

CHEMICAL COMPOSITION OF THE MATERIAL 23X ΓC2MØ NY

C	0.20 - 0.24
Si	1.8 - 2.0
Mn	0.5 - 0.8
Cr	0.6 - 0.9
Mo	0.25 - 0.30
V	0.10 - 0.15
Ni	1.0 Max
S	0.025 MAX.
P	0.025 MAX.

MECHANICAL PROPERTIES OF THE MATERIAL 23X ΓC2MØ NY (MINIMUM)

ULTIMATE STRENGTH	140 Kgf/mm ²
YIELD STRENGTH	120 Kgf/mm ²
RELATIVE ELONGATION	6%
IMPACT STRENGTH	4 KgfM/cm ²

FOR COMPONENT NO 2A42-05-021 RH FEED PAWLS 8 2A42-05-024 LH FEED PAWLS

AS PER LAST DC (1) No. LETTER N
ACCEPTANCE OF CASTING IS CARRIED OUT AS PER GOST 977-75 (PARAGRAPH 2 AND 3) BUT WHILE MANUFACTURING CASTING AS PER MELTED MODELS AS PER OST 3-4365-79

MECHANICAL PROPERTIES OF STEEL IS DETERMINED ON THE SPECIMENS, CUT FROM THE TEST BARS AS PER GOST 977-75 AFTER CARRYING-OUT COMPLETE HEAT-TREATMENT PROCESS

TENSILE TEST IS CARRIED OUT AS PER GOST 1497-73 ON CYLINDRICAL SPECIMEN WITH DIAMETER 10mm. WITH LENGTH 50mm

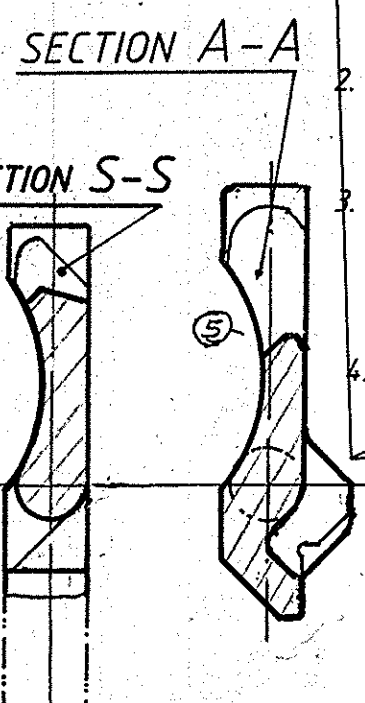
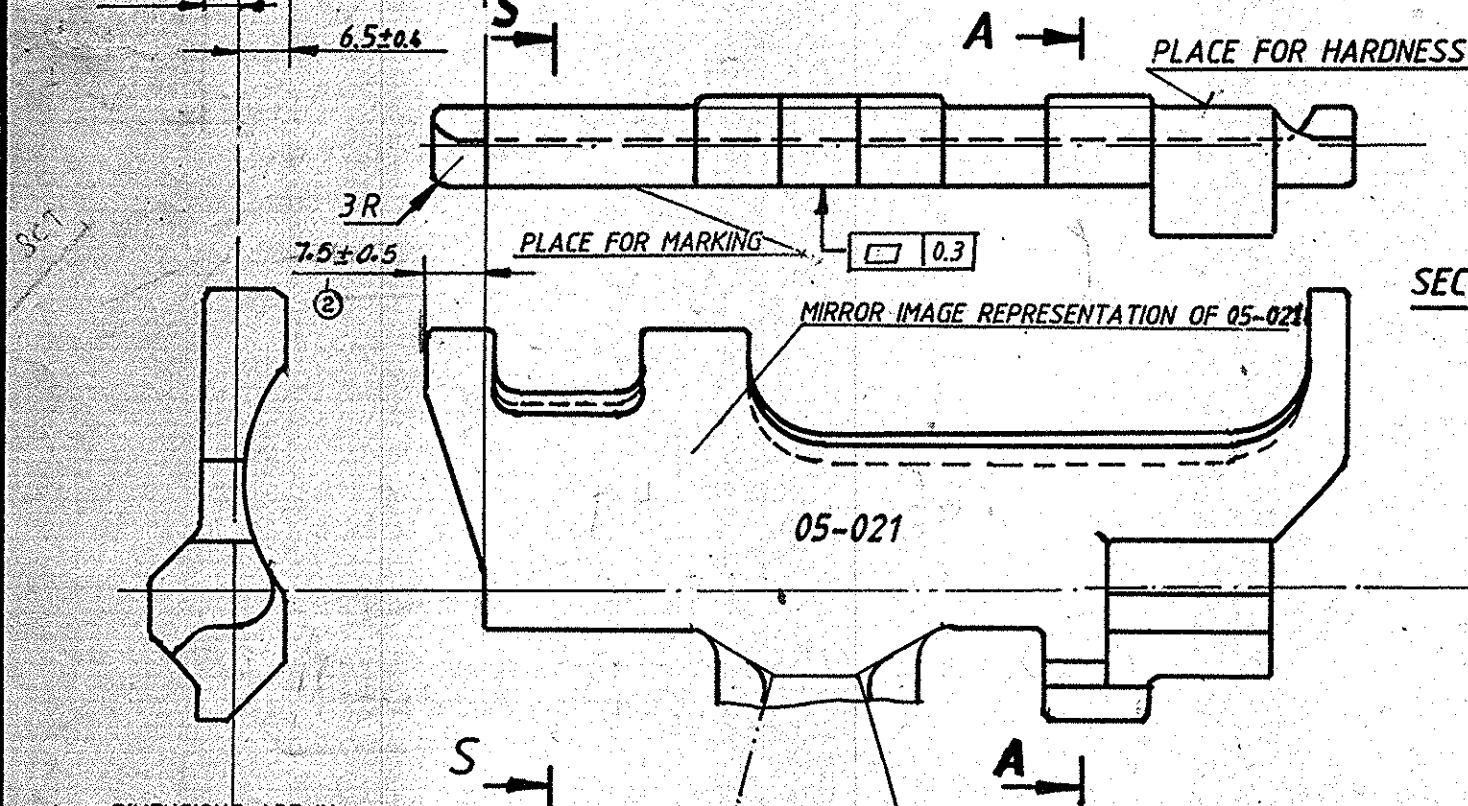
TESTS ON SPECIMENS (SAMPLES) ON 5mm DIAMETER WITH 25mm LENGTH IS PERMITTED

