



METALLURGICAL REQUIREMENTS :-

- 1) MATERIAL : ZF 7B, AS PER CUSTOMER STD. ZFN417 - C
- 2) GRAIN SIZE : * 5 OR FINER
- 3) INCLUSION RATING : * K4 OXIDE - (DIN 50602)- ≤25 (AS PER 7B)
- 4) JOMINY VALUE : * J5mm=39-43 HRC,
J10mm=35-39 HRC,
J25mm=27-31 HRC,
J50mm≥ 24 HRC
- 5) REDUCTION RATIO : 6:1 MIN.

ABOVE METALLURGICAL REQUIREMENTS AS PER ZF 7B

* MATERIAL TO BE PROCURED FROM CUSTOMER APPROVED SOURCE ONLY.

FORGING REQUIREMENTS :-

- 1) HEAT TREATMENT : NORMALISED
- 2) HARDNESS : 160 ~ 200 BHN
- 3) MICROSTRUCTURE : UNIFORMLY DISTRIBUTED LAMELLAR PEARLITE WITHOUT ANY INTERMEDIATE PRODUCT OR PRONOUNCED BANDING
- 4) SURFACE CONDITION : SCALE FREE & SHOT BLASTED
- 5) UNSPECIFIED DIMENSIONS :-
DRAFT ANGLE : 5°
FILLET RADII : 2 R
CORNER RADII : 3 R
- 6) FORGING TOLERANCES : AS PER IS : 3469 (PART II) - 1974
- 7) ALL DIMENSIONS TO BE CONSIDERED AT CROSSING POINT.

OTHERS :-

- 1) MARK MATERIAL & PART NO. ON FORGING.

FR 3	CUSTOMER SPECIFIED FUNCTION RELATED CHARACTERISTIC	SYMBOL	DISCRIPTION	SIGN.	DATE	UNSPECIFIED LINEAR TOLERANCES IS 2102(PART-1),1993 (MEDIUM CLASS)								
		B	EECD CRITICAL			TOLERANCE								
						±0.1	±0.2	±0.3	±0.5	±0.8				
						SIZE								
						OVER	0.5	6	30	120	400	1600		
UP TO							6	30	120	400	1600			
METALLURGIST APPROVAL														

				ALL DIMENSIONS ARE IN MILLIMETERS			
				DO NOT SCALE, IF IN DOUBT, PL. ASK			
				MATERIAL			
REV. NO.				AS SPECIFIED			
DRAWING TITLE				PRPD	CHKD	APRD	DATE
FORGING DRAWING FOR INPUT GEAR				NAME	SIGN	DATE	SCALE
				PRPD	VAISHALI	03.12.18	N.T.S.
COMP. ED 0844 (CUST. PART NO. 5846 304 010)				CHKD	R. PATHAK		NT. WT.
				APRD	B. LEVA		14 Kg
VE COMMERCIAL VEHICAL LTD. (UNIT : EICHER ENGINEERING COMPONENTS) 78 - 86, INDUSTRIAL AREA NO.- 3, A. B. ROAD, DEWAS (M.P.) 455 001				SHT. 01 OF 01		SL. NO. 4-14311 DRAWING NO.	REV. 00
CAD DRG. (FILE) NAME :				ED 0844 / F			
				SIZE : A3, (297 × 420 mm)			