



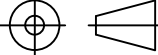
FOR REFERENCE ONLY
DATE - 03.02.18

1. MATERIAL :- SAE 8620 H (QL - 3)
Additional requirements : Ca:< 0.002%, S:0.01-0.04%, Cu:<=0.35%
2. HEAT TREATMENT : NORMALISED
3. HARDNESS - 165 - 200 BHN.
4. FORGING TO BE SHOT BLASTED.
5. JOMINY VALUE - J 4 / 16" = 32 ~ 36 HRC. Δ
6. GRAIN SIZE : ASTM 5 TO 8 AS PER ASTM E112.
7. STEEL SHOULD BE FROM VACCUM DEGASSED ROUTE.
8. NONMETALIC INCLUSION RATING (WORST FEILD) OF CARBON & ALLOY STEEL BAR PRODUCT S & FORGING SHALL CONFORM TO THE FOLLOWING SPECS

QUALITY LEVEL	TYPE A		TYPE B		TYPE C		TYPE D	
QL-3	THIN	HEAVY	THIN	HEAVY	THIN	HEAVY	THIN	HEAVY
	3	2	3	2	1	1	2	1.5

NOTE : NONMETALIC INCLUSION SHALL BE EVALUATED IN CONFORMANCE TO ASTM E 45 , METHOD A , EXCEPT THAT FOR EACH INCUSION TYPE & THICKNESS , THE WORST FIELD RATING ON ANY TEST SPECIMENS (NOT THE AVERAGE OF WORST FIELD RATING ON INDIVIDUAL TEST SPECIMENS) SHALL BE USED TO DETERMINE THE FINAL RATING & REPORTED.

9. INTERNAL SOUNDNESS OF ALLOY STEEL BARS & FORGING
S - 3 Max. , R - 3 Max. , C - 3 Max. (GRAIN REFINER - Al OR Nb)
REDUCTION RATIO GREATER THAN OR EQUAL TO 6:1
10. MICROSTRUCTURE:- UNIFORMLY DISTRIBUTED LAMELLER PEARLITE WITHOUT ANY INTERMEDIATE PRODUCTS OR PRONOUNCED BANDING.
11. UNSPECIFIED CORNER RADII : 2 , FILLET RADII : 3 , DRAFT ANGLES : 5°
12. FORGING TOLERANCES AS PER IS : 3469 (PART II) 1974.
13. ALL DIMENSIONS ARE AT CROSSING POINT.
14. SPARK TESTING : 100% REQUIRED .

						ALL DIMENSIONS ARE IN MILLIMETERS				
						DO NOT SCALE, IF IN DOUBT, PL. ASK				
	JOMINY VALUE J ₁₆ " = 32 ~ 36 HRC. WAS J ₁₆ " = 36 ~ 40 HRC. CHANGED; AS PER DCR NO. 1122				DIGPAL	R.P.	B.LEVA	02.2.18	MACHINE ---	
	100% SPARK TESTING REQUIREMENT ADDED.(Ref. DCR No. 93)				MRIDUL	R.P.	B.LEVA	07.3.12	MATERIAL	
REV.NO	REVISIONS				PRPD	CHKD	APRD	DATE	SEE NOTE	
DRAWING TITLE <div><i><u>FORGING DRAWING</u></i></div> (DROPBOX IDLER GEAR)					NAME		SIGN	DATE		SCALE
					PLND	R.P.		28.10.10	NT. WT.	PROJECTION
					CHKD	R.P.			1.72 Kg.	
					APRD	B.LEVA				
COMP. ED-2097					SHT. 01 OF 01		SL.NO. 4 - 3003			REV. 02
VE COMMERCIAL VEHICLES LIMITED (UNIT : EICHER ENGINEERING COMPONENTS) 78 - 86, INDUSTRIAL AREA NO.- 3, A. B. ROAD, DEWAS (M.P.) 455 001							DRAWING NO.			
							ED - 2097 / F			
COAD DRG.-:							SIZE : A4, (210 × 297 mm)			