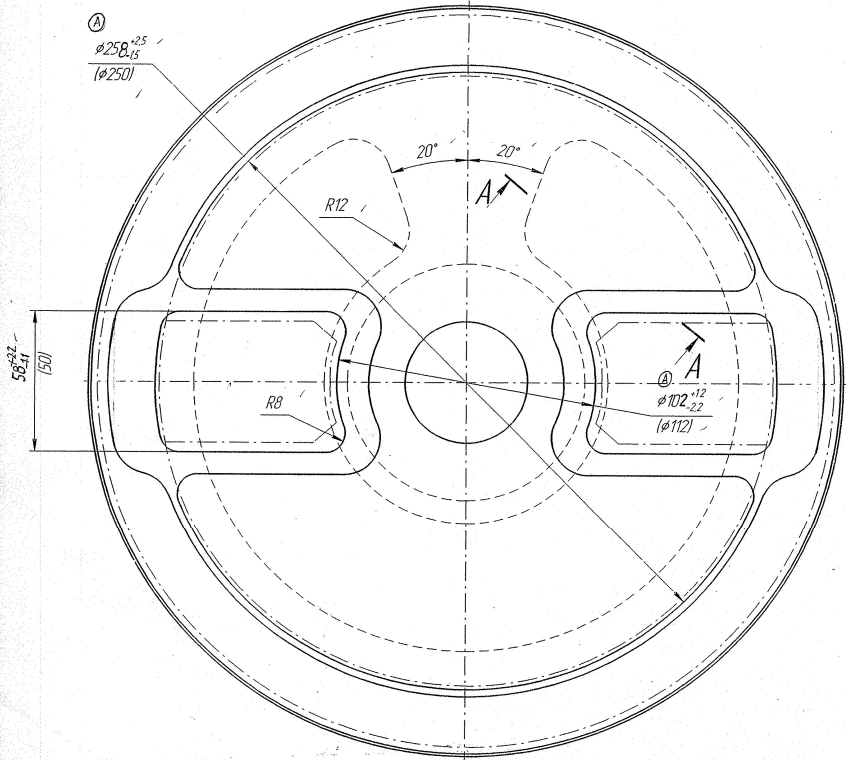
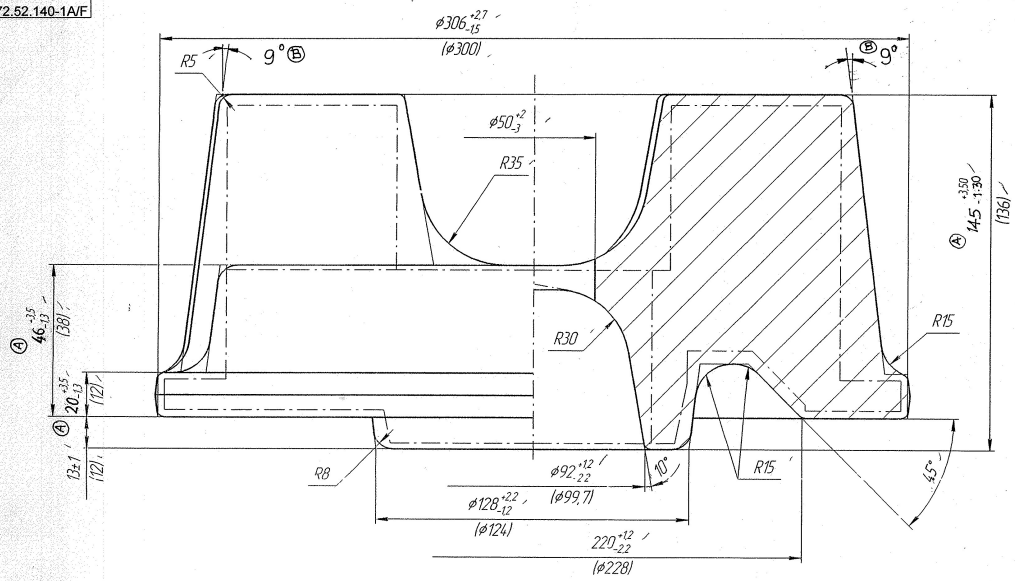
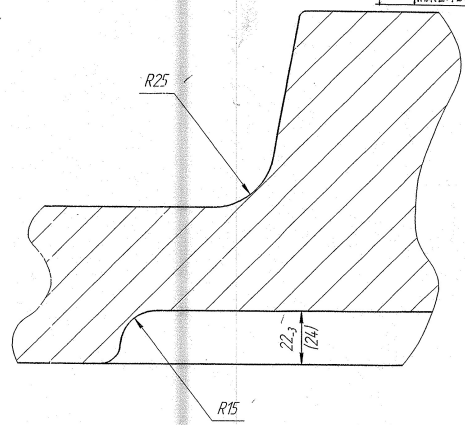


DRAWING NO.
172.52.140-1A/F



ISS.	MODIFICATION	DATE	ISS.	MODIFICATION	DATE
(B)	THE SEGMENT OUTER DRAFT ANGLE 9° WAS 7° REF. JWM/KS/Hr.no.0505/RS/78/2006-07 DT 12.5.06	12/05/06	(A)	FOLLOWING DIMS ARE MODIFIED: 20 DIMN. WAS 18 46 DIMN. WAS 44 145 DIMN. WAS 144.5 DIA. 258 WAS DIA. 256 DIA. 102 WAS DIA. 106 Ref. RA Hr. no. 07271/RA/ MATL. PLAN/05-06 Dt 12-1-06	12/11/06

A-A



TECHNICAL REQUIREMENTS

01. ≤ 256 HB.
02. SURFACE DEFECTS AND REGESSES DUE TO SCALES UP TO MAX. 50% OF ACTUAL ALLOWANCE MAY BE ALLOWED.
03. DISPLACEMENT OF DIES IS ALLOWED UP TO MAX. 1.3 MM.
04. CONTINUOUS ON STAMPED BURR IN HOLE AND ON CONTOUR MAY BE UP TO 4.0 MM MAX.
05. SHRINKAGE OF EDGES ON HOLE DIA 50 MM IS ALLOWED.
06. LAPS OF METAL AT PLACES ALONG R 35MM MAY BE ALLOWED.
07. WARPAGE OF PART MAY BE UP TO 2.0 MM.
08. IT IS ALLOWED TO MARK PART NUMBER.
09. RESIDUAL FIN ON PERIMETER OF CUT MAY BE UP TO 2.2 MM MAX.
10. ECCENTRICITY OF BROACHED HOLE MAY BE UP TO 2.5 MM MAX.
11. STAMPING DRAFTS - 7° .
12. UNSPECIFIED FILLET RADII - MAX R 3.0 MM.
13. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
14. DIMENSIONS WITHOUT TOLERANCES ARE FOR MAKING DIES.
15. DE-SCALES (SHOT BLASTING).
16. PAINT RED OXIDE.

NOTE :-

FORGING IS COMMON FOR T-72 & T-90
FORGING IS COMMON FOR 172.52.142A/F
PARTITION ALSO.

		T-72 & T-90	
MATERIAL	FORGING WT.		
45XH GOST 4543-71	26.70 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	EK-32	NTS	
DRAWN	CHECKED	APPROVED	
DRAWING NO. 172.52.140-1A/142A/F		PARTITION.	
HEAVY VEHICLES FACTORY AVADI, CHENNAI			