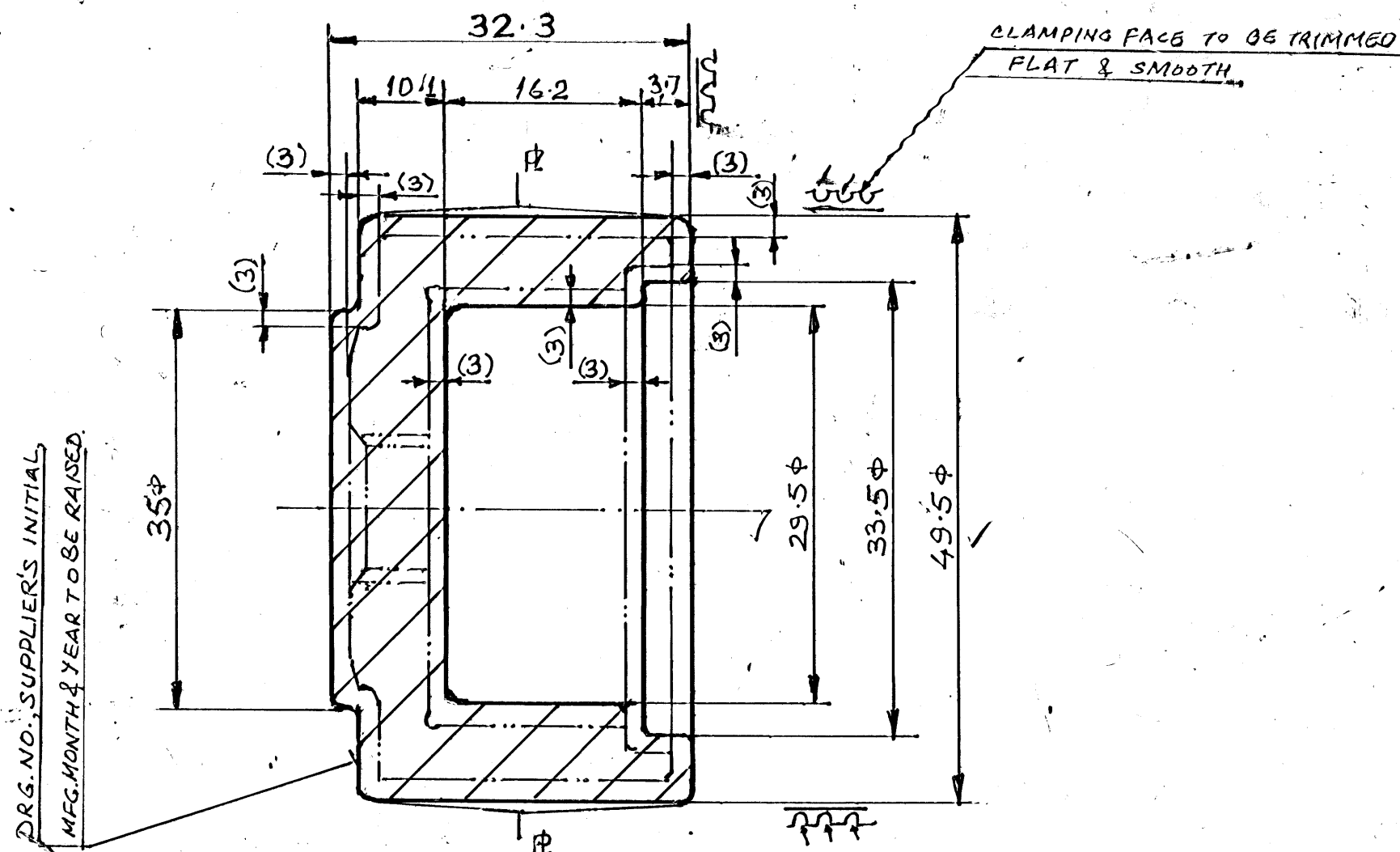


ALL DIMS. ARE IN M.M.



NOTE:-

1. FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALLOVER
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. DIM. IN BRACKET INDICATES MACHINING ALLOWANCE.
6. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION PIPING FLAKES ETC.
7. DRAFT ANGLE - 3°
8. UNSPECIFIED RADII. - 2.5R
9. ~~CLAMPING~~ CLAMPING FACE & ~~STOP~~ STOP FACE FOR 1ST MACHINING OPERATION.

MATL:- EN 353
BS: 970

ALT. MATL.
EN-352

CHEMICAL COMPOSITION IN %

HEAT-TREATMENT: 150 THERMAL ANNEALED
HARDNESS:- 170-210 BHN
MICRO-STRUCTURE: ANNEALED STRUCTURE
GRAIN SIZE:- ASTM 5 OR FINER
INCLUSION RATING: 3 ABCD THIN
SERIES OR FINER AS PER IS: 4163
1967. STEEL SHOULD NOT HAVE ANY
LARGE INCLUSIONS OR A CONGLOMERATION
OF INCLUSION.

FORGING TOL. AS PER IS: 3469-74

FORGING WEIGHT APPROX.	ENVELOP WEIGHT	COMPLE XITY	INTRAC OF MATL	FORGING GRADE
0.36 kg	0.48 kg	S ₁	M ₁	NORMAL

KIND OF DIM.	TOL.	KIND OF DIM.	TOL.
LENGTH/DIA.	+0.8 -0.1	RESIDUAL FLAT	+0.5
THICK.	+0.7 -0.3	TRIMMED FLAT	-0.5
MISMATCH	0.4	ANGULAR	+2° -1°
STRAIGHTNESS	0.6	RADII.	+50% -25%
INTERNAL DIMS. REVERSE SIGN. + & -			

(A)	DRG. NO. X1802115-3 CHANGED TO D-9045315-3(A) AS PER E/BOM LATES	8/3/00	U.K.L.
INDEX	ALTERATION	DATE	SIGN

K ₁									
DRN	TCD	CKD	JWM/TDO	JWM/PR	WM/HT	DO/TPE			

FORGING DRAWING	REF. DRG. No.	2:1
FOR:- NEEDLE HOUSING	M/C	SCALE
FOR:- DOUBLE UJ.	T.D.O	4.9.99
FT. AXLE, SHAFT	SECTION	DATE
STALLION	DEMANDED BY	1/1
	1/CTPE L/NO. 138/TPE/	SHEET
	Pring/11/4, DT. 24.8.99	

VEHICLE FACTORY JBP.	DRG. NO. D9045315-3(A)
	X1802115-3

(FOR H.T. & HARDNESS Ref. DRG. NO. S 3344411 LAY SHAFT, STALLION)

13/1-1117

31.2.106

A3