

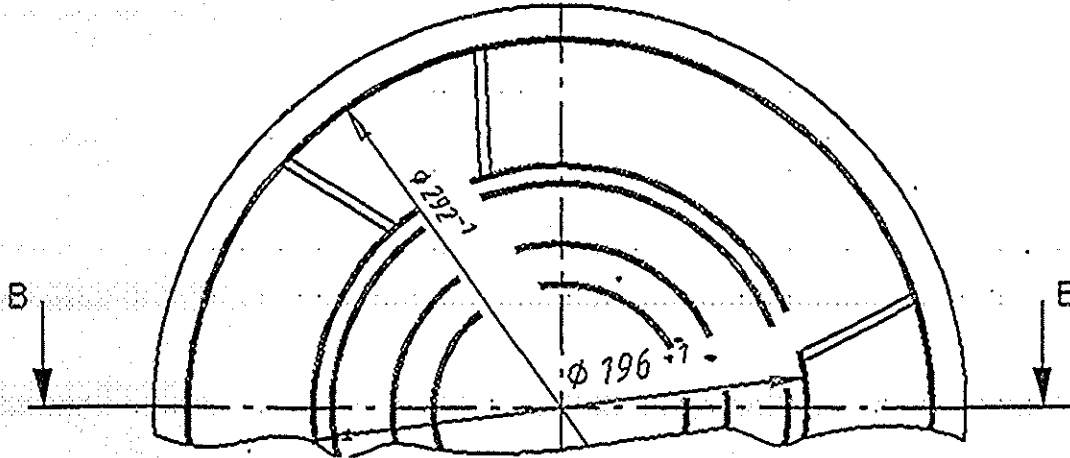
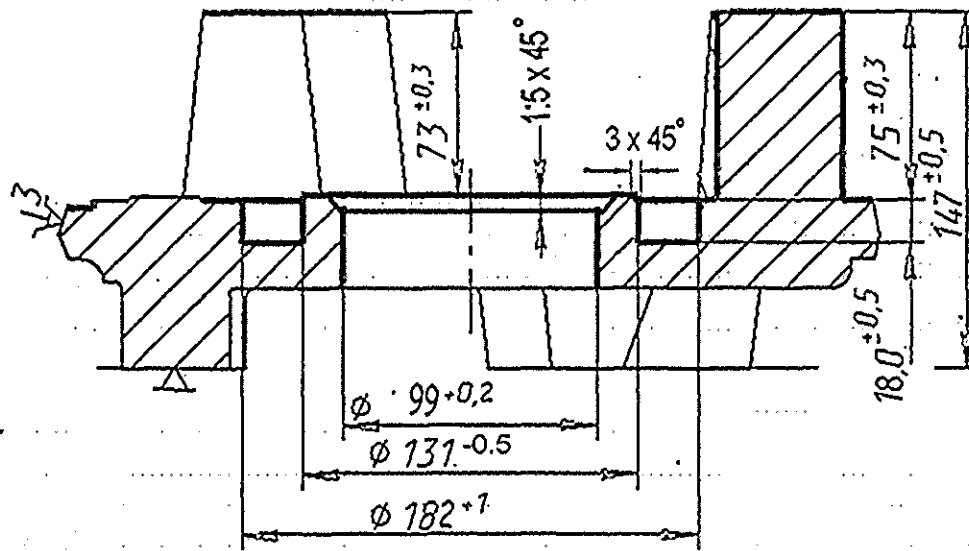
TECHNICAL REQUIREMENTS

