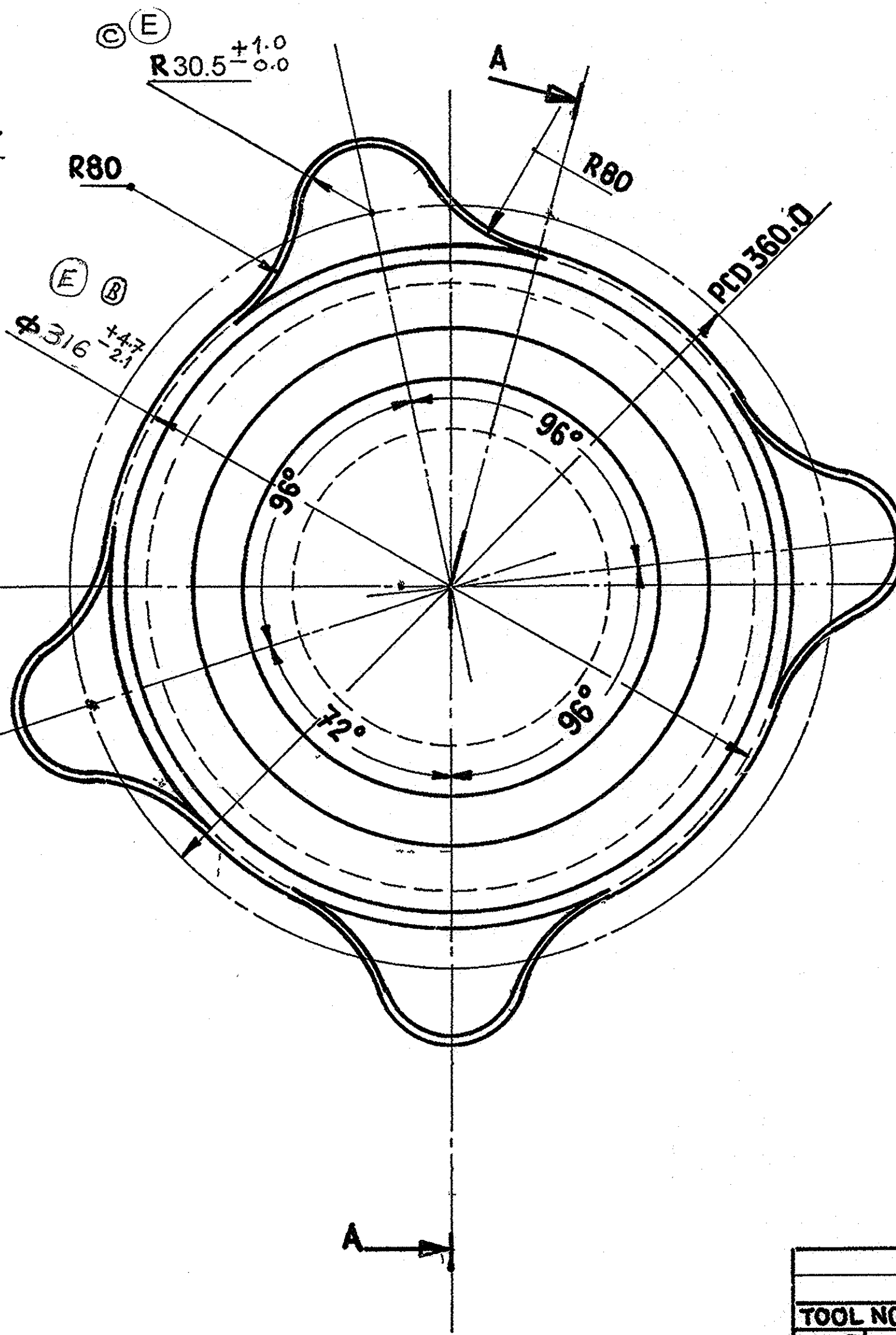
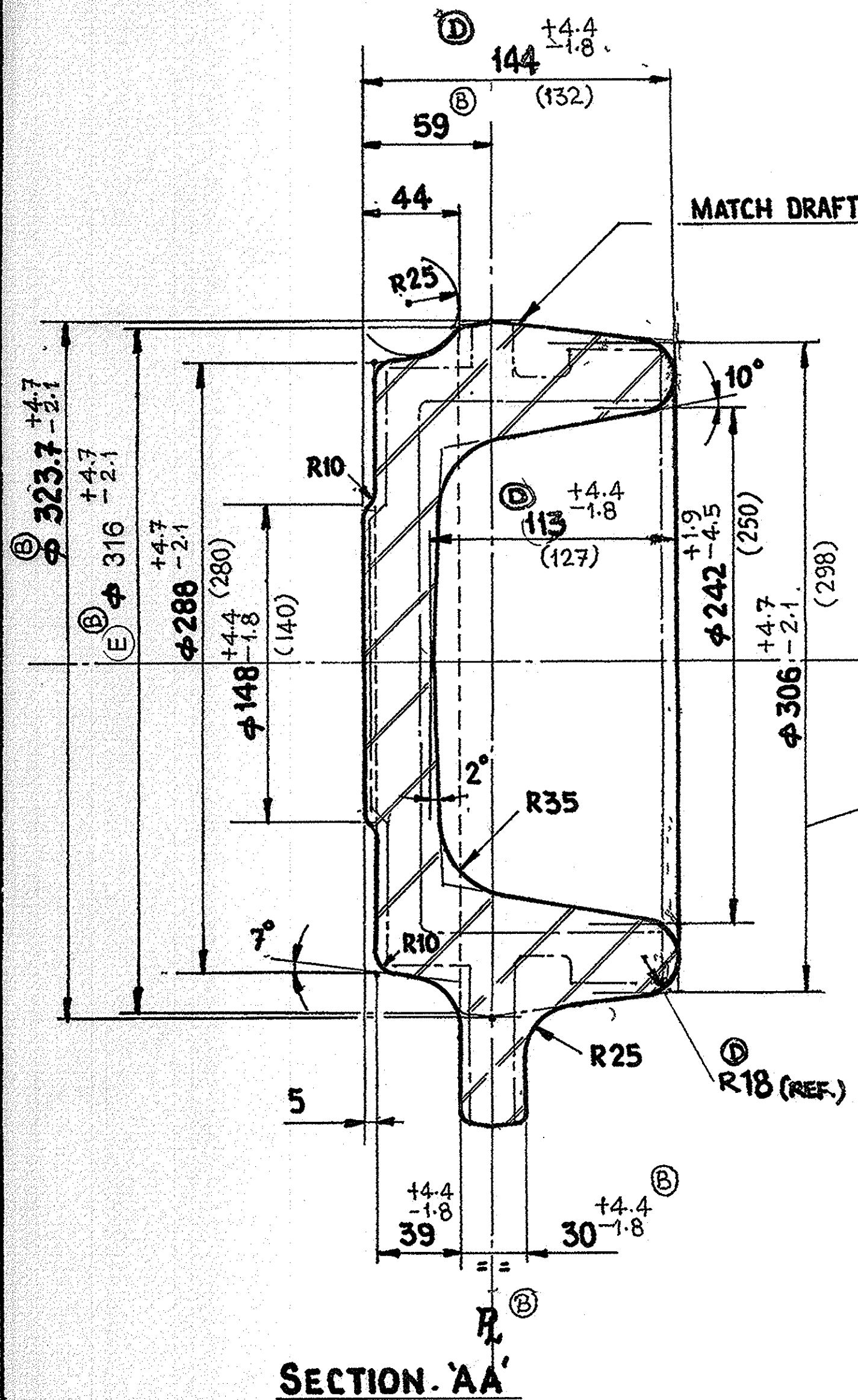




