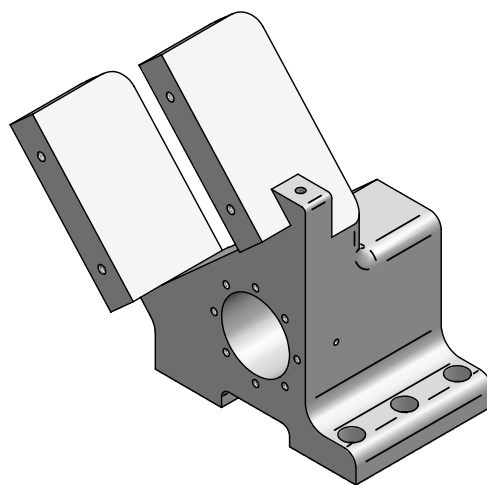


NOTE:
TO BE STRESS RELIEVED, SOAKING TIME - 2 Hrs
STRESS RELIEVING TEMP. SHALL BE 600°C ±15°C
TEMP. OF COMPONENTS WHILE LOADING/ UNLOADING
FROM FURNACE SHALL BE 300°C OR LESS.

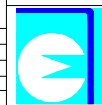
HEATING AND COOLING RATE SHALL BE 100° PER Hrs.
SIZES ARE INCLUSIVE OF MACHINING ALLOWANCE



| Roughness Symbol, grade and Ra value | | | | | | | | | | | | Allowable Deviations for Dimensions without specified tolerance | | | | | | | | | | | | |
|--------------------------------------|-------------|-------|------|-----|-------|-----|----------|-----|---------|-----|------|---|--------------|-------------------------------------|-----|-----|-----|-----|------|------|------|------|--|--|
| SYMBOL | | | | | | | | | | | | OVER | 0.5 | 3 | 6 | 30 | 120 | 315 | 1000 | 2000 | 4000 | | | |
| VALUE | 0.012 | 0.025 | 0.05 | 0.1 | 0.2 | 0.4 | 0.8 | 1.6 | 3.2 | 6.3 | 12.5 | 25 | 50 | UP TO | 3 | 6 | 30 | 120 | 315 | 1000 | 2000 | 4000 | | |
| in μm | | | | | | | | | | | | | FOR MACHINED | 0.1 | 0.1 | 0.2 | 0.3 | 0.5 | 0.8 | 1.2 | 2 | 3 | | |
| in GRADES | N1 N2 N3 N4 | | | | N5 N6 | | N7 N8 N9 | | N10 N11 | | N12 | PARTS | 0.2* | 0.5* | 1* | 2* | 4* | - | - | - | - | - | | |
| | | | | | | | | | | | | | | * Applicable for radii and chamfers | | | | | | | | | | |

| Allowable Angular Deviations | | | | | |
|------------------------------|-------------------|-----|-----|-----|-----|
| FOR MACHINED PARTS (°mm) | OVER | — | 10 | 50 | 120 |
| | UPTO | 10 | 50 | 120 | — |
| | Δ_{mm} | 0.1 | 0.2 | 0.6 | 0.8 |
| | Δ_{∞} | 1' | 30' | 20' | 10' |

| | | | | | | | | | | |
|----------|------------------------------|-----------------------|--|---------------------------------------|--|------|---------------------|------|--|--|
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| NO. | AMENDMENT | | | | | ZONE | DONE | APPD | | |
| TITLE: | BEARING HOUSING CASTING DRG. | | | | | | DATE: 03/ 12 / 2012 | | | |
| NO. OFF | MATERIAL | FINISH PAINT | | SCALE | | | | | | |
| 01 | F6300 | | | 1 : 5 | | | | | | |
| DESIGNED | SAGAR | SURFACE FINISH | | DRG NO: | | | | | | |
| DRAWN | SAGAR | N8(N6) ✓ | | | | | | | | |
| CHECKED | VSG | CUSTOMER: | | ARK - PA300 - 100 - 02 CASTING_REV 01 | | | | | | |
| APPROVED | VSG | PA - 300 (GRAZIANO) | | | | | | | | |



ARK MachTek Pvt. Ltd