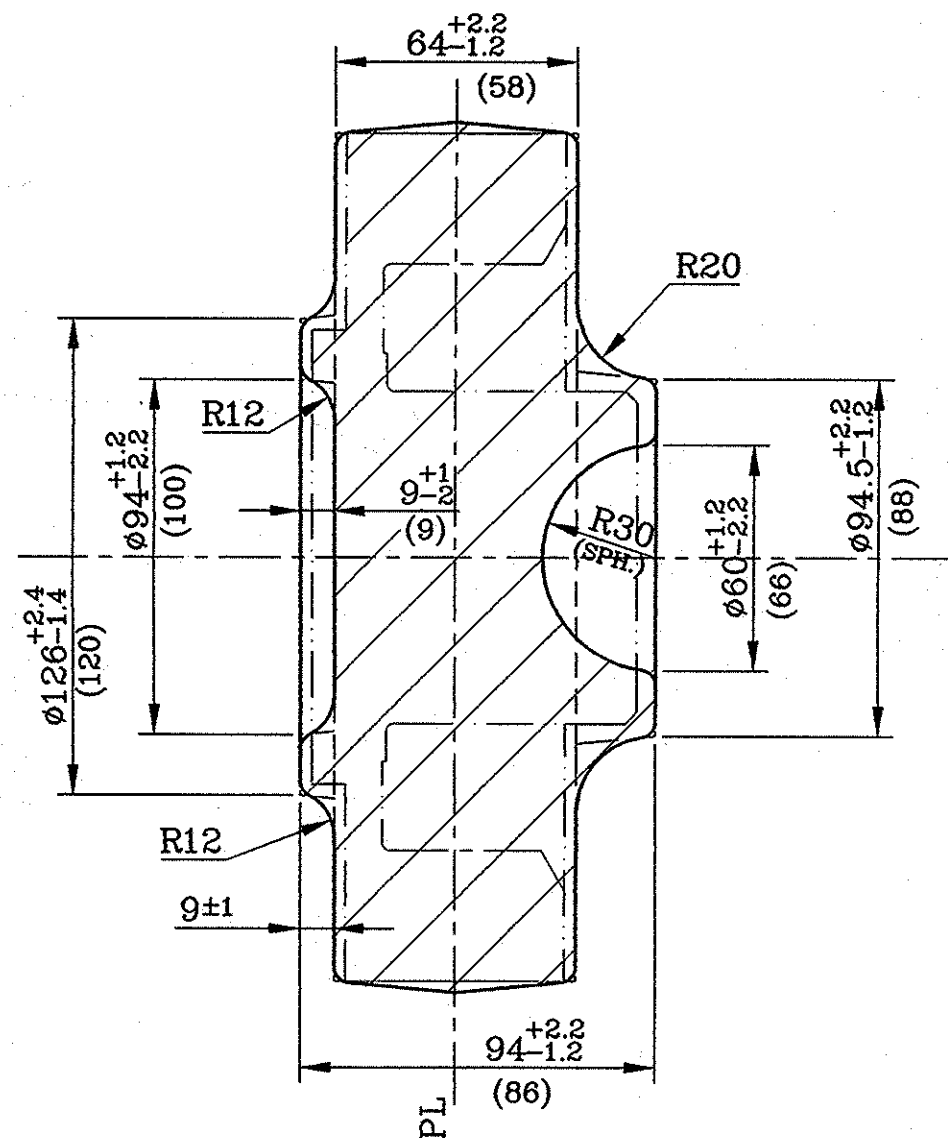