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| <p>01. ACCURACY CLASS OF FORGING T5, GRADE STEEL M 2, CATAGORY OF COMPLEXITY C2, INDEX 18 AS PER GOST 7505-89.</p> <p>02. GROUP OF FORGING II AS PER GOST 8479-70.</p> <p>03. MARK CODE OF SHOP IN-CHARGE.</p> <p>04. < 255 HB.</p> <p>05. DE-SCALES (SHOT BLASTING).</p> <p>06. SURFACE DEFECTS AND RECESSES DUE TO SCALES UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE MAY BE ALLOWED.</p> <p>07. PERMISSIBLE DISPLACEMENT ALONG PARTING OF DIE MAY BE ALLOWED UPTO 1.8 MM.</p> <p>08. PERMISSIBLE HEIGHT OF BURR ALONG THE CONTOUR OF TRIMMED FIN MAY BE UPTO 6 MM, IN THE BROACHED PLACE 8 MM.</p> | <p>09. PERMISSIBLE RESIDUAL FIN UPTO 1.8 MM IS ALLOWED.</p> <p>10. PERMISSIBLE DEVIATION FOR CONCENTRICITY OF BROACHED HOLE MAY BE UPTO 2.5 MM.</p> <p>11. PERMISSIBLE DEVIATION FOR FLATNESS - UPTO 1.8 MM.</p> <p>12. UNSPECIFIED FILLET RADII - R 10</p> <p>13. UN-SPECIFIED STAMPING DRAFTS - 7°</p> <p>14. DIMENSIONS IN BRACKETS ARE GIVEN FOR MACHINING.</p> <p>15. DIMENSIONS WITHOUT TOLERANCES ARE FOR MAKING DIES - NOT TO BE CHECKED.</p> <p>16. PAINT RED OXIDE.</p> |
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MATERIAL	FORGING WT.	
38XC GOST 4543-71	42.00KGS	
ALT. MATERIAL	HAMMER	SCALE
	DG-13	
DRAWN	CHECKED	APPROVED
<i>L. Suresh</i>	<i>M. Suresh</i>	<i>S. D. Suresh</i>
DRAWING NO.	172.40.316/F	
NOMENCLATURE:	CARRIER OF 1,2 AND 3 PLANETARY GEAR SET	
HEAVY VEHICLES FACTORY AVADI, CHENNAI		

SECTION: B-B

Rz80



* -DIMN. FOR REFERENCE

RUN OUT OF ALL DIAMETER SHOULD NOT EXCEED 0.2mm

DRG. NO	: 172.40.316/SMF	CARRIER OF 1st, 2nd & 3rd
OPN. NO.	: 020 TURNING	PLANETARY GEARSET
MATERIAL	: STEEL 38XC GOST 4543-71	
HARDNESS	: ≤ 255 BHN	
SHEET NO.	NOT TO SCALE	

