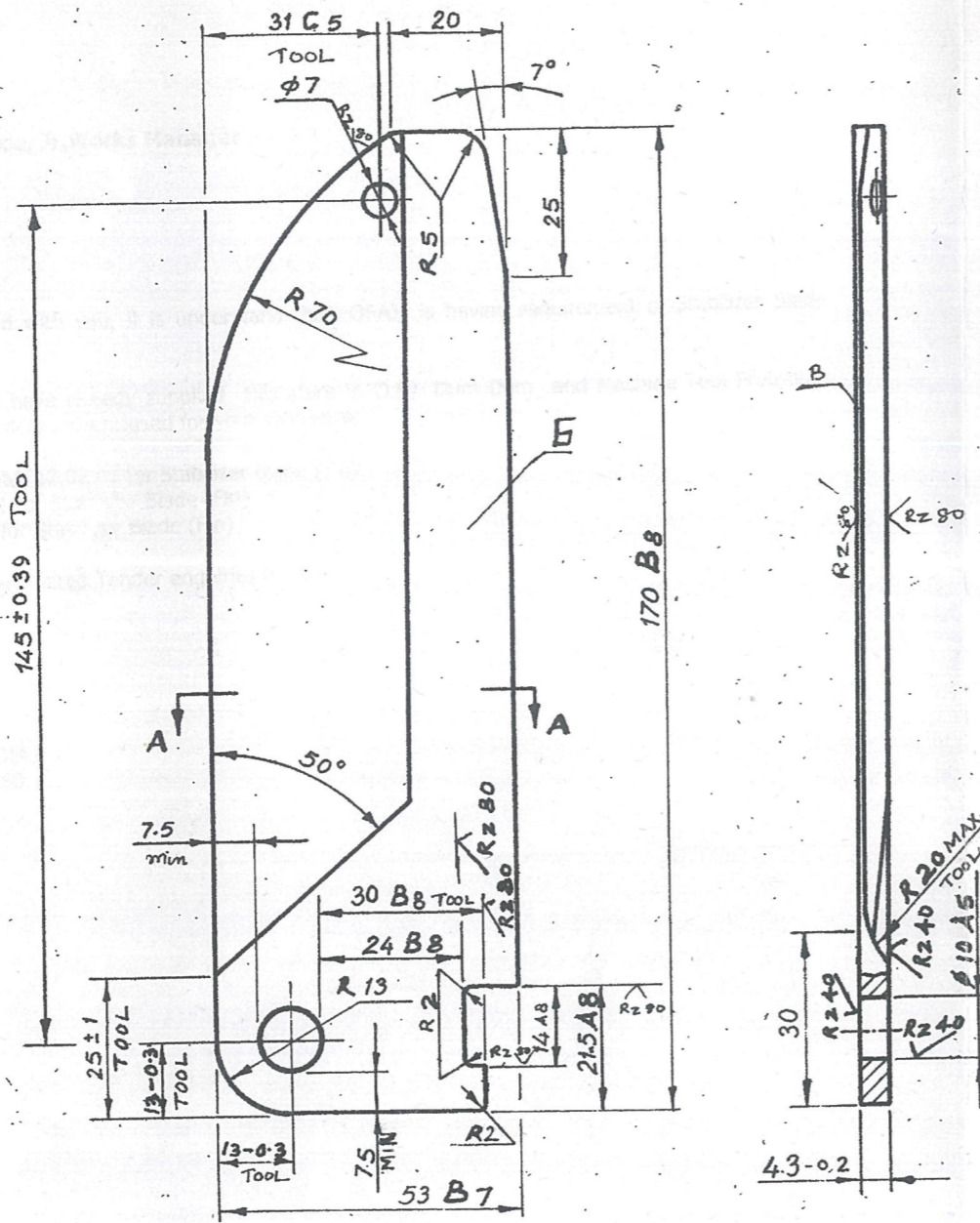


For Mechanical Factory.

