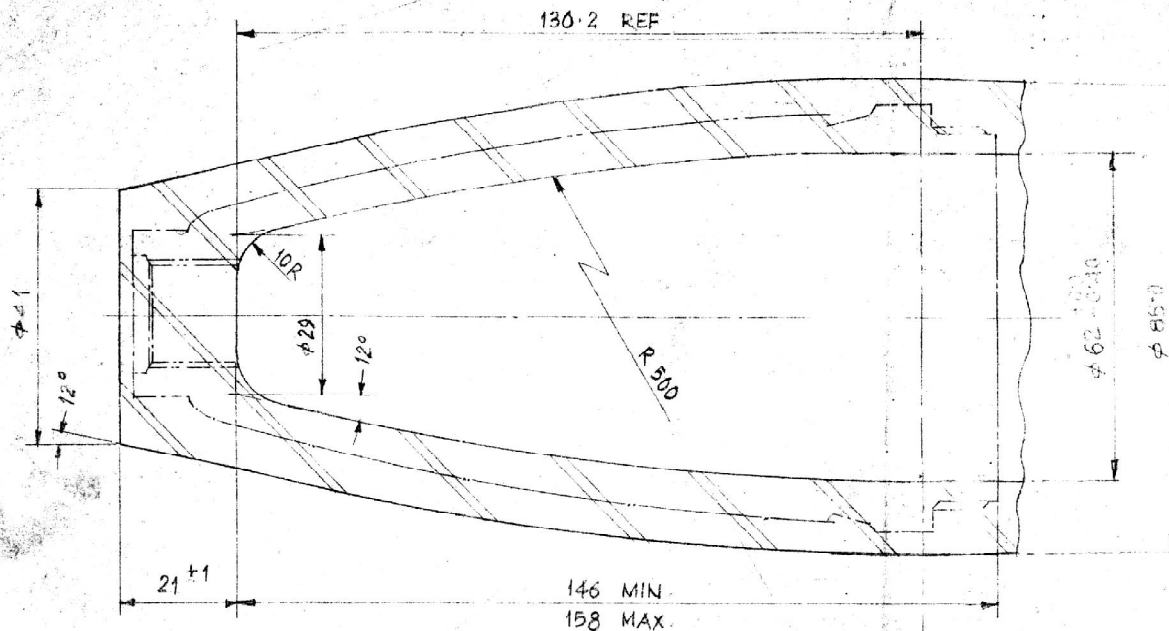


4 TO 13 MARKED ON



NOTE:

1. TOTAL INDICATOR READING BETWEEN INSIDE & OUTSIDE DIA. = 3 mm MAX.
2. The test piece representing the hardened and tempered Rear Part Forging, shall conform to the Mechanical Properties shown below:

Tensile Strength (Rm) = 835 - 1030 MPa
 0.2% Proof Stress = 500 MPa minimum
 Elongation Percentage(A) = 8 minimum (L_e = 5.65√S_e)
 Hardness = 302 - 248 HB

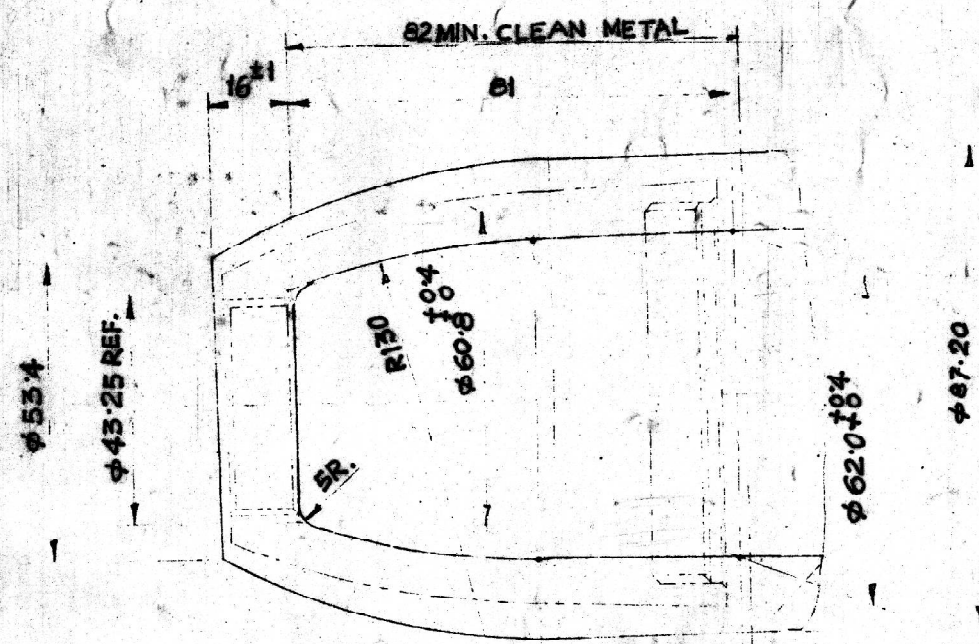
REV.	DATE	DESCRIPTION	SIGN.	REV.	DATE	DESCRIPTION	SIGN.
				253/83	26.5.84	DRG. RETRACED. MECHANICAL PROPERTIES INTRODUCED. MATERIAL OF COMPT. CHANGED, REF. DCC1 33537-A, dt. 11.1.84	DGM/SF
				268/77	4.11.77	TOTAL INDICATOR READING BETWEEN I/D & O/D = 3mm MAX ADDED	Sd/- AM/SF
				79/73	4.6.73	DIMNS φ 43.15, φ 89 & 22 IS AMENDED TO φ 41, φ 85 & 21 RESPECTIVELY, 158 IS DELETED 146 & 158 ADDED DIMNS. 15.8 DELETED	Sd/- DMP-1
				R1	13.9.72	NOMENCLATURE OF COMPT. AMENDED AS PER STORE DRG. DC.1. NO 80201-A DATED 20.12.71	Sd/- VC DO
276/04	13-09-04	WM/SFL NO 2958/81mm SF/DT. 26.8.04 AND SPENC. NO C&A(C) 2305(L) DC NO 35789 A DT. 10 JULY 2003 IN MECHANICAL PROPERTIES 0.2% PROOF STRESS = 500 MPa (MIN) WAS YIELD STRESS (R _e) = 550 MPa (MIN) RSPLY.	WM/SF				

