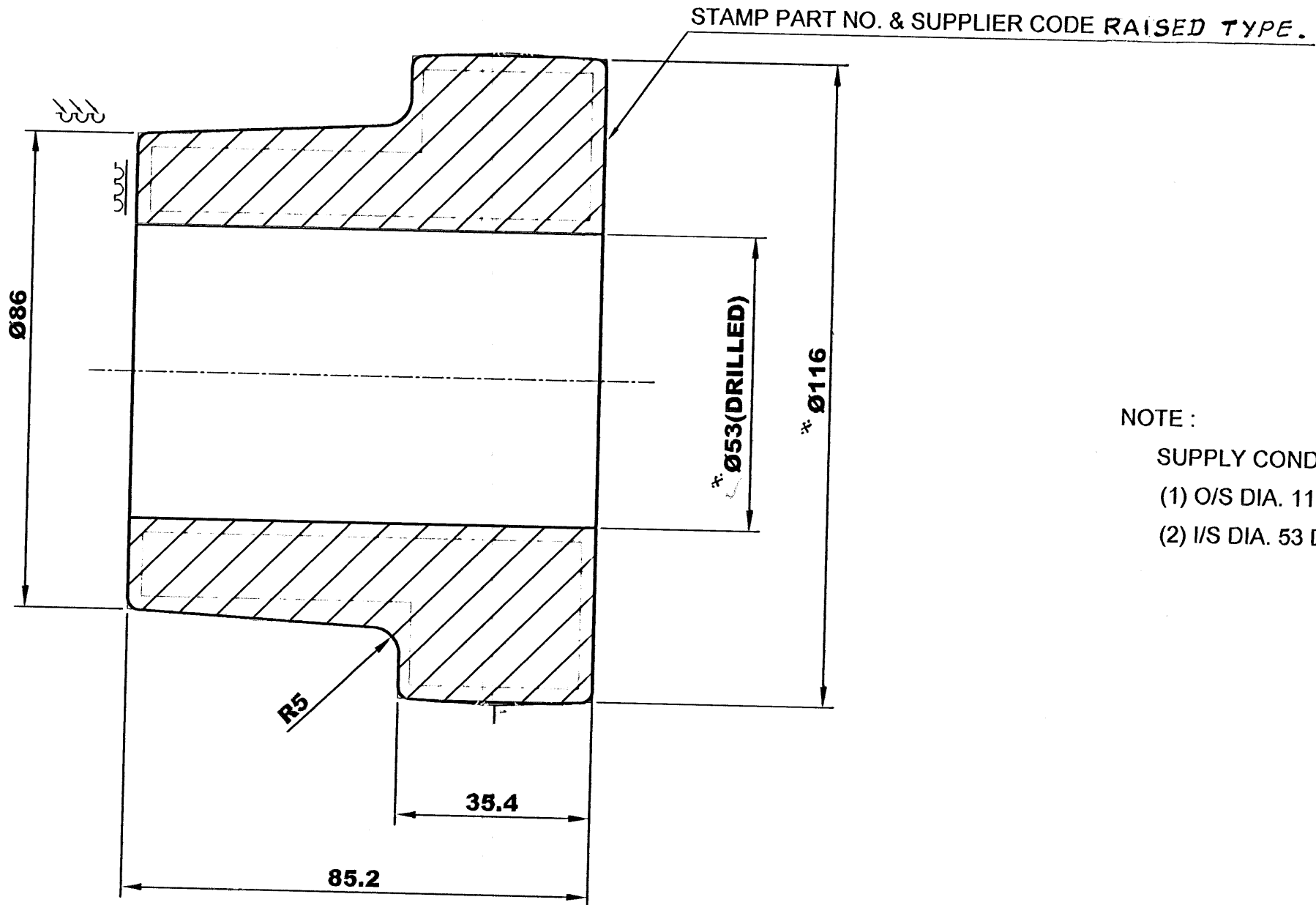


ALL DIMENSIONS ARE IN MM.

IF IN DOUBT PLEASE ASK



NOTE :
SUPPLY CONDITION PRE-MACHINED
(1) O/S DIA. 116/116.5
(2) I/S DIA. 53 DRILLED.

- NOTE:
1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
 2. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS:3 - 47-13 BY BRUSHING OR SPRAYING.
 3. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
 4. STEEL SHOULD BE FREE FROM CENTRE , SEGREGATION,PIPING,FLAKES ETC.
 5. DIMS. IN BRACKET INDICATES MACHINING . ALLOWANCE.
 6. CLAMPING FACE } FOR 1st MACHINING - OPERATION .
 7. DRAFT ANGLE: INNER - 7°, OUTER - 5°
 8. UNSPECIFIED RADII: CORNER - 2R, FILLET - 3R

MATERIAL: 815 M17(En 353)OF BS-970 HARDENABILITY: JOMINY HARDENABILITY VALUE OF J 6/16"=35 TO 39 HRC (FOR TEST PIECE) COMP.OF En353: C 0.14-0.20, Si 0.35MAX., Mn 0.50-1.00,S 0.015-0.04, P 0.035MAX,Ni 1.0-1.5,Cr 0.75-1.25,Mo 0.08-0.15 PHYS.PROP.: HEAT-TREATMENT: ISO THERMAL ANNEALING. HARDNESS: 150 - 210 BHN MICRO STRUCTURE: UNIFORM LAMELLER PEARLITE & FERRITE BAINITE & INTERMEDIATE STRUCTURE 10% MAXIMUM. EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS PRESENT,MINIMUM NUMBER OF BANDS/mm SHALL BE 14 (WHEN VIEWED AT 100X MAGNIFICATION) GRAIN SIZE: ASTM 5 - 8 INCLUSION RATING: 3A,3B,3C,3D MAX. OF IS 4163	FORGING TOLERANCE AS PER IS : 3469 - 1974											
	FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE	INDEX	ALTERATION	DATE	SIGN.	R.C.R.KOLTE JWM / DDO	JWM/GS	APPD.
	4.0Kg				NORMAL					R. ORAM DRN.	TCD.	DO/PROD.
	KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.								
	LENGTH/DIA	+1.1 -0.4	RESIDUAL FLASH	-	FORGING DRAWING FOR 3rd.GEAR ON LAY SHAFT GEAR BOX,STLN.MK-IV				REF. DRG. AS PER SAMPLE 2-F1668611/D			
	THICKNESS	+1.5 -0.0	TRIMMED FLAT	CLOSE TRIM					1:1 SCALE			
	MISMATCH	0.6	DRAFT ANGLE	+2° -1°					M/C. DDO SECTION			
	STRAIGHTNESS	0.6	RADII	+50% -25%					12/02/2014 DATE			
INTERNAL DIMS. REVERSE SIGN + & -					VEHICLE FACTORY JABALPUR				DRG. NO. F1668611-3			
									1/1 SHT. A3			