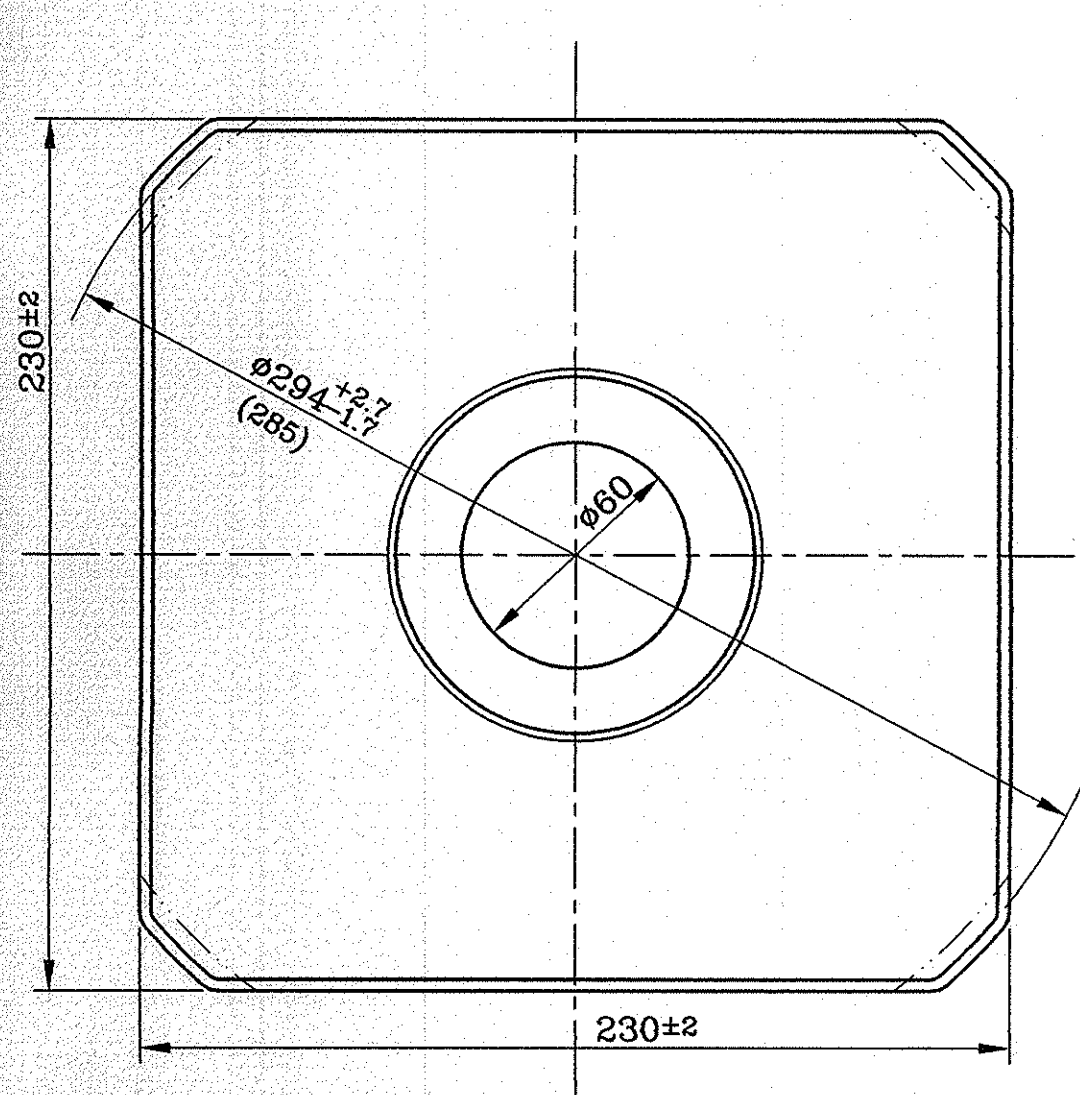


