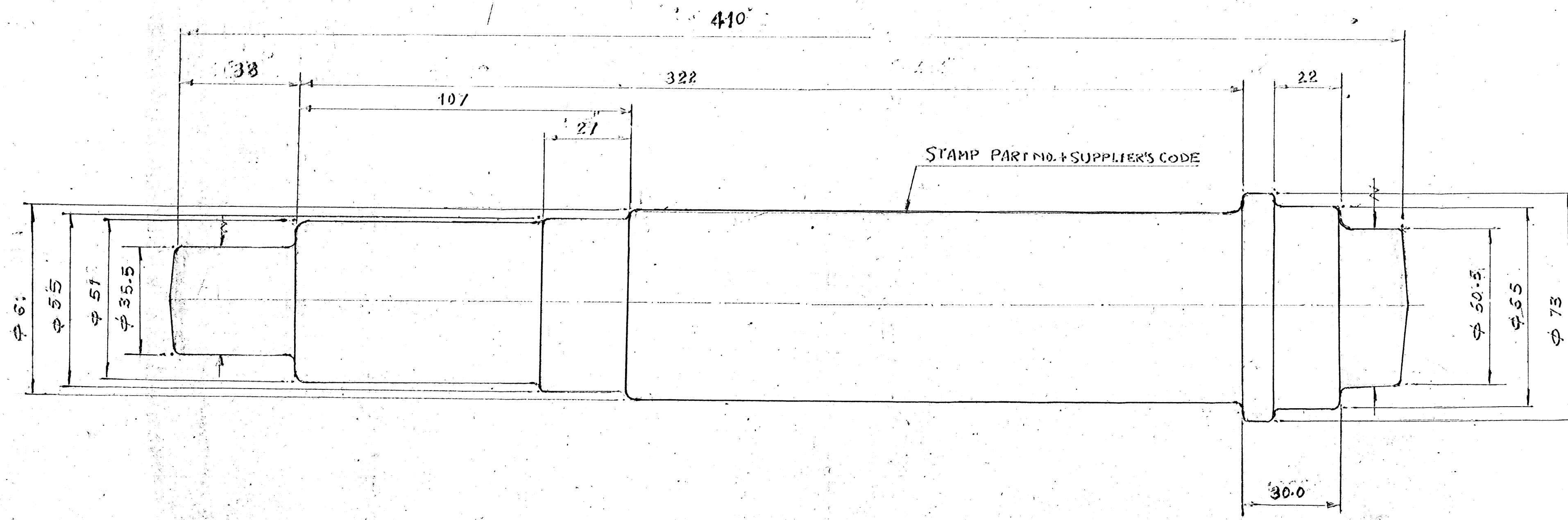


ALL DIMS. ARE IN MM.



SUPPLY CONDITION -
TRACES OF PARTING LINE NOT PERMITTED

- NOTE: 1) ALL LOCATING, RESTING AND CLAMPING SURFACES
TO BE CLEAN, SMOOTH, FLAT AND CYLINDRICAL.
- 2) ALL THE TOLERANCES AS PER IS: 3469 (PART I TO III) - 1974
- 3) SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
- 4) FORGING TO BE SUPPLIED AFTER APPLYING RED
OXIDER PRIMER FOR RUST PREVENTION.
5. GRAIN SIZE: ASTM 5 OR FINER.
6. INCLUSION RATING: 3 ABCD THIN SERIES OR FINER
AS PER IS: 4163-1967.
- | S.N. | DETAIL | MATERIAL |
|------|--------|----------|
| 1 | | |
| 2 | | |

MATERIAL CONSTITUENTS		
S.N.	DETAILS	MARK IV
1	MATERIAL	EN 353
2	IS	822 M-17
	EQUIVALENT	
3	TYPE OF STEEL	2% Ni Cr Mo CH Steel (Low Cr)
4	C	0.2 Max
5	Si	0.35 Max
6	Mn	0.4-0.7
7	Ni	1.8-2.2
8	Cr	1.4-1.7
9	Mo	0.15-0.25

TOLERANCES IN MM	
DIE WEAR (TOTAL)	+2.5 , -0.0
DIE THICKNESS	+2.0 , -0.0
MIS MATCH	0.3
FLUSH EXTENSION	CLOSE TRIM
STRAIGHTNESS	0.2
CORNER RADIUS	+50% , -25%
DRAFT ANGLE	+2° , -1°
ECCENTRICITY TO THE PUNCH HOLE	-
SURFACE	0.5

ALL DIMENSIONS AND DRAFT ANGLES TAKEN TO SHARP CORNERS		MATERIAL	EN 355 FINE GRAIN	LOCATE
DRAFT	EAT 3°	HEAT TREATMENT	ISOTHERMAL ANNEALING FORGING TO BE SUPPLIED IN SHOT BLASTED COND.	REST
ANGLE	INT	HARDNESS	160-210 BHN	CLAMP
CORNER RADIUS	2.0 mm	MICRO STRUCTURE	FINE FERRITE & PEARLITE	
FILLET RADIUS	3	WEIGHT		

(R1)	NOTE: AT S.N. 10, 11 & 12 UNDER MATH. CONT. HEADING DELETED REF. JUM 34FRB84 L.N. 451/ 9AT/32R-1/13.5.13.13 OF 1-2-13	DATE	SIGN
	INDEX	DATE	SIGN

FORGING DRAWING		1/1
INPUT SHAFT		05-02-10
AGB/STLN:		
MARK - IV		1/1

T.D.O	VEHICLE FACTORY JABALPUR	DRG. NO. X3303611-3 (R1)
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