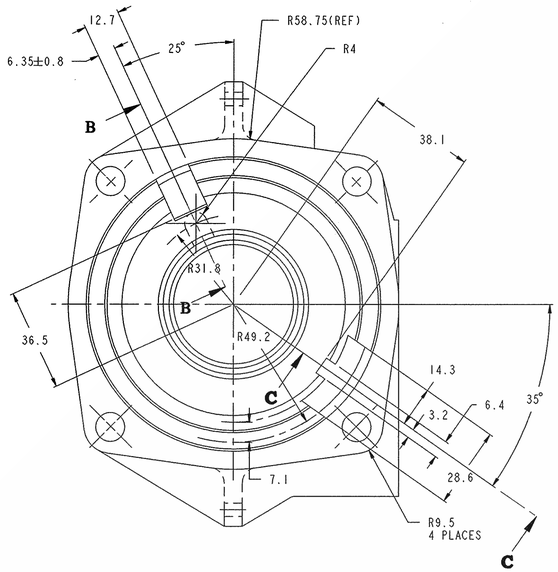
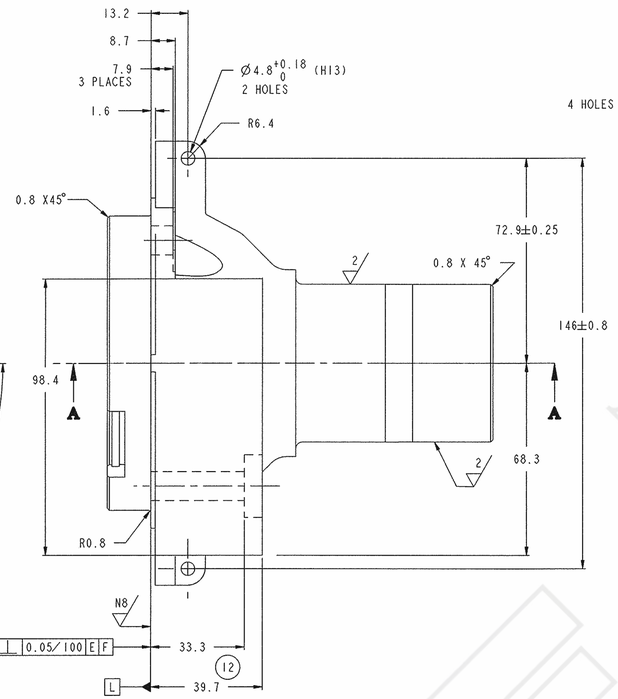
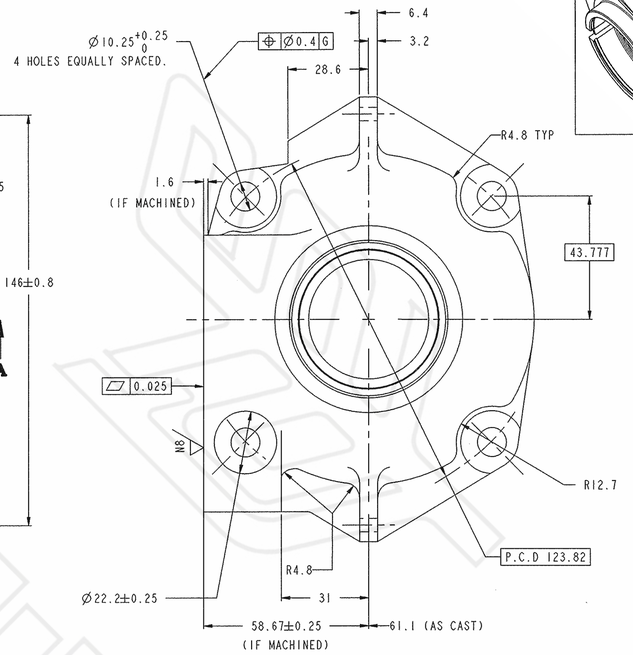
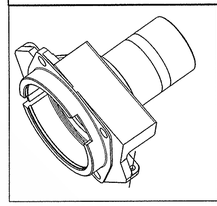
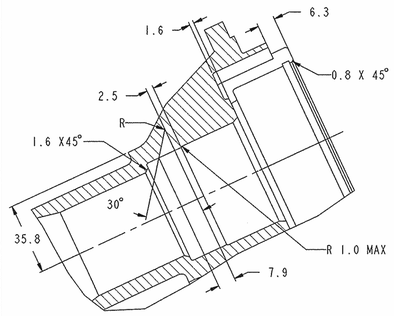
DO NOT SCALE	IF IN DOUBT ASK	REMOVE BURRS AND SHARP CORNERS	ALL DIMENSIONS ARE IN mm.



