



- 8 UNSPECIFIED ROUNDING OFF RADIUS R7 MM
- 9 UNFILLING OF CORNERS SHOULD NOT EXCEED 2/5 OF ACTUAL ALLOWANCE. STAMPING DEFECTS AT THE ENDS FOR TEST PIECE NEED NOT BE CHECKED.
- 10 MAXIMUM CURVATURE IN RELATION TO THE AXIS OF THE SHAFT MAXIMUM 1.5° MAXIMUM 4 MM MAXIMUM CURVATURE OF WHOLE FORGING IS 12 MM
- 11 CRANK PIN THICKNESS INCREASE NOT TO EXCEED 6 MM BEYOND TOLERANCE DUE TO DIE WEAR
- 12 ELLIPTICITY AND TAPER SHOULD BE WITHIN THE TOLERANCE ON CORRESPONDING DIMENSION
- 13 MISMATCH OF PARTING LINE SHOULD NOT EXCEED 3.0 MM
- 14 FLASH ALONG PARTING LINE MAXIMUM 5 MM [K' MAXIMUM ALLOWED 15.0 MM] STAMPING FLASH IS ALLOWED. 1AT PLACES
- 15 ON SURFACES SCALE DEPRESSIONS AND OTHER SURFACE DEFECTS TO A DEPTH NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE IS ALLOWED
- 16 ON SURFACES SHRINKAGE, HAIR CRACKS AND OTHER SURFACE DEFECTS (EXCEPT CRACK) TO A DEPTH MAXIMUM 0.5 OF ACTUAL ALLOWANCE IS ALLOWED DEFECT DEPTH IS TO BE DETERMINED BY MACHINING OF 0.5% FROM A BATCH
- 17 DRESS THE SCALES.
- 18 INSPECTION GROUP III AS PER GOST 8479-70
- 19 MARK MELT NUMBER WITH LETTERS NO-10 GOST 2930-62
- 20 MARK THE ODD NUMBER TO THE SHAFT (ASCENDING ORDER) WITH THE TYPE OF LETTERS NO-10 AS PER GOST 2930-62 WHILE CUTTING THE FORGING. MARK THE SECOND SHAFT WITH THE EVEN NUMBER OF THE SHAFT AND MELTING NUMBER
- 21 REST OF THE TECHNICAL REQUIREMENT AS PER GOST 8479-70 AND GOST 7505-74.
5. FORGINGS TO BE SUPPLIED NORMALIZED AT 940°C ± 20°C HIGH TEMPERED AT 640°C ± 20°C, HARDNESS 197 --- 269 BHN

NOTE.

1. THIS DRG HAS BEEN PREPARED AS PER MINUTES OF THE MEETING HELD ON 13-9-91 WITH M/S SHARDLOW INDIA LIMITED, MADRAS AND PROTOCOL OF 14-8-91.
2. THIS DRG SUPERSEDES ALL THE PREVIOUS DRAWINGS UPTO ISSUE -7

Sketch amended as discussed with Mr. Shardlow (Mr. Sarabhai) on 2/12/92 after structural maching trials on Calsons steel Sample Temp-730. Allu/3/12/92

ISSUE	DATE	REFERENCE	20-05-06-4 (PROV)		
APPROVED	N. VENKATA RAMAN	[Signature]	LETTERS	MASS	SCALE
CHECKED	G. K. MURTHY	[Signature]			130 1:25
DRAWN	A. R. BURMAN	[Signature]			140
			CRANK SHAFT (FORGING)		
			18x2H4MA-W(18x2H4BAW) ENGINE FACTORY AVADI		
			TY 14-1-1971-76		

FOR REFERENCE ONLY