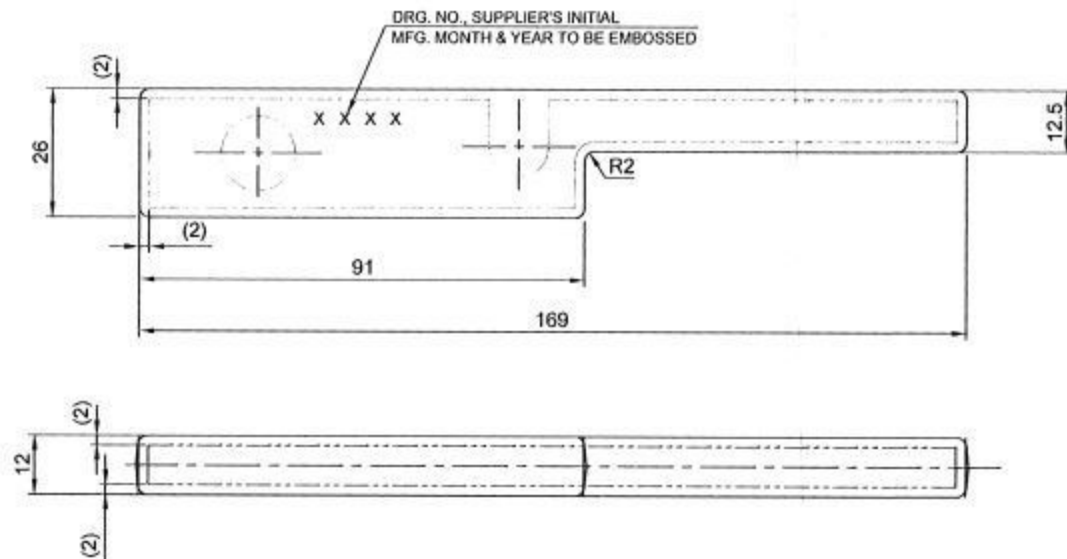
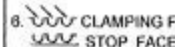


ALL DIMENSIONS ARE IN MM.



NOTE:

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

MATERIAL: 16MnCr5 (DIN 17210)

COMP. OF

PHYS. PROP.:

HEAT-TREATMENT: ISO THERMAL ANNEALING.

HARDNESS: 150 - 210 BHN

MICRO STRUCTURE: FINE FERRITE & PEARLITE
GRAIN SIZE: ASTM 5 OR FINER

INCLUSION RATING: 3 A B C D THIN SERIES OR FINER AS PER IS:4163-1967. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.

FORGING TOLERANCE AS PER IS : 3469 - 1974

FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE
0.32 kg				NORMAL
KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.	
LENGTH/DIA	+1.1 -0.4	RESIDUAL FLASH		
THICKNESS	+0.7 -0.4	TRIMMED FLAT		
MISMATCH	0.6	DRAFT ANGLE	+2° -1°	
STRAIGHTNESS	0.6	RADII	+50% -25%	
INTERNAL DIMS. REVERSE SIGN + & -				

**FORGING DRAWING
FOR
OD SELECTOR PLATE
GEAR BOX STLN. MK-IV**

VEHICLE FACTORY JABALPUR

R.C.R. KOLTE JWM / DDO	JWM/GS	APPD.
RAJEEV DRN	TCD.	DO/PROD.
REF. DRG.	1 : 1 SCALE	
M/C.	DDO SECTION	05/02/2014 DATE
DEMANDED BY	1/1 SHT. A3	
DRG. NO.	FF 200114-3	