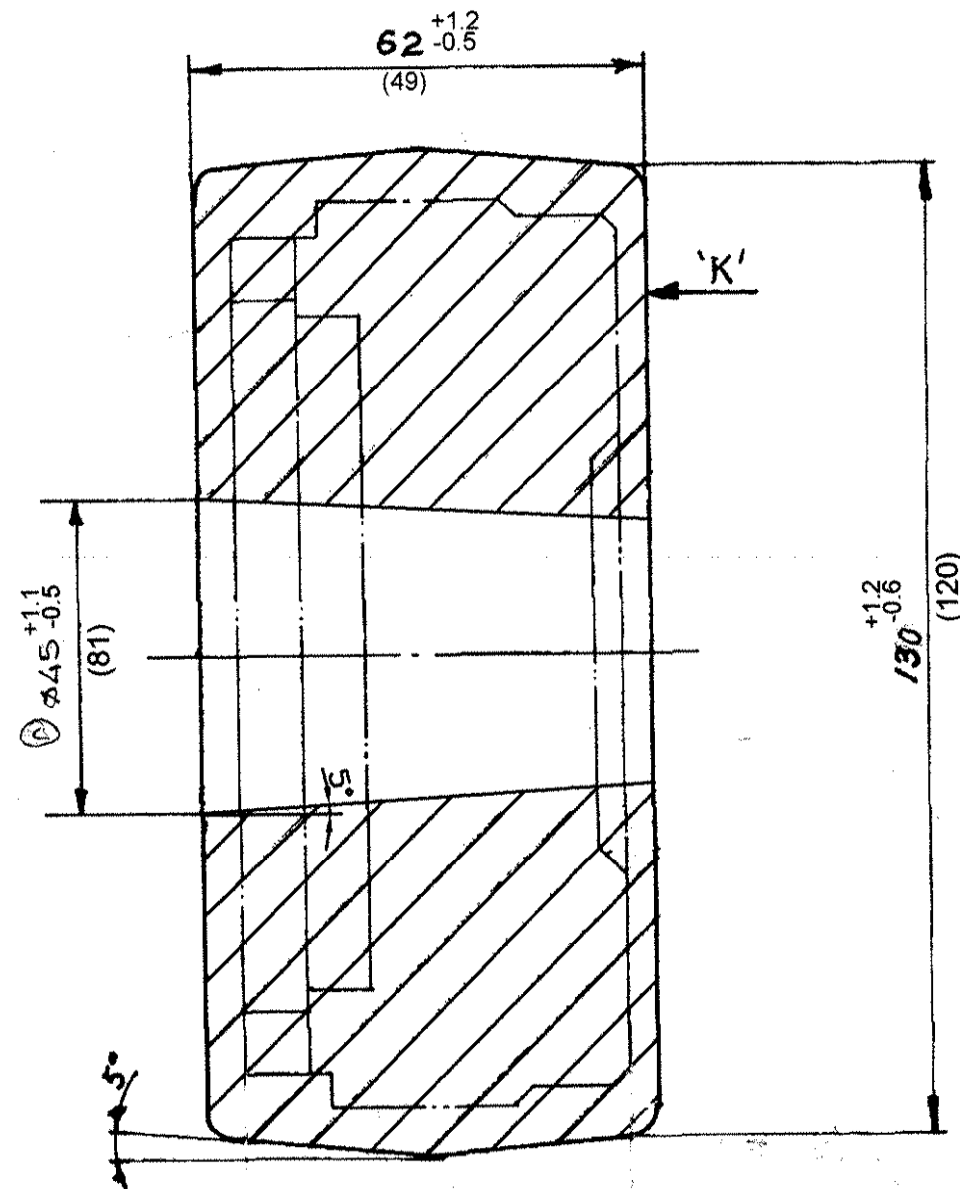


NOTE:-

1. FORGING RIDGES TO BE TRIMMED CLEAN AND SMOOTH FINISH ALL OVER
2. SAMPLE(10Nos)TO BE APPROVED BEFORE BULK SUPPLY.
3. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION,PIPING,FLANKES ETC.
4. UNSPECIFIED DRAFT ANGLE INNER AND OUTER -7°
5. UNSPECIFIED RADII CORNER - 3R.
6. FORGING TO BE SHOT BLASTED AND SUPPLIED AFTER APPYLYING RED OXIDE PRIMER TO JSS:3-47-13 BY BRUSHING OR SPRAYING.
7. CHAIN DOTTED LINE SHOWN FINISH COMPNENT.

