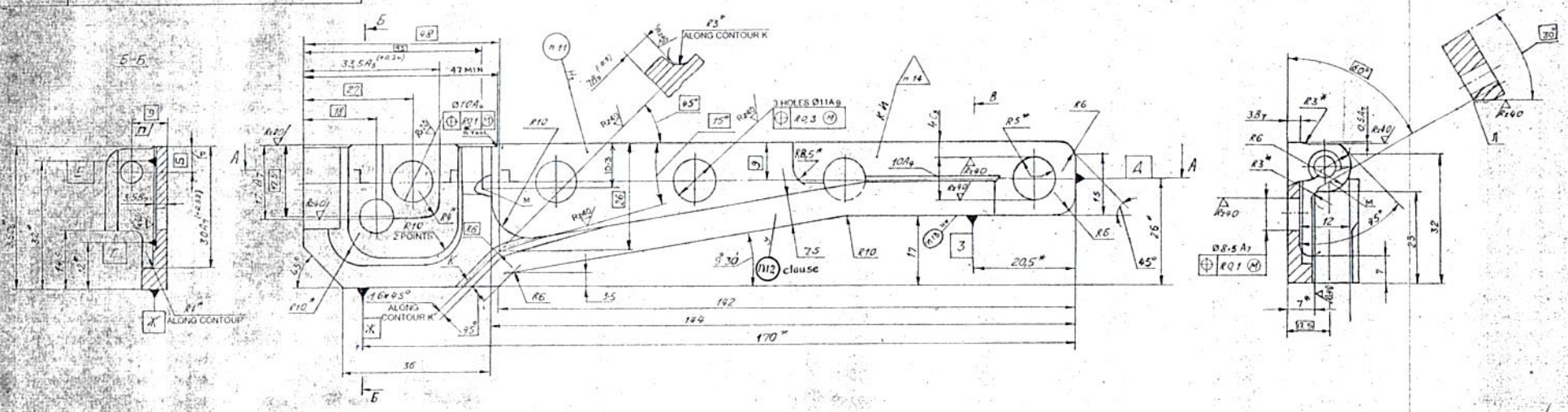
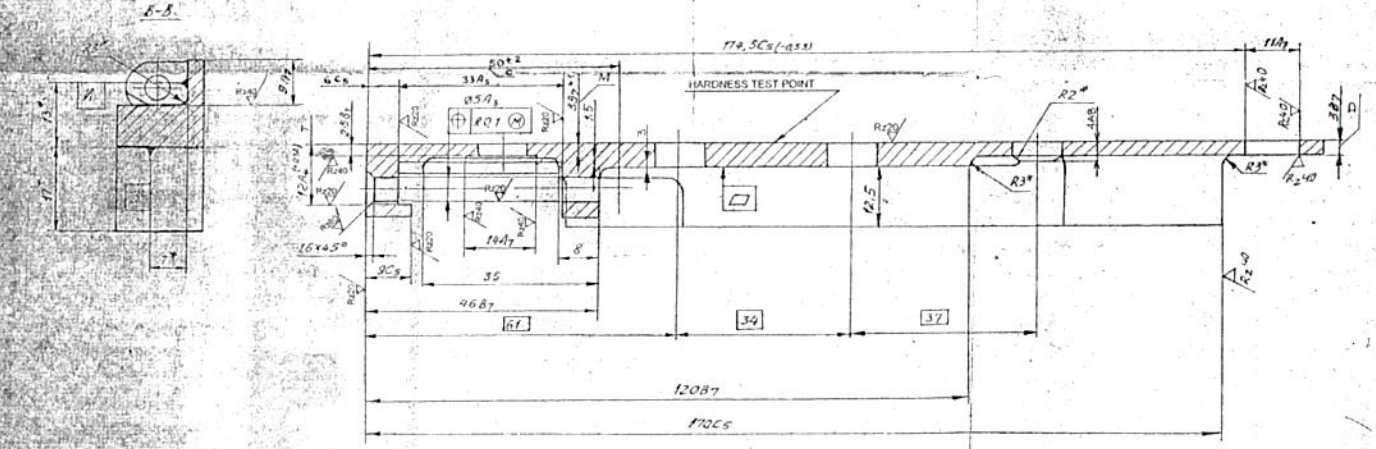
DS CAT. No
3040-016833





