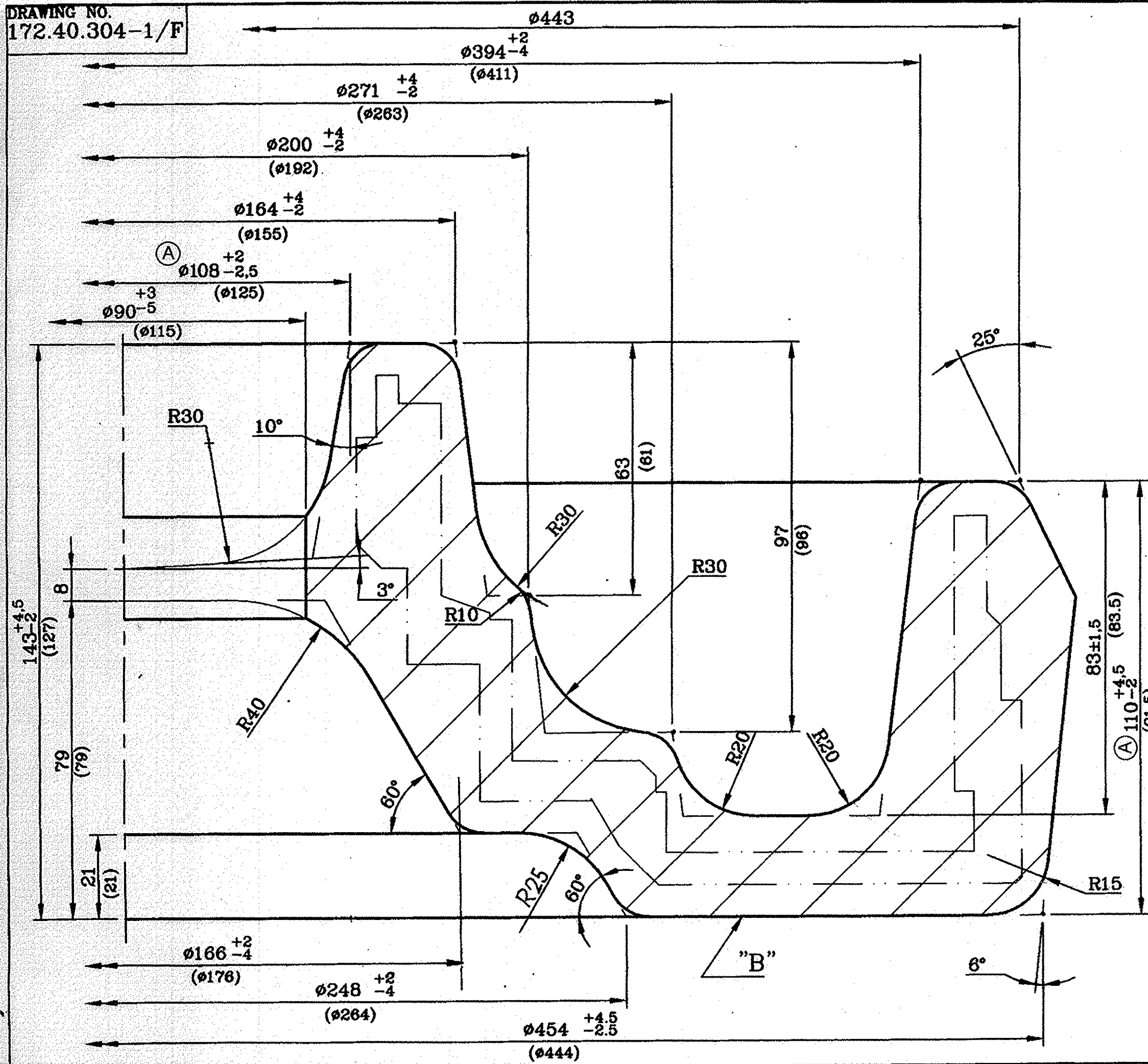


DRAWING NO.
172.40.304-1/F



MODIFICATIONS & ADDITIONS		
ISSUE	MODIFICATIONS & 'N' OF 'A'	SIGN.
A	DIMNS Ø108 WAS Ø112, 110 WAS 108 Rer. Trans. Lt. No. 07271/Trans/Matl. Ptg/40 Dt. 29.05.07	<i>[Signature]</i>