FORGING TOLERANCE AS PER IS:3469-1964

FORGING WEIGHT	COMPLEXITY	INTRAC OF MATL	FORGING GRADE
5.34 kg APPX	S1	M1	NORMAL
KIND OF DIM	TOL	KIND OF DIM	TOL
DIA	+1.5 -0.7	RESIDUAL FLASH	+1.2
THICKNESS	+1.3 -0.7	TRIMMED FLAT	-1.2
STRAIGHTNESS	1.0	DRAFT ANGLE	+2° -1°
MIS MATCH	1.0	RADII	+50% -25%
FOR INTERNAL DIMS. REVERS + AND - SIGN			
LENGTH/WIDTH	+1.7 -0.8		

CHEMICAL COMPOSITION & MECHANICAL PROPERTY

GRADE	C	Si	Mn	Cr Max.	Ni Max.	S Max.	P Max.	Cu Max.	YIELD STRENGTH Kgf/mm ²	ULTIMATE TENSILE STRENGTH Kgf/mm ²	PERCENTAGE ELONGATION%	REDUCTION OF AREA %	IMPACT STRENGTH Kgf.m/Cm ²
12XH3A GOST 4543-71	0.09-0.16	0.17-0.37	0.30-0.60	0.60-0.90	2.75-3.15	-	-	-	70	95	11	55	9
655M13 BS:970 PT-I-83	0.10-0.16	-	0.35-0.60	0.70-1.00	3.00-3.75	-	-	-	-	1000 N/mm ²	9	-	30 ft.lb

MICRO STRUCTURE
FINE FERRITE AND PEARLITE
GRAIN SIZE:-ASTM5 OR FINER
HEAT TREATMENT:-

@ALT. MATL. STEEL 655M13
BS:970 PT-I - 83

NORMALISED
HARDNESS:-250 TO 270 BHN

INCLUSION RATING :-3ABCD THIN SERIES OR FINER AS PER IS:4163-1967

STEEL SHOULD NOT HAVE ANY LARGER INCLUSION OR CONGLOMERATION OF INCLUSIONS

REMARK:-

DIMENSIONS OF THE PART AFTER ROUGHING
ARE INDICATION BY THIN LINES
INDICATION OF ARROW 'K'
ORDER NO :- PARTNO:-
MELTING NO:-

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

संख्या NO. OFF		विवरण DESCRIPTION		पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS
सामान्य सहिष्णुता GENERAL TOLERANCE				MECH. PROPERTY & CHEM. COMPOSITION				
रेखिक परिमाण LINEAR DIMENSION				ADDED ON DT-29-9-05				
0-6 ±0.1				ARTICLE 2A46M ADDED AS PER RECORD FOR DISCUSSION DURING MONTHLY INTERACTION MEETING HELD ON 27-2-06				
6-30 ±0.2				ADDED ON 25-3-06				
30-120 ±0.3								
120-315 ±0.5				EQUIVALENT MATERIAL ADDED REF. LETTER				
315-1000 ±0.8				CQA (AVA) / 417 / MATL / T-90 DATED : 16/09/04				
1000-2000 ±1.2								
कोणिक परिमाण ANGULAR DIMENSION		संख्या NO. OFF	संबंधित पुर्जा का आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	दिनांक DATE	नाम NAME	
1-10 ±1°								
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								
मूलमाप व अन्वयोजन NOMINAL SIZE & FIT		विचलन DEVIATION		HALF COUPLING FORGING FOR HALF COUPLING HAND ELEVATING MECHANISM FOR T-72/T-90 ARTICLE 2A46M				
				मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				
				कार्यालय OFFICE WMT				
				मापमान SCALE आरेखित DRAWN जौचा CHECKED अनुमोदित APPROVED NTS				
				द्वारा बदला REPLACED BY हेतु बदला REPLACED FOR आरेखण क्र. DRAWING NO. 2A46.21-20-3				

T-72 AF-3