

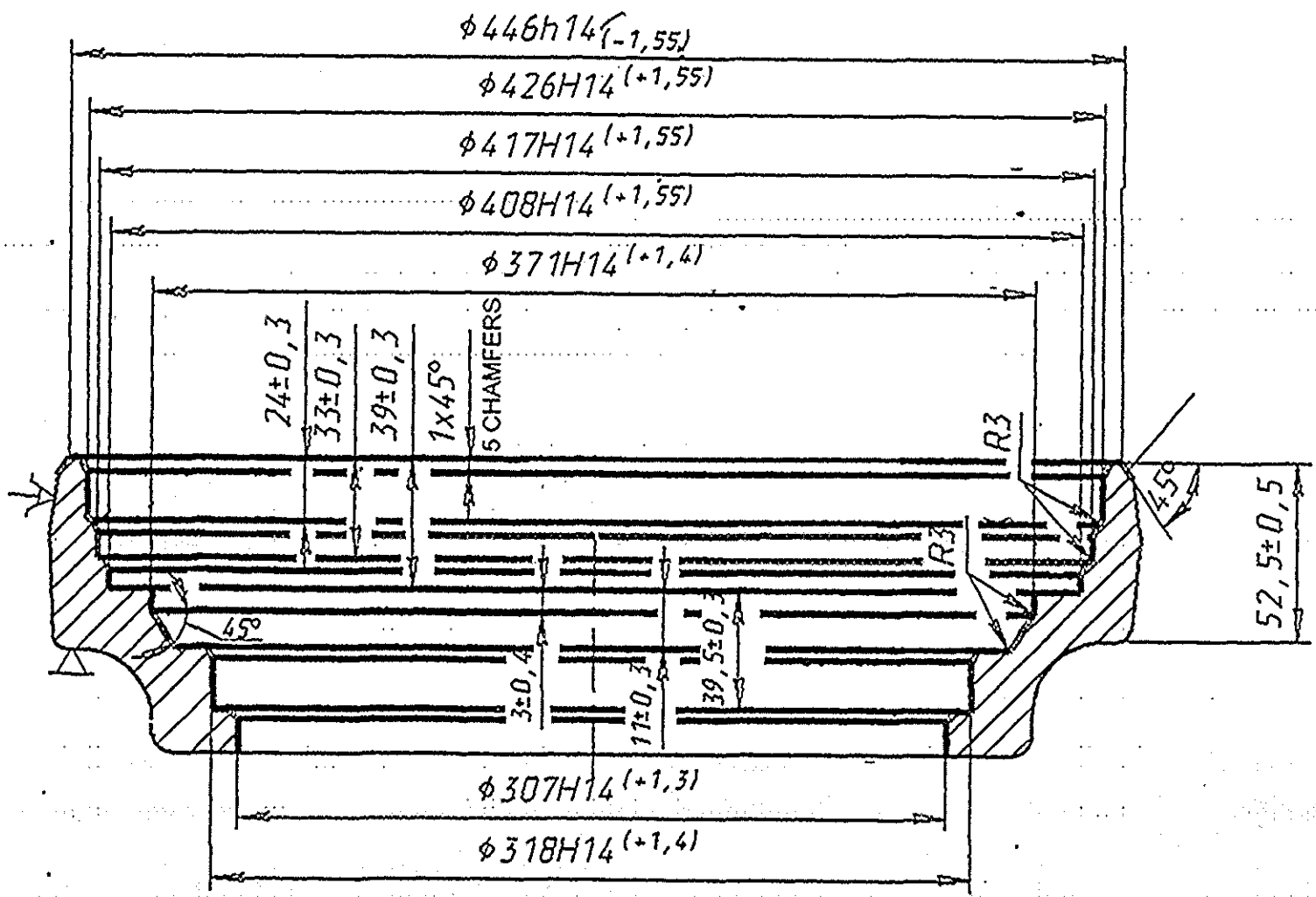
TECHNICAL REQUIREMENTS

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|---|--|
| <p>01. MARK CODE OF SHOP IN-CHARGE.</p> <p>02. < 256 HB.</p> <p>03. DE-SCALES (SHOT BLASTING)</p> <p>04. SURFACE DEFECTS AND RECESS DUE TO SCALES MAY BE ALLOWED UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE.</p> <p>05. PROJECTION DUE TO BURR MAY BE UPTO 2.2 MM.</p> <p>06. CONTINUOUS BURR IN HOLE IS ALLOWED.</p> <p>07. SHRINKAGE ON SURFACE A AS PER DRAWING IS ALLOWED.</p> <p>08. DISPLACEMENT (SHIFT OF AXES OF DIES) MAY BE UPTO 1.7 MM.</p> | <p>09. MISALIGNMENT OF BROACHED HOLE MAY BE UPTO 3.0 MM.</p> <p>10. UNSPECIFIED STAMPING DRAFTS OUTER - 7°, INNER - 10°</p> <p>11. DIMENSIONS IN BRACKETS ARE GIVEN FOR MACHINING.</p> <p>12. DIMENSIONS WITHOUT TOLERANCES ARE GIVEN FOR MAKING DIES - NOT TO BE CHECKED.</p> <p>13. PAINT RED OXIDE.</p> |
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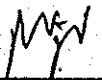
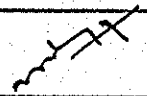
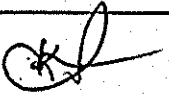
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MATERIAL	FORGING WT.		
38XC GOST 4543-71	39.0 KGS		
ALT. MATERIAL	HAMMER	SCALE	
	EK-32	NTS	
DRAWN	CHECKED	APPROVED	
<i>L. B. H. 27/18/03</i>	<i>M. S. 28/09/03</i>	<i>S. J. 28/09/03</i>	
DRAWING NO.	172.40.309/F		
NOMENCLATURE:	CROWN GEAR OF SECOND PLANETARY GEAR SET.		
<p>HEAVY VEHICLES FACTORY AVADI, CHENNAI</p>			