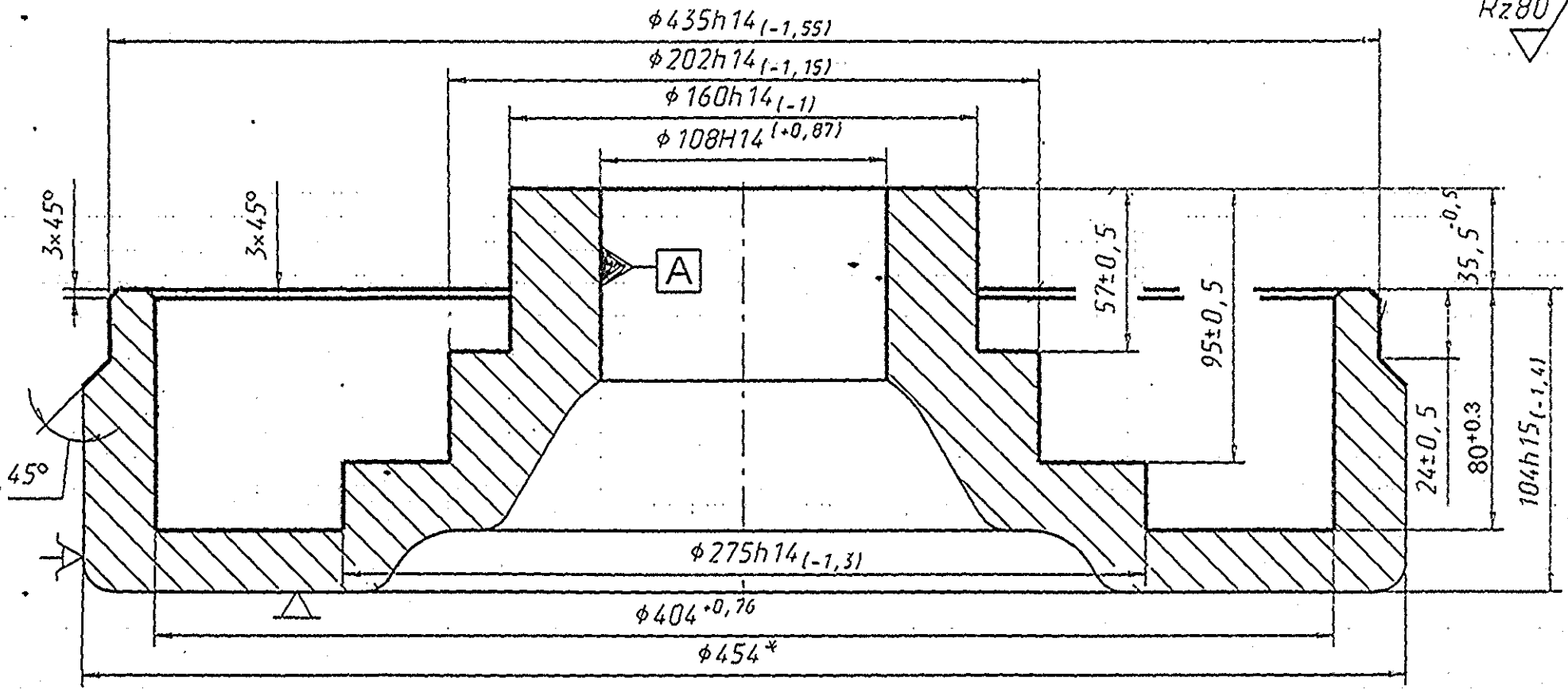
TECHNICAL REQUIREMENTS.

01. < 256 HB
02. DE-SCALES (SHOT BLASTING)
03. MARK THE MELT NO. AND CODE OF CHIEF.
04. SURFACE DEFECTS AND RECESSES DUE TO SCALES MAY BE ALLOWED UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE.
05. DISPLACEMENT MAY BE UPTO 2.0 MM
06. PROJECTION DUE TO DEBURRING MAY BE UPTO 2.5 MM.
07. CONTINUOUS BURR IN HOLE IS ALLOWED.
08. SHRINKAGE ON PLANE 'B' MAY BE UPTO 3.0 MM
09. DEVIATION FOR CONCENTRICITY OF BROACHED HOLE MAY BE UPTO 5.0 MM
10. UNSPECIFIED DRAFT ANGLE ARE TO BE 7°
11. UNSPECIFIED RADII ARE TO BE 10 MM.
12. DIMENSIONS IN BRACKET ARE GIVEN FOR MACHINING.
13. DIMENSIONS WITHOUT TOLERANCES ARE GIVEN FOR MAKING DIES - NOT TO BE CHECKED.
14. PAINT RED OXIDE.

MATERIAL	FORGING WT.		
20X2H4A GOST 4543-71	75.0 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	EK-32	1:1	
DRAWN	CHECKED	APPROVED	
<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	
DRAWING NO.	172.40.304-1/F		
NOMENCLATURE:	SUN GEAR OF FIRST PLANETARY GEAR SET.		
HEAVY VEHICLES FACTORY AVADI, CHENNAI			