DRAWING NO.  
175.40.024-1/F

MODIFICATIONS & ADDITIONS

ISSUE	MODIFICATIONS & 'N' OF 'A'	SIGN.
A	REDRAWN	<i>[Signature]</i>



TECHNICAL REQUIREMENTS.

- HEAT TREAT. DIA.OF IND.  $\geq$  3.8 MM.
- DESCALE
- DEPTH OF SURFACE DEFECTS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE ARE ALLOWED. ON NOT TO BE MACHINED SURFACES,THEY SHOULD NOT EXCEED TOLERANCE LIMIT.
- MISMATCH SHOULD NOT EXCEED 1.3 MM.
- RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 1.7 MM.

- BUCKLING SHOULD NOT EXCEED 0.8 MM.
- MARK PART NO.
- UNSPECIFIED DRAFTS = 7°
- UNSPECIFIED RADII = R 4 MM.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UNTOLERANCED DIMENSIONS ARE FOR REFERENCE AND NOT TO BE CHECKED.

T-72

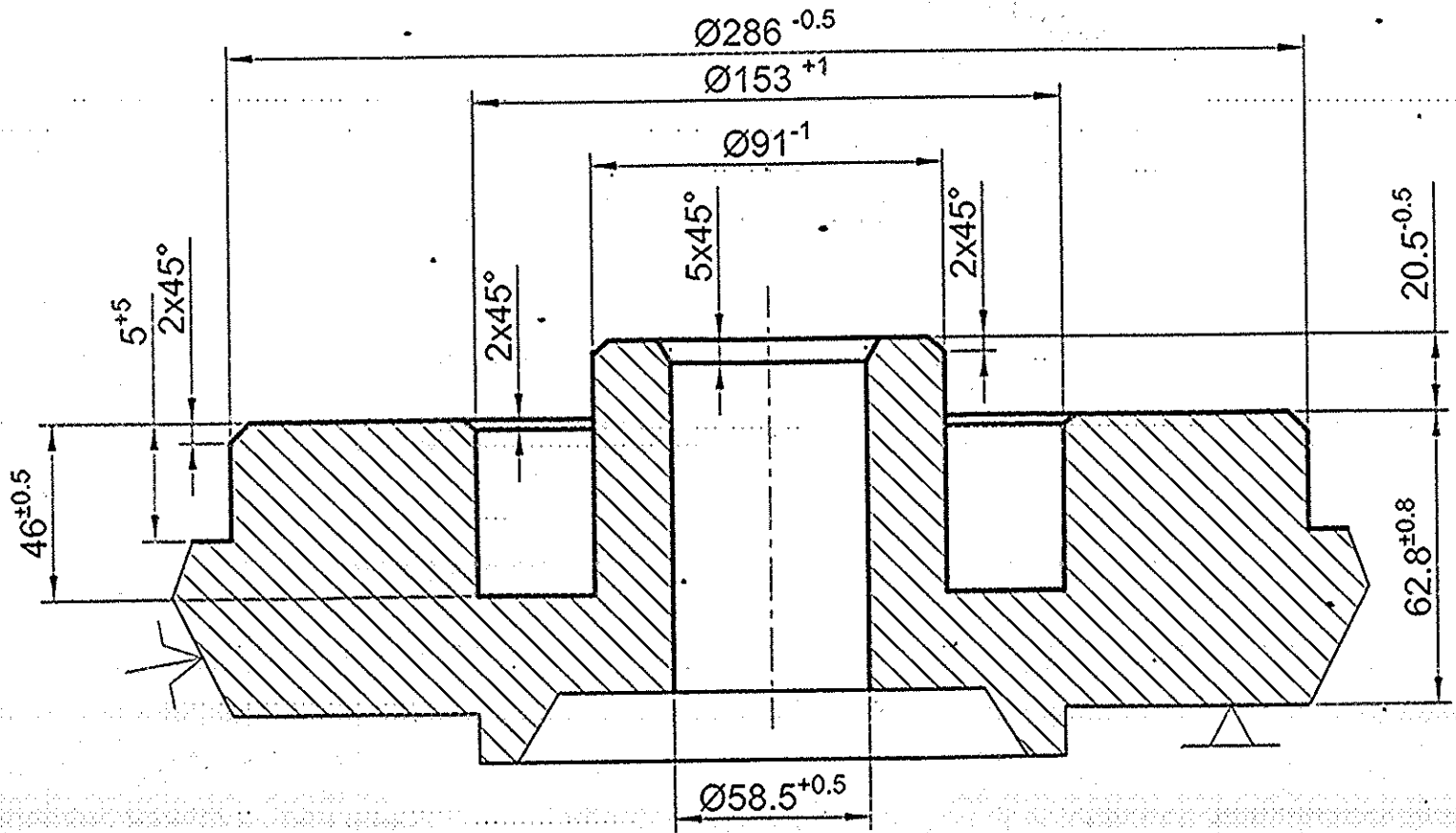
MATERIAL	FORGING WT.	
38XC GOST 4543-71	26.50 KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-13	1:2
DRAWN	CHECKED	APPROVED
<i>[Signature]</i> 30/5/08	<i>[Signature]</i> 31/5/08	<i>[Signature]</i> 26/6/08

