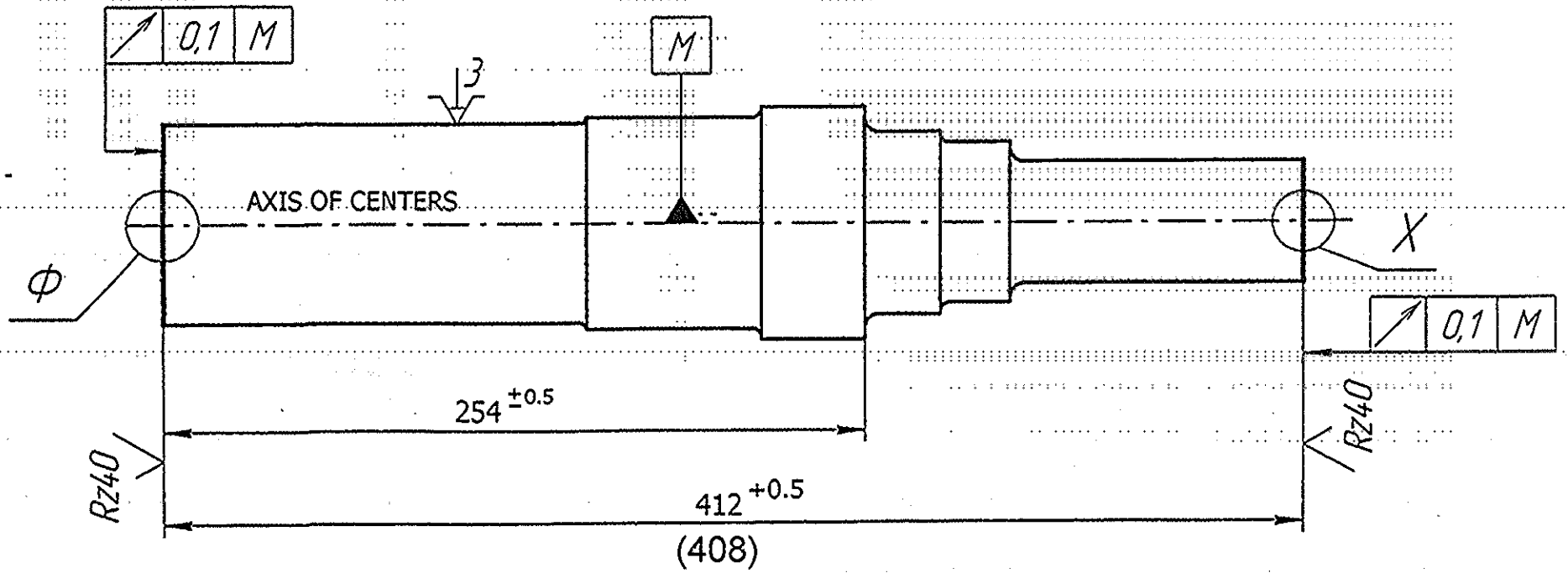


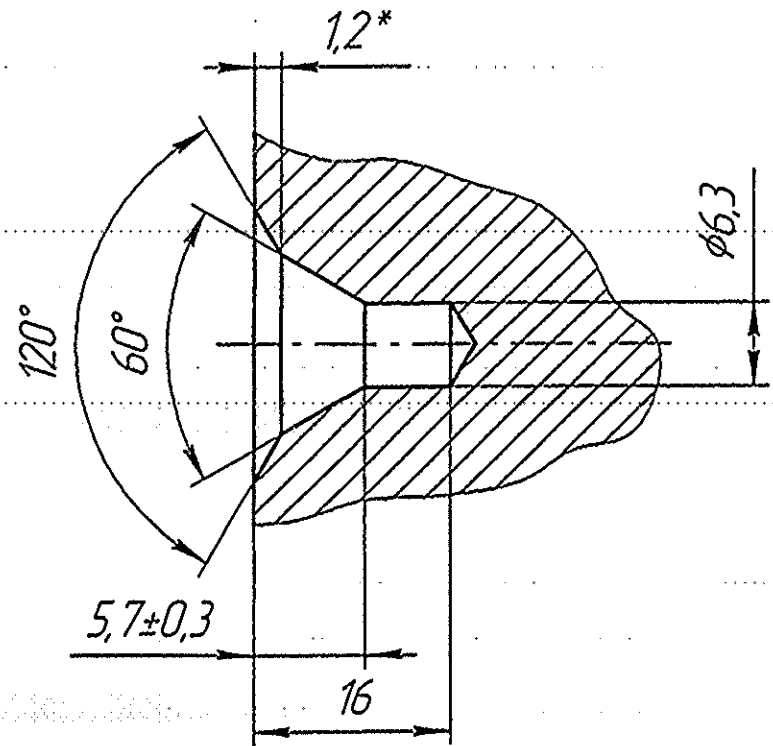
Rz80  
✓(✓)