23

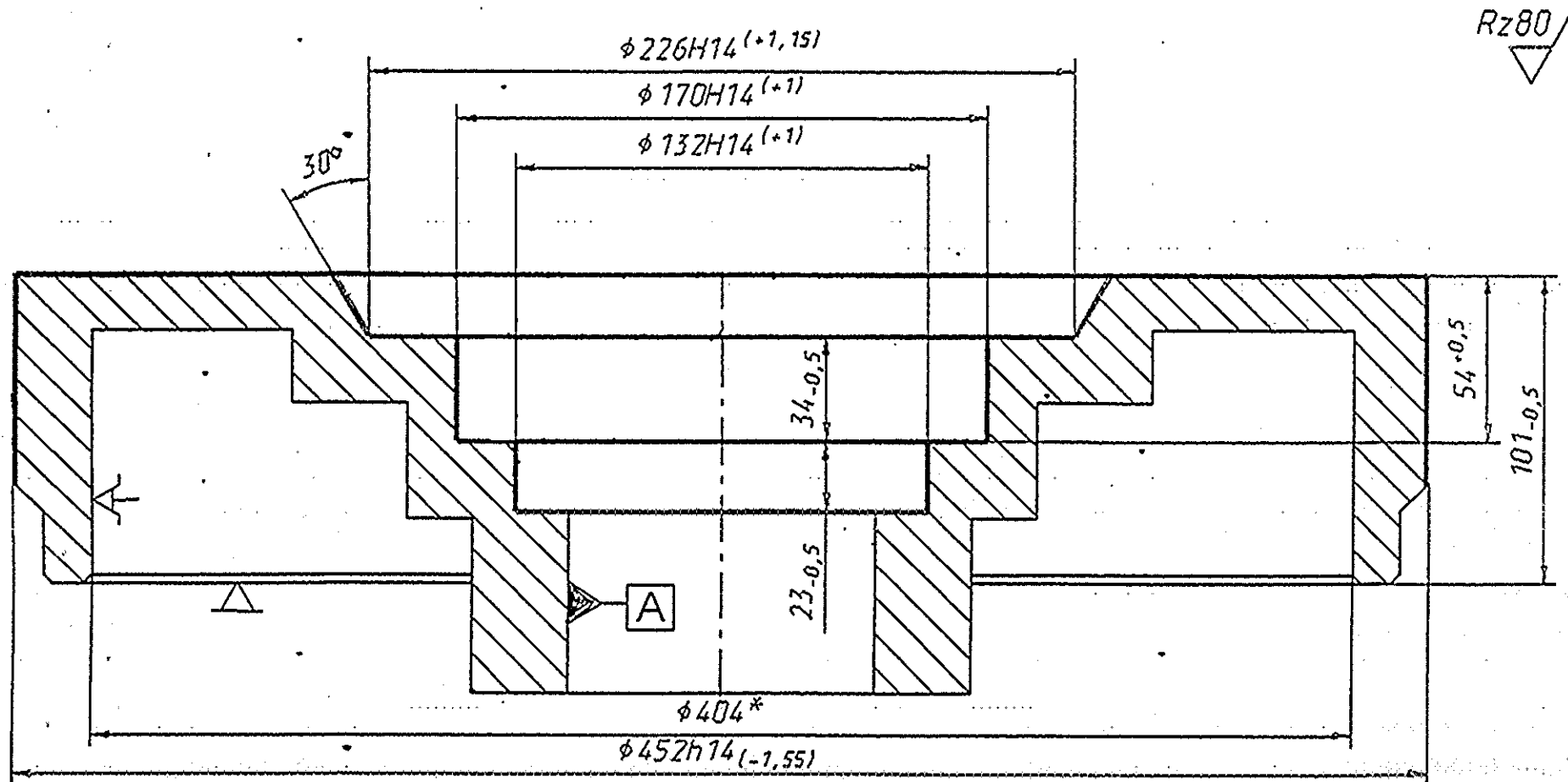
Rz80



RUN OUT OF ALL DIAMETER WITH REFERENCE TO 'A' SHOULD BE WITH IN 0.3MM MAX.

DRG. NO	: 172.40.304-1/SMF, SUN GEAR OF 1ST
OPN. NO.	: 010 (TURNING) PLANETARY GEAR SET
MATERIAL	: STEEL 20X2H4A
HARDNESS	: ≤ 288 BHN
SHEET NO.	
NOT TO SCALE	

PREPARED	CHECKED	APPROVED
VIJAYANAND. A JWM/TRG	S. SARAVANAN JWM/TRG	K. DURAIRAJ. JWM/TRG (HOS)



- * DIMENSION FOR REFERENCE.
- RUN OUT OF ALL DIAMETER WITH REFERENCE TO 'A' SHOULD BE WITH IN 0.3MM MAX.

			DRG. NO : 172.40.304-1/SMF, SUN GEAR OFIST	
			OPN. NO. : 030 (TURNING) PLANETARY GEARSET	
			MATERIAL : 20X2H4A	
			HARDNESS : ≤ 288 BHN	
			SHEET NO.	NOT TO SCALE

PREPARED

VIJAYANAND.A
JWM/TRG

CHECKED

S.SARAYANAN.
JWM/TRG.

APPROVED

K.DURAJ RAJ.
JWM/TRG (Hos).