

⑥ MATERIAL :- STEEL 35X17Cr GOST 977-75
 TECHNICAL REQUIREMENTS FOR CASTINGS ARE AS PER
 TY 83-65-88. CHEMICAL COMPOSITION IS AS PER
 GOST 977-75
 MATERIAL FOR INDIA :- IS:10343-1999 Gr. 16Q
 BS:3146 Pt.1:74 TYPE CLASS 2 GR. A TO GR. A CASTINGS
 ⑦ RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE
 STANDARDS FOR GAS HOLE AND FOREIGN MATERIAL: LEVEL-3-
 SHRINKAGE [ALL TYPES] LEVEL-2.
 ALSO REFER CQA [MEV] ICHAPUR INSPECTION INSTRUCTION
 NO. MRA-1/QA-3/12. Dt. 5-5-94 FOR OTHER DETAILS

UN CONTROLLED COPY

Details to be marked on the Tag:-
 Sl.no. of the Tag
 Batch no.
 No. of comp. in the Batch
 Insp. mark of mould check

MATERIAL COMPOSITION

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE
 STEEL 35X17Cr GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED
 MECHANICAL PROPERTIES OF OEM OR IS:10343-1999 GRADE 16-Q.

b) MATERIAL COMPOSITION TO BE FOLLOWED IS AS UNDER :-

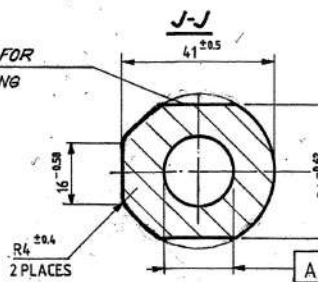
%C	%Mn	%Si	%Cr	%Ni	%Cu	%P	%S
0.30	1.00	0.60	0.60	0.30	0.30	0.040	0.040
0.40	1.30	0.80	0.90	max	max	max	max

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
 2. DRAFT ANGLE IS UPTO 1°.
 3. UNSPECIFIED CASTING RADII UPTO 1 mm.
 4. MISALIGNMENT ALONG PARTING PLANE UPTO 02 mm.
 5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2 mm.
 6. STAMP THE SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED STAMP INSPECTION MARK
 7. SECTION A-A FOR MEASURING DEPTH OF DECARBURISED LAYER.
 8. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS. DRG. NO: M 882
- HARDNESS HB. 241 MAX.

VETTED FOR MATERIAL ONLY
 26/04/17
 ASAO
 SQA/CA
 TRICHY.

DA NO. 001/20 AS PER DC No: 27193-5A, Dt. 08.04.19 amended on 22.02.20

PLACE FOR STAMPING



DA NO. 001/18 Dt. 25/11/19 GOST. MATL. ADDED REF: CQA M/BA/12-7/VI Dt. 24/12/19	DA No. 001/17 Dt. 03-17
DA NO. 12/08 Dt. 12-7-198 MATERIAL FOR INDIA AMENDED REF DC NO. 24191-5A Dt. 23-10-78	S. Rep. 30-11-78
MATERIAL FOR INDIA AMENDED 24078-5A Dt. 0-4-98 DA NO. 8/98 Dt. 12-7-78 Dt. 16-6-98	S. Rep. 16-6-98
DA NO. 4/85 Dt. 2-2-85 D. 2.2 mm Dt. 4-3-95	S. Rep. 4-2-85
MATL. FOR INDIA ADDED	DATE & SIGN.

DS. CAT NO. 1005 00 7184

FLASH HIDER

SHEETS : 1	1 ANGLE	DRWN	I/C PROJ.	CASTING DRG.
SHEET NO : 1	PROJECTION	CHECKED		6P11-1-12
ALL DIMENSIONS ARE IN mm.	SCALE : 1:1		DIV. OFFICER	DRG. NO. : 62 C-1012 250 H3

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE: 17.11.2020
 Design & Drawing Office
 Chinnance Factory
 Trichy-620016