DRG. NO	: 172.40.314 /SMF
OPN. NO.	: 010 FACING AND CENTERING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	
	NOT TO SCALE

PREPARED	CHECKED	APPROVED

$\phi, X$



1. BEFORE MACHINING NOTE THE MARKING OF POINTS IN LOG AND MAKE THE MARKING IN OPERATION 0.25

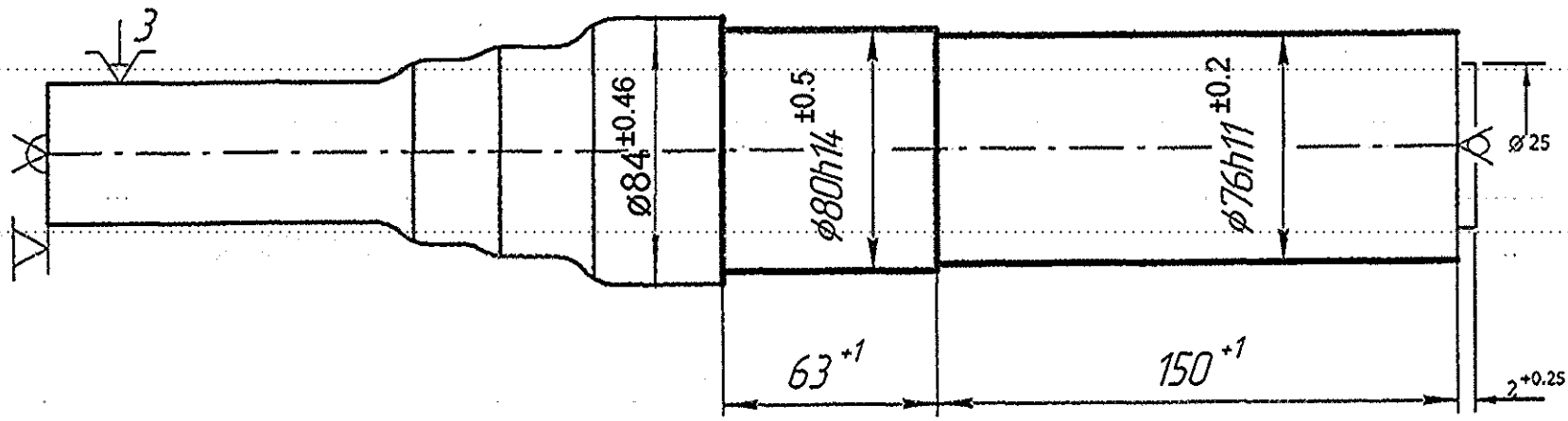
DRG. NO	: 172.40.314 /SMF
OPN. NO.	: 010 FACING AND CENTERING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	NOT TO SCALE

  
PREPARED

  
CHECKED

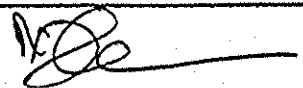
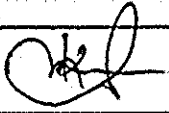
  
APPROVED

Rz80  
 ✓(✓)

