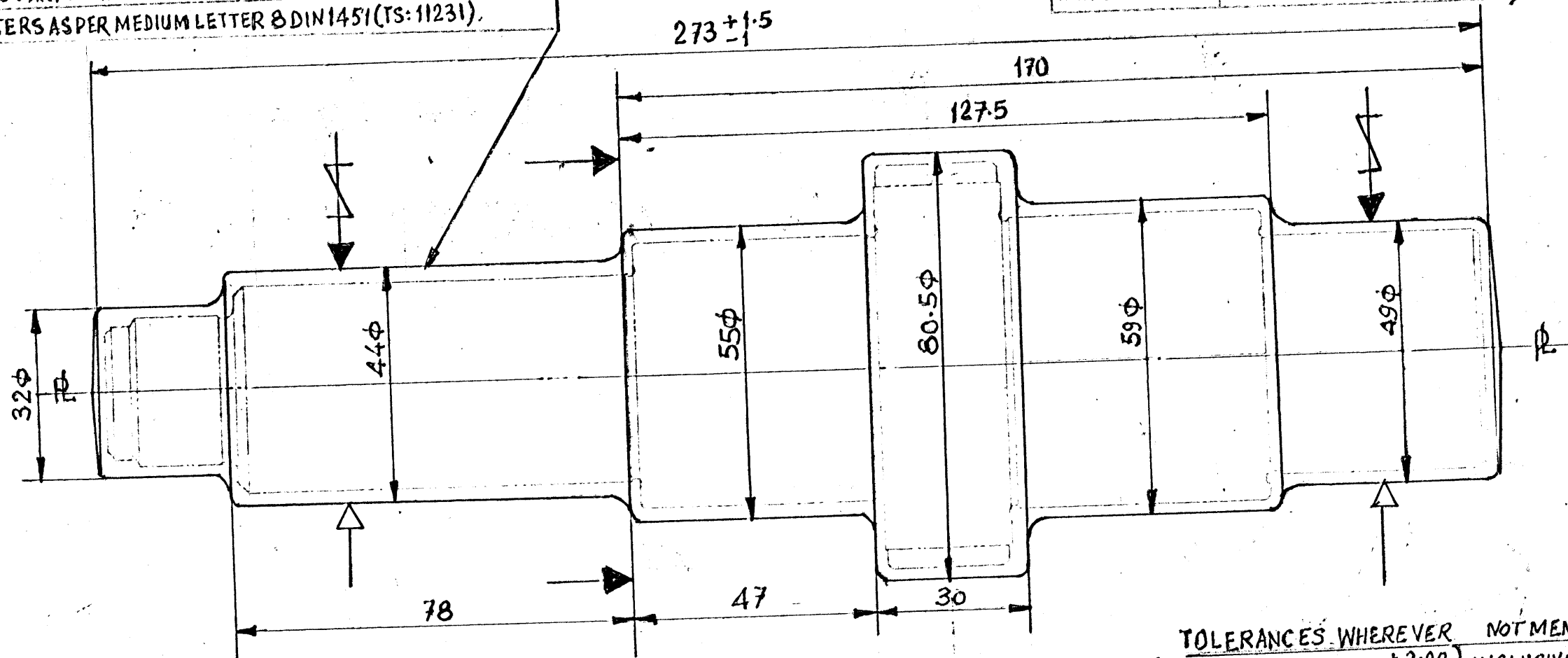


TELCO PART NO. AND SUPPLIER'S CODE NO. TO BE IN 0.4mm RAISED LETTERS AS PER MEDIUM LETTER 8 DIN 1451 (TS: 11231).

All Dimensions are in mm. If in doubt, Ask. Drawing drawn to 1st Angle Projection



TOLERANCES WHEREVER NOT MENTIONED

- ① 1.0 ON THICKNESS ± 2.00 INCLUSIVE OF DIE WEAR & SHRINKAGES.
 -0.5
- ① 2.0 ON DIAMETERS ± 2.00
 -0.5

NOTES:-

1. FORGING SHOULD BE SUPPLIED AS PER SS: 10 000.
2. LOCATING AND CLAMPING SURFACES SHOULD BE SMOOTH.
3. SURFACE COATING T.C.P.F. IS: 1154 (174 TS: 25205).
4. $\rightarrow$ LOCATION. $\rightarrow$ CLAMPING $\rightarrow$ REST, PARTING LINE
5. RADII CORNER 2R
FILLET 4R
6. MISMATCH 0.8mm.
7. DRAFT ANGLE $3^{\circ} \pm 1^{\circ}$
8. STRAIGHTNESS WITHIN 1.0mm.
9. FORGING SHOULD BE FREE FROM DEFECTS SUCH AS LAPS, CRACKS, UNFILLING PITS ETC.
10. HEAT TREATMENT AS PER TELCO'S INSTRUCTIONS.
11. TOLERANCE FOR FILLET & EDGE RADII TRIM BURRS AND DRAFT ANGLES TO BE AS PER IS: 3469.

DESIGN & DEV.	CENTRAL	FORGE.
FORGE	PLG	

(A) H.T. = 130-THERMAL ANNEALED.
HARDNESS = 140-187 BHN (R)
MICRO-STRUCTURE = FINE
FERRITE & PEARLITE

Material Description Size Spec Std No

20 Mn Cr 5 SS: 4027, T3
(50-65)

(R) HARDNESS 140-187 BHN WAS 170-210 BHN CHANGE AS PER CORRESPONDING TS: 50-65. kg/mm²
KPa (R)
(A) H.T. 130-THERMAL ANNEALED, HARDNESS 170-217 BHN & MICRO FINE FERRITE & PEARLITE ADDED AS PER DIN STANDARD. INSTR. OF JE-GM/T KPa (R).

15.97 P-1027
6.7.96
NEW RELEASE

DATE	SIGN	DATE
13.6	hdp	
15.9	R...	
9.7		

Product Group No
AUX. GEAR BOX

RAW PART FOR DRIVE SHAFT

13/3-2055

00322 282 03 01 50 (R)

R-NO: 7 A/3