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

UN CONTROLLED COPY

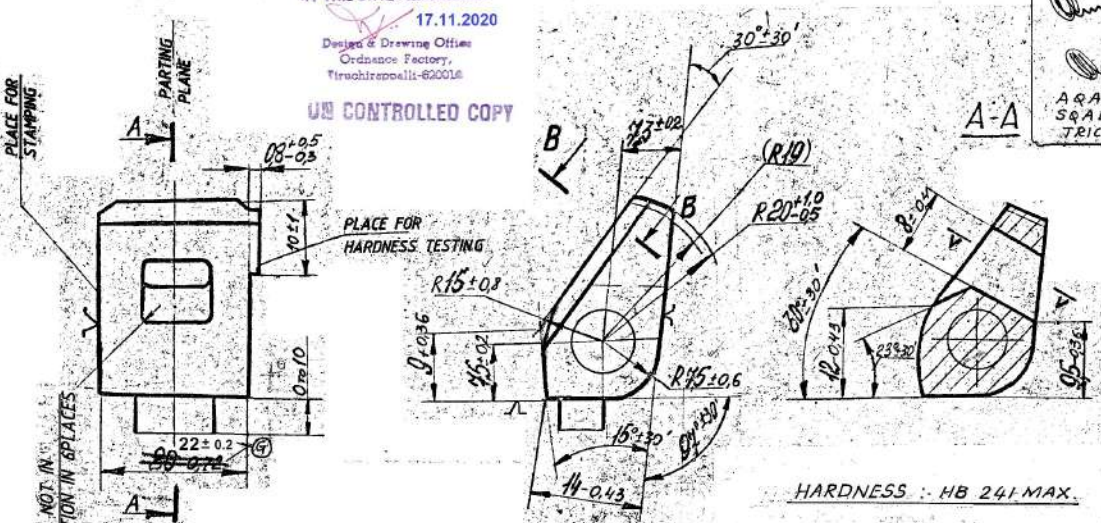
VETTED FOR MATERIAL ONLY

ARAD SQAE(A) TRICHY

Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Armts)
Tiruchirappalli - 620 016.

Details to be marked on the Tag

Sl.no. of Tag
Batch no.
No. of compts. in the Batch
Insp. mark of mould check
Insp. mark of Component



MATERIAL FOR INDIA:-
BS. 3146 PT.2 1974 TYPE CLA.-12 GRADE 'B'
OTHER TECHNICAL DETAILS
ARE AS PER COA (MET.) INSPECTION
INSTRUCTION NO. MQA-1/QA-1/12 DT. 5.5.94

HARDNESS :- HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5mm.
6. STAMP THE SL.NO. OF TAG ON WHICH THE DETAILS ARE MARKED.
7. SECTION V-V FOR MEASURING DEPTH OF DECARBURIZED LAYER.
8. DIMENSIONS IN ( ) ARE FOR REFERENCE ONLY.
9. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG.No. MBB2

MATERIAL FOR INDIA:- IS: 10343-1999 GRADE 16 Q
~~BS.3146 PT.1 :74 TYPE CLA. 12 GR. A CASTINGS~~.
RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS :- LEVEL : 3, SHRINKAGE (ALL TYPES) LEVEL - 2. ALSO REFER CRACMET) ICHAPUR INSPECTION INSTRUCTION NO MQA-1/QA-1/12 DT. 5.5.94 FOR OTHER DETAILS.

G	DA.No. 002/19 Dt. 18.7.19 Dimn. Amended		C	D.A. NO 4/95 D.12mm DT. 4.3.95	S.Rep. 4.3.95		
F	DA.No. 001/17 Dt. 01.03.17 MATL. AMENDED.						
E	DA.NO.12/98 D/12.7mm DT. 30.11.98 MATL. FOR INDIA AMENDED REF. DC NO. 24193-SA DT. 26.10.98	S.Rep. 30.11.98	B	MATL. FOR INDIA ADDED			
D	MATERIAL FOR INDIA AMENDED. 24097-SA DT. 5.5.98 DA NO. 8/98 D/12.7mm DT. 16.6.98	S.Rep. 16.6.98		AMENMENTS	SIG. & DATE		

DS. CAT NO. 5340011158				CATCH FRICTION COVER FEED
SHEETS : 1	1ST ANGLE PROJECTION	DRAWN	I/C PROJ.	CASTING DRG. 6P11-6-23
SHEET No : 1				
ALL DIMENSIONS ARE IN mm.	SCALE : 2:1	CHECKED	DIV. OFFICER	DRG. NO. 62C 6023 250 G3