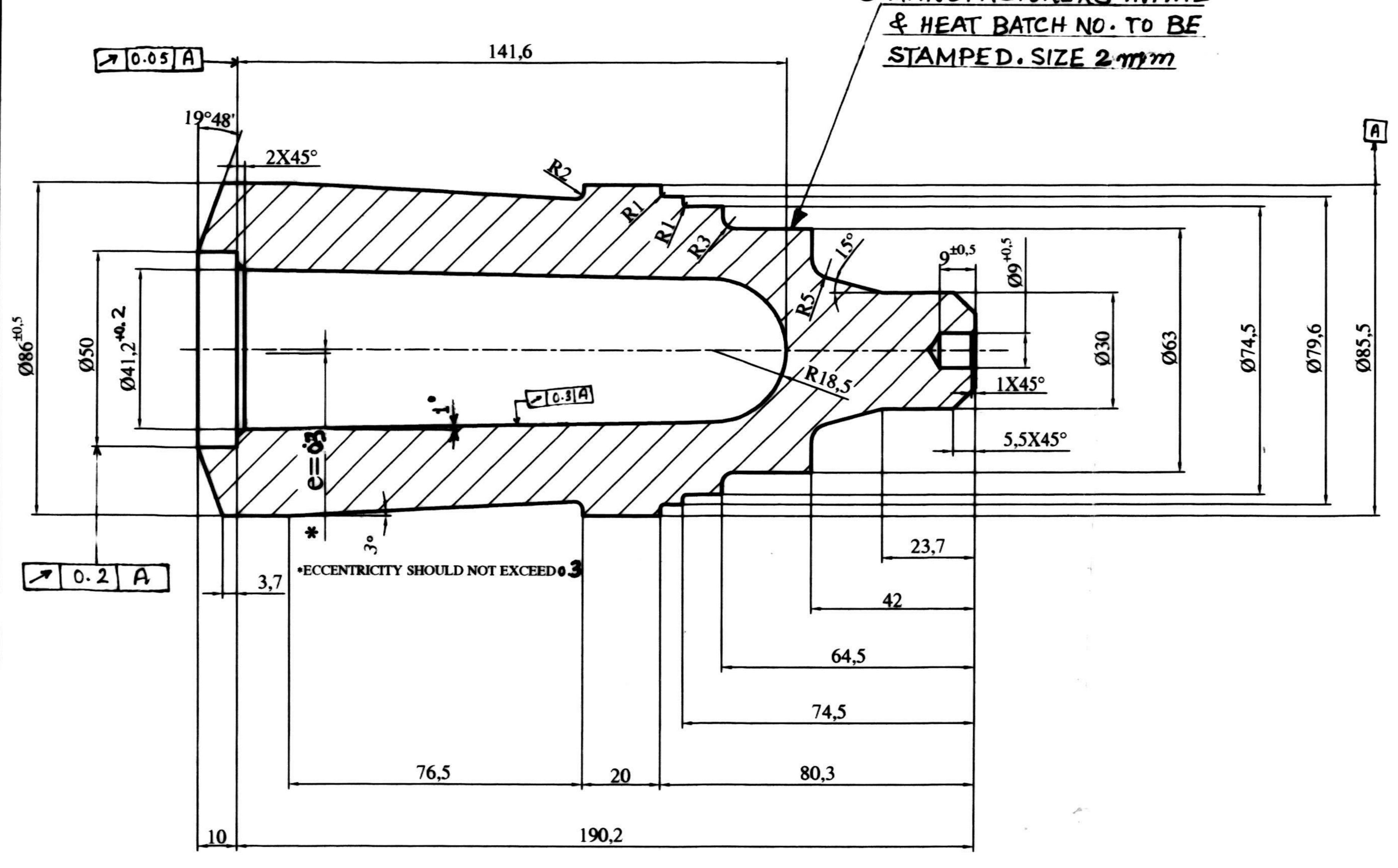
DRG NO. F-22773

TOLERANCE CHART										
SIZE	0-3	3-6	6-10	10-18	18-30	30-50	50-80	80-120	120-180	180-250
OF IT-14	0.25	0.30	0.36	0.43	0.52	0.62	0.75	0.87	1.00	1.15

ALL DIMNS. ARE IN mm

TOL. ON UNTOLERATED DIMNS ARE ± IT 14/2

(2) MANUFACTURER'S INITAL & HEAT BATCH NO. TO BE



MATERIAL:-

FORGING TO SPECN. IS:734-1991, Gr. 64430 IN 'WP' CONDITION HARDNESS:- 80-110 HB MASS: - 1700 gms (APPROX)

NOTE:-

- 1) THE FORGING STOCK OF AL-ALLOY BAR SHOULD BE INSPECTED FOR THE FOLLOWING
 - i) CHEMICAL COMPOSITION AS PER SPECIFICATION
- ii) SURFACE DEFECTS
- iii) INTERNAL SOUNDNESS BY ULTRASONIC TESTING (AS PER CQA/MET DIRECTIVE ISSUED VIDE CQA/AMN QA 11068/PROJ/CNC, DTD. 30.11.2002)
- iv) PERIPHERAL GRAIN GROWTH BY MACRO- EXAMINATION
- 2) FORGING BLANK SHOULD BE INSPECTED FOR THE FOLLOWING:
 - i) FORGING SHOULD BE FREE FROM CRACK, HEAVY DENTS AND DEEP SCRATCHES
 - ii) HARDNESS SHALL BE CHECKED ON 2.5% OF FORGING PER HEAT TREATMENT BATCH
 - iii) TWO SAMPLE FROM EACH HEAT TREATMENT BATCH HAVING HIGHEST AND LOWEST HARDNESS VALUE TO BE CHECKED FOR
 - a) MECHANICAL PROPERTIES AS PER SPECIFICATION
 - b) PERIPHERAL GRAIN GROWTH:- FORGING SHOULD BE FREE FROM PERIPHERAL GRAIN GROWTH.
 - 3) SURFACE FINISH W

Jt. GM/Re

APPROVED BY JWM/Fs

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APPROVED BY AWM/Sh

NO. NO. OFF DESCRIPTION MATERIAL OF PARTS LIST @ NOTE ABOED ANTISTRY I JUM COO F1301-047291G COMPT:-SCHEDULE NO :-PROJECTILE BODY D.A. No. DC. 86598-A 84 mm TPT ROUND Dt. 23/09/1999 SEMI MACHINED FORGED PROJECTILE **BODY FOR 84 MM TPT ROUND** TRACED BY : CHECKED BY : DRG. NO. F-2277 B On MORILO APPROVED BY : NO. OF SHTS.:-DESCRIPTION CONCURRED BY: DT.&SG. M/C: SHT. NO. :-SIGN. DATE : G. & S. FY. COSSIPORE. **AMENDMENTS**

FORGED

BLANK

01 AS ABOVE

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