

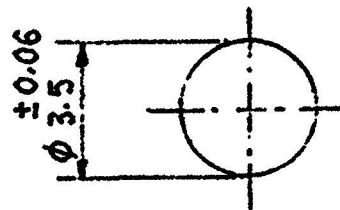
DRG. CONVENTIONS CONFORM TO IS : 696

ON PART

DIMS. ARE IN mm



DC 36037-A.



ACTUAL SIZE

**NOTES :-**

- 1) THE DIMNS OF BALLS BEFORE PLATING SHALL BE H = 3.51 & L = 3.45 mm
- 2) HARDENED & TEMPERED : HARDNESS 55 TO 65 HRC
- 3) BALLS SHALL BE ELECTROPLATED WITH NICKEL TO SPEC. DTD - 905  
OR  
ELECTROPLATED WITH CADMIUM TO SPEC. DTD 904 OR IS: 1572 CLASS cd. 12 FOLLOWED BY CHROMATE PASSIVATION TO SPEC. DEF. 130 OR IS: 1340. THE BALLS MUST BE SMOOTH & ANTIFRICTION.
- 4) BALLS SHOULD BE DEMAGNETISED.
- 5) SURFACE ROUGHNESS SHOULD BE Ra = 0.200

**ALTERNATIVE MATERIAL:-**

CHROME ALLOY STEEL TO AISI-52100

INDIGENOUS EQUIVALENT MATERIAL :-

GRADE 104 Cr 6 TO IS : 4398-94 REAFFIRMED 1998

**TECHNICAL DETAILS OF STEEL BALL B 3.5-200 AS PER SPEC. GOST-3732-81**

- a) NOMINAL DIA - 3.5 mm
- b) DEVIATION OF MEAN DIA -  $\pm 60 \mu$
- c) DEVIATION IN SPHERICAL SHAPE -  $5 \mu$  Max.
- d) DIFFERENCE IN DIA SIZE WITHIN A BATCH -  $10 \mu$  Max.
- e) SURFACE FINISH - Ra -  $0.2 \mu$  Max.  
Rz -  $0.6 \mu$  Max.
- f) BALLS SHALL BE HEAT TREATED HRC - 62-65
- g) MATERIAL - BALL BEARING STEEL AS PER GOST 801-78 & GOST 4727-67
- h) BALL SHALL BE FREE FROM CRACKS, CORROSION STAINS & POLISHING DEFECTS WHICH MAY LOOK LIKE STAINS OF SECONDARY ANNEALING & TEMPERING.
- i) BALL SHALL BE FREE FROM INDENTS, IMPRESSIONS & MARKINGS, WHICH COULD BE DETECTED BY A NAKED EYE OF NORMAL EYESIGHT UNDER THE ILLUMINATION OF 300 AT A DISTANCE OF 0.5 m, AS WELL AS TRACES OF DECARBURISATION DETECTED BY COLD PICKLING OR A FLAW DETECTOR.
- j) BALLS SHALL RECEIVE RUST PREVENTIVE TREATMENT.
- k) BALL SHALL BE PACKED SO AS TO PROTECT THEM AGAINST MOISTURE & CORROSIVE AGENT.
- l) WEIGHT OF 1000 BALLS - 0.176 kg.
- m) BREAKING LOAD NOT LESS THAN 630 kgf.

R. No.	DATE	AUTHORITY	REVISION	ZONE	AHSP SIG.	D.O.
	05-01-2011	DGQA S.O. Sec. I Chap 10 para 40	Drg. scan, clean & edit without change 8. m/c replaced in supersession of existing dilapidated copy of same No.			
	08-11-10	DC 37271-A	INDIGENOUS EQUIVALENT MATL. UPDATED.			
	1-2-06	DC 37040-A	INDIGENOUS EQUIVALENT MATL. ADDED			
	20-11-95	DC 36037-A	DRG. SEALED PROVISIONALLY.			
DRG. SEALED :- 20-11-95 (PROV)						

DRN :- Shivan	CHD :- Vign	TRD :-	COMP :-
APPD.	OKC D.O.	SCALE :- 5:1	EST. MASS :-
		GAUGE SCHED :-	DATE :- 5-9-95
MATERIAL :- AS ABOVE			
PROTECTIVE FINISH :- AS ABOVE			

ASSY. DRG.
DESIGNER'S REF. CQA(A)/AMN/2970
PART No.
D.S. CAT. No.
AHSP :- CQA (A), KIRKEE

**BALL B-3.5-200 FOR FUZE A670M/30 mm BMPT II**