III Machine shop drawing



12. FOR MARKING ON STABILIZER BLADE (FIN) PLEASE REFER DRG NO CQA(2)/AMN/3186.

DATE	AUTHORITY	REVISION	AHSP	DO
19-2-11	DC 37275-A	UNDER NOTE No IV SI. No 3 UPDATED		

R. No	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.	SIQ.
	17-4-08	DC 36892-A	TOLERANCE ON MASS ADDED				
	26-07-01	DC 36771-A	PARA No 12 ADDED				
	12-11-91	DC 35212-A	DRG. TITLE, I.F., MATL. SHOWN UNDER TITLE & VARIOUS NOTES AMENDED & EQUIVALENT MATL TABLE ADDED.				
	2-7-90	D.C. 34909-A	MASS ADDED.				
	4-6-85	D.C. 1.33760-A	DRG. SEALED PROV.				

के. कृपाकर, म.आ.नि.स
संयुक्त महाप्रबंधक
K. KRIPAKAR, I.O.F.S
JOINT GENERAL MANAGER
Govt. of India: Ministry of Defence
ORDNANCE FACTORY AMBAJHARI, NAGPUR

STABILIZER BLADE (FIN)

- I. ~~Stabilizing vane~~
- II. Steel, strip, spring, grade ~~50 X 7~~ 50 X 7, GOST 14959.79.
- III. Machine shop drawing.
- IV. 1. Desired mechanical properties of finished ~~vane~~ material 0.2%
PROOF STRESS ~~0.2~~ 95 kgf/mm² min. ~~reduction percentage 30% min.~~
R OF A
2. Machining over profiles to Rz 80/ is allowed.
3. Brinell/hardness indentation to be located on surface, A. T
40 mm from lower end. IMPRESSION: DE 5 mm BALL (AT 750 Kgf LOAD FOR 10 ± 2 S) TO BE IN THE RANGE OF 1.65 mm TO 1.45 mm INDICATING HARDNESS OF 341 TO 410 BHN.
4. Non. flatness of surface B not to exceed 0.3 mm all over the length.
5. Occasional decrease of dimension 7.5/min. not exceeding 0.2 mm allowed.
6. Dimension 4.3 ± 0.2 to be ensured over 30 mm from lower face of ~~vane~~ and on the sloping side beyond that, ~~vane~~ thickness of 4.3 B7 is allowed.
7. Rounding edges to R 1/max/ allowed.
8. Decrease of dimension 1 ± 0.2 amounting to half-tolerance is allowed over 1/3 of ~~vane~~ length.
9. Coating chemical phosphating, ~~chromium~~ CHROMIATED varnish MA-592 (2) TY 6-10-846-75-IV ~~MA-592~~ varnish grade ~~MA-592~~ TY 6-10-1236-77 is allowed.
10. Excess varnish in hole ϕ 10 A5 and in recess to receive lock are not allowed.
11. For rest of requirement, refer to CST B ~~Mat 84-485-71~~.

MATERIAL	SPECIFICATION No	APPROVED INDIGENOUS EQUIVALENT/ALTERNATIVE
i) STEEL STRIP SPRING GRADE 50 X 7	GOST 14959-79	IS 2507 DESIGNATION, 50 X 7 TO BE HARDENED AND TEMPERED TO SATISFY 0.2% PROOF STRESS 95 kgf/mm ² (MIN) AND R OF A 30% MIN.
ii) VARNISH MA-592 (3)	TY 6-10-846-75	JSS 8010-22
iii) VARNISH GRADE ϕ A 582	TY 6-10-1236-77	JSS 8010-28

4-024610	30 ϕ 19
STABILIZER BLADE (FIN)	024
Steel Strip Spring	
Grade 50 X 7 GOST 14959-79	
MASS - 0.21 kg ± 0.005 kg	APPD. Sakharekar FOR C.T. (A)
	AHSP: - C.I.(A) KIRKEE

ए. पी. थुलकर/A. P. Thulkar
व.व.अ./SSO-II
कृते व.गु.आ.अ./For S.Q.A.Q.
व.गु.आ.स्था.(आ)/S.Q.A.E. (A)
अम्बाजरी नागपुर/Ambajhari, Nagpur

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यह प्रति सौ. डी.डी. ओ. एफ. ए. जे.
द्वारा जारी है।
दिनांक 15-09-20
Date 15-09-20 for JWM/CDD