ISS.	MODIFICATION	DATE	ISS.	MODIFICATION	DATE
D	DIMN. 144 ± 4.4 WAS DIMN. 141 ± 4.4 DIMN. 113 WAS 110 R 18 (REF.) ADDED. DRG. UPDATED IN LINE WITH FORGESHOPE REQUIREMENT.	1/2 25/16	A	HEAT TREATMENT DETAILS ADDED	SD 22.1.87
E	RADIUS 30.5 ± 1.0 WAS RADIUS 29.5 ± 1.0 DIA. 316 ± 4.7 WAS DIA. 320-21 REF. JWM/IRG L.Y. NO. 07271/IRG/T-90/FDDP 1/10-11 06.16-4-10	1/2 5/5/10 6/5/10	B	REDESIGNED PARTING LINE SHIFTED TO CENTRE OF COLLAR DIA. 309 DELETED DIA. 320 & 323.7 ADDED DIMN. 59 WAS 74	1/2 19/12/98
			C	RADIUS 29.5 ± 1.0 WAS 33 ± 1.0	1/2 8/2/2007

TECHNICAL REQUIREMENT

HEAT TREATMENT :- NORMALISE (A)
DIA. OF IND ≥ 3.8 mm (255 BHN)

DESCALE

MARK IDENTIFICATION MARK.

DEPTH OF SURFACE DEFECTS AND PITS FROM
SCALE UPTO 0.5 OF ACTUAL MACHINING
ALLOWANCE IS ALLOWED, ON NOT TO BE MACHINED
SURFACES IT SHOULD BE WITHIN THE LIMITS
OF TOLERANCES.

MISMATCH SHOULD NOT EXCEED 1.5 mm.

RESIDUAL FIN ALONG WITH PARTING LINE
SHOULD NOT EXCEED 2.0 mm.

UNSPECIFIED DRAFT ANGLE ARE TO BE 7°

UNSPECIFIED RADII ARE TO BE 5mm.

MACHINING DIMENSIONS ARE SHOWN IN BRACKETS

UNTOLERANCED DIMENSIONS ARE NOT TO BE
CHECKED.

PAINT RED OXIDE.

MATERIAL :- STEEL 38XC GOST 4543-71

FORGING WEIGHT :- 57 KG

NOTE :- FORGING COMMON FOR 172-52-134/F

T-72 & T-90

TOOL NO.	DESCRIPTION	MACHINE	REMARKS
SCALE	COMPONENT ~ T-72	MACHINE	COMPT./FORGING
1:2	172-52-133/F 172-52-134/F		10FF 172-52-133 OR 10FF 172-52-134
THIS DRG. IS TO BE USED WITH J&T SPECN. 11/31 ISS:ML			H.V. FACTORY, AVADI
DGN.	CHD.	APPD.	DRG. NO.
			172-52-133/F

FORGING DRG.