

HEAT-TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO:	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	FIXTURE	HARDNESS INSPN. %
UPPER LINK C 5115	30XPA	NORMALIZING HEATING	CHAMBER-ELECTRIC FURNACE OR PUSHER TYPE FURNACE	850-870	3 HOURS PUSHING INTERVAL 15 MINUTES	AIR	ON TRAY ON TRAY	3% ; OF FORGINGS FROM A BATCH; BUT NOT LESS THAN 3 PIECES.

DESIG.

⑤ 1. DRESSING OF PLACES FOR HARDNESS TEST. ⑤ ④
 2. HARDNESS TEST.
 VENTIL FOR MATERIAL ONLY
 AS PER LAST DC (1) No. 2017/10
 MRA-3/TS/BL/Dt 6/11-6-97
 INDIGENOUS MATERIAL: IS 4367-91, 25 Cy 13 Mo 6 'M' OR IS 5517-93
 25 Cy 13 Mo 6 'M' TEST SAMPLE SHALL BE HEAT TREATED AND
 TESTED TO LRS 63 mm
 AUTHORITY: CQA (METALS) ICHAPUR Lt. NO. MGA-3/TS/B/Dt 6/11-6-97

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

UN CONTROLLED COPY

M. V. JAGADISHAN
 Sr. Metallist Officer
 Sr. Quality Assurance Boss (Arms)
 Tiruchirappalli-620016

G3	DA.No. 007/16, Dt. 22.07.16 RUSSIAN MATL. AMENDED (PP) 22.7.16
F⑤	DANO. 048/97 Dt. 7-8-97
UPDATED	DA.No: 022/97 Dt. 23-3-97
E④	DANO. 058/96 Dt. 27-6-96
D③	QA.No. 030/95 Dt. 13-4-95
AMEND-MENTS	DESCRIPTIONS/DETAILS
	SIG. & DATE

⑤ INDIGENOUS MATERIAL: BS 970 Pt. 1-83/2d 817/M 40A (OR) IS 5517-93 DESIGN 40 N/6
 25.4 MQ/3. LRS 30/mm (TENSILE STRENGTH 1506 MPa Myn. (REF DC/0.18225-4/ Dt. 26-2-96)
 IN "Z" CONDITION

SHEET NO: 2	Sadhvi 27-06-97	A. SETHURAMAN	6/88					
SHEETS : 2	REDRAWN	CHECKED	APPROVED	I/C. PROJ.	WM/PROJ.	ORDNANCE FACTORY	DRG NO:	G3
						TIRUCHIRAPALLI-16	64 C 5115 200 F 3	