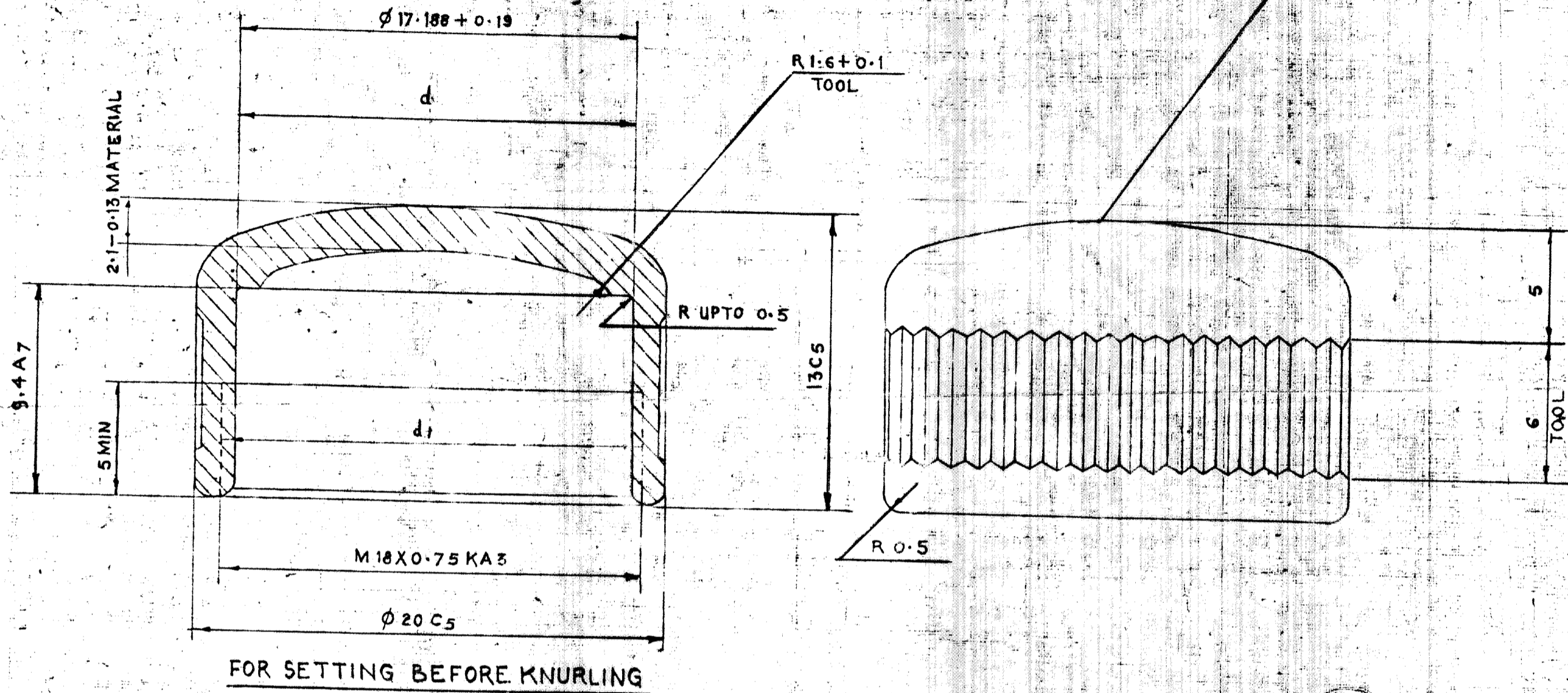


RADIUS OF SPHERE IS GOT BY STAMPING WITH THE FLA PUNCH WITH RADIUS



- 1) CROSSWISE INCLINED KNURLING AS PER OCT 26017.15 PERMITTED.
- 2) KNURLING ALL OVER PERMISSIBLE
- 3) ALTERNATIVE MATERIALS:-
 - a) STEEL 35 GOST 1050-60 OR
 - b) STEEL STRIP AS PER GOST 1388-47 THICKNESS 2 ± 0.13 GOST 8075-56, OR
 - c) THIN STRIP STEEL OF GROUP I-II MK 10-08 NC, 08KN GOST 914-56, THICKNESS 2 ± 0.13
- 4) PERMISSIBLE COAT M 3-06 OR 49 XP (ZINC PLATING AND CHR MATE PASSIVATION)
- 5) ON THE EXTERNAL SURFACE R1.6+0.1 (TOOL) SUPERFICIAL RIPPLES FORMED DURING STAMPING ARE PERMISSIBLE.
- 7) SOAKING TO BE DONE WITH OIL VARNISH № 32-A TYMKH 694-41 AFTER PHOSPHATING.
- 8) SCREWING IN OF THREADS GAUGE "NO 60" UP TO $3/2$ ROUND IS ALLOWED

PROTECTIVE TREATMENT :-