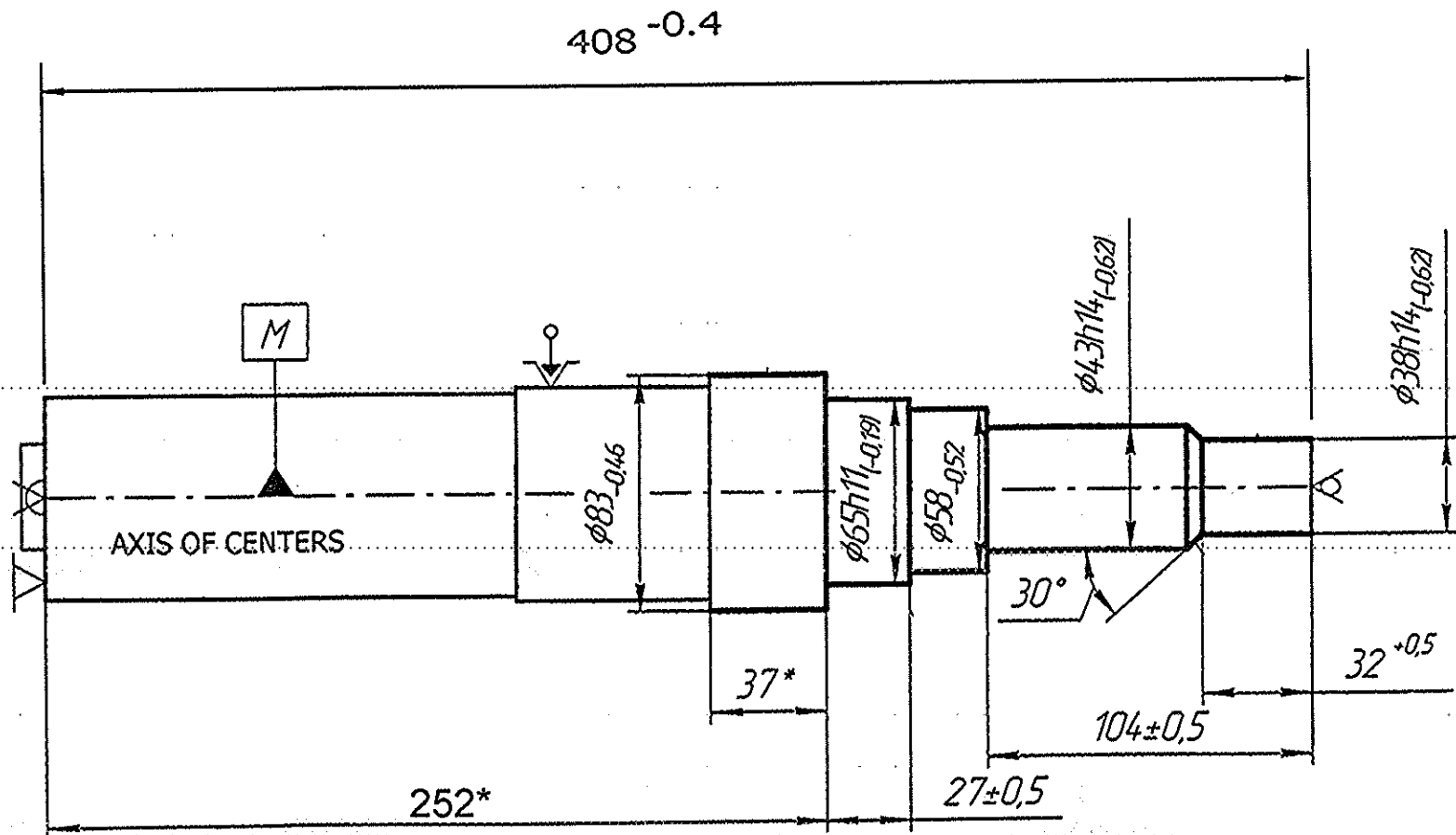


1. RUN OUT OF MACHINED SURFACES WITH RESPECT TO AXIS  
 OF CENTERS NOT MORE THAN 0.3mm

DRG. NO	: 172.40.314/SMF
OPN. NO.	: 020 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	NOT TO SCALE

 PREPARED	 CHECKED	 APPROVED
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Rz80  
✓(✓)



1. RUN OUT OF MACHINED SURFACES WITH RESPECT TO AXIS OF CENTERS NOT MORE THAN 0.3mm

DRG. NO	: 172.40.314 /SMF
OPN. NO.	: 030 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	NOT TO SCALE