[Signature]
PREPARED

[Signature]
CHECKED

[Signature]
APPROVED

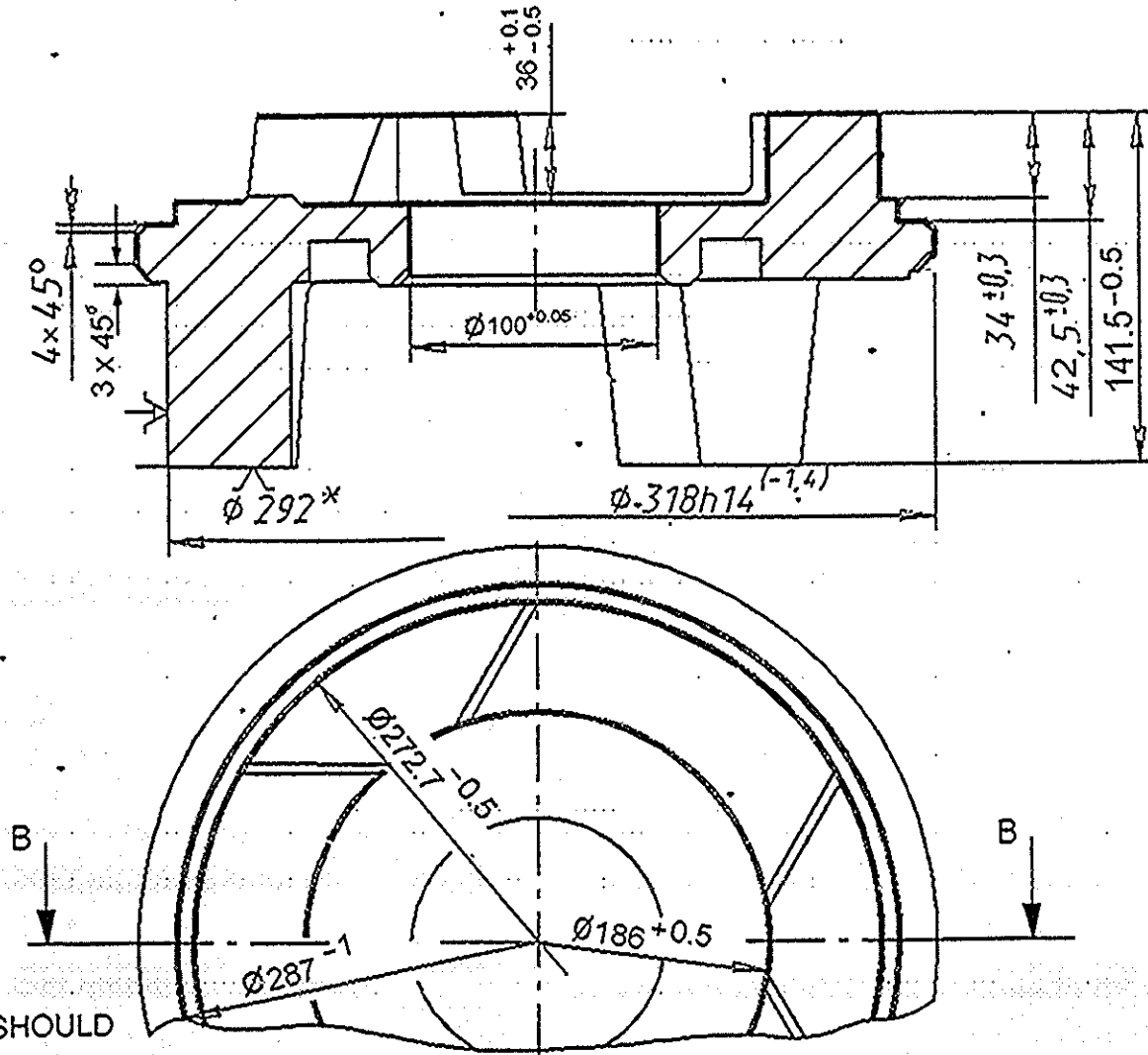
VIJAYANAND. A
JWM/TRG.

SUMIT
CM/TRG.

