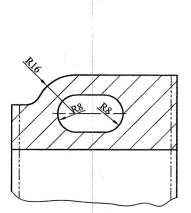
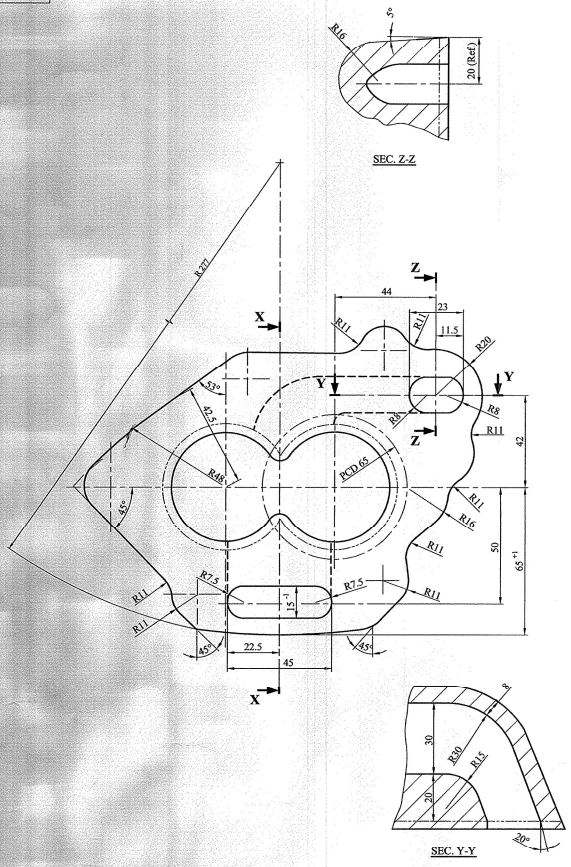
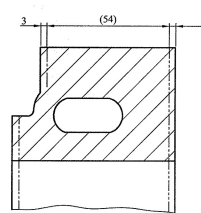


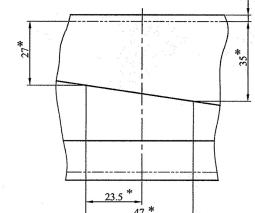
MODIFICATIONS & ADDITIONS		
ISSUE	MODIFICATIONS & N OF A	SIGN



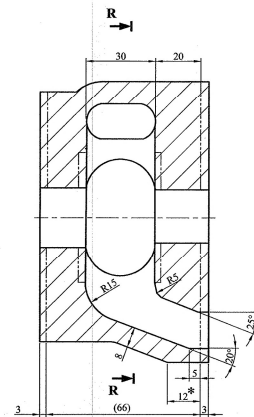
SEC. U-U



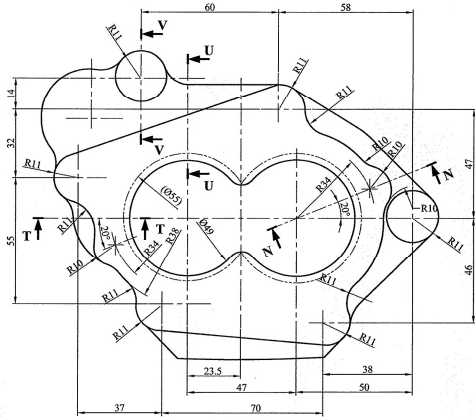
SEC. V-V



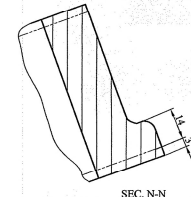
VIEW - T'



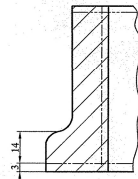
SEC. X-X



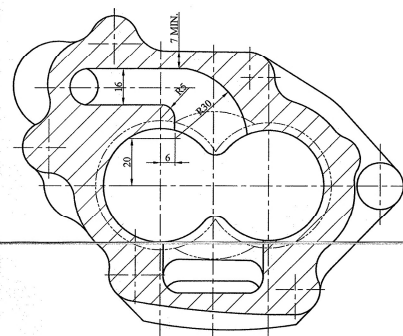
SEC. Y-Y



SEC. N-N



SEC. T-T



SEC. R-R

NOTE:-

- HARDNESS HB 170 - 241 (DIA OF INDENTATION 4.6 - 3.9)
- DRAFT SHOULD NOT EXCEED 2°.
- UNSPECIFIED CASTING RADII SHOULD BE PERFORMED R4 - 6 mm.
- CASTING SHOULD BE FREE FROM FOUNDRY DEFECTS.
- REQUIREMENTS FOR CASTING SHOULD COMPLY WITH 172.TY 7 (GENERAL REQUIREMENTS)
- MACHINING DIMENSIONS ARE GIVEN IN BRACKETS.
- ALL DIMENSIONS ARE IN MM.
- PHANTOM LINES INDICATES MACHINED SURFACE.
- * MARKED DIMENSIONS FOR REFERENCE.
- PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

EXPLANATORY NOTE:-

REFERENCE MATERIAL QUOTED:- GREY IRON CASTING OF GRADE C4 20 TO SPECN. GOST 1412 - 85.

CHEMICAL COMPOSITION:-

GDE OF CAST IRON	CONTENT OF ELEMENTS %				
	C	Si	Mn	P	S
				MAXIMUM	
C4 20	3.3 - 3.5	1.4 - 2.2	0.7 - 1.0	0.2	0.15

MECHANICAL PROPERTIES:-

GDE OF CAST IRON	ULTIMATE TENSILE STRENGTH Kg/mm ²	ULTIMATE BENDING STRENGTH Kg/mm ²	HARDNESS
			HB
C4 20	MINIMUM		170 - 241
	20	40	

ALT. MATERIAL:

G.I. CASTING GDE FG. 220 TO IS:210 - 78.

MATERIAL	CASTING WT.	SCALE
CASTING C4 20 GOST 1412 - 85 ALTERNATE MATL.		
		NTS
DRAWN	CHECKED	APPROVED

USER APPROVAL	DRAWING No. : 172.46.066 / C
<i>Rahm</i> 14/1/15 Head 1 r.m.	NOMENCLATURE : BODY OF LH SUCTION PUMP HEAVY VEHICLE FACTORY, AVADI, CHENNAI.