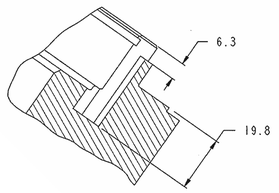




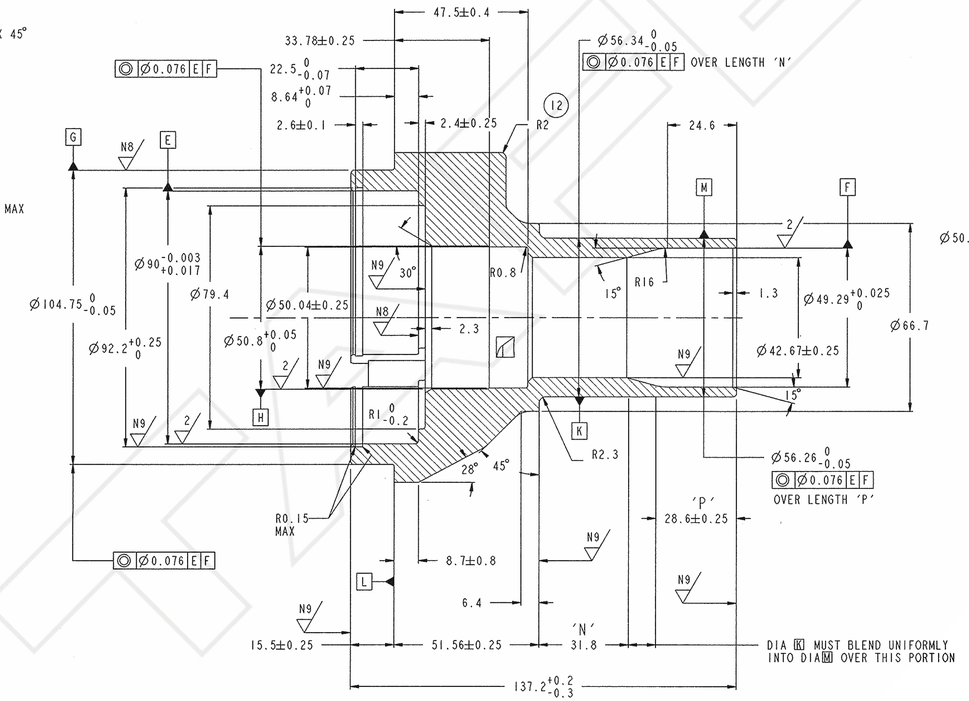




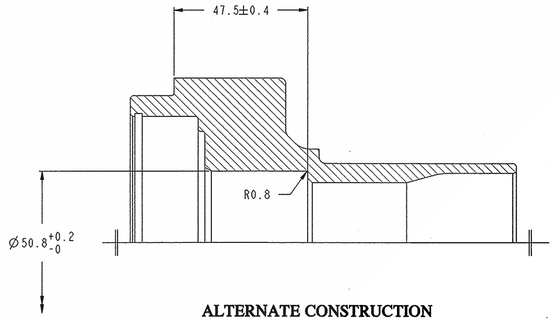
SECTION B-B



SECTION C-C



SECTION A-A



ALTERNATE CONSTRUCTION

NOTE:-

1. WITH PART MOUNTED ON DIA'S E&F, DIA'S G.H.K&M MUST BE CONCENTRIC WITH AXIS WITH IN 0.076 MM (.003") TIR ALSO SURFACE 'L' MUST BE SQUARE WITH THE AXIS WITHIN 0.05%
2. ALL RADII TO BE 1.6 UNLESS OTHERWISE SPECIFIED
3. ALL DRAFT ANGLES TO BE 3° MAX
4. CASTINGS MUST BE DENSE, HOMOGENEOUS AND FREE FROM BLOWHOLES AND GAS POROSITY
5. FINISH: A) COAT WITH ZINC CHROMATE PRIMER TO MF SPEC M1006 ON CASTING, B) APPLY DW 902 CASTROL RUST PREVENTIVE OIL ON MACHINED SURFACES.

