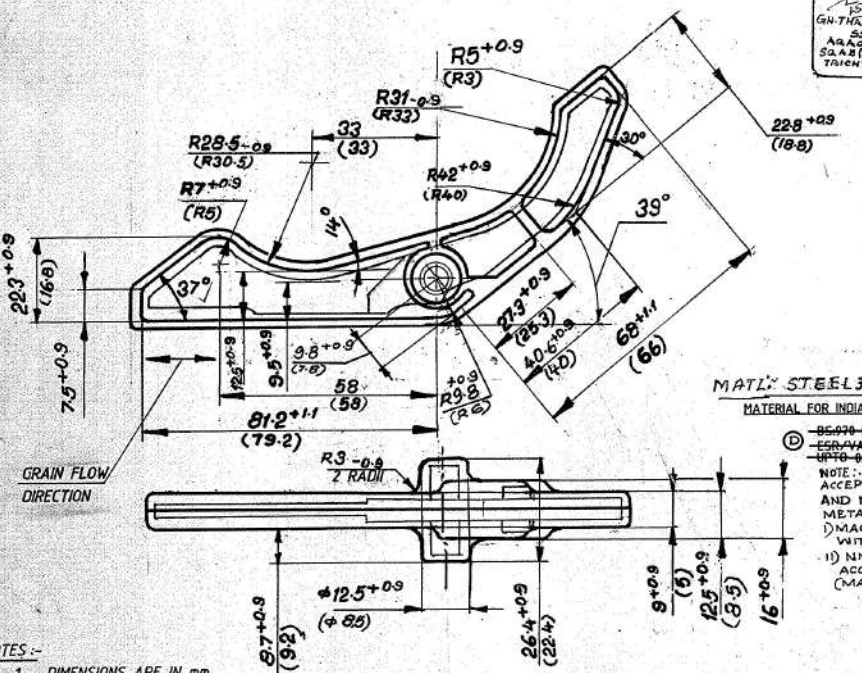
VETTED FOR MATERIAL ONLY

15/3/99
GN. THARAKARAM
SSO-I
AQAO
SQAB(A)
TRICHY-16

Principal Scientific Officer,
Quality Assurance Officer
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Armrs)
Tiruchirapalli - 620 016.

CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE.....
17.11.2020
Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY




STRESSED COMPONENT

MATL: STEEL 35XH2MØA-W TY 3-928-76

MATERIAL FOR INDIA:- IS: 5517-1993 DESIGN. 40 Ni10 Cr3 Mo6

(D) ~~BS.970 PT.1 1983 Gr.826 M-40 STEEL SHOULD BE MADE BY ESR/VAR ROUTE 'S' & 'P' CONTENT TO BE RESTRICTED UPTO 0.01 % MAX. & 0.016% MAX. RESPECTIVELY.~~

NOTE:-
ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSIONS FOR STEEL.
I) MACRO ETCH TEST AS PER ASTME-381 WITH ACCEPTANCE STANDARD AS $C_2$, $R_2$, $S_2$.
II) NMIR TEST AS PER IS: 4163-1982 WITH ACCEPTANCE STANDARD 3 THIN (MAX) & 1 THICK (MAX) IN ALL 'A', B, C & D SERIES.

CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES OF MATERIAL

| STEEL 35XH2MØ A-W-a | |
|---|---|
| C | 0,32 - 0,37 |
| Si | 0.17 - 0.37 |
| Mn | 0.30 - 0.60 |
| Cr | 0.60 - 0.90 |
| Ni | 2.00 - 2.40 |
| Mo | 0.20 - 0.30 |
| TUNGSTEN | — |
| BORON | — |
| Al | — |
| Ti | — |
| V | 0.10 - 0.18 |
| P | 0.016 MAX. |
| S | 0.010 MAX. |
| Cu | 0.20 MAX. |
| HARDNESS | 269 BHN |
| TENSILE STRENGTH | 180Kgf/mm² |
| ELONGATION | 8% |
| REDUCTION IN AREA | 40% |
| IMPACT STRENGTH | 5KgfM/cm² |
| YIELD POINT | 150Kgf/mm² |

DRAWING PROVISIONAL

COMPONENT DRG: No. 2-64

EJECTOR SMALL ARM CARTRIDGE.

NOTES:-

1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION.
3. SCALE:- 1:1
4. FORGING OF GROUP III AS PER GOST 8479-70, HB 269 MAX.
5. DRAFT ANGLE 7°.
6. UN-SPECIFIED RADII 1.5R.
7. FLASH REMAINDER UP TO 0.5 mm.
8. WARPING UP TO 0.8 mm.
9. DIE SHIFTING UP TO 0.4 mm.
10. CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
11. STAMP PART NO, MELT NO. AND Q.C.D STAMP ON THE TAG.
12. 100% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
13. WEIGHT OF THE FORGING 0.178 Kgs.
14. MARK THE GRAIN FLOW IN THE CERTIFICATE.

HEAT-TREATMENT:-FORGINGS ARE NORMALIZED AND TEMPERED. FOR HEAT-TREATMENT SCHEDULE REFER DRAWING NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 4 SL.NO: 8.

DS.CAT NO. 1005007329

| | | |
|---|---|---|
| D | MATL.AMENDED AS PER DA.No. 27095-SA Dt.02.06.17 Amended Dt. 01.11.17 | |
| C | MATERIAL FOR INDIA & NOTE AMENDED DC.NO.24251-SA. Dt. 07-01-99 | S. Raji 13/3/99 |
| B | MATL. FOR INDIA ADDED | |
| | AMENTMENTS | SIG. & DATE |

| REDRAWN | CHECKED | APPROVED | I/C. D&DO | DIV. OFFICER | ORDNANCE FACTORY, TIRUCHIRAPALLI-16. | DRG. NO: 62 C 2464 200 D3 |
|---|---|---|---|---|---|---|
| 29-1-88 | | 3/88 | | | | |