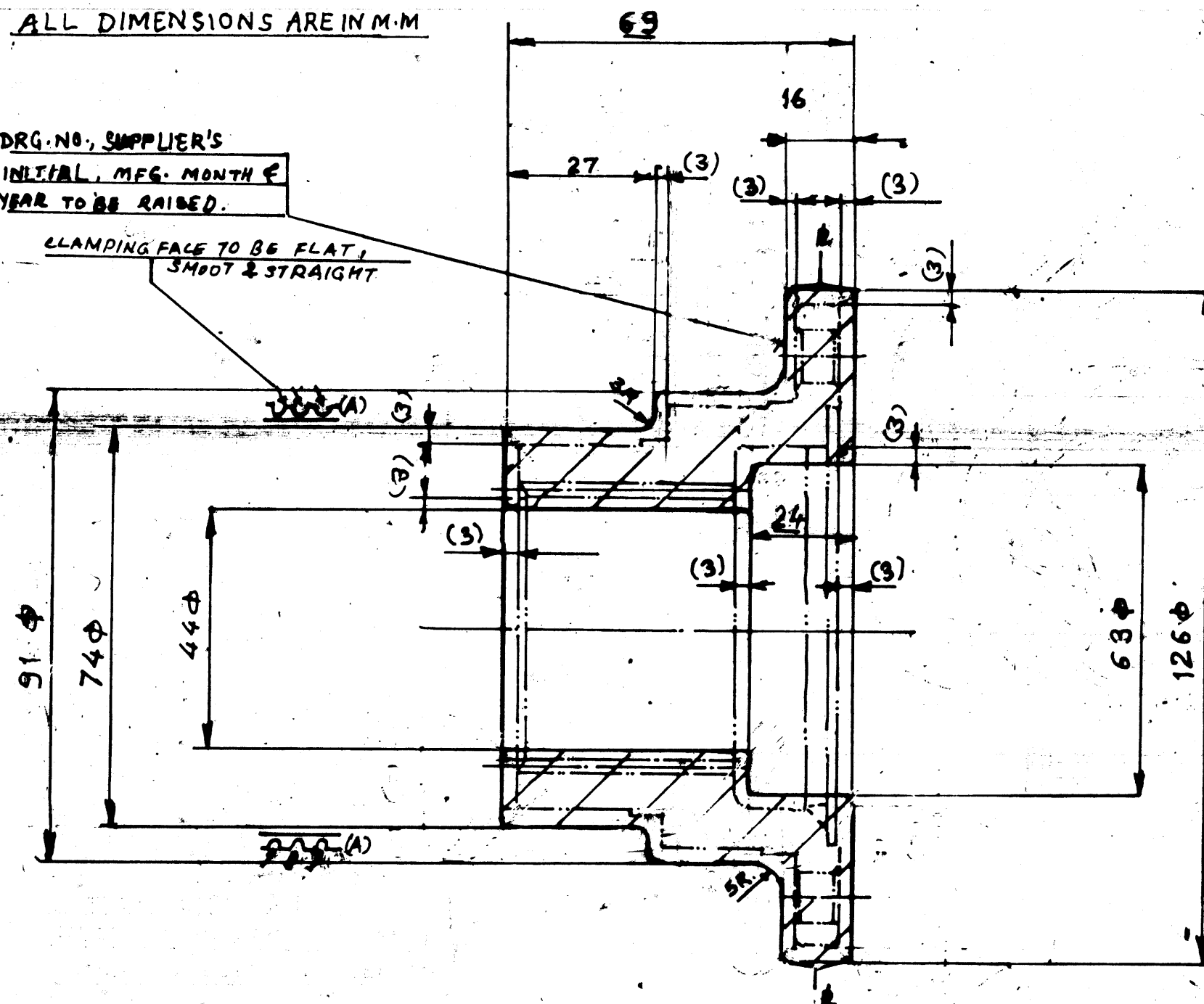


ALL DIMENSIONS ARE IN M.M

DRG. NO., SUPPLIER'S  
INITIAL, MFG. MONTH &  
YEAR TO BE RAISED.

