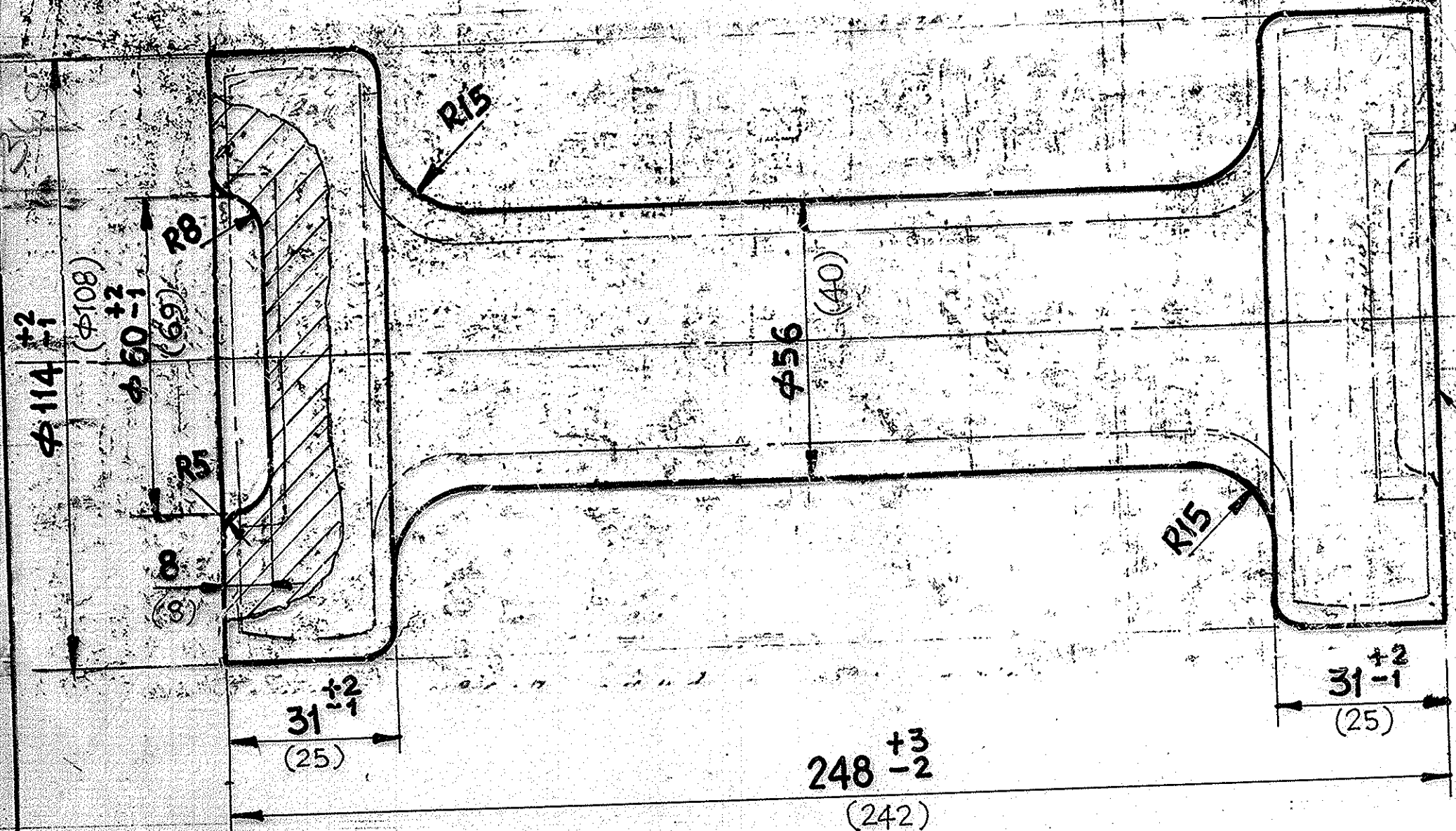


172-45-018-3

ГОРЬБАХОВСКИЙ ЗАВОД ИМ. А.А. ГОРЬБАХОВА  
 ОКРЕДНИК № 100/1074

ВАН



PLACE FOR MARKING  
 DEPTH SHOULD NOT EXCEED 1 mm

248 <sup>+3</sup>/<sub>-2</sub>  
 (242)

MATERIAL: 45XH2MΦA-W  
 TO SPECN. TY14-1-1725-76.

FORGING WEIGHT. 8.35 kg

TECHNICAL REQUIREMENTS.

