

ALL DIMENSIONS ARE IN MM.

TECHNICAL SERVICES SECTION

Vehicle Factory, Jabalpur

CERTIFIED CORRECT COPY

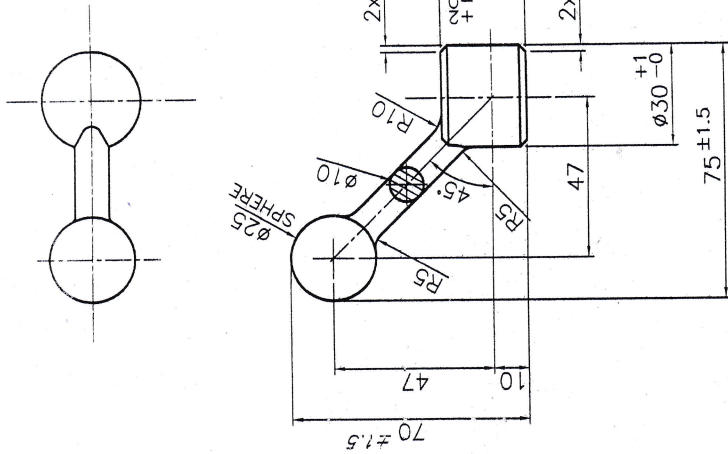
JWM/MM-1

10/06/2022

JWM/TSC

STAMP PART NO & SUPPLIER CODE

John



AMENDMENT 'A':-- DETAILS FOR MICRO STRUCTURE, GRAIN SIZE & INCLUSION RATING ADDED.

FORGING WEIGHT :- 0.250 KG (APPROX)

NOTE: SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

QTY./MEH = 12 NOS.

<p>NOTE:</p> <ol style="list-style-type: none"> FORGING RIDGES TO BE TRIMMED. CLEAN & SMOOTH FINISH ALL OVER. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO ISS 3-47-1B3Y BRUSHING OR SPRAYING. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION, PIPING, FLAKES ETC. DIMS. IN BRACKETS INDICATE MACHINING ALLOWANCE. DRAFT ANGLE: INNER 7°, OUTER 5°. UNSPECIFIED RADIUS: CORNER -2R, FILLET-3R. UNSPECIFIED RAMPING FACE & CHAMFER FACE OR 1ST MACHINING OPERATION. 	<p>MATERIAL: C-45 IS-2004</p> <p>COMP. OF CLASS-4: C:0.44, Si:0.35MAX, Mn:0.60-0.90, S:0.04MAX, P:0.04MAX,</p> <p>HEAT TREATMENT: NORMALIZED</p> <p>HARDNESS: 150-210 BHN</p> <p>MICRO STRUCTURE: FINE FERRITE & PEARLITE</p> <p>GRAIN SIZE: ASTM 5 OR FINER</p> <p>INCLUSION RATING: 3 A B C D THIN OF IS 4163.</p> <p>FORGING TOLERANCE AS PER IS 3469-1974</p>	<p>KIND OF DIMS.</p> <p>LENGTH / DIA: +1.2, -0.6</p> <p>THICKNESS: +0.9, -0.5</p> <p>MISMATCH: 0.6</p> <p>STRAIGHTNESS: 0.6</p> <p>RESIDUAL FLAT: +0.7</p> <p>TRIMMED FLAT: -0.7</p> <p>ANGULAR: +2, -1</p> <p>RADI: +50%, -25%</p> <p>INTERNAL DIMS, REVERSE SIGN + & -</p>	<p>TOL</p> <p>+1.2</p> <p>-0.6</p> <p>+0.9</p> <p>-0.5</p> <p>0.6</p> <p>0.6</p> <p>+0.7</p> <p>-0.7</p> <p>+2</p> <p>-1</p> <p>+50%</p> <p>-25%</p>	<p>ALTERATION</p> <p>SIGN</p> <p>DATE</p> <p>FORGING BLANK FOR BALL HANDLE FOR GUN PORT UPGRADED MPV 4X4</p>	<p>ALTERNATE DATE</p> <p>2742-57-31</p> <p>REF DRG. NO.</p> <p>REPLACED BY</p> <p>REPLACEMENT FOR</p>	<p>SCALE</p> <p>1:1</p> <p>DATE</p> <p>4-5-22</p>	<p>DIR/ODC</p> <p>AD/ODC</p> <p>JWM/ODC</p> <p>DRN</p> <p>CKD</p>