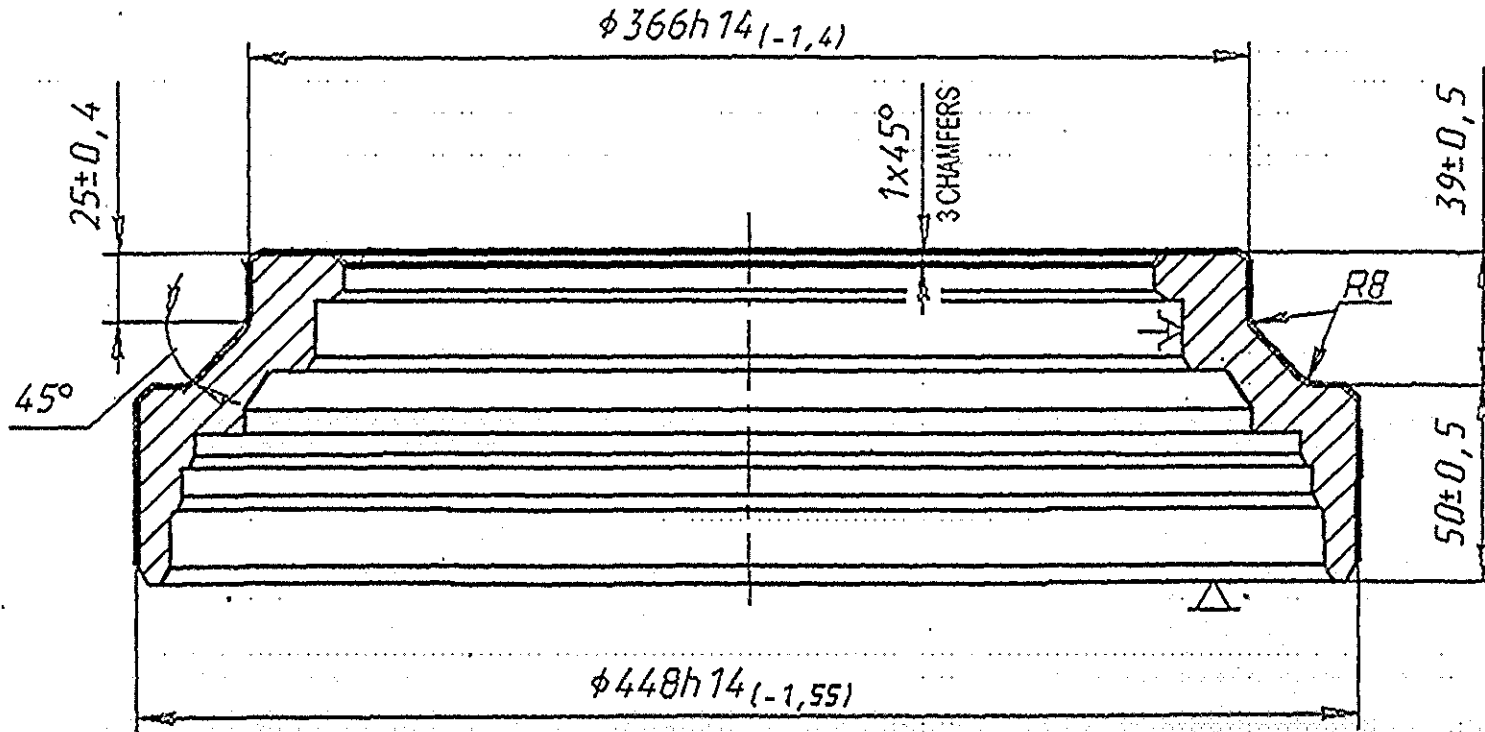
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DRG. NO. : 172.40.309/SMF, CROWN GEAR OF. 2ND
OPN NO. : 010 TURNING PLANETARY GEAR SET
MATERIAL : 38XC
HARDNESS : 255 BHN
SHEET NO.
NOT TO SCALE

 PREPARED [M. V. SARAVANAN] Jwm / TRA	 CHECKED [S. SARAVANAN] Jwm / TRG	 APPROVED [K. DURAGRA] Jwm / R. G. (HOS)
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Rz80



DRG. NO : 172.40.309/SMF, CROWN GEAR OF 2ND

OPN. NO. : 020 TURNING PLANETARY GEAR SET

MATERIAL : 38XC

HARDNESS : 255 BHN

SHEET NO.

NOT TO SCALE

PREPARED

CHECKED

APPROVED

[SARAVANAN]
Jwm/TRG

[S. SARAVANAN]
Jwm/TRG

[K. DURAJARAJ]
Jwm/TRG (1505)