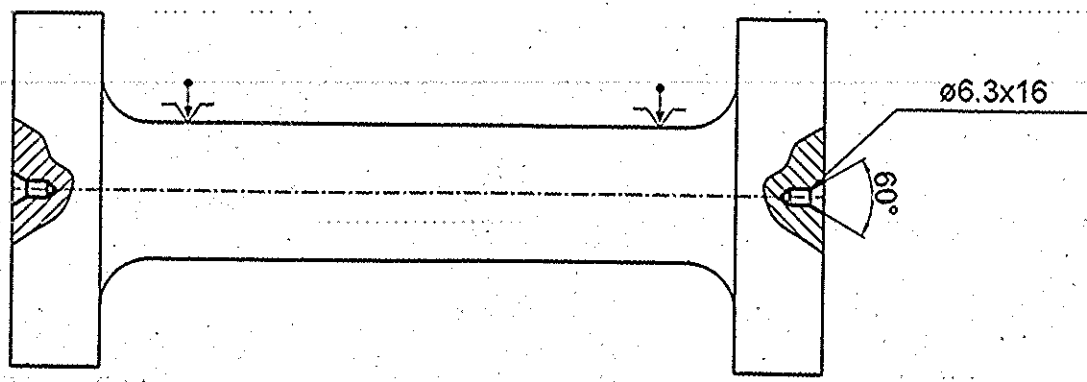
1. MARK PART NO., MELT NO. AND IDENTIFICATION MARK. "Э".
2. HEAT TREAT. DIA OF IND. ≥ 3.8  
 (A) NORMALISE & TEMPER 255 BHN. MAX.
3. DESCALE. / PAINT RED OXIDE
4. DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE ARE ALLOWED.
5. ELLIPTICITY OF HEADS SHOULD NOT EXCEED TOLERANCE LIMITS.
6. ONESIDE RADIAL SHIFT OF HEAD AXIS RELATIVE TO THE SHAFT SHOULD NOT EXCEED 2 mm. MAY BE CHECKED IF NECESSARY.
7. FOLDING OF FIN SHOULD NOT EXCEED 2 mm.
8. FIN ON FACE SHOULD NOT EXCEED 5 mm.
9. RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 1.5 mm
10. SHIFT IN AXIS OF BORE Ø 50 RELATIVE TO THE AXIS OF HEAD Ø 114 SHOULD NOT EXCEED 3.5 mm
11. UNSPECIFIED RADII = R 6 mm.
12. ELLIPTICITY IN THE PLACE OF GRIPPING IS ALLOWED WITH MINIMUM DIMENSION OF 48 mm.

B	REDRAWN	15/12/78
A	HEATTREATMENT DETAILS ADDED	8/3/6/87
ISSUE	N OF A	DE/15/8.
NOTIFICATION OF AMENDMENTS.		


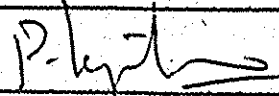
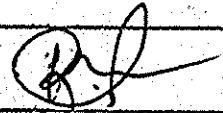
CHD.	Romur 16/1/78	APPD.	JONSON 16/1/85
DRG. NO.	172-45-018-3/F		
TITLE:	SHAFT.		
HEAVY VEHICLES FACTORY, AVADI.			

172-45-018-3/F

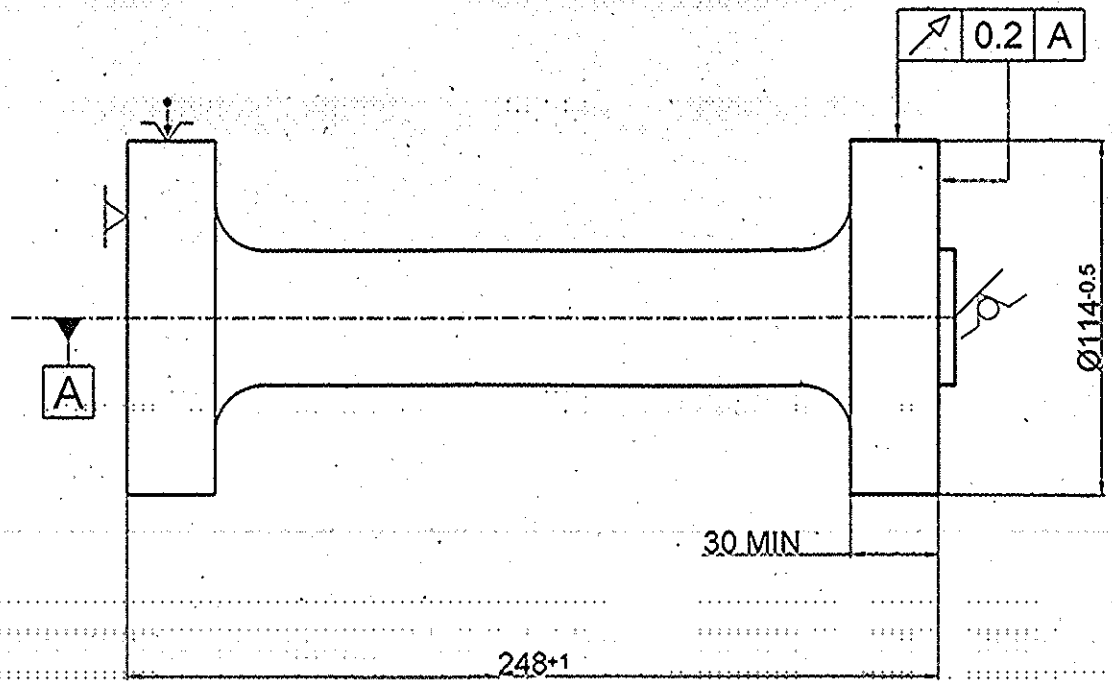
Rz 40 ✓



DRG NO.	: 172.45.018-3/SMF, SHAFT
OPN NO.	: 10 CENTERING
MATERIAL	: STEEL 45 X H2 M
HARDNESS	: BHN 255 - 285
SHEETNO.	: NOT TO SCALE