CLAMPING FACE TO BE FLAT,  
SMOOTH & STRAIGHT



NOTE:-

1. FORGING RIDGES TO BE TRIMMED  
CLEAN & SMOOTH FINISH ALL OVER
2. FORGING TO BE SHOT BLASTED.
3. FORGING TO BE COATED WITH RED  
OXIDE PRIMER TO ISS: 3-47-13 BY  
BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE  
BULK SUPPLY.
5. DIM. IN BRACKET INDICATES MACH-  
INING ALLOWANCE.
6. STEEL SHOULD BE FREE FROM CENTRE  
SEGREGATION PIPING FLAKES ETC.
7. DRAFT ANGLE -
8. UNSPECIFIED RADII. - 2.5R, 3R
9. CLAMPING FACE & STOP FACE  
FOR 1ST MACHINING OPERATION.

MATL.

45C8  
(73 551 4027)

EQUIV. MATL.

CHEMICAL COMPOSITION IN %

HEAT-TREATMENT: HARD & TEMP.

HARDNESS:- 208-252 BHN

MICRO-STRUCTURE:- TEMP. MARTENSITE

GRAIN SIZE:- ASTM 5 OR FINER

INCLUSION RATING: 3A B C D THIN

SERIES OR FINER AS PER IS: 4163

1967. STEEL SHOULD NOT HAVE ANY  
LARGE INCLUSIONS OR A CONGLOMERA-  
TION OF INCLUSION.

FORGING TOL. AS PER IS: 3469-74

| FORGING<br>WEIGHT | ENVELOP<br>WEIGHT | COMPLE-<br>XITY. | INTRAC<br>OF MATL | FORGING<br>GRADE |
|-------------------|-------------------|------------------|-------------------|------------------|
| 2.5kg             | 6.34 kg           | S2               | M                 | NORMAL           |

| KIND OF DIM. | TOL. | KIND OF DIM. | TOL. |
|--------------|------|--------------|------|
|--------------|------|--------------|------|

|        |              |                  |      |
|--------|--------------|------------------|------|
| LENGTH | +1.3<br>-0.7 | RESIDUAL<br>FLAT | +0.8 |
|--------|--------------|------------------|------|

|     |              |                 |      |
|-----|--------------|-----------------|------|
| DIA | +1.5<br>-0.7 | TRIMMED<br>FLAT | -0.8 |
|-----|--------------|-----------------|------|

|          |     |         |            |
|----------|-----|---------|------------|
| MISMATCH | 0.7 | ANGULAR | +2°<br>-1° |
|----------|-----|---------|------------|

|              |     |       |              |
|--------------|-----|-------|--------------|
| STRAIGHTNESS | 0.6 | RADII | +50%<br>-25% |
|--------------|-----|-------|--------------|

INTERNAL DIMS. REVERSE SIGN + & -

| INDEX                                                                           | ALTERATION |     |         |        |       |              | DATE                    | SIGN              |
|---------------------------------------------------------------------------------|------------|-----|---------|--------|-------|--------------|-------------------------|-------------------|
| R.R. JAIN                                                                       |            |     |         |        |       |              |                         |                   |
| DRN                                                                             | TCD        | CKD | JWN/TDO | JWN/PR | WM/NT | APPD/<br>TPE |                         | APPD              |
| FORGING DRAWING<br>FOR COUPLING FLANGE<br>REAR AXLE<br>L.P.T.A. 715<br>B.S. III |            |     |         |        |       |              | REF. DRG. No.           | 1:1<br>SCALE      |
|                                                                                 |            |     |         |        |       |              | M/C                     | T.D.O             |
|                                                                                 |            |     |         |        |       |              | SECTION                 | DATE              |
|                                                                                 |            |     |         |        |       |              | DEMANDED BY<br>Jt. GM/T | 1/1 A<br>SHEET    |
| VEHICLE FACTORY JBP.                                                            |            |     |         |        |       |              | DRG. No.                | 2730 3530 50 01-3 |

46-2-16