I OF A

DIMENSIONS ARE IN mm
 THIRD ANGLE PROJECTION
 SCALE - 1:1
 1984
 DRAWN: S. P. BISWAS 12.6.69
 TRACED: H.S. 16.5.84
 CHECKED: S.C.C. 24.5.84
 F.D.O.
 DGM/SF

MATERIAL: JSS 9510-1AUG'82 TO CODE NO 5S/F44
 NOMENCLATURE:
FORGED BODY
 SCHEDULE NO.
 STORE - BOMB 61 mm MORTAR
 EMPTY BODY

APPVD I OF A
 ORDNANCE FACTORY
 AMBAJHARI
 DRAWING NO.
F-10'D
 SHEET NO. - 1
 NO. OF SHEETS - 1
 OPERATION NO. -
 COMPT. -



1. TOTAL INDICATOR READING BETWEEN INSIDE & OUTSIDE DIA. = 3 mm MAX.

2. FORGING TO ACHIEVE THE FOLLOWING MECHANICAL PROPERTIES IN AS FORGED CONDITION.

TENSILE STRENGTH (Rm) = 590 TO 885 MPa
 0.2% PROOF STRESS = 310 MPa (Min)

36.15
 34

REV.	DATE	DESCRIPTION	SIGN.
275/04	13-09-04	MECHANICAL PROPERTIES INTRODUCED. REF WM/SF L NO 2008/04. DT 25-8-04. REF. NO. CHA (A) 22008/04. DT. 10 JULY 2003. TENSILE STRENGTH (Rm) 590 TO 885 MPa 0.2% PROOF STRESS = 310 MPa (MIN) REPLY.	
G	09/00/04	Ø 67.20 WAS Ø 67.25	
F	7-01-04	CLEAN METAL MIN 82 WAS 93.3 L 108 H 123 DELETED	
E	17-8-02	NOTE NO 2.10 MECHANICAL PROPERTIES OF TEST PIECE OMITTED REF: CI (M) LETTER NO-0019/294/MQA 2 DT. 09 MAY 05	

53/84	26-5-84	DRG. RETRACED MECHANICAL PROPERTIES INTRODUCED. MATERIAL & PROPERTY CHANGED. REF. NO. 3387/A, dt. 11-11-84	DGM/SF
267/77	4-11-77	TOTAL INDICATOR READING BETWEEN INSIDE & OUTSIDE DIA. = 3mm MAX. ADDED	sd/- RM/SF
76/73	4-6-73	DIM. 17 IS AMENDED TO 16.198. DIM. 1108 & 1123 & 93 ADDED	sd/- DMP-1
R1	13-9-92	NOMENCLATURE OF COMPONENT AMENDED AS PER STORE DRG D.C.I. NO: BCCOP DATED 20-12-91	sd/- 1/3 DO

sd/-
 APPVD. I OF A

JSS 9510-1 AUG 82
 TO CODE NO. 15/F44

FORGED BODY

F-9G

S.P. BISWAS 12.6.63
 plc 14.5.64

DGM/SF

26/6/84

SOME 31mm MORTAR
 C-EMPTY BODY

