DC NO. 37282-A	DT. 25-5-2011	MATERIAL AMENDED.

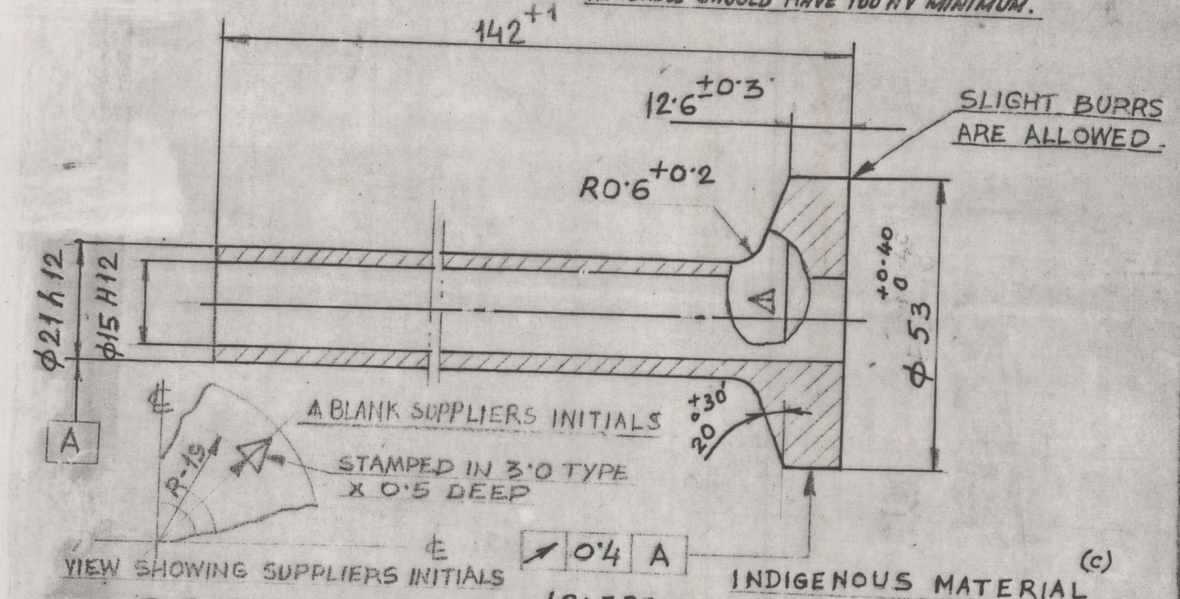
Material : ALUMINUM W3-4212-06
Al - Si1MgMn
Material Requirements :
Chemical Composition -

	Al %	Cr %	Cu %	Fe %	Mg %	Mn %	Si %	Ti %	Zn %	Other %	
										Of each	Total
Nom	97.4	-	-	-	0.9	0.7	1	-	-	-	-
Min	-	-	-	-	0.6	0.4	0.7	-	-	-	-
Max		0.25	0.10	0.50	1.2	1.0	1.3	0.10	0.20	0.05	0.15

AFTER THE SOLUTION TREATMENT / ARTIFICIAL AGING
THE DISTANCE TUBE SHOULD HAVE HARDNESS 85-120 HV

DC NO. 35509-A, DT. 21.5.93.

(b) AFTER THE SOLUTION TREATMENT / ARTIFICIAL AGING THE TUBE HARDNESS SHOULD HAVE 100 HV MINIMUM.



(c) INDIGENOUS MATERIAL
I.S: 733:1983 GRADE 64430 IN WP CONDITION.
MATERIAL INSPECTION OF FINISHED COMPONENT
AS PER IS: 1285: 1975 GRADE 64430 IN WP

(d) NOTE: NO HIGH GRAIN SIZE AREAS ARE PERMITTED IN FINISHED PRODUCT AFTER MACHINING.

FOR FORGING
* MATL:- SIS AL 4212 - 06

STRENGTH *

CONDITION	TENSILE STRENGTH δ0.2 kP/mm² min	δB kp/mm²	δ5% min.	HARDNESS HV.
ARTIFICIALLY AGED.	25.0	min 30.0	8	min Ca 100.

COMPOSITION *

	Mg%	Si%	Mn%	GRAIN REFINING ADDITION %	IMPURITIES Cu%	Fe%	Zn%	Cr%
MIN.	0.6	0.7	0.4					
MAX.	1.1	1.4	1.0	0.2	0.10	0.5	0.2	0.20

SURFACE ROGHNESS: 4

BASED ON FFV DRG.NO:
F-1334-255220 B

(a) FOR EXTRUSION
⊕ IS-1285 HV 30 (WP) O.?
⊕ BS 1474 HE-30 (TF)

⊕ INDIGENOUS ALTERNATIVE MATERIAL TO IS: 1285 HV 30 (WP) B.S. 1474 HE 30 (TF) FOR SMALL QTY/PILOT BATCH PRODUCTION CERTIFIED CORRECT AS PER C.I. (A) KIRKEE LETTER NO. QA.11060-SEC DT. 14 FEB 80.
FOR S.I.A. COSSIPORE
DT. 25.9.80 S.N. Ghosh SIG. Sd-

ITEM NO.	NO. OFT	MATERIAL	DESCRIPTION
1.	1.	AL. ALLOY. (AS STATED)	DISTANCE TUBE.

LIST OF PARTS

COMPT.: 84 mm TPT	STORE. DRG. NO (d)
DISTANCE TUBE	F-1301-047281D

BLANK FOR DISTANCE TUBE
P/PROJ-II/TPT/195/1

GSF REF. No. F 1947 | 1/1 SHT.

NOTE ADDED. VIDE D.C.I. NO. 36160-A dt 31.8.96 MATL AMENDED	DIMNS. ARE IN mm.	
VIDE DC.NO 35509-A DT 21.5.93 HARDNESS ADDED	SCHEDULE NO.	
VIDE. DC-35366-A (a) DT. 22.8.92. MATL. AMENDED VIDE DC 34989A DT. 21.12.90	SCALE 1/1.	PROJECTION THIRD ANGLE
	DRAWN BY	
	TRACED BY	14.6.88
	CHECKED BY	7/7/88
	APPROVED BY	
	APPROVED BY	