

TECHNICAL REQUIREMENTS

- 01. ACCURACY CLASS OF FORGINGS T5, GRADE OF STEEL M2, COMPLEXICITY CATAGORY C2, INDEX 18 AS PER GOST 7505-89.
- 02. GROUP OF FORGING II AS PER GOST 8479-70.
- 03. MARK CODE OF SHOP IN-CHARGE.
- 04. ≤ 256 HB.
- 05. DE-SCALES (SHOT BLASTING).
- 06. SURFACE DEFECTS AND RECESSES DUE TO SCALES UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE MAY BE ALLOWED.
- 07. PERMISSIBLE DISPLACEMENT ALONG THE PARTING OF DIES MAY BE UPTO 2.0 MM.
- 08. PERMISSIBLE RESIDUAL FIN MAY BE UPTO 2.0 MM.
- 09. PERMISSIBLE HEIGHT OF BURR ALONG THE CONTOUR OF TRIMMED FIN MAY BE UPTO 6.0MM AND AT THE BROACHING PLACE UPTO 8.0 MM.
- 10. MAXIMUM DEVIATION FOR CONCENTRICITY OF BROACHED HOLE MAY BE UPTO 3.0 MM.
- 11. UN-SPECIFIED FILLET RADII R 8.

T 90

FORGING WT.	
31.0 KGS	(b) +>
HAMMER	SCALE
EK-32	NTS
снескер	APPROVED
1. 1. 20/0/03	8.747
172.40.320 CROWN C	0/F
	HAMMER EK-32 CHECKED 172.40.32

HEAVY VEHICLES FACTORY
AVADI, CHENNAI