1. UNSPECIFIED CASTING RADII R = 2 mm
2. HRC REF 41.5 TO 51.5
3. IN ADDITION CHECK FOR IMPACT STRENGTH IN COMPLIANCE WITH SECTION 3, TOCT 977 - 75
4. * THE SIZES ARE PROVIDED BY TOOLS
5. *1 THE SIZE IS GIVEN RELATIVE TO BASE SURFACES Г, Е, Ж, З, Л, И
6. *2 THE SIZE IS GIVEN RELATIVE TO BASE SURFACES Х, З, Л
7. INNER CORNERS WITH R = 0.4 mm
8. BLUNT EDGES TO R = 0.6 mm
9. TOLERANCE ALONG CONTOUR K IS 0.2 mm
10. COATING : ACCELERATED ELECTROLESS PHOSPHATING WITH CHROMATE TREATMENT / IMPREGNATION WITH ADHESIVE 88 - 4, TOCT 12172 - 74 WITH NIGROSINE, GRADE A, TOCT 9307 - 78 ONE COAT OR PHOSPHATIN ; (ACCELERATED) Gde] TO JSS : 0465 : 01 - 94 WITH COATING OF DUNLOP ADHESIVE S 758 ONE LAYER & NIGROSINE TO JSS/1036
11. MARK WITH TYPE: П О - 5, ГОСТ 2930 - 62
12. STAMP
13. CHECK SIZE M BEFORE MARKING SIZE D IS MAINTAINED
14. MARK SERIAL No. OF PART WITH TYPE ПО - 3 GOST 2930 - 62
15. TOLERANCE ALONG CONTOUR П IS 0.8 mm
16. DIMENSIONS Л, Р Т TO BE CHECKED OVER SECTION C
17. (a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM - E - 446 : 84, LEVEL II.
    (b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
    (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CQA (MET) ICHAPUR.
    OR
    THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO CQA (MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.
    (d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOULD AND MATERIAL HAS BEEN APPROVED BY CQA (MET) ICHAPUR.
    (e) 5% OF THE CASTING SELECTED AT RANDOM FROM THE BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA (MET) ICHAPUR.

MATERIAL
Casting 1Л-ООЦ 3-4365-79
2310ХЛДА7 ТУАЖИ-116-78

INDIGS MATL - 16.1103.4.3 - 1995, GR.18 & OR BS : 3146, Pt.1 : 74, TYPE CLA - 5 GR 'B', CASTING TO BE HEAT TREATED TO ACHIEVE 41.5 - 51.5 HRC SEPARATELY CAST TEST BARS SHALL MEET THE SPECIFIED MECH PROPERTIES INCLUDING IZOD IMPACT VALUE 14 J MIN

G-1024

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE 21/9/23
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI -620 016.

AMENDMENT NOTICE No.
2A42 - 1137 T - 87 dtd 8-8-88
(P - 3 (1)/2869)
2A42 - 1140 E - 86 dtd 18-3-88
(P - 72/1/2869)

DATE	AUTHORITY	ZONE	AMENDMENTS	SIG AHSP	SIG DO
14.9.95	1944.6-W	B/I-3	INDIGS MATL AMENDED		
7.5.03	19157-W		D.S CAT. No. ADDED & NOMEN AMENDED		
			SCANNED & PRINTED WITHOUT CHANGE		

PREV DC Nos :-16407-W,16657-W,16699-W,17220-W,17715-W,18100-W,18149-W,18174-W,18193-W, 18283-W & 18845-W DT 13-1-04

DRG SEALED :- 18174-W Dt 22-09-95

DO CQA(W)

DRAWN :- PKA
SCANNED :- PKA
CHD :- GPS
CHD :-
AHSP
DO
FOR CQA(W)
ASSY DRG :-
DATE :-
SCALE :- 2 : 1
ESTD mass :- 0.23 :-
MATERIAL :- AS ABOVE
PROTECTIVE FINISH :-

PAWL पॉल

CQA(W), JABALPUR

DESIGN No.
PART No. 2A42.01.024
DS CAT No. 3040-016833