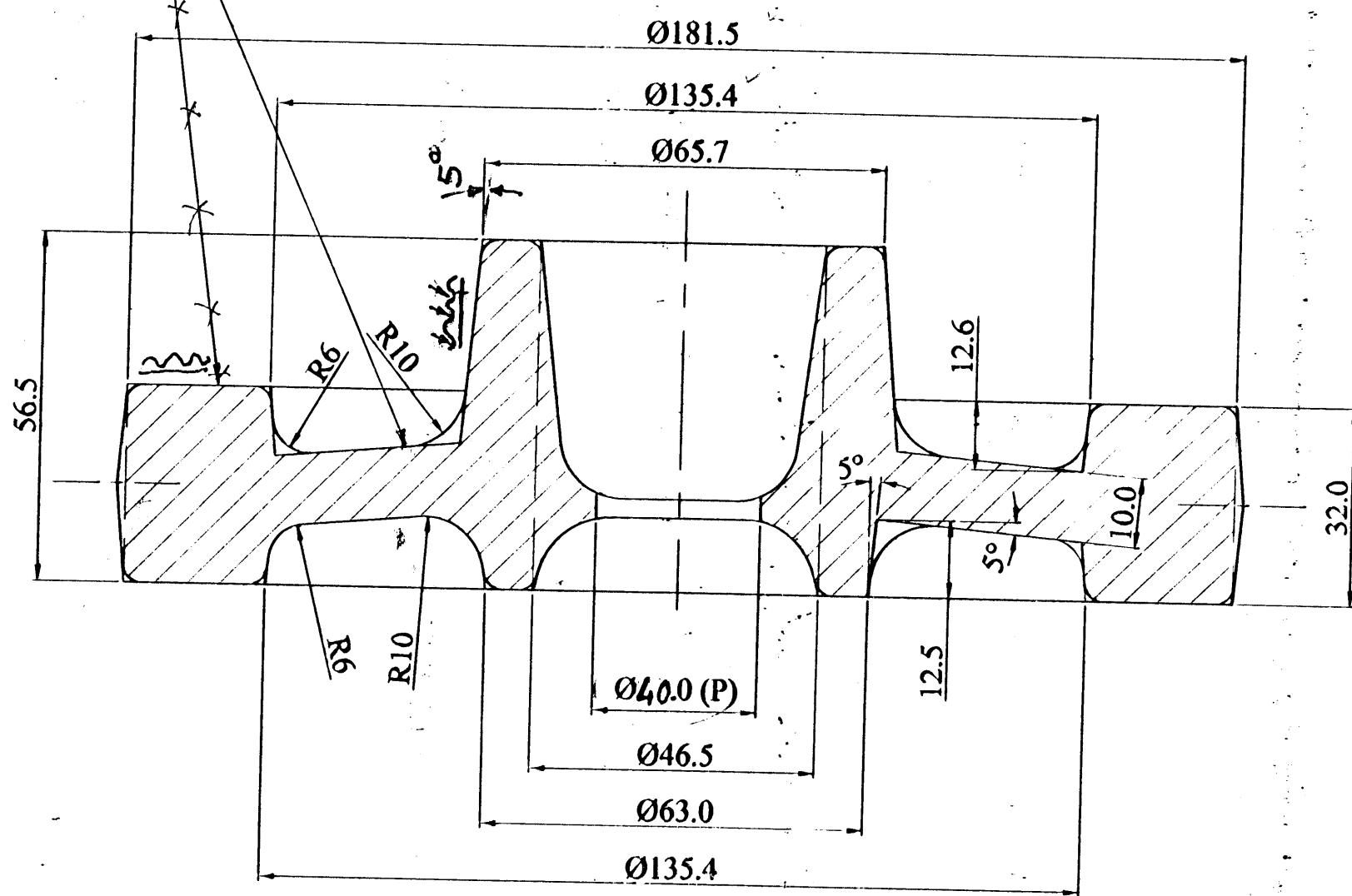


STAMP 2691 2630 5414, FIRM'S INITIAL, MONTH & YEAR  
(5x1 RAISED TYPE)



- NOTES:
1. ALL DIMENSIONS ARE IN MM.
  2. DRAFT ANGLE: OUTER- 5°, INNER- 7°  
CORNER RADII- 2 & FILLET RADII- 5  
(UNLESS OTHERWISE STATED)
  3. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PITS, LAPS, CRACKS, UNFILLINGS ETC.  
(MAX. DEPTH DEFECT ALLOWED 0.3 MM.)
  4. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLIT WITHOUT HARMFUL CONTINUOUS BANDING.
  5. GRAIN SIZE: ASTM NO. 5-8 AS PER 'MC' QUAI- EHN TEST (FILED GRADE AL KILLED CONDITION)
  6. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
  7. HARDNESS: 150 - 200 BHN
  8. MATL: 815 M17 BS 970-1 T13SS4027
  9. FORGING ARE TO BE SHOT BLASTED
  10. HEAT-TREATMENT- ISOTHERMAL ANNEALING.

11. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
12. FORGING TO BE COATED WITH RUST PREVENTIVE RED OXIDE PRIMER
13. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
14. CLAMPING FACE ~~TO~~ & STOP FACE ~~TO~~ FOR 1ST MACHINING OPERATION.

SUPPLY CONDITION: PRE-MACHINED  
OUTSIDE DIA. -- 181.5/182.0  
INSIDE DIA. -- 46.0/46.5

ECCENTRICITY OF PIERCING	0.7
THICKNESS	+1.3, -0.0
DIE WEAR	+1.9, -0.0
FLASH PROJECTION	0.7
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
FLATNESS	0.6
MISMATCH	0.7

TOLERANCES UNLESS OTHERWISE SPECIFIED  
INT. DIMS. REVERSE SIGN. + & -

ITEM	DESCRIPTION	NO OFF	10 F MAT	IS MAT	SIZE/WT	REMARK		
R1	POSITION OF STAMPING FIRM'S INITIAL & DRG NO. ETC. CHANGED AS PER AWM/GS: LND/OTS/AWM/GS AND/OT DT. 22/7/15					APPD		
INDEX	ALTERATION		DATE	SIGN	DRN	TCD	CKD	C/CKD
DIM	TOL							
0-30	± 0.1							
30-150	± 0.1							
150-300	± 0.3							
300-1000	± 0.5							
> 1000	± 0.8							
<b>FORGING DRAWING</b>						REFERENCE DRG	2691 2630 5414	NT S SCALE
<b>FOR: OVER DRIVE GEAR (G/S)</b>						MACHINE		25. 9.10 DATE
<b>GEAR BOX, LPTA-715(BSIII)</b>						DEMANDED BY		1/1 SHEET
T.D.O.	VEHICLE FACTORY JABALPUR				DRG NO	2691 2630 5414-3 (CR)	CHANGE NO:	

13/3-2007 462-07

13/3-2007