



NOTE :

- 1) PARTING OF BILLETS ARE TO BE GOVERNED BY THE WEIGHT AND NOT BY LENGTH. LENGTH AS MENTIONED IS FOR GUIDANCE ONLY.
- 2) 25-30mm WITH "BROWN" COLOUR BAND IS TO BE PAINTED THROUGHOUT THE LENGTH AND PARTED FACE OF EACH PARTED BILLET ON ONE SIDE.
- 3) HEAT/CAST NO. ALSO TO BE PAINTED WITH SAME COLOUR ON ANY PARTED FACE OF EACH BILLET.
- 4) ENDS OF EACH PARTED BILLET ARE TO BE SAW CUT & DEBURRED. (PLUSMA/GAS CUT IS NOT ALLOWED.)
- 5) PACKING/PALLETISATION OF PARTED BILLETS SHOULD BE SECURED BY STEEL STRAP TO FACILITATE EASY LOADING/UNLOADING. PACKING IS TO BE DONE HEAT/CAST WISE WITH STEEL TAG MENTIONING STEEL GRADE, HEAT NO, QUANTITY AND FIRM NAME.
- 6) OTHER PARAMETERS ARE TO BE GOVERNED BY THE O.F. AJ. SPECN. NO. F-347 (LATEST ISSUE) ~~EXCEPT POINT NO. 7.5, 8.1, 8.2, 8.4, 8.5, 8.7 & 8.6~~

WEIGHT = 41.5 ± 0.5 kg

REV.	DATE	DESCRIPTION	SIGN.	APPVD.	DGM/SF	DATE	MACHINE :	STORE :
52/2014 D	15-3-14	OBLIQUITY 2±1 WAS 1.0 mm MAX.	[Signature]	WM/SF				
267/13 C	27-12-13	EXCEPT POINT NO ARE DELETED FROM COLUMN NO 6	[Signature]	WM/SF				
562/06 B	27-12-06	NOTE 6, ADDED "EXCEPT POINT NO. - - - - -"	[Signature]	WM/SF				
514/06 A	25-11-06	TOL. ON DIMNS. AMENDED, OBLIQUITY 1.0 WAS 1.5 mm, NOTE NO 5 ADDED, NOTE NO 1, 2, 3, 4 AMENDED, NOTE NUMBERS ADJUSTED ACCORDINGLY.	[Signature]	WM/SF				
AMENDMENTS								
					DGM/SF	29-7-99		
					DGM/CC(SHELL)	29-7-99		

DIMENSIONS ARE IN mm			MATERIAL : JSS 9510-1, GRADE SS/B26		ORDNANCE FACTORY AMBAJHARI
THIRD ANGLE PROJECTION			NOMENCLATURE :		
SCALE : 1 : 2			PARTED BILLET		DRG. NO : F-456 D
1999	NAME	DATE			SHEET NO :
DRAWN	[Signature]				NO. OF SHEETS : 1
TRACED					OPERATION NO : 1
CHECKED	[Signature]	29-07-99			COMPT. : FORGED BODY F-262
JWM/CDO	[Signature]	29.7.			
APPVD.	DGM/SF	29-7-99	MACHINE :		
	DGM/CC(SHELL)	29-7-99	STORE : 130mm HE		