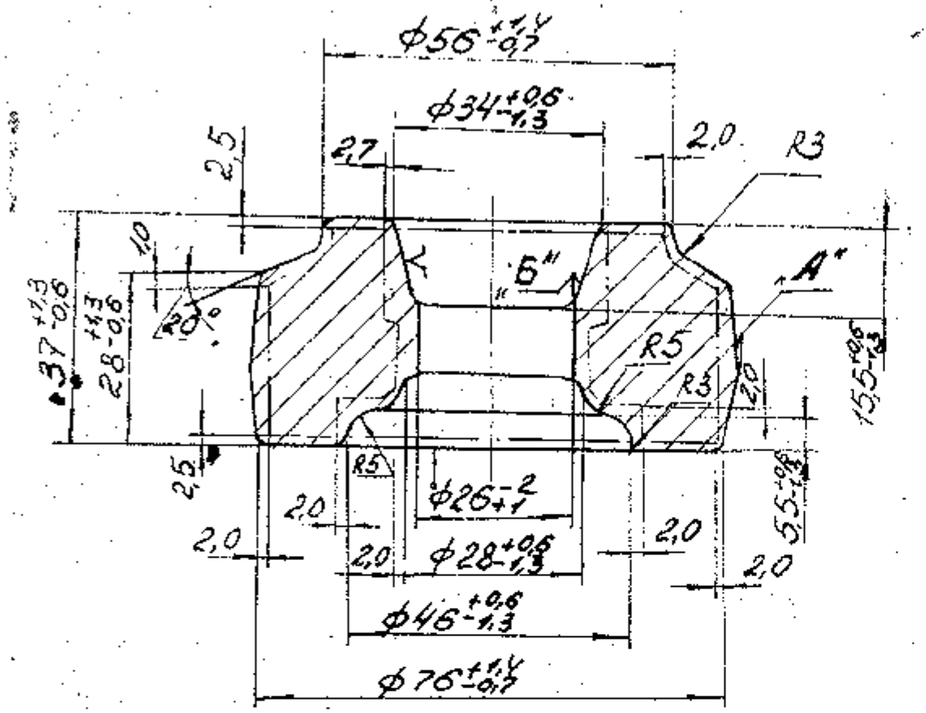

1. STEEL GROUP M2 AS PER GOST 7505-74.
2. FORGING COMPLEXITY GRADE C 2 AS PER GOST 7505-74.
3. MANUFACTURING ACCURACY CLASS II AS PER GOST 7505-74.
4. HOT STAMPING.
5. ~~NORMALISING, TEMPERING BHN 269-197 (DIA OF INDENTATION 3.7...4.3).~~ (1)
6. UNSPECIFIED ROUNDING OFF RADII R 2 M.M.
7. UNSPECIFIED DRAFTS INTERNAL 10°..12°, EXTERNAL 5°..7°.
8. UNFILLING OF CORNERS SHOULD NOT EXCEED 0.5 OF ACTUAL ALLOWANCE.
9. MISALIGNMENT OF HOLES Φ 26 -2 +1 IN RELATION TO 76 +1.4 -0.7 IS MAXIMUM 1.0 M.M.
10. MISMATCH OF PARTING LINE SHOULD NOT EXCEED 0.6 M.M.
11. FLASH ALONG PARTING LINE MAXIMUM 1.0 M.M. FOLDING OF FLASH 'A' MAXIMUM 2 M.M. ALLOWED. FLASH 'B' NEED NOT BE CHECKED. STAMPING FLASHES ALLOWED.
12. ON SURFACES SCALE DEPRESSION AND OTHER SURFACE DEFECTS TO A DEPTH OF MAXIMUM 0.5 OF ACTUAL ALLOWANCE IS ALLOWED.
13. ON SURFACES SHRINKAGE, HAIR LINE CRACKS AND OTHER DEFECTS (EXCEPT CRACK) TO A DEPTH NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE IS ALLOWED. DEFECT DEPTH IS TO BE DETERMINED BY MACHINING 0.5% FROM A BATCH.
14. DRESS THE SCALES.
15. INSPECTION GROUP II AS PER GOST 8479-70.
16. REST OF THE TECHNICAL REQUIREMENT AS PER GOST 7505-74 AND GOST 8479-70.

(1) 5 FORGINGS TO BE SUPPLIED NORMALIZED AT 940°C+20°C HIGH TEMPERED AT 640°C+20°C, HARDNESS 269-197 BHN.

ISSUE	DATE	REFERENCE				
(1)	4.1.91	Vide GM's letter dated 13.12.90	20-07-16			
APPROVED	K.R.G.	10/1/91	CAM SHAFT GEAR (FORGING)	LETTERS	MASS 1.05	SCALE 1:1
CHECKED (TRANSLATION)				SHEET	SHEETS 1	
DRAWN	P.R.K.RAO		18X2H4MA (18X2H4BA) TY 14-1-381-72	ENGINE FACTORY AVADI		