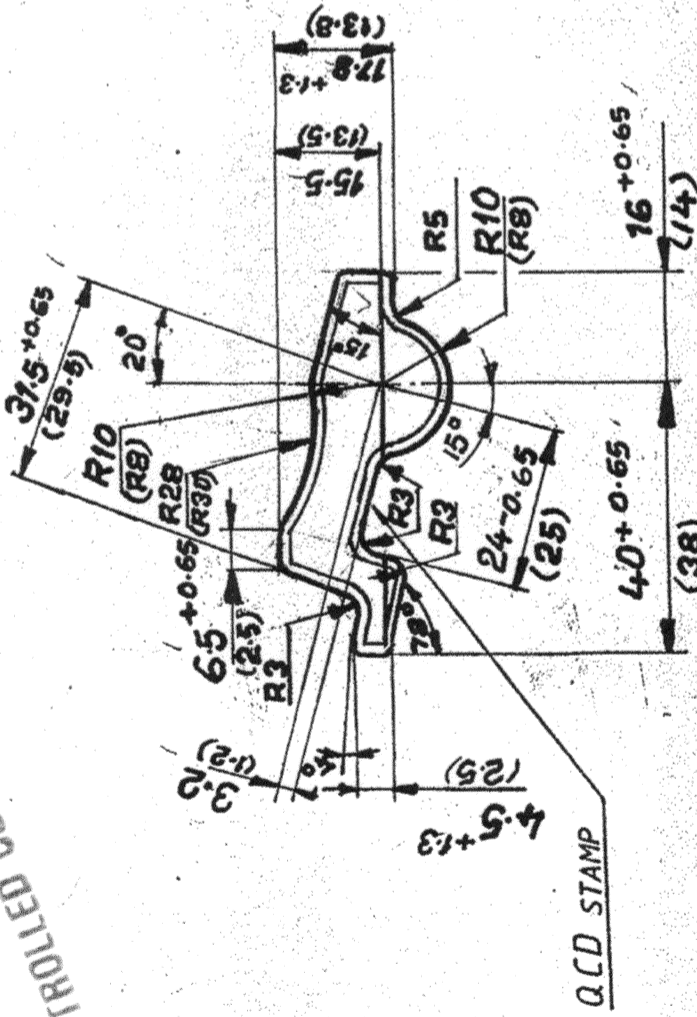
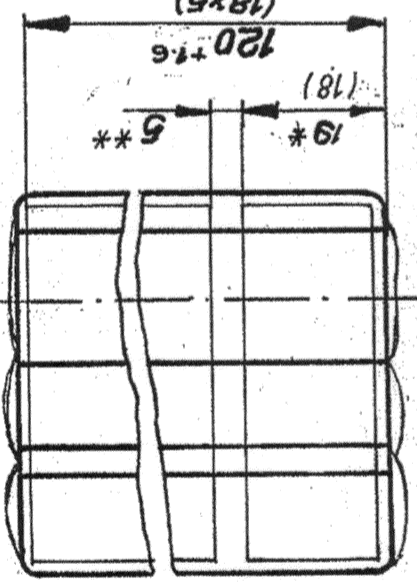


**CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES OF MATERIAL**

30XH2MΦA	
C	0.27 - 0.34
Si	0.17 - 0.37
Mn	0.30 - 0.60
Cr	0.60 - 0.90
Ni	2.00 - 2.40
Mo	0.20 - 0.30
V	0.10 - 0.18
S	0.025 MAX.
P	0.025 MAX.
Cu	0.20 MAX.
HARDNESS	HB269
ELONGATION	10%
REDUCTION IN AREA	40%
IMPACT STRENGTH	9 Kgf.M/cm <sup>2</sup>
TENSILE STRENGTH	90 Kgf/mm <sup>2</sup>
YIELD POINT	80Kgf/mm <sup>2</sup>

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

MATL. FOR INDIA :  
1993  
BS-970-PT-1-1983-GR-826-M-31 OR IS : 5517 - 78  
DESIG 31 Ni 10 Cr 3 Mo 6 WITH RESTRICTION OF 'S' & 'P' CONTENT UP TO 0.025 % MAX. FOR EACH  
STRESSED COMPONENT



**NOTES:-**

- DIMENSIONS ARE IN mm.
- FIRST ANGLE PROJECTION.
- SCALE :- 1:1
- FORGING OF GROUP II AS PER GOST 8479-70, HB 269 MAX.
- DRAFT ANGLE 7°
- UN-SPECIFIED RADII 2R
- FLASH REMAINDER UP TO 0.9 mm.
- WARPING UP TO 0.8 mm.
- DIE SHIFTING UP TO 0.6 mm.
- CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
- STAMP PART NO, MELT NO. AND Q.C.D STAMP ON THE TAG.
- 5% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
- WEIGHT OF THE FORGING 0.770 Kgs.
- FORGING TO BE DONE FOR 5 PARTS.
- \* DIMENSIONS FOR REFERENCE.
- \*\* DIMENSIONS FOR TOOLING.

**VETTED FOR MATERIAL ONLY**  
Principal Scientific Officer,  
Quality Assurance Officer,  
For Senior Quality Assurance Officers,  
Senior Quality Assurance Estt. (Airframe)  
Tiruchirappalli-620 016.

HEAT-TREATMENT:-FORGINGS ARE NORMALIZED AND TEMPERED.  
FOR HEAT-TREATMENT SCHEDULE REFER DRAWING  
NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 6 SL.NO: 21.

**MATERIAL:-**  
STEEL- 30XH2MΦA OST-3-98-90 ✓  
**ALT. MATERIAL:**  
STEEL 30 X H 2 M Φ A GOST 4543 - 71 ✓

COMPONENT DRG. NO. 6PII-7-3  
SEAR

DS. CAT NO. 1005007168

DRAWING PROVISIONAL

DA.No. 003/17 Dt. 16.06.17 Matl. Amended	11.8.17	ORDNANCE FACTORY,	DRG. NO.:
Redrawn	APPROVED	TIRUCHIRAPALLI-16	62 C 7003 200 B 3
CHECKED	DIV. OFFICER		

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE. 20/10/2016

Design & Drawing Office,  
Ordnance Factory,  
Tiruchirappalli-620016

UN CONTROLLED COPY