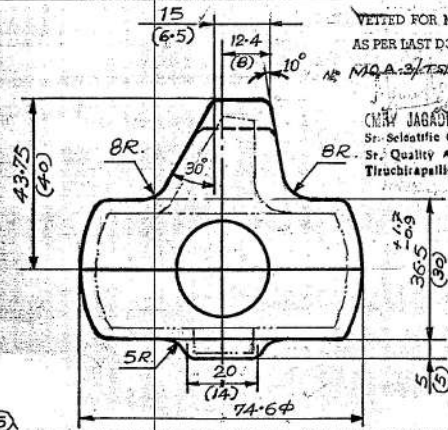
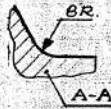
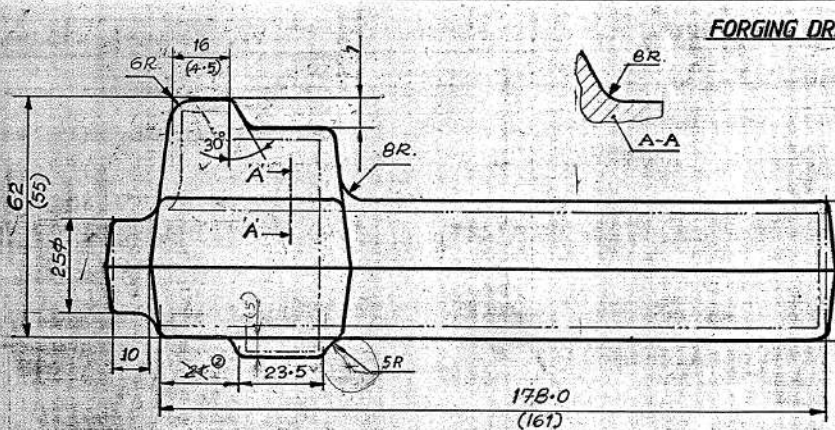
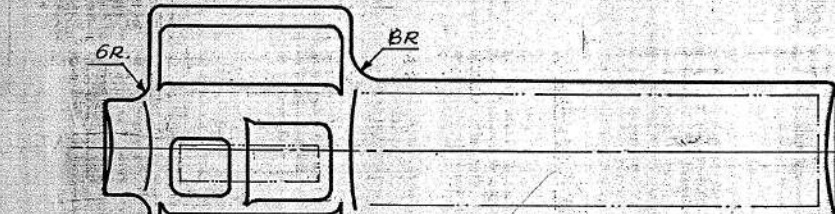


**FORGING DRAWING**



VETTED FOR MATERIAL  
AS PER LAST DC (C) No. 1272  
No. NQA-2/15/81/50/6/1 of 97  
CMR JAGADISH  
Sr. Scientific Officer  
Sr. Quality Assurance Engg. (Arms)  
Tiruchirapalli-620016.

INDIGENOUS MATERIAL: BS 970 Pt 1 83 Gd. 826 M40 WITH S7, 0.010 MAX, P7, 0.015 MAX. ESR QUALITY. THE MATERIAL SHOULD ACHIEVE THE FOLLOWING MECHANICAL PROPERTIES:  
 RM : 1763 MPA MAX  
 RE : 1420 MPA MAX  
 EY : 110 Min.  
 CHARPY IMPACT (U NOTCH) : 6 Kgm/Cm<sup>2</sup> Min.  
 MACROSTRUCTURE SHALL BE BETTER THAN OR EQUIVALENT TO C1 R15 FOR PLATE 1 AND NIL FOR PLATE 2 TO SPECN IS 13015, NMIR 1.5 THIN SERIES MAX, FOR ABCD AND NIL FOR THICK SERIES TO IS 4153, FIG 2.  
 AUTHORITY: (CRAT/METALS) ICHAPUR, LY-NO. MGA-31515/12 DL.G/n-6-97



THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF 48.5 - 55.5 HRC AFTER FINAL HEAT TREATMENT

9. UN-SPECIFIED DRAFT ANGLE 7°
10. UN-SPECIFIED RADIUS 3mm
11. ALLOWANCES AS PER CLASS II, GOST 7505-74 'M'
12. TOLERANCES AS PER CLASS II, GOST 7505-74 'C' AND AS FOLLOWS EXCEPT THOSE SPECIFIED  
 VERTICAL ±0.19 EXCEPT THOSE SPECIFIED  
 HORIZONTAL ±0.10
13. DIE FORGING BY HAMMER
14. NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE
15. DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING
16. WEIGHT OF THE FORGING 2500 Kgs.
17. RAW MATERIAL SIZE - 65φ x 125 LONG (HOT ROLLED 1175mm x 95 LONG)
18. MATERIAL - 35KH2MFA-V - DST-3-98-80.  
 FORGE No, MANUFACTURER'S INITIALS, YEAR OF MANUFACTURE AND RESD. No. TO BE STAMPED/ENGRAVED SIZE 6mm x 0.5mm DEEP.

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

**UN CONTROLLED COPY**

18. SURFACE TOLERANCE SHOULD NOT EXCEED 0.5mm
19. SURFACE DEFECTS:- HAIR LINE CRACKS, NICKS AND SCALE PITS SHOULD NOT EXCEED 50% OF ACTUAL ONE SIDED MACHINING ALLOWANCE ACCORDING TO GOST 8479.10
20. MARKING - LETTERING IT05280ST 2930-62
- INDIGENOUS  
 MATL: BS 970 Pt 1-1983 Gd. 826 M31 CONDITION 2 WITH S&P FONTENT  
 0.010 & 0.015 MAX. RESPECTIVELY (ESR STEEL) TO ACHIEVE REQUIRED HARDNESS.

|         |                         |          |
|---------|-------------------------|----------|
| DRG NO. | DA No. 22/87/23-307     | 17/11/20 |
| D       | DA No. 66/86/2517/86    | 17/11/20 |
| C       | DA No. 146/84, 41/11/82 | 17/11/20 |
| B       | DA No. 65/92            | 17/11/20 |
| A       | DA No. 30-10-92         | 17/11/20 |
| SI. NO. | STORE DRG. NO ADDED     | DATE     |
|         | AMENDMENTS              | DATE     |

FOR COMPONENT NO 2A42-03-015-BREECH BLOCK

1. DIMENSIONS ARE IN mm.
2. SCALE - 1:1
3. FIRST ANGLE PROJECTION.
4. HEAT-TREATMENT - NORMALIZING, AND HIGH TEMPERING HARDNESS HB 285 MAX.
5. DESCALING - PICKLING.
6. DISPLACEMENT IN THE PARTING PLANE SHOULD NOT EXCEED 0.7 mm.
7. REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 10 mm.
8. ROD CURVATURE SHOULD NOT EXCEED 0.5 mm.
9. SURFACE DEFECTS SHOULD NOT EXCEED 0.5 mm IN DEPTH

|                    |                      |                  |            |           |                                       |                              |
|--------------------|----------------------|------------------|------------|-----------|---------------------------------------|------------------------------|
| Redrawn<br>27/6/83 | Checked<br>sethupama | Approved<br>7/88 | F/M - PROJ | A/WM/PROJ | ORDNANCE FACTORY<br>TIRUCHIRAPALLI-16 | DRG NO:<br>64 C 3015 200 E 3 |
|--------------------|----------------------|------------------|------------|-----------|---------------------------------------|------------------------------|