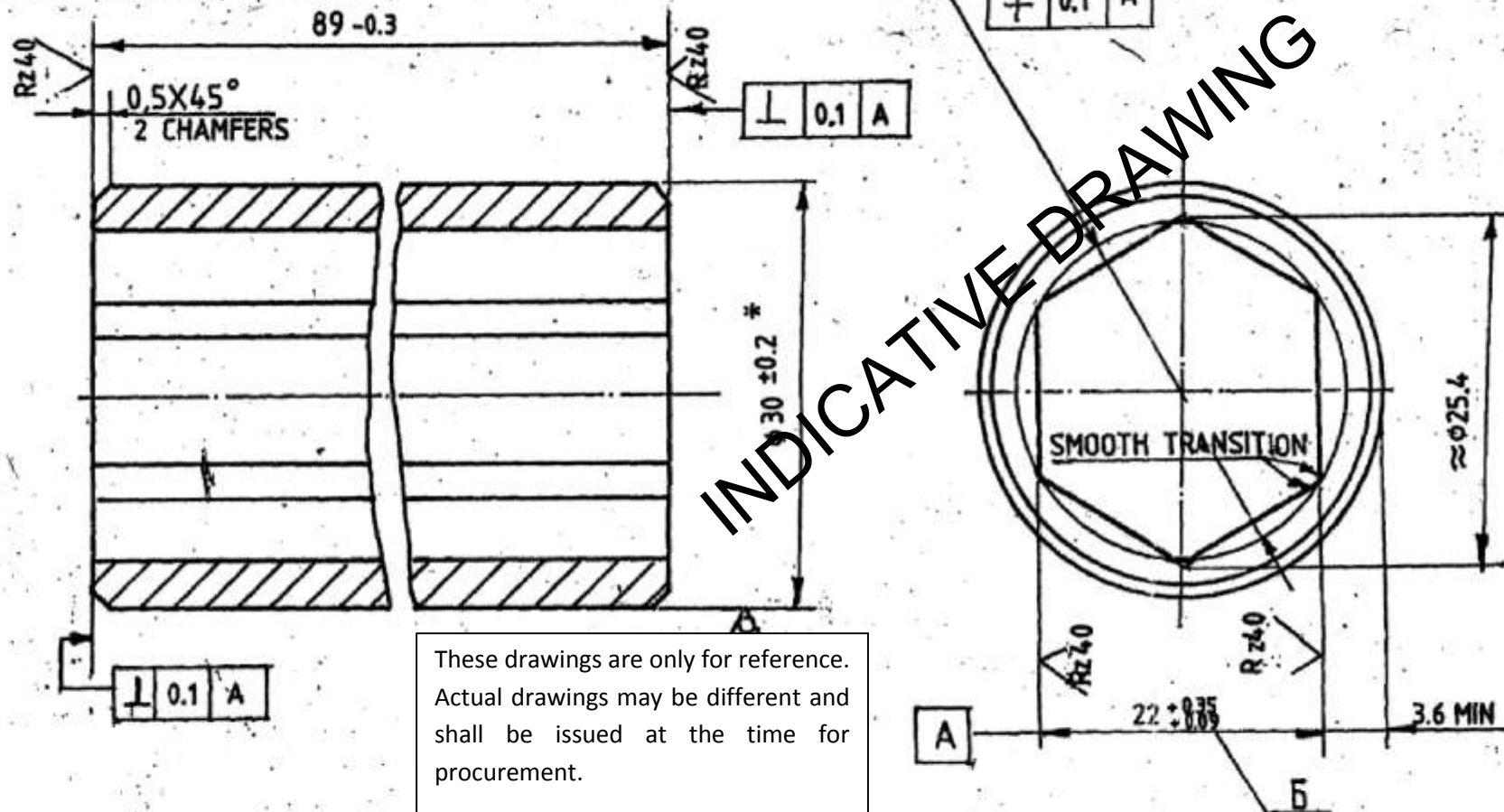


DRAWING NUMBER

613 44 059

Rz80 (✓) (✓)



These drawings are only for reference. Actual drawings may be different and shall be issued at the time for procurement.

INDICATIVE DRAWING

7. THE REST OF THE REQUIREMENTS ARE IN COMPLIANCE WITH APPENDIX NO 3 TY. 105.42-77

EXPLANATORY NOTE

8. REFERENCE MATERIAL QUOTED AND REFERENCE NOTE 3.

COLD DEFORMED TUBE WITH INNER HEXAGON PROFILE OF SIZE B 22 ^{+0.35}/_{+0.05} mm WITH CONJUGATION RADIUS 0.5-TO 2.0 mm AS PER TY 14-3-232-74 OF CHROME STEEL OF GOOD QUALITY GRADE 40X GOST 4543-71.

(a) CHEMICAL COMPOSITION : AS PER STEEL GRADE 40X GOST 4543-71.

CONTENT OF ELEMENTS %					
C	Si	Mn	Cr	S	P
				MAX	
0.36-0.44	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.30 % EACH.

(b) MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm ²
MINIMUM				
100	80	10	45	6

- ① 1. ~~HRC 34~~ ^{35.5.....45.5 HRC} HARDNESS TO BE CHECKED ON CYLINDRICAL SURFACE. FLAT NOT EXCEEDING 0.5 mm IN DEPTH AND 15 mm LENGTH, LOCATED PARALLEL TO THE FACE PLANE AT A DISTANCE OF ATLEAST 25 mm FROM ANY FACE IS ALLOWED. DURING REPEATED HEAT TREATMENT SECOND FLAT IS ALLOWED.
2. AFTER HEAT TREATMENT DIMENSIONS δ MAY BE INCREASED TO 22.47 mm.
3. PIPE WITH INNER HEXAGONAL PROFILE, IS SUPPLIED AS PER TY 14-3-232-74.
4. MINIMUM VALUE OF DIMENSION δ AND CORRECTNESS OF THE SHAPE OF HEXAGONAL HOLE ARE TO BE CHECKED BY COMPLEX HEXAGONAL GAUGE 22.08 -0.01 X 24.25 -0.02 X 20 mm.
5. * DIMENSION FOR REFERENCE.
6. NOT TO BE MARKED.

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Received vide letter no. OFM/TDS/TA/07A dt. 22-11-2010

OFM 13298

ALT. MATL: CHROME MOLYBDENUM STEEL 40.(Cr 1 Mo 28) TO IS: 5517-69 OR EN-19A TO BS. 970

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	<i>[Signature]</i>	MATERIAL :	STEEL 40X GOST 4543-71	USED ON :	613 44 055 Cb
CHD	<i>[Signature]</i>	SEE P.3			
TCO	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)			
APPD	<i>[Signature]</i>	AVADI			
DATE	01-03-86				
SCALE	2 : 1				
DIMENSIONS IN mm		TITLE			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		LONG BUSHING			
ALL THREADS TO CONFORM TO		D S CAT NUMBER		DRAWING NUMBER	613 44 059
1	1-7-91	NOTN.N31-89	AL.12/BK.3		
ISSUE DATE	NATURE OF AMENDMENTS				

DRG.INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

F.188/89

SIZE A3