

MANUFACTURER'S SYMBOL
& PART NO, ED5460
WITH 5mm HT. & 0.5mm
RAISED LETTERS.

NOTE:-

- 1) MATERIAL:- 25MoCr4E BTS : 4027
- 2) HEAT TREATMENT :- ISOTHERMAL ANNEALING.
- 3) HARDNESS :- 152 - 190 BHN.
- 4) REDUCTION RATIO : 6 MIN.
- 5) JOMINY VALUE :-

HARDENABILITY (DISTANCE IN mm)	1.5	3	5	7	11	15	20	25	30
MIN. - HRC	44	42	41	40	36	33	30	28	27
MAX. - HRC	49	49	48	47	44	41	39	37	36

- 6) GRAIN SIZE:- 5 ~ 8 ASTM E 112 : PI IV
- 7) INCLUSION RATING :- IS 4163 . ASTM E45A

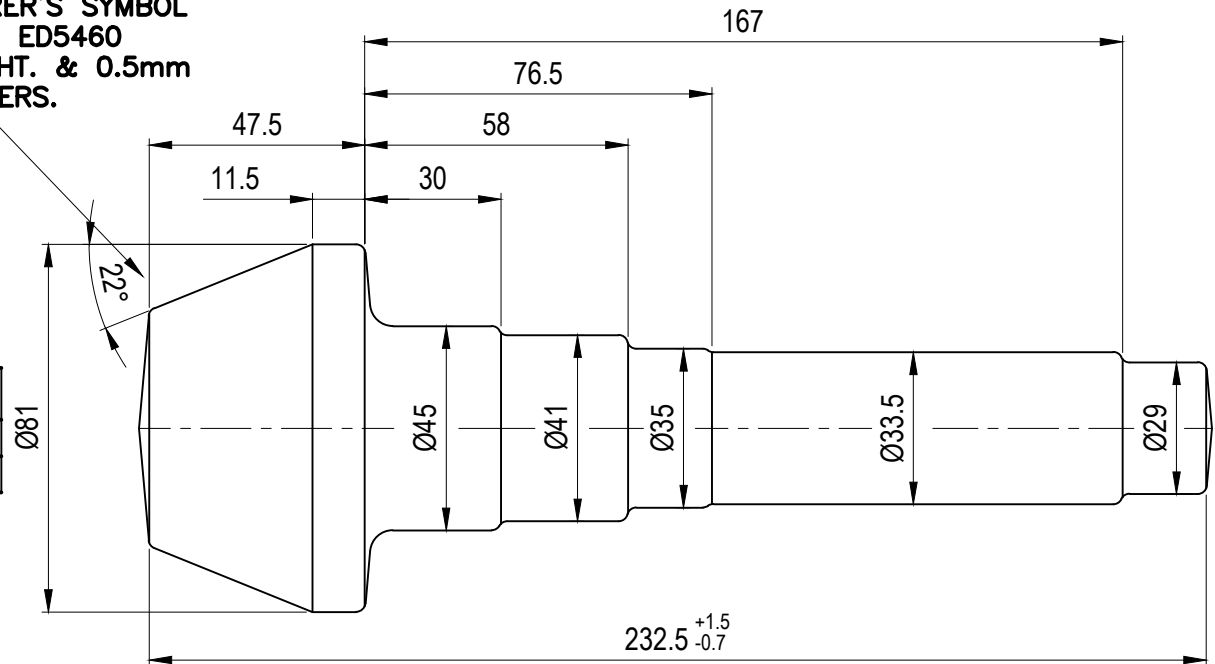
INCLUSION RATING	A		B		C		D	
	T	H	T	H	T	H	T	H
MAX.	2.0	1.0	2.0	1.0	2.0	1.0	2.0	1.0

- 8) MICROSTRUCTURE :- UNIFORMLY DISTRIBUTED EQIAXED GRAINS OF FERRITE & PEARLITE WITHOUT BANDING & INTERMEDIATE PHASE.

- 9) UNSPECIFIED DIMENSIONS. :-
CORNER RADII : 2R FILLET RADII: 5, + 50%, 25%
DRAFT ANGLE : 5° +2°, -1° LENGTH / DIA. = +1.3, -0.7
THICKNESS OR DIE CLOSURE = +1.3, -0.7
SHRINKAGE OR DIE WEAR = +1.3, -0.7
ACTUAL MISMATCH = 0.7
FLASH EXTENSION = 0.8
STRAIGHTNESS = 0.9
FLATNESS = 0.9

- 10) FORGING TOL. AS PER EUROFORGE DIN : 7526

- 11) FORGING TO BE SHOT BLASTED.
- 12) FORGING SHOULD FREE FROM DEFECTS SUCH AS CRACKS, SCALES PITS Etc.
- 13) ALL DIMENSIONS ARE AT CROSSING POINT.



COMPOSITION (25MoCr4E)

AS PER STD. BTS 0053

%	C	Mn	Si	P	S	Cr	Mo	Al	Ca
MIN.	0.19	0.70	0.15	0.00	0.020	0.65	0.40	0.020	15 PPM
MAX.	0.23	1.00	0.40	0.035	0.035	1.00	0.50	0.050	25 PPM

CRITICAL	CHARACTERISTIC
EECD	CUSTOMER

				ALL DIMENSIONS ARE IN MILLIMETERS			
				DO NOT SCALE, IF IN DOUBT, PL. ASK			
				MACHINE			
				MATERIAL			
				SEE NOTE			
REVISIONS				PRPD	CHKD	APRD	DATE
FORGING DRG (PINION SHAFT)				NAME	SIGN	DATE	SCALE
				PRPD	MW	18.08.15	N. T.S.
				CHKD	SDP		HARDNESS
				APRD	BLEVA		SEE NOTE
COMP. - ED 5460 (08 686 353 05 10)				NT. WT.		PROJECTION	
VE COMMERCIAL VEHICLES LIMITED.				3.0			
(A UNIT OF EICHER MOTORS LTD.) DEWAS (M.P.)				Kg.			
DESIGN & DEVELOPMENT DEPTT.							
SHT. 01 OF 01				SL.NO. 3-11454		REV. 00	
CAD DRG. (FILE) NAME :				DRG. NO. ED 5460 /F		SIZE : A3, (297 x 420 mm)	