



1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION.
3. SCALE :- 1:1
4. FORGING OF GROUP II AS PER GOST 8479-70, HB 217 MAX.
5. DRAFT ANGLE 7°
6. UN-SPECIFIED RADII 1.5mm.
7. REMAINDER FLASH UP TO 0.7 mm
8. WARPING UP TO 0.8mm
9. DIES SHIFTING UP TO 0.5mm
10. CONVENTIONAL CONTOUR AND DIMENSIONS IN BRACKET PERTAIN TO THE FINISHED PART
11. 5% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8470-70
12. WEIGHT OF THE FORGING 0.028 Kgs. 0.9 kg. 8.2 - ①

NOTE
 ACCEPTENCE STANDARDS FOR MACRO ETCH TEST & MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL
 1. MACRO ETCH TEST AS PER ASTM E-381 WITH ACCEPTENCE STANDARD AS C2, R2, S2
 2. NMIR TEST AS PER IS : 4163 - 82
STRESSED COMPONENT

MATERIAL FOR INDIA

- BS 970 PT. 1 : 1983 GR. 530 M-40 (BS 970 : 1955 EN-18)
- OR
- BS 970 PT. 1 : 1983 GR. 709 M-40 (BS 970: 1955 EN-19)
- OR
- BS 970 PT. 1 : 1983 GR. 708 M-40 (BS 970: 1955 EN-19 A)

①- DA NO. 001/05 Dt. 14.12.05

HEAT-TREATMENT:-FORGINGS ARE NORMALIZED AND TEMPERED.
FOR HEAT-TREATMENT SCHEDULE REFER DRAWING NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 7. SL.NO: 26.

MATERIAL:- STEEL 40X OST 3-98-80,
ALT.MATERIAL : STEEL 40 X GOST 4543-71
COMPONENT DRG. NO. 6P11-7-6
SAFETY LOCKING BOLT.

VETTED FOR MATERIAL ONLY

[Signature]
 Principal Scientific Officer,
 Quality Assurance Officer,
 For Senior Quality Assurance Officer,
 Senior Quality Assurance Estt. (Arms)
 Tiruchirapalli - 620 016.

DRAWING PROVISIONAL

DS.CAT NO. 1005007170

<i>Sodhi</i> 23/10/87	<i>[Signature]</i>	11.87	<i>[Signature]</i> 11.87	<i>[Signature]</i>	ORDNANCE FACTORY, TIRUCHIRAPALLI-16.	DRG. NO: 62 C 7006 200	C3 B3
REDRAWN	CHECKED	APPROVED	I/C, D & DO	DIV. OFFICER			

1 2 3 4 5 6 7 7.6 8