



TECHNICAL REQUIREMENTS

01. 207...268 HB.
02. SURFACE DEFECTS AND RECESSES DUE TO SCALES MAY BE ALLOWED UPTO MAX. 0.5 OF ACTUAL ALLOWANCE.
03. SHIFT OF AXES OF DIES IS ALLOWED UPTO 0.6 MM MAX.
04. PROJECTION DUE TO DEBURRING ON PARTING OF DIES IS ALLOWED UPTO 0.8 MM MAX.
05. WARPAGE OF PART IS ALLOWED UPTO 0.8 MM MAX.
06. IT IS ALLOWED TO MARK PART NUMBER.
07. PRESENCE OF PROJECTION ON RECESS DUE TO PUSHER IN DIAMETER DIA 18 MM AND HEIGHT 1.5 MM MAX. IS ALLOWED ON THE FACES OF PART.
08. STAMPING DRAFTS - 7°
09. UN-SPECIFIED FILLET RADII - MAX. R 2.0 MM.
10. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
11. DE-SCALES (SHOT BLASTING).
12. PAINT RED OXIDE.

T 90

MATERIAL	FORGING WT.		
20X2H4A ✓ GOST 4543-71 ✓	1.4 KGS ✓		
ALT. MATERIAL	HAMMER	SCALE	
	MPM	NTS	
DRAWN	CHECKED	APPROVED	
<i>L. Duffon</i> 30/8/03	<i>[Signature]</i> 30/8/03		
DRAWING NO.	176.23.120-4/F		
NOMENCLATURE:	HALF COUPLING		
HEAVY VEHICLES FACTORY AVADI, CHENNAI			