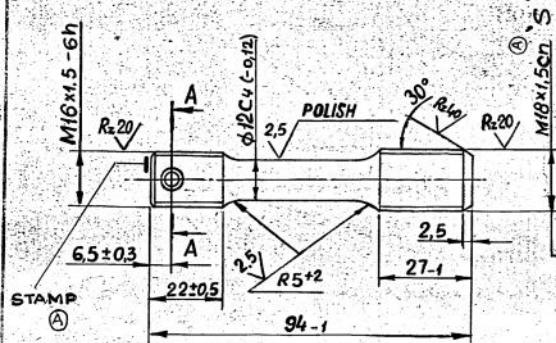
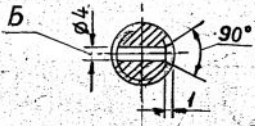


17-05-07

R<sub>z</sub> 80 (✓)



A-A



GROUPS OF THREAD B

GROUP No.	PITCH DIAMETER OF THREAD
1	17.166 TO 17.166
2	17.166 TO 17.186
3	17.186 TO 17.206
4	17.206 TO 17.226

EXPLANATORY NOTE :

10. REFERENCE MATERIAL QUOTED :

CHROMIUM STEEL OF HIGH QUALITY (A) TO GRADE 38XA.

a) CHEMICAL COMPOSITION :

GRADE	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
38XA	0.35-0.42	0.17-0.37	0.50-0.80	0.80-1.10	MAXIMUM			
					0.025	0.025	0.30	0.30
40X	0.36-0.44	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035	0.30	0.30
45X	0.41-0.49	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035	0.30	0.30

b) PHYSICAL PROPERTIES :

GRADE	TENSILE STRENGTH Kgf/mm <sup>2</sup> (min)	YIELD POINT Kgf/mm <sup>2</sup> (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kgf/cm <sup>2</sup> (min)
38XA	95	80	12	50	9
40X	100	80	10	45	6
45X	105	85	9	45	5

(A) REPAIR SIZE DIMENSION.

CATEGORY	DESIGNATION OF SIZE.	DIMENSION 'S'
20-50-21R1	DIAMETER	M 20 x 1.5 CП
	DIMETRAL PITCH	19.026 +0.34 +0.26

STAMP R1 WHERE MARKED THIS -

- INSPECTION GROUP III AS PER TECHNICAL REQUIREMENTS TT-11. HRC 33 TO 37 OR HB 302 TO 341.
- ALTERNATE MATERIAL IS STEEL 40X; 45X, GOST 4543-71.
- MAKE THREAD B AS PER STANDARD 82020-14, ISSUE 7.
- UNSPECIFIED LIMIT DEVIATIONS ARE AS FOLLOWS:-  
FOR HOLES - AS PER A,  
OTHERS - AS PER CM.
- COATING : CHEMICALLY OXIDIZED, OILED.
- PERMITTED WITH IN THE AREA OF THE HOLE FOR THE COTTER PIN AREA:-  
(1) FLATTENED PROFILE OF THREAD.  
(2) OVAL CHAMFER.  
(3) DECREASE IN THE MAJOR DIAMETER OF THE THREAD DOWN TO 0.3mm.
- TOLERANCE FOR ALIGNMENT OF HOLE B WITH RESPECT TO AXIS OF THE PART SHOULD NOT EXCEED 0.3mm.
- CHECK THE PART BY USING THE MAGNETIC FLAW DETECTOR. CARRYOUT ACCEPTANCE AS PER INSTRUCTIONS UB 20-17.
- CHECK FILLET RADI AND CHAMFERS BEFORE MAKING THE THREAD.
- (B) DETERMINE THE GROUP OF THREAD 'B' AS PER THE MAXIMUM PITCH DIAMETER.
- (B) MARK THE GROUP NUMBER AS PER DIMENSION OF THE PITCH DIAMETER OF THREAD 'B'.
- (C) ALTERNATE MATERIAL STEEL 709M40 (EN-19) TO BS: 970-P1-1983

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION \* 38XA GOST 4543-71

C	EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
25.12	0.120 Kg	(LETTERS)
96		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
27.3		MATERIAL - * SEE ABOVE
6.12		USED ON - C5 20-01-02-9
1.1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
1.1		TITLE - ADAPTOR STUD
20.08.87		D S CAT NUMBER
		DRAWING NUMBER 20-50-21

KVD No: 63584