*M. J. V.*

PREPARED

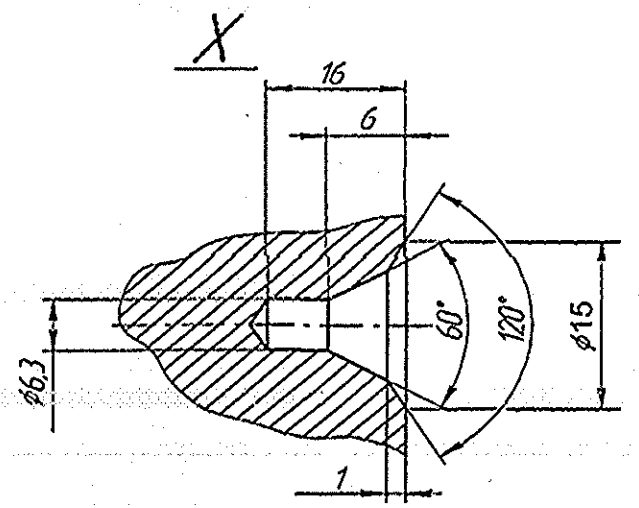
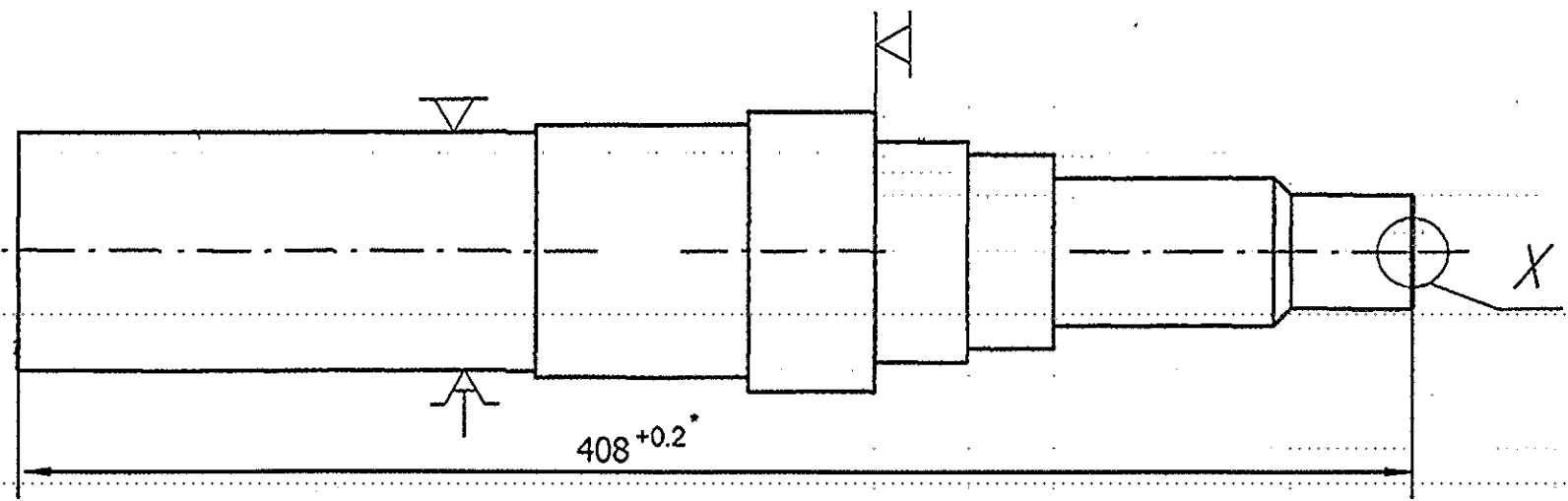
*[Signature]*

CHECKED

*[Signature]*

APPROVED

Rz20  
✓(✓)

