendy	MATERIAL - ROUND BAR GOST 7417-75 38XA GOST 1051-73	USED ON :- Cb 3301-15-44 C6 3301-15-30 (B)
APPD	Prendy	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	15-6-83	TITLE STUD M8x72	
SCALE	1:1	D S CAT NUMBER	DRAWING NUMBER 350-122
ISSUE	DATE	NATURE OF AMENDMENTS	

COMMON TO V-92SZ ENGINE

A-11
26
SIZE A2