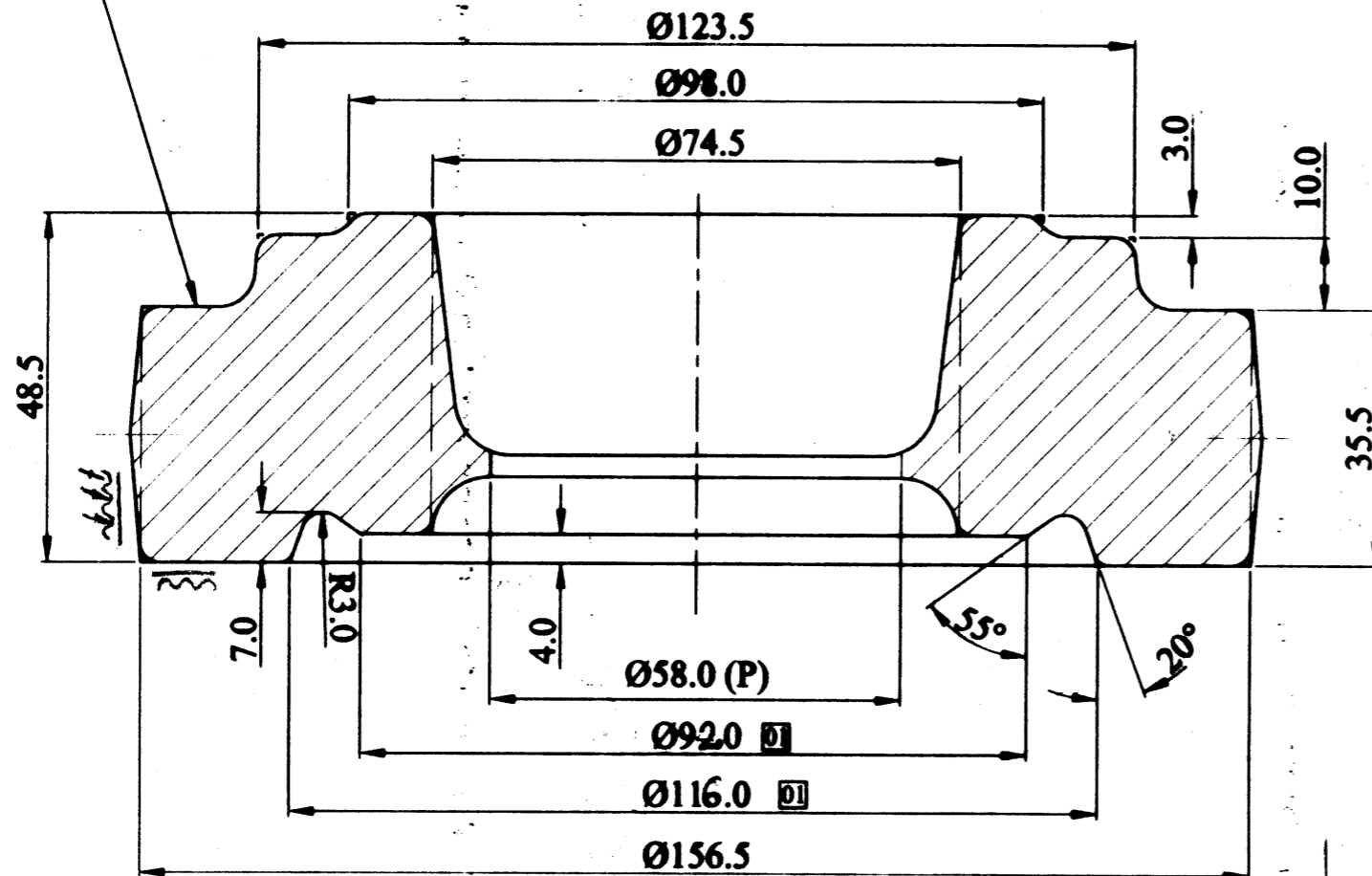


STAMP PART NO., FIRM'S INITIAL, MONTH & YEAR
(5 x 1 RAISED TYPE)



- 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 0.4 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: 20MnSiCrB
 9. FORGING ARE TO BE SHOT BLASTED
 10. HEAT-TREATMENT - 520-THERMAL 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 *W* & STOP FACE *W* FOR 1ST MACHINING OPERATION

SUPPLY CONDITION:
PRE-MACHINED
OUTSIDE DIA. = 156.5/157.0
INSIDE DIA. = 74.0/74.5

THICKNESS	+1.2, -0.0
DIE WEAR	+1.7, -0.0
FLASH PROJECTION	0.9
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
FLATNESS	0.7
MISMATCH	0.6
ECCENTRICITY OF PIERCING	0.5

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

ITEM	DESCRIPTION	NO OFF	10 F MAT	IS MAT	SIZE/WT	REMARK
INDEX	ALTERATION	DATE	SGN	DRN	TCD	CKD
DIM	TOL					
0-30	± 0.1					
30-50	± 0.2					
50-80	± 0.3					
80-200	± 0.5					
> 200	± 0.8					
FORGING DRAWING						
FOR						
3RD SPEED GEAR (M/S)						
GB / LPTA - 715, BS-III						
				REFERENCE DRG		NTS
				2691 2620 5414		SCALE
				MACHINE		27.9.16
				DEMANDED BY		1/1
						SHEET
T.D.O.				VEHICLE FACTORY JABALPUR		DRG NO
						2691 2620 5414-3
						CHANGE NO

46-2-02