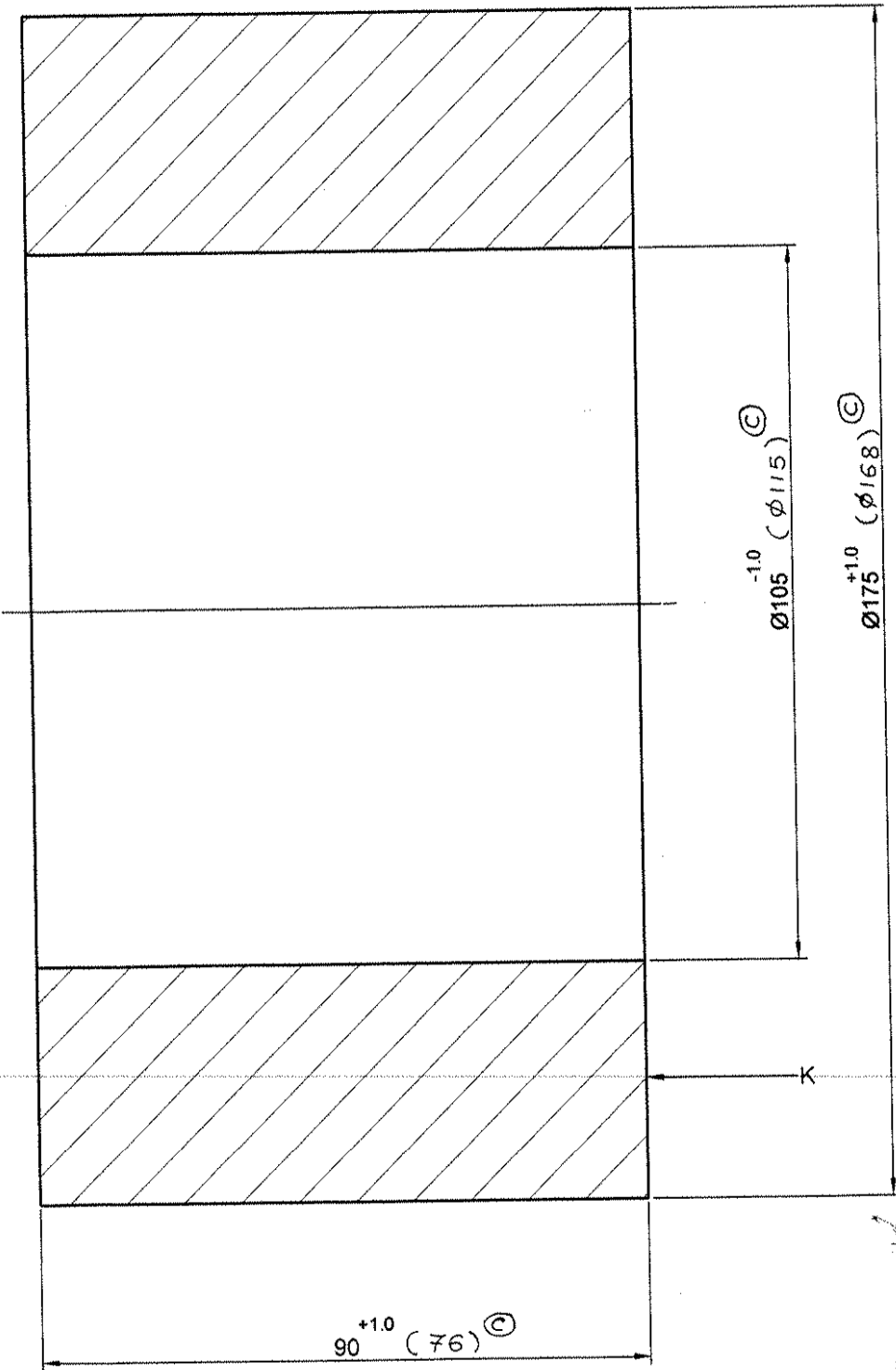


CHEMICAL COMPOSITION & MECHAICAL PROPERTY

| GRADE | Cu % | Al % | Fe % | Mn % | Po Max | Si Max | Sn Max | As Max | Ni Max | Zinc | Lead Mix | TOTAL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | PERCENTAGE ELONGATION% | 0.2% PROOF STRESS Min | HARDNESS BHN |
|------------------------------------|-----------|---------|----------|---------|--------|--------|--------|--------|--------|------|----------|-------|---|------------------------|-----------------------|--------------|
| LTS23A6ZH-3MTS2TS GOST-17711-80 | 64.0-68.0 | 4.0-7.0 | 2.0-4.0 | 1.5-3.0 | 0.7 | 0.3 | 0.7 | 0.1 | 1.0 | | | 1.8 | 72 (705 MPa) | 7 | - | |
| HTB-3 BS:1400 | 55.0 | 3.0-6.0 | 1.5-3.25 | 1.5-4.0 | - | 0.10 | 0.20 | - | 1.0 | Rema | 0.20 | 0.20 | 740-930 N/mm ² | 13-21 | 400-500 | 150-230 |



