
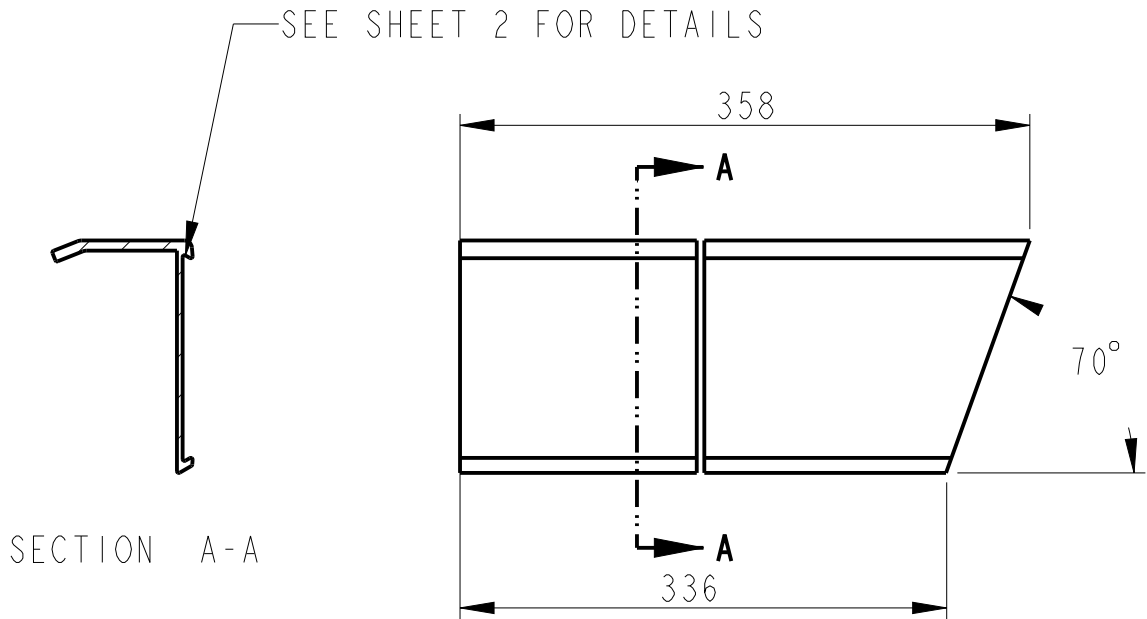







C.L.	E.C.O.	REVISION	CHKD.	DATE
	CA-19-00001445	NEW DRAWING RELEASE	PD	11/2/19



- NOTE-**
1. STANDARD NO- WCQ-AL-001
 2. DIE NO. 77874
 3. APPLICABILITY AS PER AIS-052
 4. PARTS TO BE SILVER ANODIZED.
 5. COATING THICKNESS -18 MICRON

ALL DIMENSIONS ARE IN MM  - CRITICAL  - MAJOR  - MINOR	HEAT TREATMENT		MATERIAL		 EICHER VE COMMERCIAL VEHICLES LTD.
	EFFECTIVE CASE DEPTH		AL IS 733-1983	WT-Kg. 0.195	
TOLERANCES UNLESS SPECIFIED	HARDNESS	SURF	SCALE	DESCRIPTION	
		CORE	1:2		
	FINISH	SURFACE ROUGHNESS	DRN	AL STEP EDGE	
		CHD	PART No./DRG. No. IU451230		
		APPD			SHT. No. 1 of 2 CL.  SIZE A4
		NVP			

P Release

C. L.	E. C. O.	REVISION	CHKD.	DATE
	CA-19-00001445	NEW DRAWING RELEASE	PD	7/2/19

FILE NAME: NEW

TRANSPORT

DIE NO :- 77874

Scale : 1:1

Note :-

- 1) All dims. are in mm
- 2) Twist & Bend :- 1,70 mm/ Mtr
- 3) Flatness :- 0.3 Concave or convex
- 4) Angularity tolerance :- ±1.5°
- 5) Critical dimensions :- * Marks
- 6) Filing complaints will be not considered if not provided before die development.

Container OD mm	Ø130	Die OD-mm	Ø190	Area-mm ²	207.37	Drawn By	
Die Plate-mm	40 mm	Bolster No		Perimeter-mm	200.83	Chkd By	
Backer-mm	60 mm	Backer No.	77714	Weight/ML-Kg.	0,510-0,600	Date	05/10/2014
Pocket Deep	18 mm	Cavity No.	1 no.	Aloy	6063-T6	App. Date	
		Ext.Ratio	63.98	Unspec'd Tol.	±0.20	Rev.no.	

J M INDUSTRIES
Ahmednagar

Ref :- Drg.no. IU345585

Title :- AL STEP EDGE-10

ALL DIMENSIONS ARE IN MM - CRITICAL - MAJOR - MINOR	HEAT TREATMENT		MATERIAL		EICHER VE COMMERCIAL VEHICLES LTD.	
	EFFECTIVE CASE DEPTH		AL IS 733-1983			
TOLERANCES UNLESS SPECIFIED	HARDNESS	SURF	SCALE	DESCRIPTION		
		CORE	DRN			
	FINISH	SURFACE ROUGHNESS	CHD	PD	PART No./DRG. No. IU451230	
			APPD	NVP		
		SHT. No. 2 of 2			SIZE A4	

P Release