DRAWING NO. 175.40.024-1/F  
NOMENCLATURE: CARRIER PLANET,4th  
PLANETARY GEAR



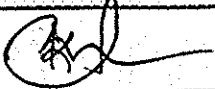
HEAVY VEHICLES FACTORY  
AVADI,CHENNAI

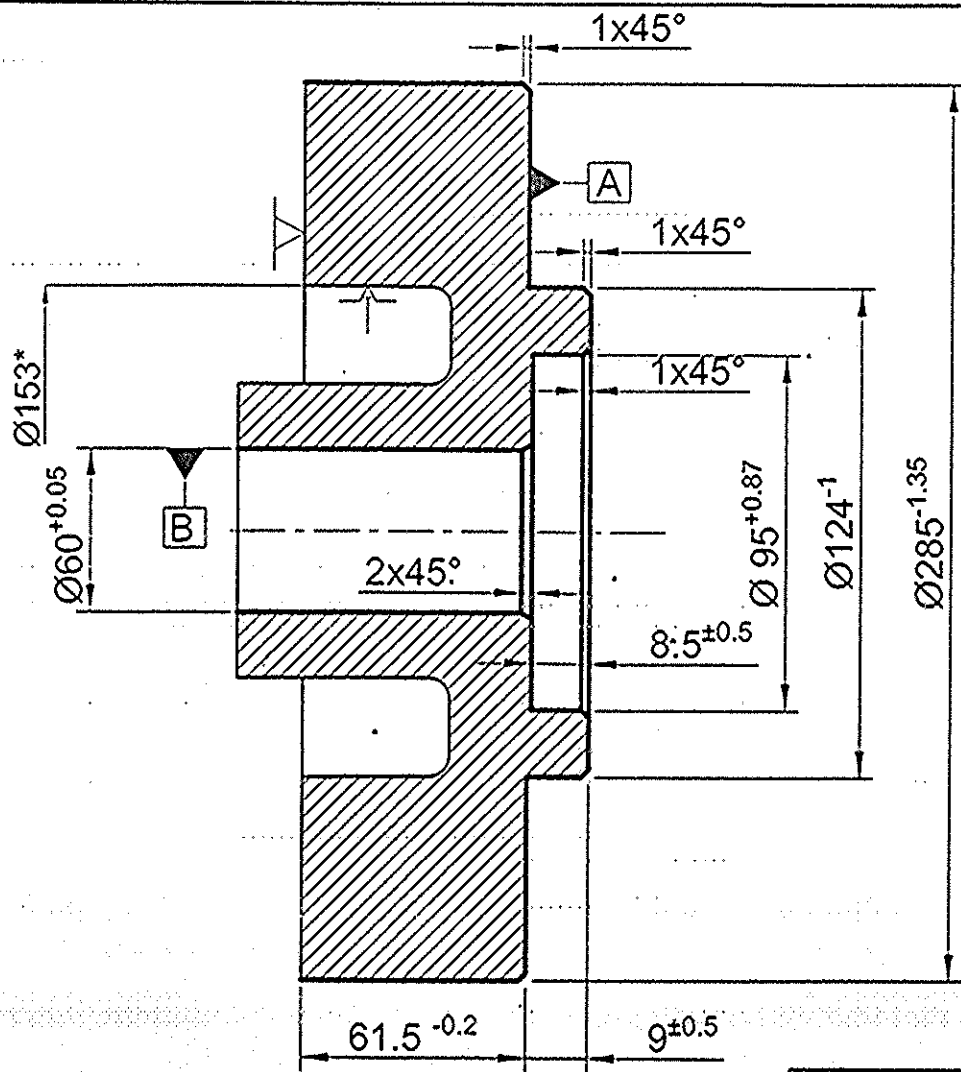
TOOL NO.	TOOL DESCRIPTION	MACHINE	REMARKS
20140	TRIMMING TOOL	600 T	
20139	STAMPING DIES	DG-13	

1



DRG NO. : 175.40.024-1/SMF	CARRIER 4th PLANETARY
OPN NO. : 020 TURNING (1st SETUP)	GEAR TRAIN
MATERIAL: STEEL 38xC GOST 4543-71	
HARDNESS: BHN 302-255	
SHEETNO. :	NOT TO SCALE

