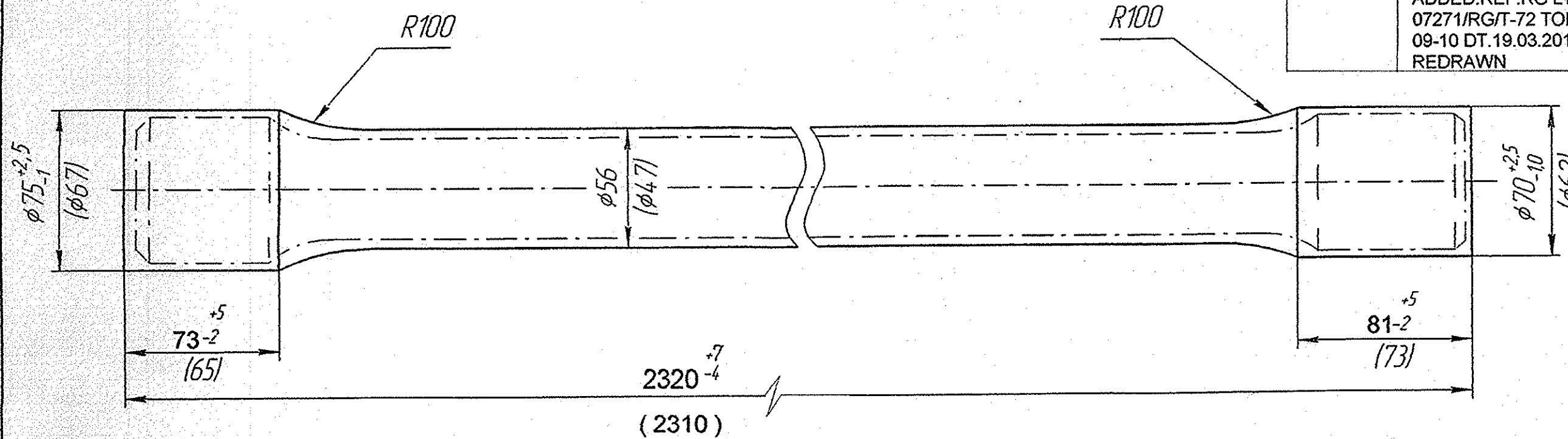


DRAWING NO.
172.51.016/F

ISSUE	MODIFICATION	DATE
A	REDRAWN	
B	ALTERNATE MATERIAL INCL. REF. JT. GM/P&TD Ltr 03512(7)/PDO/T-72/2K2 DT12.3.02(VACUM DEGASSED)	
C	ALT. MATERIAL, VACUM DEGASSED STEEL IS DELETED. REF. Jt. GM/C&S LTR NO. HVF/IFD/ 071040/2K2-2K3/AJY/STL/AJYFA DT. 14.06.02	
D	ISOTHERMAL ANNEALING IS ADDED. REF. RG LTR NO. 07271/RG/T-72 TORSION BAR/ 09-10 DT. 19.03.2010 REDRAWN	1/2 31/10



MATERIAL:- 45XH2MΦA-W
GOST 4543-71
(TY-14-1-1725-76)

T-72

TECHNICAL REQUIREMENTS

- MARK HEAT NUMBER, BATCH NUMBER AND PART NUMBER.
- HEAT TREAT: ISOTHERMAL ANNEALING 255 BHN MAX. (D)
- BEND UPTO 1.5 MM ALONG THE AXIS OF $\phi 56$ IS ALLOWED. AFTER ANNEALING.
- GRINDING SURFACE DEFECTS AND SCALE PITS ARE ALLOWED. WITHIN 0.5 OF ACTUAL ALLOWANCE.
- FORGING FIN UPTO 2 MM IS ALLOWED.
- RUNOUT OF HEAD IN RELATION TO SHANK IS ALLOWED UPTO 3 MM. RUNOUT IS TO BE CHECKED TO A LENGTH OF 200 MM FROM THE HEAD FACE. RUNOUT OF HEAD IS TO BE CHECKED IN 50 MM LENGTH FROM THE FACE.
- ELLIPTICITY OF HEAD SHOULD NOT EXCEED 2 MM.
- FACIAL FIN IS ALLOWED UPTO 6 MM.
- MISMATCH IS ALLOWED UPTO 1 MM.
- ELLIPTICITY AT THE PLACE OF GRIPPING IS ALLOWED WITH MINIMUM 54 MM DIMENSION.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UN TOLERANCED DIMENSIONS ARE NOT TO BE CHECKED.

MATERIAL	FORGING WT.	TOLERANCE	
45XH2MΦA-W GOST 4543-71 (TY-14-1-1725-76)	46.9 Kgs		
ALT. MATERIAL	HAMMER	SCALE	
		NTS	
DRAWN	CHECKED	APPROVED	
<i>L. Suresh</i>	<i>M. S. A. I. O.</i>	<i>A. S. I. O.</i>	
DRAWING NO. 172.51.016/F		NOMENCLATURE: SHAFT TORSION-FORGING	
HEAVY VEHICLES FACTORY AVADI, CHENNAI			