VETTED
2 NOV 2007
+ eel
JWM/STO-CELL

~~VETTED~~
03 JAN 2006
JWM/QC

SAMPLE (10 NOS) TO BE APPROVED BEFORE BULK SUPPLY.
HARDNESS OF 100% CASTINGS FROM ONE MELTING SHOULD BE CHECKED.
CHECKING OF HARDNESS IS 100% HARDNESS:170 HB.
CASTING SHOULD BE FREE FROM CASTING DEFECTS SUCH AS FLAWS, CRACKS, THROUGH, CAVATIES, THROUGH SHRINKAGW. POROSITY/ BLOW HOLES.
TECHNICAL REQUIREMENTS AS PER CASTING GROUP II OST-3-4227-79

METAL CHARGE

- 1). FOR WHOLE FOR 1 PART COUNTOUR OF FINAL PART.
- 2). CASTING IN METAL MOULD ACCORDING TO INSTRUCTION.

CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM - E -310-1999 - LEVEL-I NOTE: "RADIOGRAPHY TESTS IS MEANT FOR TRADE SUPPLIES ONLY"
MARK IN DIRECTION OF ARROW 'K'
NO:-MELTING
NO:-PART NOTE:- DIMENTIONS IN BRACKET ARE OF MACHINIG DIMNS.

INDEX OF ARTICLE MATERIAL

- @ ALT-MATL: CENTRIFUGAL CAST BRASS BS:1400 HTB-3
- ⇒ MATERIAL:CASTING BRASS GOST-17711-80 JL423A6K3M42L

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

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| | |
|---|--------------------|
| मूलमाप व अन्वयोजन NOMINAL SIZE & FIT | विचलन DEVIATION |
|---|--------------------|

| | | | | | | | |
|---|----------------------|---|--------------------|---------------------------------------|----------------------|---|----------------|
| WORM WHEEL | | | | | | Wt.: -11.22 Kg | |
| संख्या NO.OFF | विवरण DESCRIPTION | पुर्जा क्र. PART NO. | पदार्थ MATERIAL | मानक STANDARD | परिमाण DIMENSIONS | अभ्यक्ति REMARKS | |
| सामान्य सहिष्णुता GENERAL TOLERANCE | ⓐ | MACHINIG DIMNS & NOTE ADDED- 28108106 | ⓑ | EQUIVALENT MATERIAL ADDED REF.LETTER | | 1/12/04 | |
| रेखिक परिमाण LINEAR DIMENSION | ⓐ | MATL ADDED AS PER LETTER NO. CQA(AVA)/417/MATL/T/90 DT.16.9.04. APPROVED ON 27.9.06 | ⓑ | CQA(AVA)/417/MATL/T/90 DATED:16/09/04 | | MECH. PROPERTY & CHEM.COMPOSITION | |
| 0-6 | ±0.1 | ⓐ) T.72 ADDED ON. | ⓑ) | ADDED ON DT-29-9-05 | | ARTICLE 2A46M ADDED AS PER RECORDS FOR DISCUSSION DURING MONTHLY INTERACTION MEETING HELDON. 27.2.06 ADDED ON 20.3.06 | |
| 6-30 | ±0.2 | ⓐ) 17.2.2010 | ⓑ) | | | | |
| 30-120 | ±0.3 | ⓐ) NOTE ADDED AS PER LETTER NO. MPF/PRD/ERT/2011 DT.14.6.2011 APPROVED ON 12.7.11 | ⓑ) | | | | |
| 120-315 | ±0.5 | | | | | | |
| 315-1000 | ±0.8 | | | | | | |
| 1000-2000 | ±1.2 | | | | | | |
| कोणिक परिमाण ANGULAR DIMENSION | संख्या NO.OFF | संबंधित पुर्जाका आरेखण क्र. DRG NO. OF ASSOCIATED PART | सूचक INDEX | संशोधन ALTERATION | 2004 | | दिनांक DATE |
| 1-10 | ±1° | | | | | | नाम NAME |
| 10-50 | ±30' | | | | | | |
| 50-100 | ±20' | | | | | | |
| >100 | ±10' | | | | | | |
| मापक 'म्यू एम' में VALUE IN 'μm' | | | | | | | |
| - | >25 | | | | | | |
| ▽ | 8-25 | | | | | | |
| ▽▽ | 1.6-8 | | | | | | |
| ▽▽▽ | 0.025-1.6 | | | | | | |
| ▽▽▽▽ | <0.025 | | | | | | |
| WORM WHEEL CENTRIFUGAL CASTING HAND ELEVATING MECHANISM FOR T-90 | | | | ARTICLE 2A46M | | T-72 | |
| मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ | | | | कार्यालय OFFICE | | D.O. | |
| MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH | | | | D.O. | | DRAWING NO. 2A46-21-21-2 | |
| मापमान SCALE | | आरेखित DRAWN | | जाँचा CHECKED | | अनुमोदित APPROVED | |
| NTS | | 3.1.06 | | 04.01 | | [Signature] | |
| द्वारा बदला REPLACED BY | | हेतु बदला REPLACED FOR | | आरेखण क्र. 2A46-21-21-2 | | | |