		
PREPARED	CHECKED	APPROVED

Rz 40 ✓



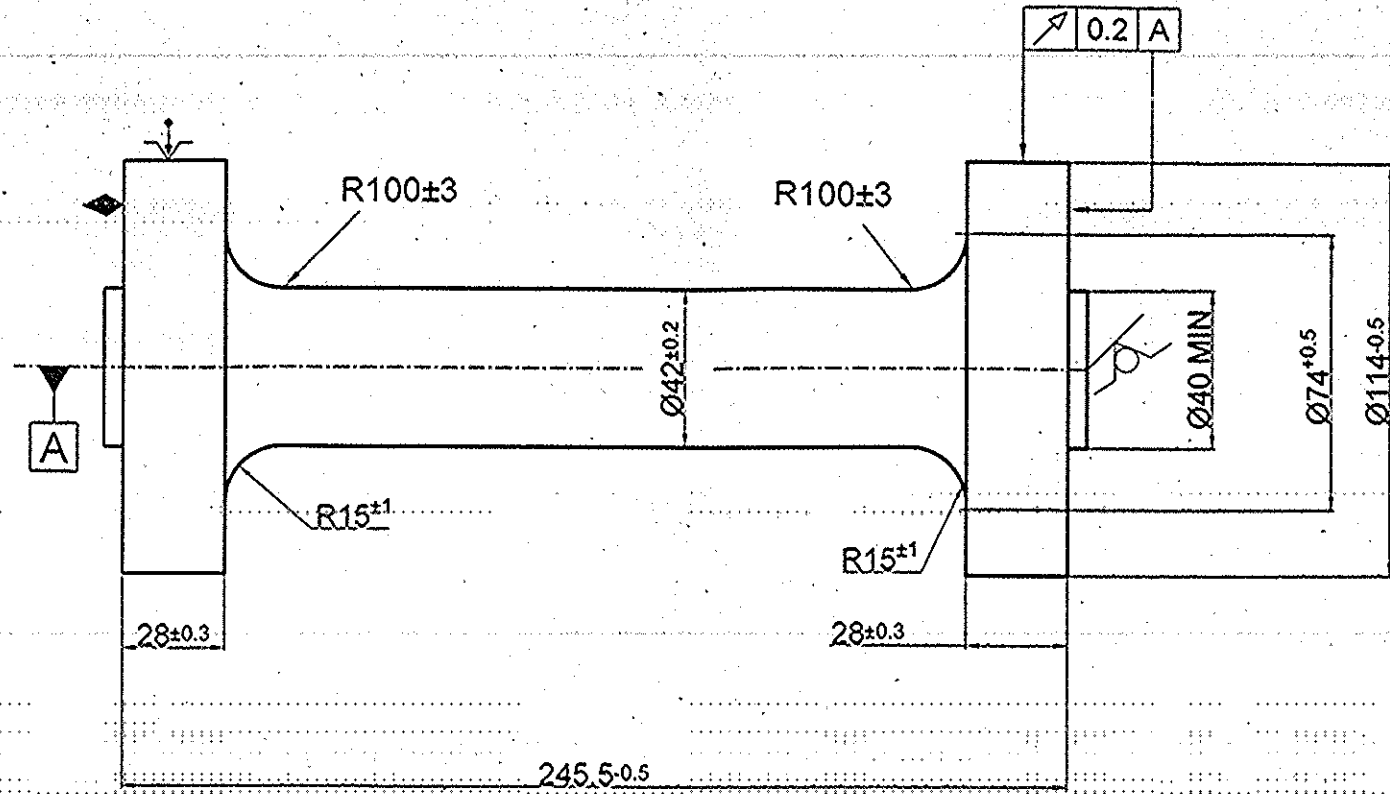
DRG NO.	: 172.45.018-3/SMF, SHAFT
OPN NO.	: 20 TURNING
MATERIAL	: STEEL 45 X H2 M.
HARDNESS	: BHN 255 - 285
SHEETNO.	: NOT TO SCALE

*Am*  
PREPARED

*P. Singh*  
CHECKED

*[Signature]*  
APPROVED

Rz 40



DRG NO.	: 172.45.018-3/SMF, SHAFT
OPN NO.	: 30 TURNING
MATERIAL	: STEEL 45 X H2 M
HARDNESS	: BHN 255 - 285
SHEETNO.	: NOT TO SCALE

PREPARED	CHECKED	APPROVED