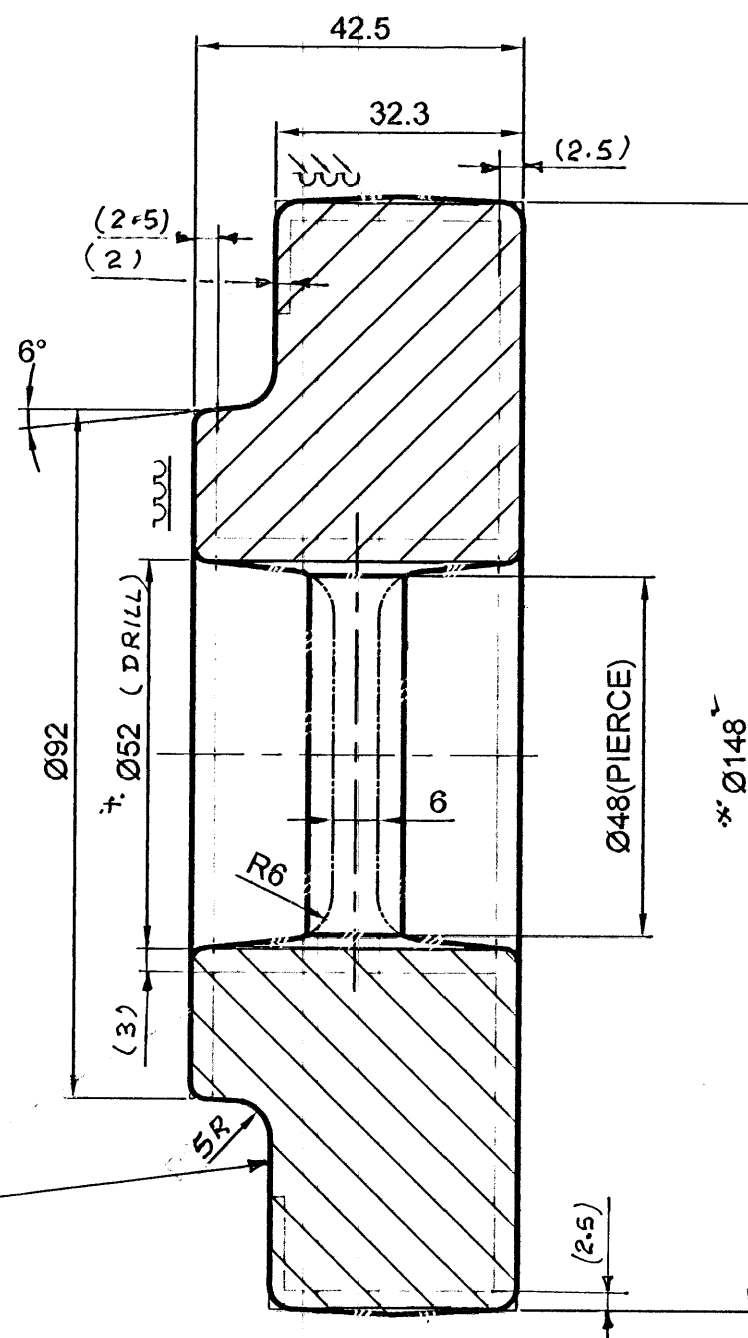


ALL DIMENSIONS ARE IN MM.

IF IN DOUBT PLEASE ASK



* NOTE :

SUPPLY CONDITION PRE-MACHINED

(1) O/S DIA. 148/148.5

(2) I/S DIA. 52.0/52.5

STAMP PART NO. & SUPPLIER CODE
IN RAISED TYPE

NOTE:

- FORGING RIDGES TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER.
- FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO JSS:3 - 47-13 BY BRUSHING OR SPRAYING.
- SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.
- STEEL SHOULD BE FREE FROM CENTRE , SEGREGATION,PIPING,FLAKES ETC.
- DIMS. IN BRACKET INDICATES MACHINING . ALLOWANCE.
- CLAMPING FACE } FOR 1st MACHINING -
STOP FACE } OPERATION .
- DRAFT ANGLE: INNER - 7°, OUTER - 5°
- UNSPECIFIED RADII: CORNER - 2R, FILLET - 3R

MATERIAL: 815 M17(En 353)OF BS-970

HARDENABILITY: JOMINY HARDENABILITY VALUE
OF J 6/16"=35 TO 39 HRC (FOR TEST PIECE)

COMP.OF En353:

C 0.14-0.20, SI 0.35MAX.,Mn 0.50-1.00,S 0.015-0.04,
P 0.035MAX,Ni 1.0-1.5,Cr 0.75-1.25,Mo 0.08-0.15
PHYS.PROP.:

HEAT-TREATMENT: ISO THERMAL ANNEALING.

HARDNESS: 150 - 210 BHN

MICRO STRUCTURE:

UNIFORM LAMELLER PEARLITE & FERRITE BAINITE &
INTERMEDIATE STRUCTURE 10% MAXIMUM.
EXCESSIVE BANDING IS NOT ACCEPTABLE IF BANDING IS
PRESENT,MINIMUM NUMBER OF BANDS/mm SHALL BE 14
(WHEN VIEWED AT 100X MAGNIFICATION)

GRAIN SIZE: ASTM 5 - 8

INCLUSION RATING: 3A,3B,3C,3D MAX. OF IS 4163

FORGING TOLERANCE AS PER IS : 3469 - 1974

FORGING WEIGHT (APPROX)	ENVELOP WEIGHT	COMPLE- XITY	INTRAC OF MATL.	FORGING GRADE
4.7 KG	-	-	-	NORMAL

KIND OF DIMS.	TOL.	KIND OF DIMS.	TOL.
LENGTH/DIA	+1.1 -0.4	RESIDUAL FLASH	
THICKNESS	+1.5 -0.0	TRIMMED FLAT	CLOSE TRIM
MISMATCH	0.6	DRAFT ANGLE	+2° -1°
STRAIGHTNESS	0.6	RADII	+50% -25%

INTERNAL DIMS. REVERSE SIGN + & -

FORGING DRAWING
FOR
4TH.SPEED GEAR ON L/ SHAFT
GEAR BOX,STLN.MK-IV
VEHICLE FACTORY JABALPUR

R.C.R. KOLTE JWM / DDO	JWM/GS	APPD.
R. ORAM DRN.	TCD.	DO/PROD. 5/14
REF. DRG. F1607211 C & SAMPLE	M/C.	1:1 SCALE
DDO SECTION	19/02/2014 DATE	1/1 SHT. A3
DEMANDED BY WMM/VMM	DRG. NO. F1607211-3	