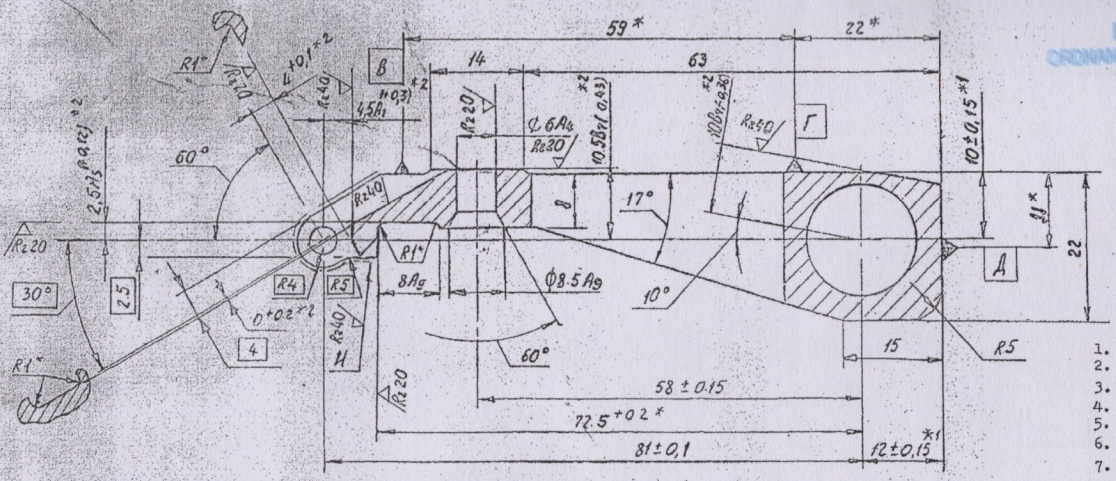
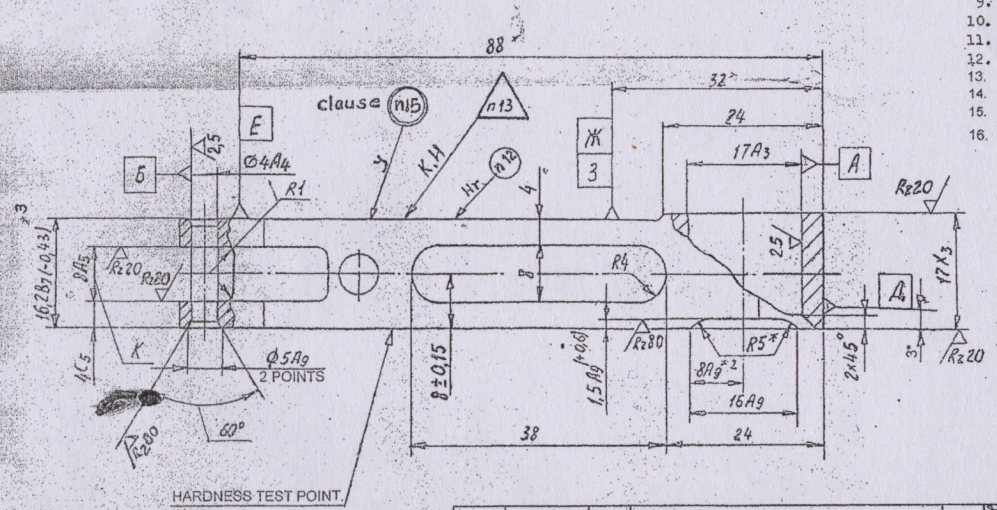
PART No.

2A42.05.089

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THE DATE 30/01/14
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI -620 016.

Rz80 ▽(√)





1. Unspecified casting radii are approx. 1.5 mm
2. HRC_3 41.5 to 51.5.
3. Additionally check impact strength in accordance with Section 3, ГОСТ 977-75.
4. Inner corners with R ≈ 1 mm.
5. Blunt sharp edges to R ≈ 0.6 mm.
6. *size to be ensured by tools.
7. *1 Sizes given in relation to surfaces В, Г, Д, Е, Ж, З,
8. *2 Sizes given in relation to surfaces А and Б.
9. Tolerance along contour И in relation to surfaces А and Б Ⓜ is 0.2 mm.
10. when making slot K, knit mark is permissible within allowance limits
11. Coating: accelerated electroless phosphating with chromate treatment
12. Mark with type ПО-5, ГОСТ 2930-62.
13. Stamp.
14. *3 DIMENSION IS GIVEN WITH RESPECT TO SURFACES E, Ж, 3
15. STAMP THE SERIAL NUMBER OF A COMPONENT WITH PRINT ПО - 3. GOST 2930-62.
16. (a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-192. ACCEPTANCE LEVEL (i) GAS HOLE-3, (ii) FOREIGN MATERIAL-3, (iii) SHRINKAGES (ALL TYPE) -2, (iv) DEFECTS LIKE CRACKS, HOT TEARS, COLD-SHUTS WILL NOT BE ACCEPTABLE
    NOTE :- THE ABOVE AMENDMENTS ARE PROVISIONAL TILL THE MANUFACTURING PROCESS IS ESTABLISHED AND FUNCTIONALITY OF THE COMPONENT MET
    (b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST
    (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CQA (MET) ICHAPUR.
    OR
    THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO CQA (MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.
    (d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOULD AND MATERIAL HAS BEEN APPROVED BY CQA (MET) ICHAPUR.
    (e) 5% OF THE CASTING SELECTED AT RANDOM FROM THE BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA (MET) ICHAPUR.

C-5089

INDIGS MATL:-
IS:10343-1999 Grade 19Q WITH C% 0.45 - 0.5

MATERIAL :- CASTING II - ОСТ 3 - 4365 - 79
2Э ХГС2МФЛУ ТУАДИ-116-78

DATE	AUTHORITY	ZONE	AMENDMENTS	SIG AHSP	SIG DO
14-9-15	19446-W		INDIGS MATL AMENDED		
08-12-14	19382-W		INDIGS MATL. AMENDED.		
16-4-13	19322-W		NOTE 16(a) AMENDED		
4-9-06			SCANNED & PRINTED WITHOUT CHANGE		

PREV DC Nos:- 16407-W, 16657-W, 16975-W, 18100-W 18149-W, 18174-W, 18383-W & 18845-W Dt 13-01-04

DRG SEALED.- 18174-W Dt 22-09-95

DO CQA(W)

DRAWN:- | CHD :- | ASSY DRG :-
SCANNED:- SKB. | CHD :- | DATE :-
C/D MAN | DO | AHSP | FOR CQA(W) | SCALE.- 2 : 1 | ESTD mass - 0 09

MATERIAL - AS ABOVE

PROTECTIVE FINISH -

CATCH BODY
कैच बॉडी

CQA(W), JABALPUR

DESIGN No

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DS CAT No