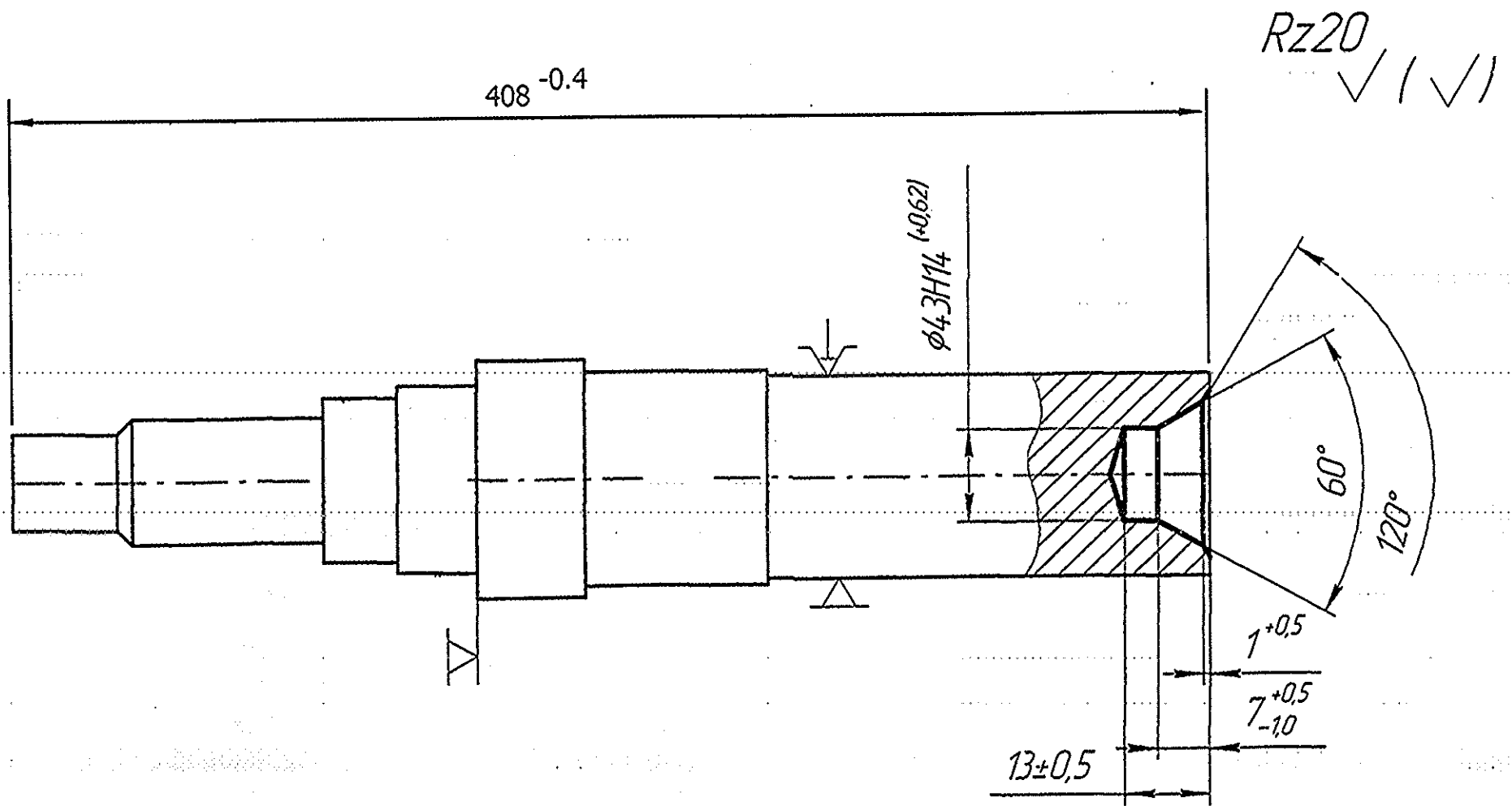


DRG. NO : 172.40.314/SMF				
OPN. NO. : 040 TURNING				
MATERIAL : STEEL 18X2H4BA				
HARDNESS : 207 - 268 BHN				
PREPARED	CHECKED	APPROVED	SHEET NO.	NOT TO SCALE

