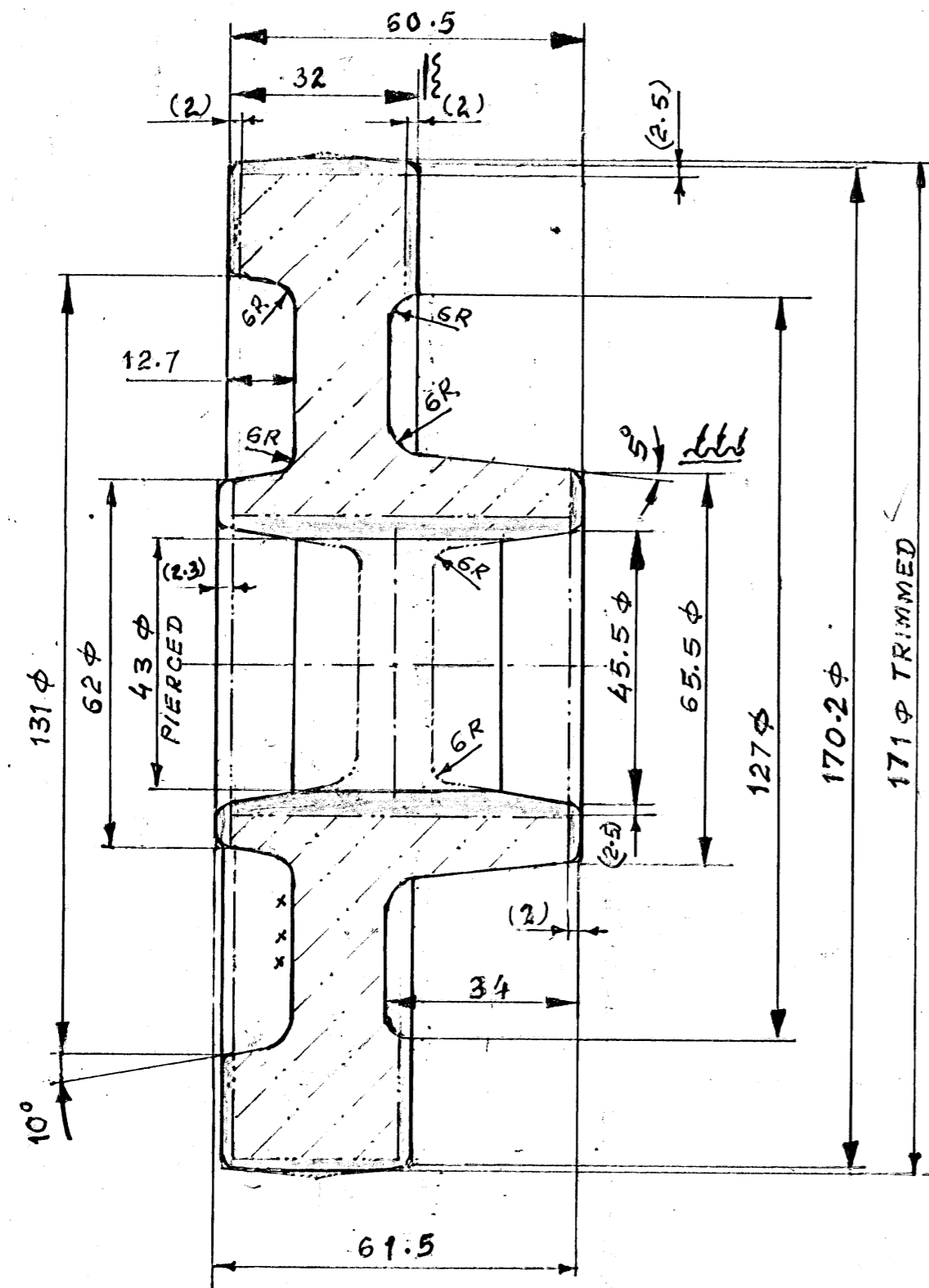


ALL DIMS. ARE IN MM.



EMBOSS DRG.NO., SUPPLIER'S INITIAL & MANUFACTURING YEAR & MONTH x x x

SUPPLY CONDITION - 1) FORGING TO BE SUPPLIED AFTER DRILLING φ47 ±0.2 CONCENTRIC W.R.T. & WITHIN ±0.5
 2) PRE-MACHINED OUTSIDE DIA: 170.0/170.5

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 JSS: 3-47-13 BY BRUSHING OR SPRAYING.
4. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
5. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION, PIPING FLAKES ETC.
6. DIMENSIONS IN BRACKET INDICATES MACHINING ALLOWANCE.
7. CLAMPING FACE *Wavy*; STOPFACE *Wavy*
8. DRAFT ANGLE - INNER 8° - OUTER 5°
9. UNSPECIFIED RADII - CORNER - 2.0R, FILLET ± 3R

MATERIAL: 20Mn 5Cr 5H SS:4027 T13		EQVT. MATL.		FORGING TOL. AS PER IS: 3469-1974			INDEX	ALTERATION			DATE	SIGN			
CHEM. COMPOSITION				FORGING WEIGHT	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE	DRN	TCD					
PHYSICAL PROPERTIES:				4.7 kg		S1	M1	NORMAL							
HEAT TREATMENT: ISOTHERMAL ANNEALING HARDNESS: 150 - 200 BHN. MICROSTRUCTURE: FINE FERRITE & PEARLITE GRAIN SIZE: A.S.T.M. 5 OR FINER INCLUSION RATING: 3 ABCD THIN SERIES OR FINER AS PER IS 4163-1987. STEEL SHOULD NOT HAVE ANY LARGE INCLUSIONS OR A CONGLOMERATION OF INCLUSION.				KIND OF DIMS	TOL.	KIND OF DIMS	TOL.	FORGING DRAWING CONSTANT MESH GEAR (COUNTER SHAFT) G/BOX, LPTA-715, BS-III VEHICLE FY. JABALPUR			DRG. NO.	1:1			
				THICKNESS/HEIGHT	+1.3 -0.7	RESIDUAL FLASH	-						SCALE		
				DIA	+1.5 -0.7	TRIMED FLAT	-1.0						TDO	30.8.10	
				MISMATCH	0.8	ANGULAR	+20 -10						M/C	SECTION	DATE
				STRAIGHTNESS	0.8	RADII	+50% -25%						REQD BY:	1/1	A2
				INTERNAL DIMS REVERSE SIGN + & -						REPT FOR	DRG. NO.	26912630 5413-3			