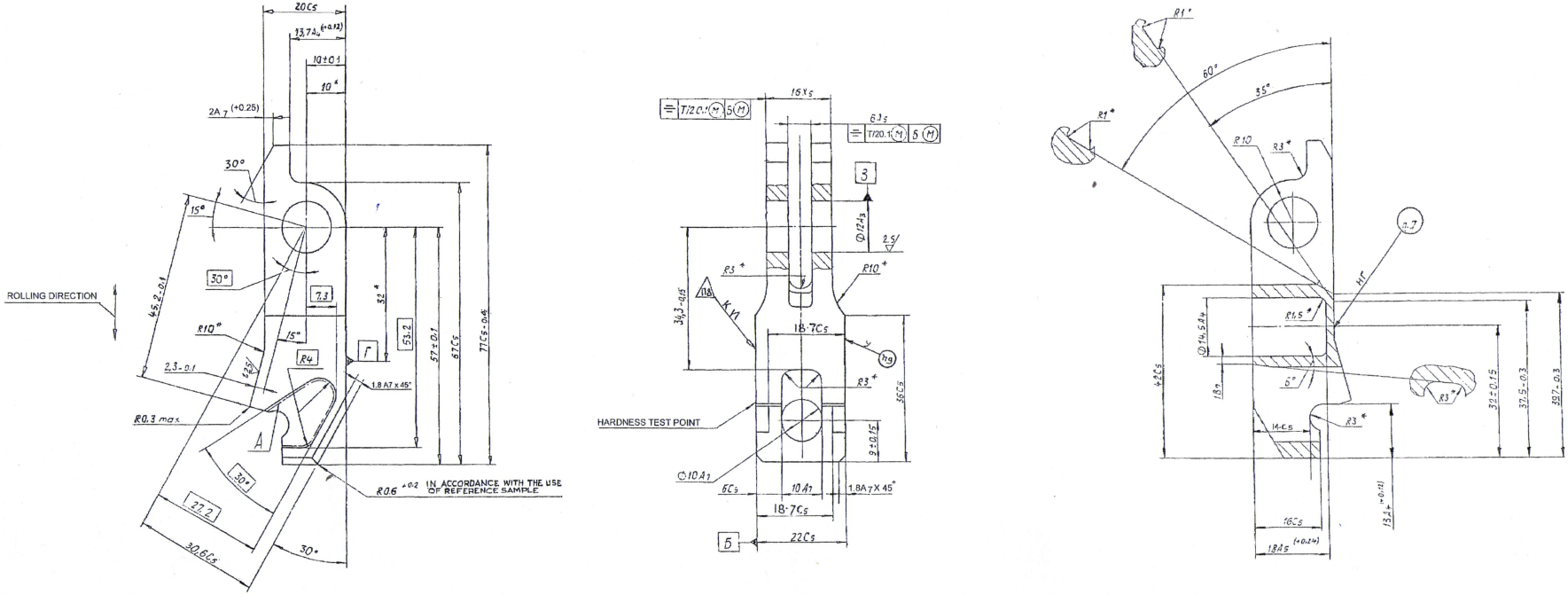
DS CAT No
1005-560073

AMENDMENT NOTICE No.
2A42 - 1130 T - 88 - dtd 18-3-88
(P -57 / 2869)

Rz20



INDIGS MATL : -
BS : 970 Pt 1 - 1983, GRADE 826 M 31, IN ' Z ' CONDITION
OR
IS: 5517 - 93, DESIGN 31 Ni 10 Cr 3 Mo 6, LRS 63 mm
(TENSILE STRENGTH 1550 MPa)
A SEPARATE TEST SAMPLE IS TO BE HEAT TREATED AND TESTED IN ' Z ' CONDITION

1. HRC3 43.5 - 51.5
2. * ENSURE SIZES BY TOOLS
3. INNER CORNERS WITH R ≈ 0.4 mm
4. BLUNT SHARP EDGES TO R≈0.6 mm
5. TOLERANCE ALONG CONTOUR - A IN RELATION TO SURFACES B AND Γ IS 0.15 mm
6. COATING : ACCELERATED ELECTROLESS PHOSPHATING WITH CHROMATE TREATMENT / IMPREGNATION WITH 5 Φ -4, ГОСТ 12172 - 74, ONE COAT
7. MARK WITH TYPE ПО -3, ГОСТ 2930 -62
8. STAMP
9. STAMP THE SERIAL NUMBER OF A COMPONENT WITH PRINT ПО -3 GOST 2930 - 62
10. LOCAL INCREASE OF TOLERANCE ALONG THE CONTOUR A BY 0.03 mm ALONG THE CONTOUR A OVER THE TOTAL LENGTH NOT MORE THAN 10 mm AFTER HEAT TREATMENT IS PERMISSIBLE

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE 21/9/23
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI -620 016.

DATE	AUTHORITY	ZONE	AMENDMENTS	SIG AHSP	SIG DO
18-3-08	19118-W		D.S.CAT.No. ADDED & NOMEN AMENDED.		
17-8-06			SCANNED & PRINTED WITHOUT CHANGE		

PREV DC Nos:- 16407-W, 16657-W, 17220-W, 17755-W, 18150-W, 18174-W, 18225-W, 18291-W, 18412-W, 18614-W & 18845-W DT 13-1-04

DRG SEALED:-18174-W DT 22-9-95

DO CQA(W)

DRAWN:- | CHD:- | ASSY DRG:-
SCANNED:- PKA | CHD:- P. R. Vaghi | DATE:-
C/DMAN | DO | AHSP FOR CQA(W) | SCALE:- 2 : 1 | ESTD mass:- 0.1
MATERIAL - 30 X H2M D A OCT 3 - 98 - 80
PROTECTIVE FINISH:-

SEAR
सीअर

CQA(W), JABALPUR

DESIGN No.

PART No. 2A42.05.029

DS CAT No. 1005-560073