*MJC*

*NDO*

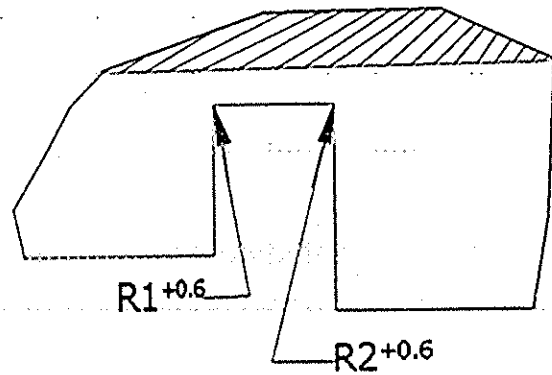
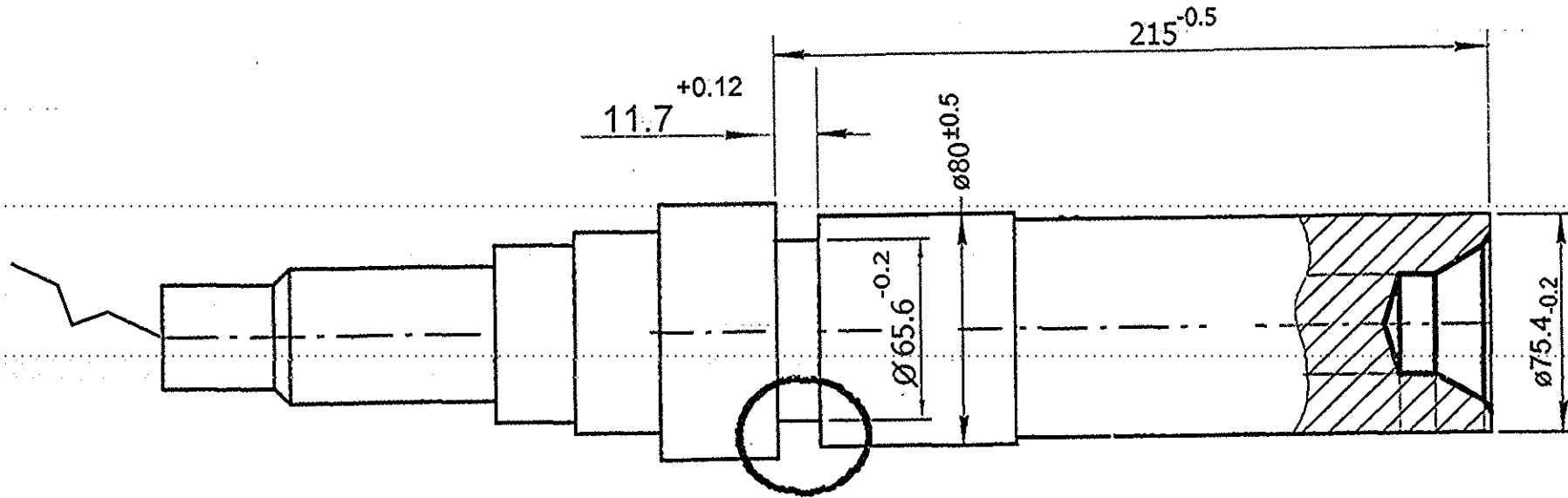
*[Signature]*



DRG. NO	: 172.40.314/SMF
OPN. NO.	: 050 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	NOT TO SCALE

PREPARED	CHECKED	APPROVED

Rz20  
✓(✓)