K. DURAIRAJ,
JWM/TRG (CHOS).

SECTION: B-B

Rz80

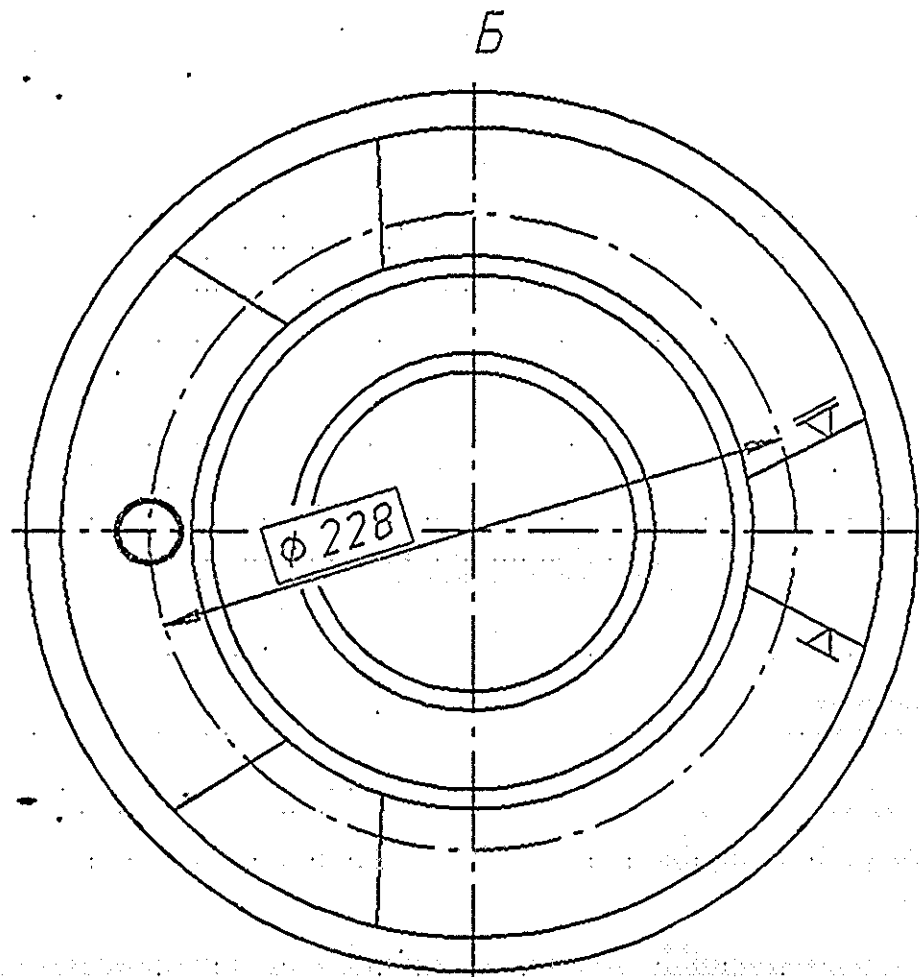
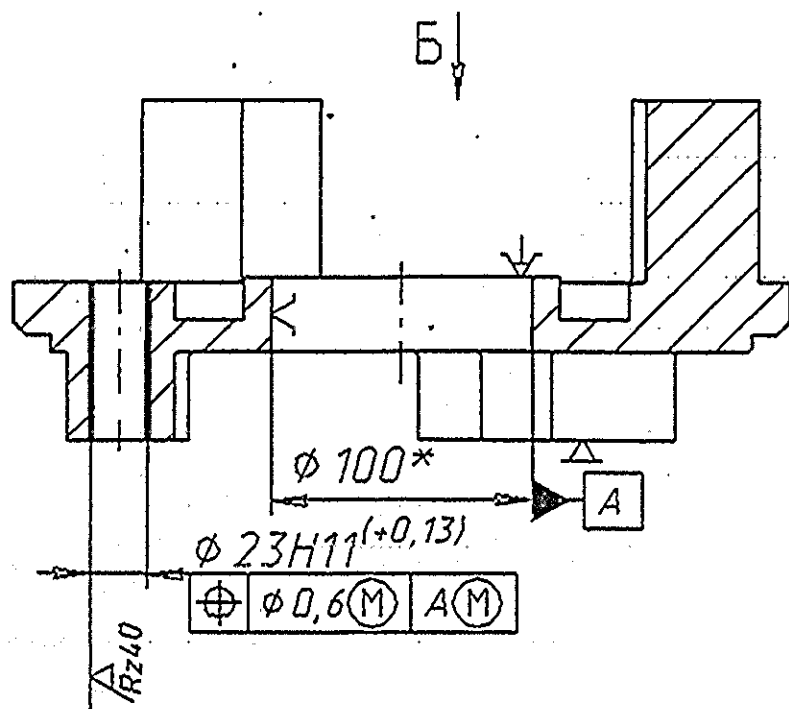


RUN OUT OF ALL DIAMETER SHOULD NOT EXCEED 0.2mm

* -DIMN. FOR REFERENCE

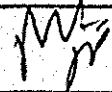
DRG. NO	: 172.40.316/SMF	CARRIER OF 1st, 2nd & 3rd
OPN. NO.	: 030 TURNING	PLANETARY GEAR SET
MATERIAL	: STEEL 38XC GOST 4543-71	
HARDNESS	: ≤ 255 BHN	
SHEET NO.		NOT TO SCALE


