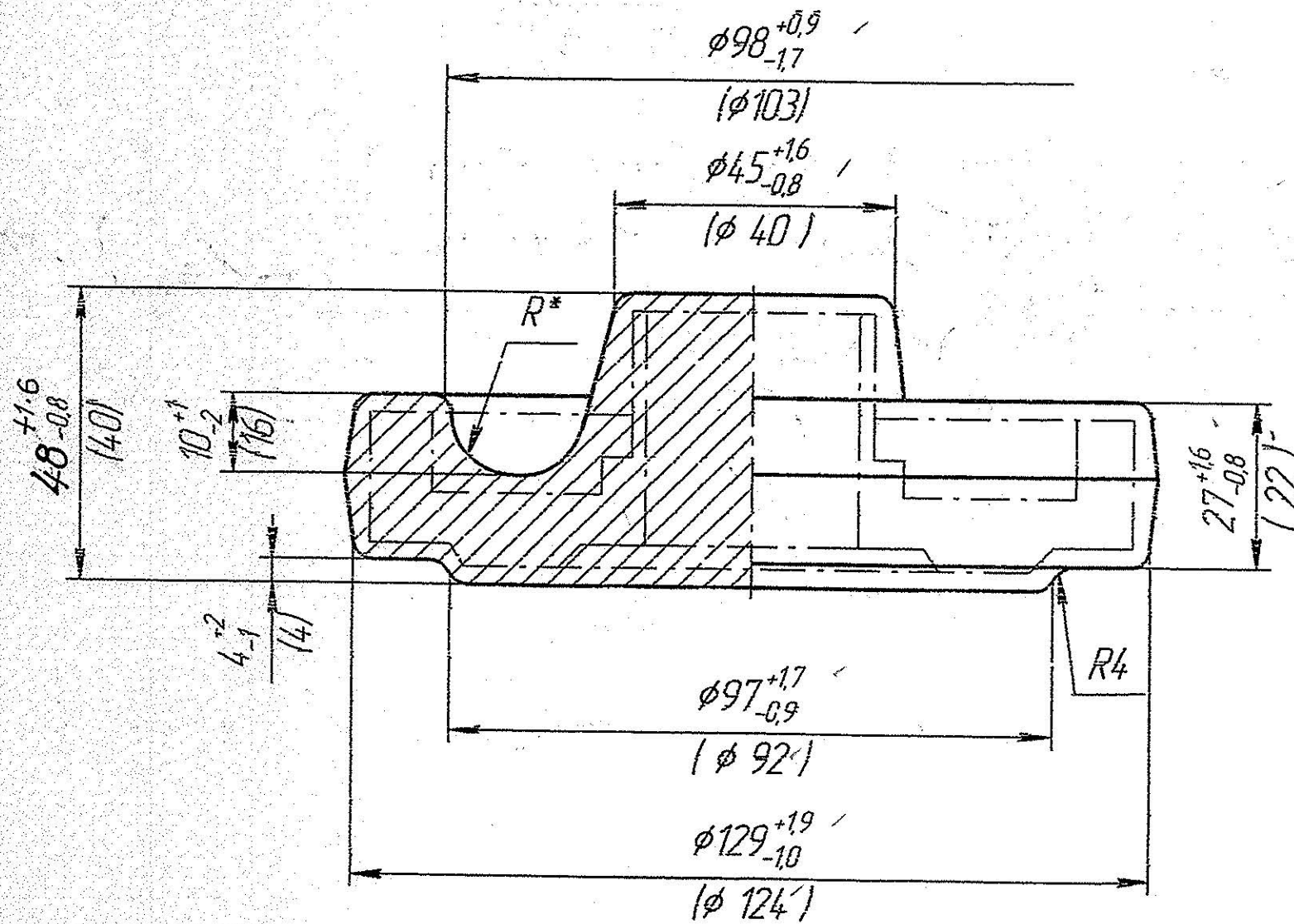


TECHNICAL REQUIREMENTS

01. 207....268 HB.
02. SURFACE DEFECTS IN DEPTH UPTO 0.5 OF ACTUAL ALLOWANCE ARE ALLOWED.
03. MISALIGNMENT OF AXES OF DIES MAY BE UPTO 0.8 MM MAX.
04. PROJECTION DUE TO DEBURRING MAY BE UPTO 1.2 MM MAX.
05. PROJECTION ON RECESS MAY BE ALLOWED ON THE FACES OF PART DUE TO KNOCK-OUT IN DIAMETER DIA 18 MM AND HEIGHT UPTO 1.5 MM.
06. WARPAGE IS ALLOWED UPTO 1.0 MM MAX.
07. UNSPECIFIED STAMPING DRAFTS - 7°
08. UN-SPECIFIED FILLET RADII UPTO R 2.5 MM.
09. DIMENSIONS IN BRACKETS ARE FOR MACHINING.
10. DIMENSIONS WITHOUT TOLERANCES ARE FOR DIE MAKING
11. DE-SCALES (SHOT BLASTING)
12. IT IS ALLOWED TO MARK PART NUMBER.
13. * DIMENSIONS FOR REFERENCE.
14. PAINT RED OXIDE.



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MATERIAL	FORGING WT.	
20X2H4A GOST 4543-71	2.0 KGS	
ALT. MATERIAL	HAMMER	SCALE
	MPM	NTS
DRAWN	CHECKED	APPROVED
<i>L. Dutt</i> 27/8/03	<i>M. S.</i> 28/8/03	<i>S. J.</i>
DRAWING NO.	172.23.103/F	
NOMENCLATURE:	GEAR	
HEAVY VEHICLES FACTORY AVADI, CHENNAI		