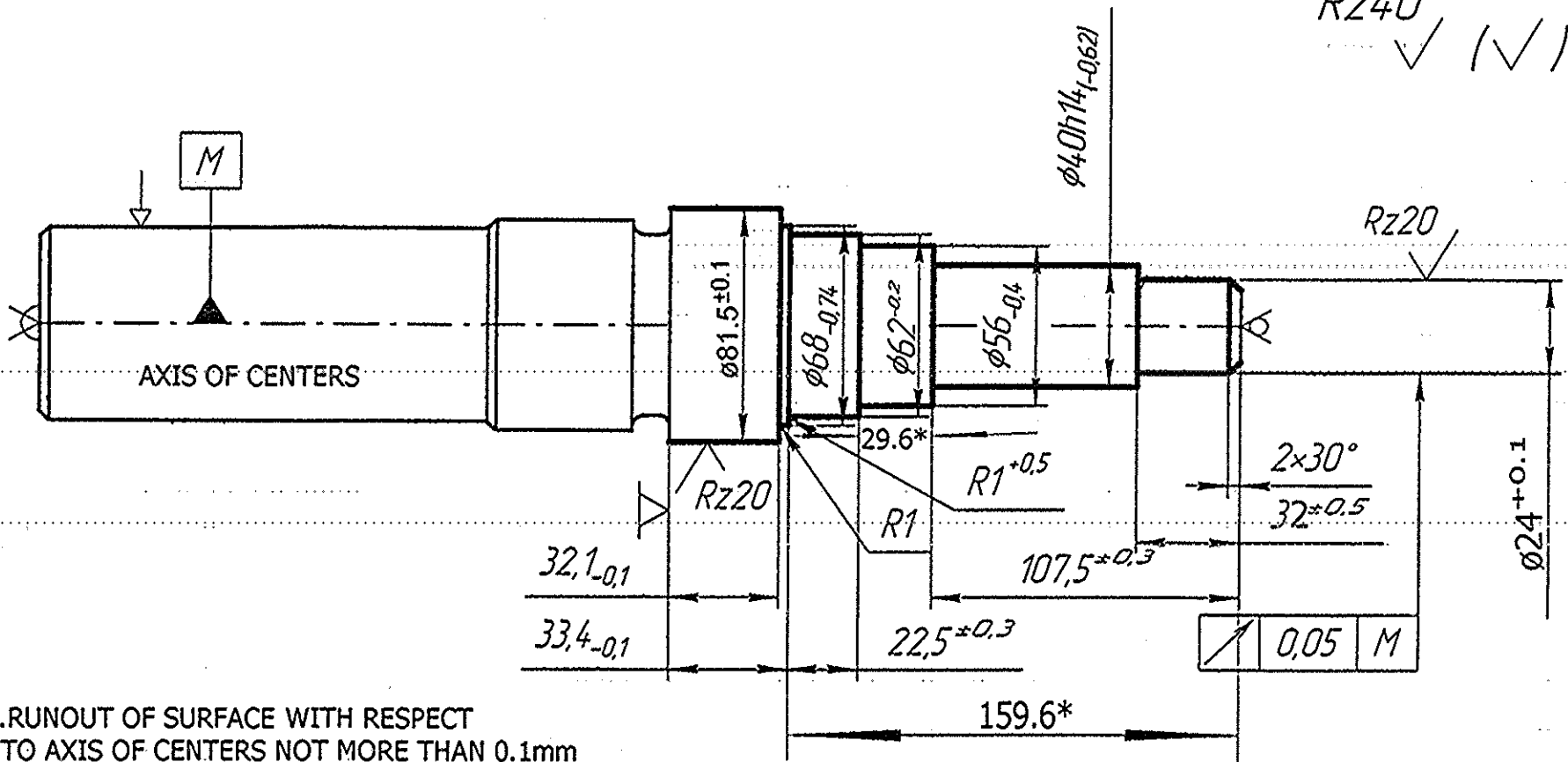
DRG. NO	: 172.40.314 /SMF
OPN. NO.	: 060 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	
	NOT TO SCALE

*[Signature]*  
PREPARED

*[Signature]*  
CHECKED

*[Signature]*  
APPROVED

Rz40  
 ✓ (✓)



1. RUNOUT OF SURFACE WITH RESPECT TO AXIS OF CENTERS NOT MORE THAN 0.1mm

DRG. NO	: 172.40.314/SMF
OPN. NO.	: 070 TURNING
MATERIAL	: STEEL 18X2H4BA
HARDNESS	: 207 - 268 BHN
SHEET NO.	
NOT TO SCALE	