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

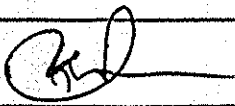


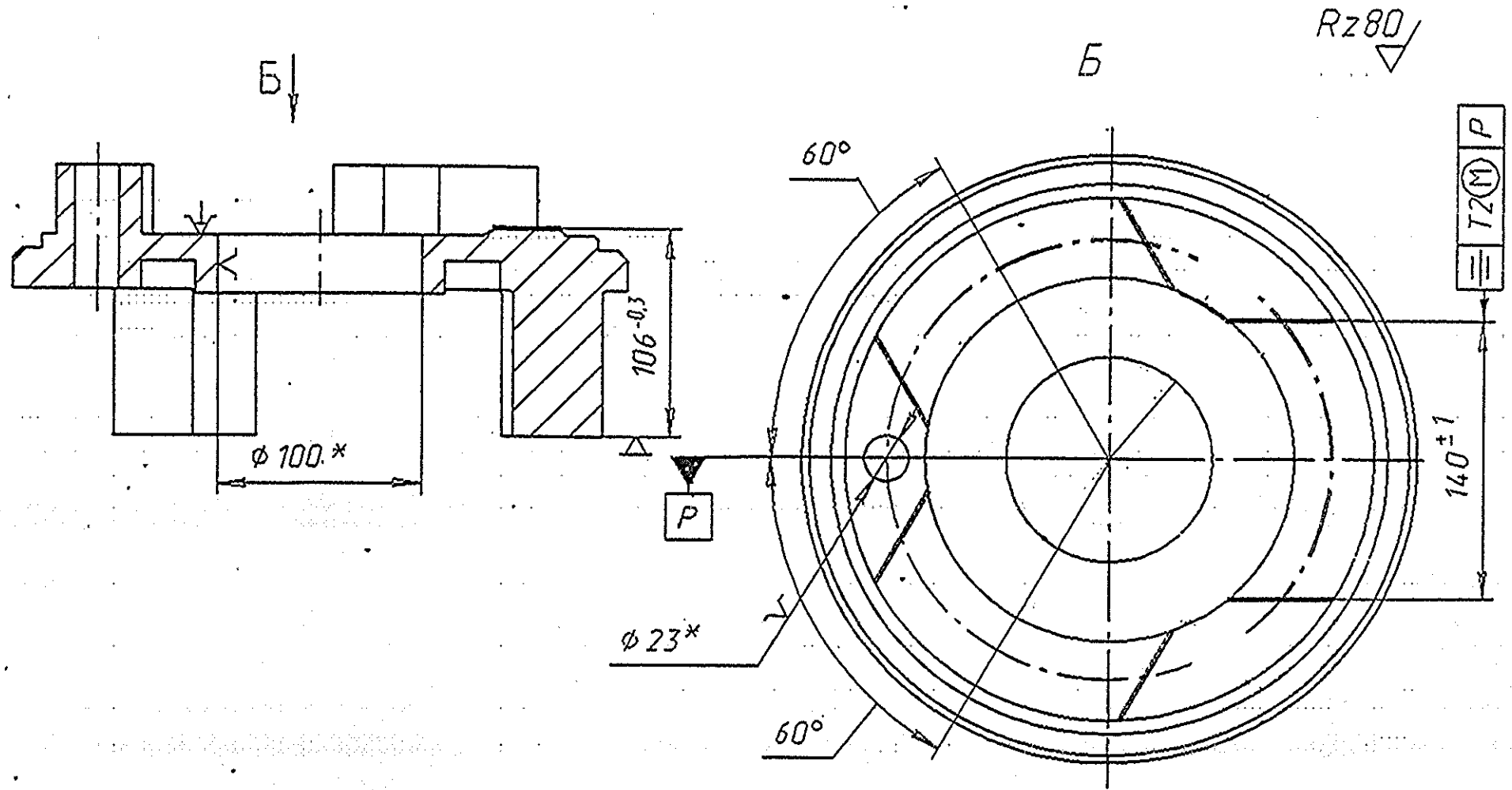
* -DIMN. FOR REFERENCE

DRG. NO	: 172.40.316/SMF	CARRIER OF 1st, 2nd & 3rd
OPN. NO.	: 050 DRILLING	PLANETARY GEAR SET
MATERIAL	: STEEL 38XC GOST 4543-71	
HARDNESS	: ≤ 255 BHN	
SHEET NO.	NOT TO SCALE	


 PREPARED
 VIJAYANAND.A
 JWM/TRG.


 CHECKED
 SUMIT
 CM/TRG.