Tractors and Farm Equipment Limited

THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF THE ABOVE NAMED COMPANY WITHOUT WHOSE PRIOR WRITTEN CONSENT IT MUST NOT BE COPIED, USED OR COMMUNICATED TO OTHERS WHOLLY OR IN PART.

DIMENSIONAL TOLERANCES FOR MACHINED/PUNCHED COMPONENTS (mm) UNLESS OTHERWISE SPECIFIED

ABOVE	1	6	30	120	315	1000	2000	4000
UP TO AND INCLUDING	6	30	120	315	1000	2000	4000	8000
TOLERANCE	±0.2	±0.5	±0.8	±1.2	±2	±3	±4	±5

TOLERANCES FOR RADII & CHAMFERS (mm), UNLESS OTHERWISE SPECIFIED

ABOVE	0.5	3	6	30	120	-	-	-
UP TO AND INCLUDING	3	6	30	120	315	-	-	-
TOLERANCE	±0.2	±1	±2	±4	±8	-	-	-

TOLERANCES FOR ANGULAR DIMENSIONS UNLESS OTHERWISE SPECIFIED ±0° 30'

Ra VALUE IN MICRONS

NXX	N5	N6	N7	N8	N9	N10	N11	N12	N13
VALUE	0.4	0.8	1.6	3.2	6.3	12.5	25	50	100

ISS. NO.	DATE	CHANGE RECORD	AUTHORITY	CKD
8	10-1-94	ALT MATL FOR TAFE		
		PRODN. ADDED	MC0102	KSR
9	8-5-96	MATL. BS 1452 GRADE		
		250 WAS ALT MATL FOR		
		TAFE PRODN.BS 1452,Gr17-		
		1961 HARDNESS 160-220		
		BHN DELETED		
		VIEW IN CIRCLE 'D' DELETED		
		ORG MODIFIED PICTORIALLY		
		NOTE DIA 'M' TO BE CONCENTRIC		
		WITH DIA 'G' WITHIN 0.005"		
		T.I.R.DELETED.DIM R0.8 ADDED		
		OWG NO SUFFIX WAS 'M01'	MC0462	KSR
10	09-01-04	DRG REVISED & REDRAWN		
		AS PER ISO STDS		
		UNSPECIFIED DIMENSIONAL		
		TOLERANCE VALUES FOR		
		MACHINING REVISED	D20397	
11	02-12-05	DIM 43.777 WAS 43.64±.25	D21149	
12	05.01.11	3.2mm RIDGE REMOVED		
		PART NO WAS 1860876M02		
		DIM 39.7 WAS 42.9		
		RADIUS 2 ADDED	ECR 102603	YS
13	17.11.11	DRG RELEASED FOR PRODUCTION	ECN 102603	

Tractors and Farm Equipment Limited
Chennai - 600 011

DRN.	MF.DRG	DATE	FEB 69	REDRN.		DATE	17.11.11
CKD.	MF.DRG	DATE	20.02.69	RECKD.		DATE	17.11.11
APPD.	MF.DRG	DATE	07.03.69	REAPPD.		DATE	22.11.11

MATERIAL: BS:1452-GRADE 250 (0.3% P MAX)

HEAT TREATMENT	---	SIMILAR PART NO
		1860876M02
PART NAME: RETAINER MAIN DRIVE SHAFT		SCALE 1:1
DRG.NO. 1612C08101		SHEET 1 OF 1
		ISSUE 13

FORM NO : R & D / 01 066

MASTER PRINT