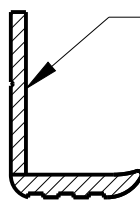
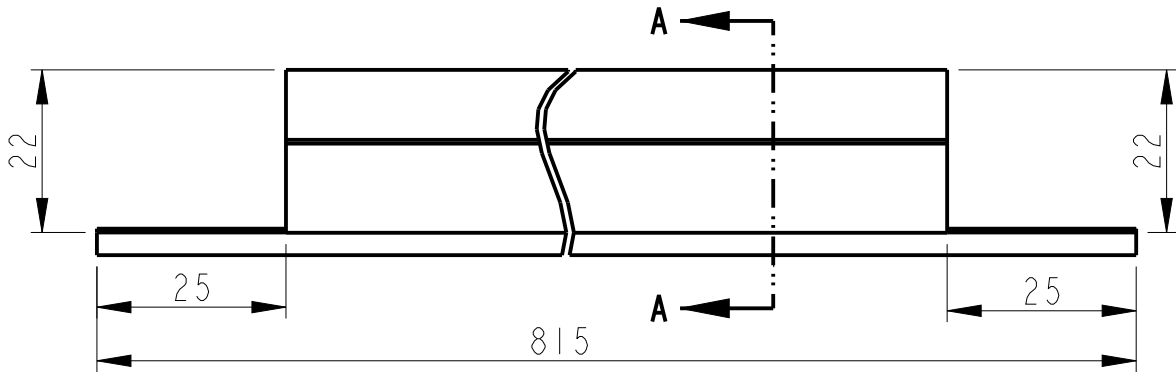


| | | | | |
|------|----------------|---------------------|-------|---------|
| C.L. | E.C.O. | REVISION | CHKD. | DATE |
| △ | CA-19-00001445 | NEW DRAWING RELEASE | PD | 19/2/19 |






SEE SHEET 2 FOR DETAILS

SECTION: A-A

NOTE-

1. STANDARD NO- WCQ-AL-001
2. DIE NO. 77773
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 | |  EIGHER VE COMMERCIAL VEHICLES LTD. | |
| | EFFECTIVE CASE DEPTH | | AL | IS 733-1983 | | |
| TOLERANCES UNLESS SPECIFIED | HARDNESS | SURF | SCALE |  | DESCRIPTION WHEEL HUMP AL EXTRUSION PART No./DRG. No. IU452523 | |
| | | CORE | 1:1 | | | |
| | FINISH | SURFACE ROUGHNESS | DRN | AT | | |
| | | | CHD | PD | | |
| | | | APPD | NVP | | |
| SHT. No. 1 of 2 | | | | |  | SIZE A4 |

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

FILE NAME : NEW

TRANSPORT

DIE NO :- 77773

Note :-

- 1) All dime. are in mm
- 2) Twist & Bend :- 1.70 mm/ Mtr
- 3) Flatness :- 0.3 Concave or convex
- 4) Angularly tolerance :- ±1.5°
- 5) Critical dimensions :- * Marks

| | | | | | | | |
|-----------------|-------|------------|-------|-----------------------|-------------|-----------|----------|
| Container OD mm | Ø130 | Die OD- mm | Ø190 | Area- mm ² | 87.0 | Drawn By | |
| Die Plate- mm | 35 mm | Bolster No | | Perimeter- mm | 83.0 | Chkd By | |
| Backer- mm | 45 mm | Backer No. | 33381 | Weight/Mt.-Kg. | 0.200-0.260 | Date | 10.04.13 |
| Pocket Deep | 18 mm | Cavity No. | 2 nos | Alloy | 6063-T6 | App. Date | |
| | | Ext.Ratio | 76.25 | Unspecified Tol. | ±0.20 | Scale | |

JM INDUSTRIES
Ahmednagar

Party :- Eicher Motors Ltd. Ref :- Drg.no. IU319539
Title :- Wheel Hump at Extrusion

| | | | | | | |
|--|----------------------|-------------------|-------------------|----------|---|---------|
| 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 WHEEL HUMP AL EXTRUSION PART No./DRG. No. IU452523 | |
| | | CORE | DRN PG | | | |
| | FINISH | SURFACE ROUGHNESS | CHD PD | APPD NVP | | |
| SHT No. 2 of 2 | | | | | | SIZE A4 |