IN INDIA COMPONENTS WILL BE PHOSPHATED TO SPECN. № JSS-0465-01:1994 REV. NO.1 CLASS II STAINED BLACK AS PER PARA 13 (F) FOLLOWED BY COATING OF AMMUNITION PROTECTIVE COMPOSITION № 12 SPECN JSS 1-65-10 OR TO BE ZINC PLATED TO SPEN № DT D 903 FOLLOWED BY CHROMATE PASSIVATION TO SPECN № DEF 130.

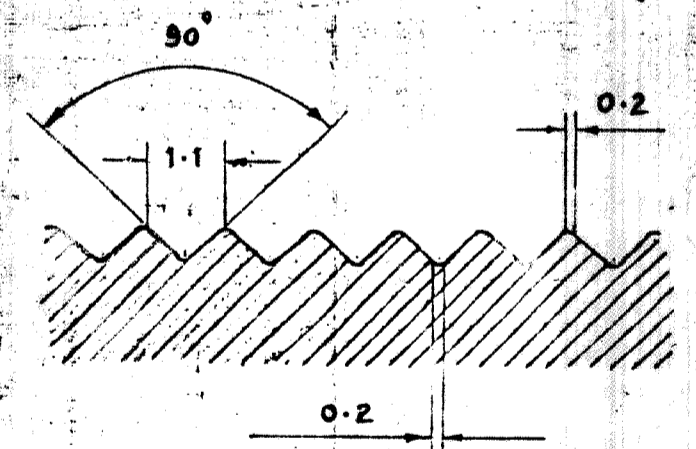
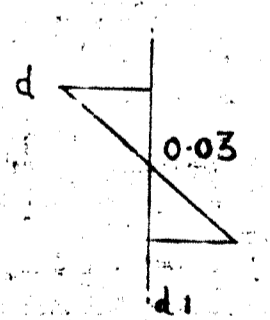
MATERIAL :-

STEEL TO SPECN. BS. 970 PT. 1:1972: 080 M 40 OR BS. 970 PT. 1:1972: 212 M 36 (BOTH IN NORMALISED CONDITION) OR BS. 1449 PT. 1B-1962 CR-2/FF OR CR-3/FE

MATERIAL :-

STEEL TO SPECN. BS: 970 PT-1: 1988, 080 M 40 (NORMALIZED) OR BS: 970 PT-III 1991, 080 M 40 (NORMALIZED) OR BS: 970 PT-1: 1983, 212 M 36 (NORMALIZED)

ECCENTRICITY



KNURLING DETAILS :-10:1

		D.S. CAT №		1390-000328	
		3-016919		53-B-055Y	
		SAFETY CAP		26	
		STEEL 35, GOST 1050-60		LETTER	
		STRIP OM - 21 GOST 503-41		MASS	
				SCALE	
				6	
				8.47	
				5.1	
DATE	AUTHORITY	REVISION	AHSP, D.C. SIGN	HEFU 130	CHD
					TRD.
					EDIP