 PREPARED	 CHECKED	 APPROVED
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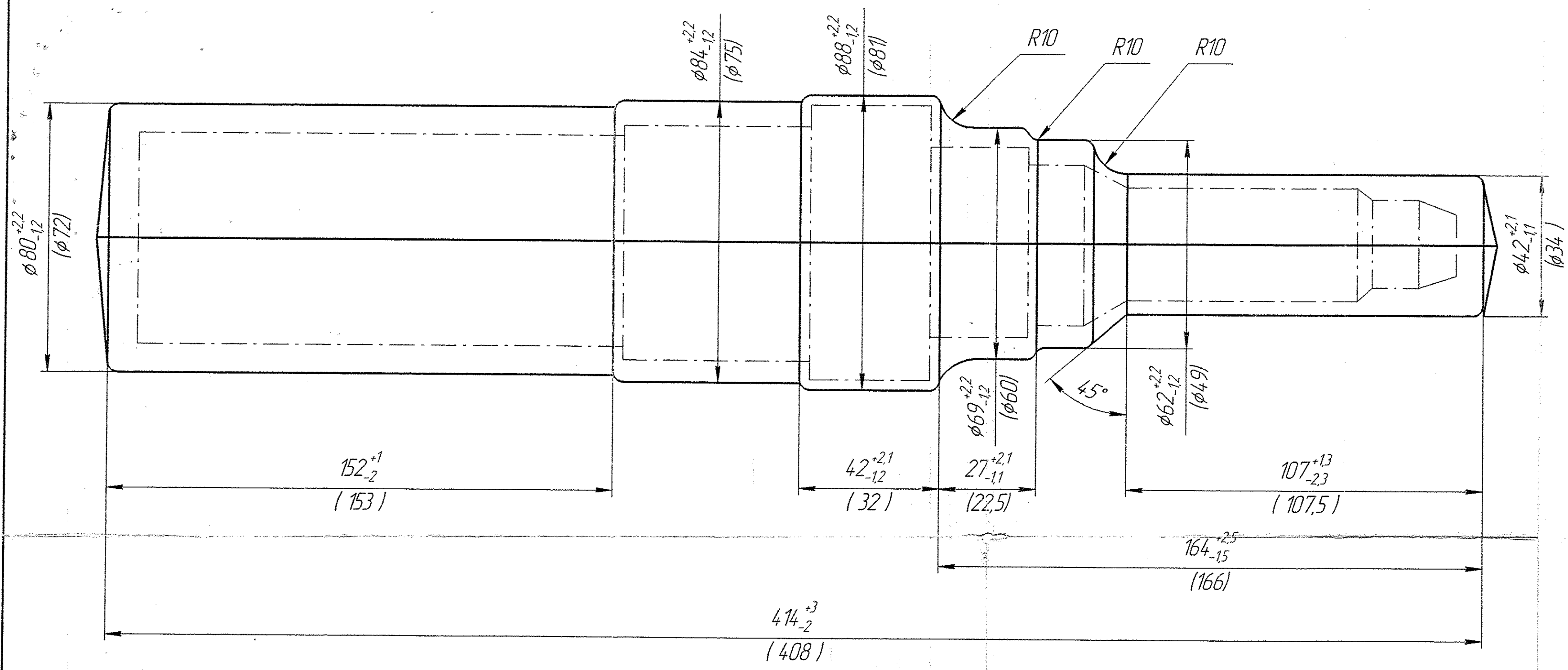
172.40.314

## Primary shaft

1. 207 - - 268 H0
2. Burs are allowed on perimeter of cut upto max. 1.7mm.
3. Displacement along parting of die upto max. 1.3mm may be allowed.
4. Bending upto max. 1.5mm may be allowed.
5. Surface defects such as dents due to scales and nicks as well as slanted chipping or finishing of ~~the~~ defects in depth upto 50% of actual one side machining allowance may be allowed.
6. Unspecified stamping drafts -  $7^\circ$ .
7. Unspecified fillet radii -  $R 3.0\text{mm}$ .
8. Dimensions in brackets are for machining.
9. Dimensions without tolerances are for making die.
10. Remove the scales (shot blasting).
11. It is allowed to mark melt no.
12. Forging class II, ~~group~~ grade of steel M2, category of complexity C1 GOST 7505-89.

Stamping  
065 Штамповка

172.40.314			
Вал первичный Primary shaft			065



1. 207...268 HB
2. Допускаются заусенцы по периметру среза не более 1,7 мм.
3. Допускается смещение по линии разъема штампа не более 1,3 мм.
4. Допускается изогнутость не более 1,5 мм.
5. Допускаются поверхностные дефекты типа вмятин от окалины и задиры, а также полая выработка или зачистка дефектов глубиной до 50% фактического одностороннего припуска на механическую обработку.
6. Неуказанные штамповочные уклоны 7°.
7. Неуказанные радиусы скруглений R 3,0 мм.
8. Размеры в скобках—для механической обработки.
9. Размеры без допусков—для построения.
10. Очистить от окалины (дробеочистить).
11. Допускается маркировать номер плавки.
12. Поковка II класса, группа стали М2, степень сложности С1 ГОСТ 7505-89.