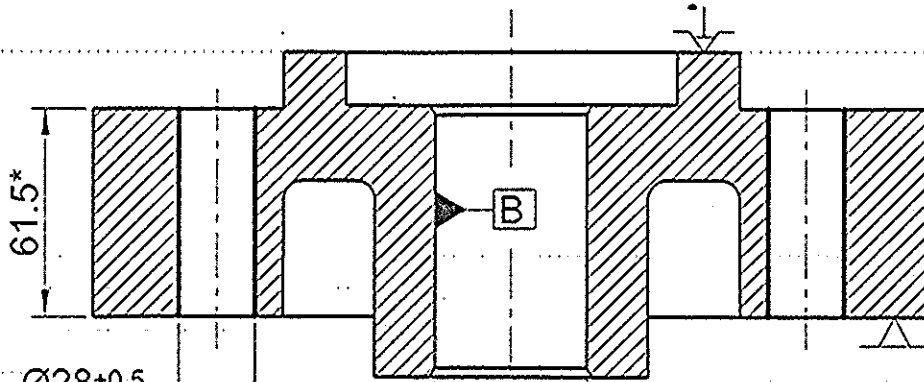
		
PREPARED	CHECKED	APPROVED
[VIJAYANANDA] JWM/TRG	[SUMIT.] CM/TRG	[K. DURAIRAJ] JWM/TRG (HOS)



Run out of A&B should not exceed 0.1mm w.r.t Ø153

DRG NO. : 175.40.024-1/SMF	CARRIER 4th PLANETARY
OPN NO. : 030 TURNING (2nd SETUP)	GEAR TRAIN
MATERIAL: STEEL 38xC GOST 4543-71	
HARDNESS: BHN 302-255	
SHEETNO. :	NOT TO SCALE

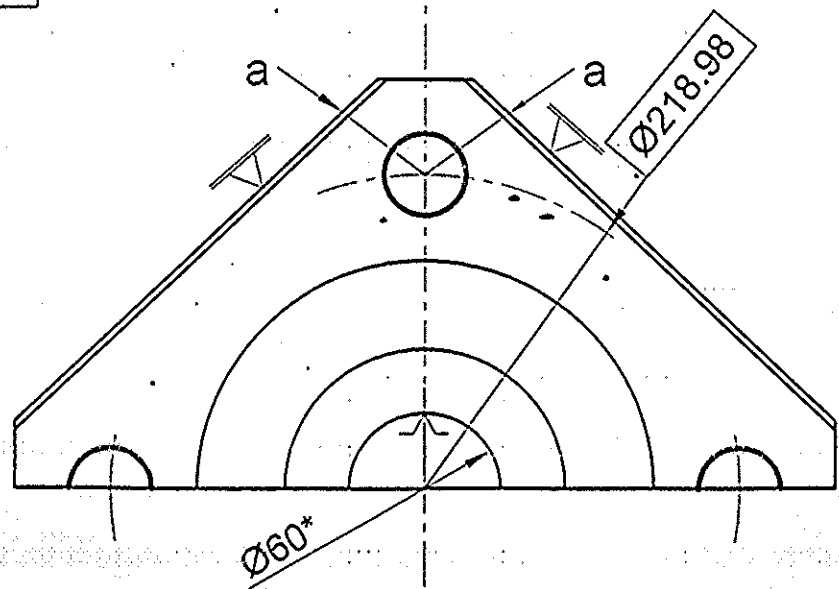
PREPARED	CHECKED	APPROVED
VIJAYANAND. A JWM/TRG.	SUMIT CM/TRG	K. DURAIRAJ. JWM/TRG (CHOS)



Rz80 (▽)