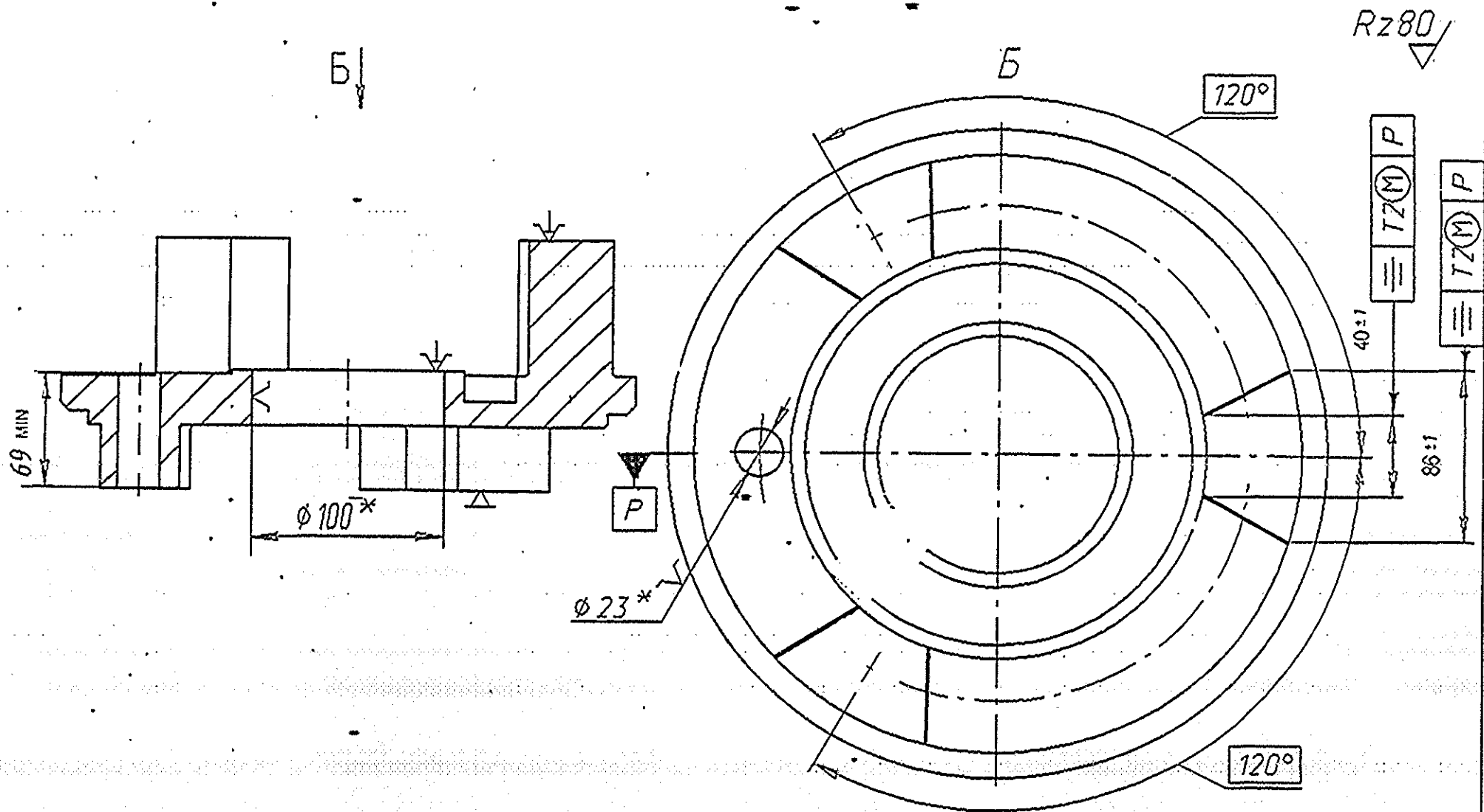

 APPROVED
 K. DURAIRAJ.
 JWM/TRG (HOS).



* -DIMN. FOR REFERENCE

DRG. NO	: 172.40.316/SMF	CARRIER OF 1st, 2nd & 3rd
OPN. NO.	: 060 DRILLING & MILLING	PLANETARY GEAR SET
MATERIAL	: STEEL 38XC GOST 4543-71	
HARDNESS	: ≤ 255 BHN	
SHEET NO.	NOT TO SCALE	

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



* -DIMN. FOR REFERENCE

DRG. NO	: 172.40.316/SMF	CARRIER OF 1st, 2nd & 3rd
OPN. NO.	: 070 DRILLING & MILLING	PLANETARY GEAR SET
MATERIAL	: STEEL 38XC GOST 4543-71	
HARDNESS	: ≤ 255 BHN	
SHEET NO.	NOT TO SCALE	

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