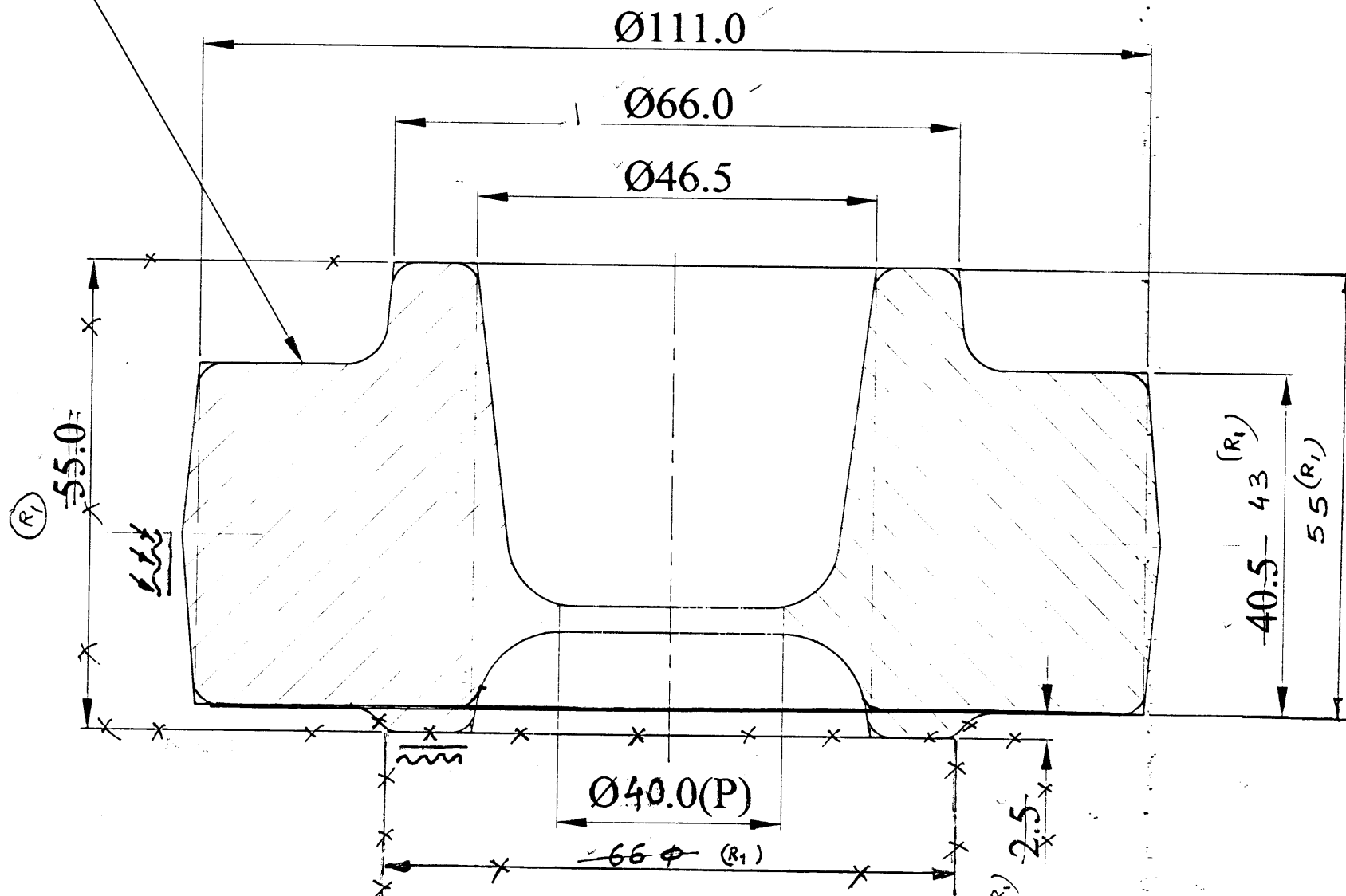


(R1) 2691 2635 5407  
**STAMP 2691 2635 5403, FIRM'S INITIAL, MONTH & YEAR**  
 (5 x 1 RAISED TYPE)



- NOTES:-
1. ALL DIMENSIONS ARE IN MM.
  2. DRAFT ANGLE : OUTER-5°, INNER-7°  
CORNER RADII- 2 & FILLET RADII- 5  
(UNLESS OTHERWISE STATED)
  3. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PITS, LAPS, CRACKS, UNFILLINGS ETC. (MAX. DEPTH DEFECT ALLOWED 0.4 MM.)
  4. MICROSTRUCTURE SHOULD BE OF UNIFORMLY DISTRIBUTED FERRITE AND LAMELLAR PEARLIT WITHOUT HARMFUL CONTINUOUS BANDING.
  5. GRAIN SIZE : ASTM NO. 5 - 8 AS PER 'MC' QUAI-D-EHN TEST (FILED GRADE AL KILLED CONDITION)
  6. GRAIN FLOW LINES SHOULD FOLLOW THE CONTOUR
  7. HARDNESS : 150 - 200 BHN.
  8. MATL.: 815 M17 BS 970-I. T13
  9. FORGING ARE TO BE SHOT BLASTED.
  10. HEAT-TREATMENT:- ISO-THERMAL ANNEALING.
  11. SAMPLE TO BE APPROVED BEFORE BULK-SUPPLY.
  12. FORGING TO BE COATED WITH RUST - PREVENTIVE RED OXIDE PRIMER.
  13. FORGING RIDGES TO BE TRIMMED, CLEAN & SMOOTH FINISH ALL OVER.
  14. CLAMPING FACE & STOP FACE FOR 1ST MACHINING OPERATION.

SUPPLY CONDITION: PRE-MACHINED

OUTSIDE DIA. - 111.0/111.5  
 INSIDE DIA. - 46.5/47.0

THICKNESS	+1.9, -0.0
DIE WEAR	+2.7, -0.0
FLASH PROJECTION	0.9
DRAFT ANGLE	+2°, -1°
CORNER & FILLET RADII	+50%, -25%
FLATNESS	0.7
MISMATCH	0.6
ECCENTRICITY OF PIERCING	0.5

TOLERANCES UNLESS OTHERWISE SPECIFIED  
 INT. DIMS. REVERSE SIGN + & -

ITEM	DESCRIPTION	NO OFF	10 F MAT	IS MAT	SIZE/WT	REMARK		
(R1)	DRG. NO. 2691.2635.5403-3 CHANGED TO 2691.2635.5403-3 ACCORDINGLY DRG. MODIFIED REF. JWM/GSL-NA. 35/18/04 DT. 16.8.13					JWM/T.D.O. JWM/GS APPD		
INDEX	ALTERATION		DATE	SIGN	DRN	TCD	CKD	C/CKD
DIM	TOL	<b>FORGING DRAWING</b> <b>FOR</b> <b>REVERSE IDLER GEAR</b> <b>GB / LPTA - 715, BS- III</b>				REFERENCE DRG	NTS	
0-30	± 0.1					2691 2635 5403	SCALE	
30-250	± 0.2					5403		
250-800	± 0.3						23.9.10	
800-2000	± 0.5						DATE	
> 2000	± 0.8				DEMANDED BY	1/1 A3		
T.D.O. VEHICLE FACTORY JABALP						DRG NO 2691.2635.5403-3	269126355403-3	

46-2-06