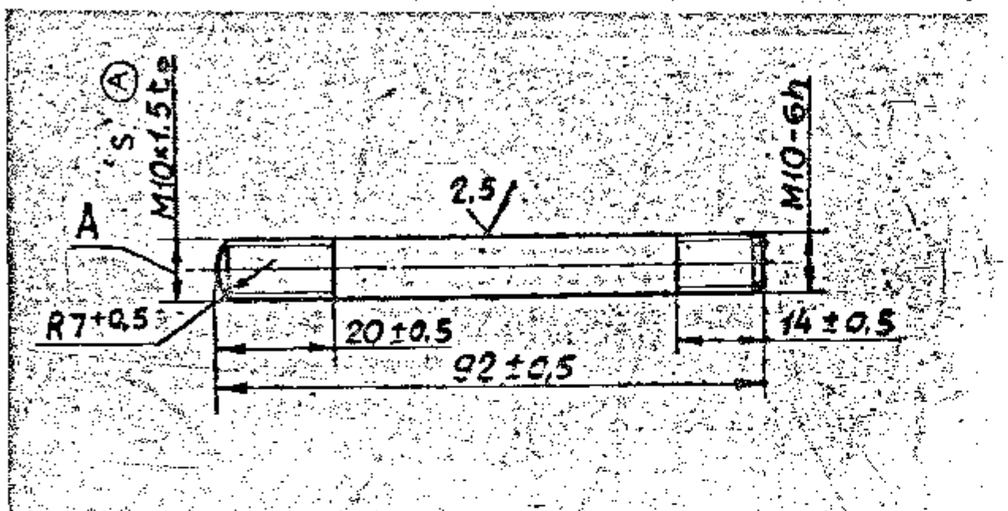
DRAWING NUMBER
20-50-06



1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11. H R C 26 TO 33.
2. MAKE THREAD AS PER STANDARD 82020-12 ISSUE 4.
3. WHEN THREAD IS MADE BY ROLLING, THE DIAMETER OF UNTHREADED PORTION MAY BE WITHIN THE LIMITS OF THE MAJOR DIAMETER OF THE THREAD.
4. COATING :ZINC PLATED, 3 MICRONS, THICK, OILED WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.

(A) REPAIR SIZE DIMENSION

CATEGORY	DESIGNATION OF SIZE	SIZE ACCORDING TO WORKING DRG	REPAIR SIZE DIMENSION 'S'
20-50-06R1	DIAMETER	M10X1.5 to	1 M12x1.5 to
	DIAMETRAL PITCH		11.026 +0.170 +0.095

All other details as per working drg.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. WT. 0.048 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

EXPLANATORY NOTE :

5. REFERENCE MATERIAL QUOTED :

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

a) CHEMICAL COMPOSITION :

CARBON	-	0.35 - 0.42 %
SILICON	-	0.17 - 0.37 %
MANGANESE	-	0.50 - 0.80 %
CHROMIUM	-	0.80 - 1.10 %
SULPHUR	-	0.025 (max)
PHOSPHORUS	-	0.025 (max)
COPPER	-	0.30 (max)
NICKEL	-	0.30 (max)

b) PHYSICAL PROPERTIES :

YIELD POINT	-	80 Kgf/mm² (min)
ULTIMATE TENSILE STRENGTH	-	95 Kgf/mm² (min)
ELONGATION %	-	12 (min)
REDUCTION IN AREA %	-	50 (min)
IMPACT STRENGTH	-	9 Kgfm/cm² (min)

(C) EQUIVALENT MATERIAL:- STEEL 709 M 40(EN-19) COLD DRAWN TO BS: 970-Pt-I-1983/AISI-4140.

(B) ~~ALTERNATE MATERIAL STEEL 709M 40(EN 19) to BS: 970 Pt I 1983~~

ISSUE	DATE	NATURE OF AMENDMENTS
C	11.11.14	Point No.4 of 9th Alt.Comm.Mtg.Dt:10.07.14.
B	28-5-09	3rd ALTERATION COMM. MINUTES POINT-2 DATE 27-2-09
A	7-8.98	AUTHY: SPECN FOR REPAIR SIZE DRG PART III

DRN
CHD
TCD
APPD
DATE 20-10-87
SCALE - 1:1
DIMENSIONS IN mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69
ALL THREADS TO CONFORM TO

MATERIAL :- 38XA GOST 4543-71

USED ON CB 20-01-02-9

CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI

TITLE STUD (M10X92)

D S CAT NUMBER

DRAWING NUMBER 20-50-06

KVD No. 63578

AMDT No: 1742-81.

SIZE A3