4 HOLES- Ø28+0.5

⊕	0.6	M	A	B
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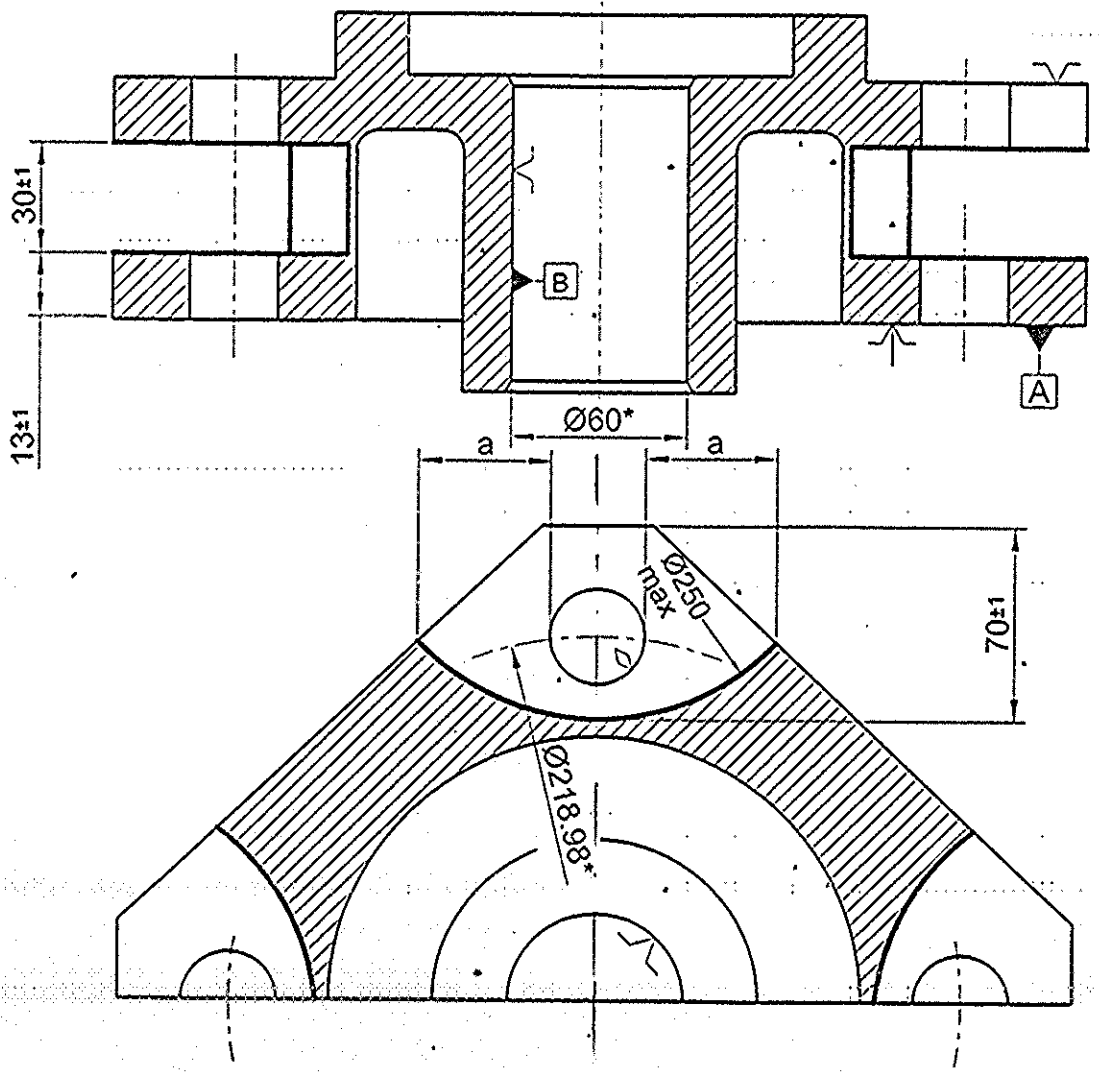
DIFFERENCE OF DIMENSION 'a' SHOULD BE WITHIN 2.5MM

\*DIMENSIONS FOR REFERENCE

DRG NO. : 175.40.024-1/SMF	CARRIER 4th PLANETARY
OPN NO. : 060 DRILLING.	GEAR TRAIN
MATERIAL: STEEL 38XC GOST 4543-71	
HARDNESS: BHN 302-255	
SHEETNO. :	NOT TO SCALE

PREPARED	CHECKED	APPROVED
VIJAYANAND. A JWM/TRG.	SUMIT CM/TRG.	K. DURAIRAJ. JWM/TRG (HOS)

Rz80 (✓)



DIFFERENCE OF DIMENSION 'a'  
SHOULD BE WITHIN 2.5MM

SHIFT OF AXIS OF REFERENCE DIA  
60MM TO DIA 250MM SHOULD BE  
WITHIN 2.5MM

PREPARED	CHECKED	APPROVED

VIJAYANAND .A  
JWM/TRG.

SUMIT  
CM/TRG.

K. DURAIRAJ.  
JWM/TRG (HOS)

DRG NO. : 175.40.024-1/SMF	CARRIER 4th PLANETARY
OPN NO. : 070 SLOT MILLING	GEAR TRAIN
MATERIAL: STEEL 38xC GOST 4543-71	
HARDNESS: BHN 302-255	
SHEETNO. :	NOT TO SCALE