DETERMINATION OF IMPACT STRENGTH IS CARRIED OUT AS PER GOST 9454-78 ON THE SPECIMEN OF TYPE I AT NORMAL TEMPERATURE AND AS PER GOST 9454-78 AT LOW TEMPERATURE.

INQI. MATL. AND RADIO GRAPHIC TEST ADDED IN SHEET NO. 2.

SHEETS: 1/2

DA NO.	007/95 dt. 8-2-95	Uwz alr
DIM.	7.5±0.5 ADDED FOR 05-021	Ilam, 25/9/92
ORG.	ADVANCED TO C3	
STORE DRG. NO.	ADDED	Uwz 25/3/92
SL. NO.	AMENDMENTS	SIG & DATE



- DIMENSIONS ARE IN mm.
- SCALE = 1:1
- FIRST ANGLE PROJECTION
- HARDNESS AFTER PRELIMINARY HEAT-TREATMENT HB 269 MAX.
- UN-SPECIFIED CASTING RADII 2 mm.

- CASTING DEFECTS ON NON-MACHINED SURFACE ARE ALLOWED AS PER OST 3-4365-79;
- MOULDING ANGLE UP TO 1° AS PER GOST 3212-80.
- IMPACT STRENGTH SHOULD BE CONTROLLED ON THE SAMPLES.
- STRAIGHTENING IS PERMITTED
- CORRECTION OF CASTING DEFECTS IS PERMITTED.
- * DIMENSIONS NEED NOT BE CONTROLLED.
- MANUFACTURING OF CASTING WITH TWO VARIANTS (TYPES) OF FEEDERS IS PERMITTED

- WEIGHT OF MATERIAL 0.250 Kgs.
- MATERIAL :- 23X ΓC2MØ NY, TYAPM116-78.
- CLEANING :- SAND BLASTING
- SURFACE FINISH ∇ Max.
- SPECIAL TEST :- MAGNETIC FLAW DETECTION
- CASTING BELONGS TO GROUP II, OST 3-4365-79 (SPECIAL PURPOSE CASTING)

CASTINGS AND TEST BARS ARE SUBJECT TO FOLLOWING HEAT-TREATMENT

- PRELIMINARY HEAT-TREATMENT (PRIOR TO MACHINING)
 - NORMALIZING AT TEMPERATURE 1000° ±20° C FOR 1-2 HOURS.
 - TEMPERING AT TEMPERATURE 720° ±20° C FOR 4 HOURS.
- HEATING FOR NORMALIZING AND HARDENING IS TO BE CARRIED OUT WITH PROTECTION OF CASTING FROM DECARBURIZATION AND OXIDATION

FINAL HEAT-TREATMENT (AFTER MACHINING) TEST BAR ONLY AS PER FOLLOWING SEQUENCE OF OPERATION. HARDENING AT TEMP. 1000° ±20° SOAKING TIME IS ONE HOUR, COOLING IN OIL. TEMPERING AT TEMP. 200° ±20° C FOR 4 HOURS

REDRAWN	CHECKED	APPROVED	F/M.PROJ	AWM/PROJ	ORDNANCE FACTORY TIRUCHIRAPALLI-16	DRG NO: 64 C 5021 250 B 3
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