



CHEMICAL COMPOSITION (%)			MECHANICAL PROPERTIES		
ELEMENT	STEEL 20X2H4A GOST 4543-71	STEEL 835M15 (EN-39B) BS: 970-83	DESCRIPTION	STEEL 20X2H4A GOST 4543-71	STEEL 835M15 (EN-39B) BS: 970-83
C	0.16 - 0.22	0.12 - 0.18	TEST BAR DIA.	-----	19 mm
Si	0.17 - 0.37	-----	TENSILE STRENGTH	130 Kgf/mm ² MIN.	1310 MPa MIN.
Mn	0.30 - 0.60	0.25 - 0.50	YIELD STRENGTH	110 Kgf/mm ² MIN.	-----
Cr	1.25 - 1.65	1.00 - 1.40	RELATIVE ELONGATION	9 % MIN.	8 % MIN.
Ni	3.25 - 3.65	3.90 - 4.30	RELATIVE COMPRESSION	-----	-----
Mo	-----	0.15 - 0.30	REDUCTION OF AREA	45 % MIN.	-----
Cu	0.30 MAX.	-----	HARDNESS BHN	207 - 269	207 - 269
S	0.025 MAX.	0.040 MAX.	IMPACT STRENGTH	8 Kgf.m/cm ² MIN.	-----
P	0.025 MAX.	0.035 MAX.	IZOD	-----	25 MIN.
			KCV (CHARPY)	-----	28 MIN.

VETTED
24 NOV 2005
JWM/QC

VETTED
07 DEC 2007
JWM/STD-CELL

TECHNICAL REQUIREMENTS

- HEAT TREAT. DIA. OF IND. 3.7 TO 4.2 (BHN 207-269)
- DESCALE.
- DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE IS ACCEPTABLE.
- MISMATCH SHOULD NOT EXCEED 0.8 mm.
- RESIDUAL FIN ALONG PARTING PLANE SHOULD NOT EXCEED 1.0 mm.
- FOLDING OF FIN IN PIERCED HOLE IS ALLOWED.
- ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED 1.5 mm.
- BUCKLING SHOULD NOT EXCEED 0.8 mm.
- MARK PART NO.
- DRAFTS TO BE 7°.
- UNSPECIFIED RADII TO BE R 2.5 mm.
- UNTOLERANCED DIMENSIONS ARE FOR CONSTRUCTION.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- PAINT RED OXIDE.
- PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

ALTERNATE MATERIAL :- STEEL 835M15 (EN-39B) TO BS: 970-83
AUTHORITY :- CQA(HV) LETTER No. O91/IFD/IND-V/MTPF/OE
DATED 17.03.2005

संख्या NO.OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाणु DIMENSIONS	अभ्यक्ति REMARKS																														
	COUPLING DRIVE (FORGING)		STEEL 20X2H4A	GOST 4543-71		MASS = 2.13 Kg.																														
<p>सामान्य सहिष्णुता GENERAL TOLERANCE</p> <p>रेखिक परिमाण LINEAR DIMENSION</p> <table border="1"> <tr><td>0-6</td><td>±0.1</td></tr> <tr><td>6-30</td><td>±0.2</td></tr> <tr><td>30-120</td><td>±0.3</td></tr> <tr><td>120-315</td><td>±0.5</td></tr> <tr><td>315-1000</td><td>±0.8</td></tr> <tr><td>1000-2000</td><td>±1.2</td></tr> </table> <p>कोणिक परिमाण ANGULAR DIMENSION</p> <table border="1"> <tr><td>1-10</td><td>±1°</td></tr> <tr><td>10-50</td><td>±30'</td></tr> <tr><td>50-100</td><td>±20'</td></tr> <tr><td>>100</td><td>±10'</td></tr> </table> <p>मापक 'न्यू एम' में VALUE IN "um"</p> <table border="1"> <tr><td>-</td><td>>25</td></tr> <tr><td>▽</td><td>8-25</td></tr> <tr><td>▽▽</td><td>1.6-8</td></tr> <tr><td>▽▽▽</td><td>0.025-1.6</td></tr> <tr><td>▽▽▽▽</td><td><0.025</td></tr> </table>							0-6	±0.1	6-30	±0.2	30-120	±0.3	120-315	±0.5	315-1000	±0.8	1000-2000	±1.2	1-10	±1°	10-50	±30'	50-100	±20'	>100	±10'	-	>25	▽	8-25	▽▽	1.6-8	▽▽▽	0.025-1.6	▽▽▽▽	<0.025
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	COUPLING DRIVE (FORGING DRG.) FOR COMP. DRG. NO. 172-45-071-1 TRANSMISSION GEAR UNIT (CODE-45 / T-72 & T-90)				1:1	<p>2005 दिनांक 20.11.05</p> <p>नाम krb</p> <p>आरेखित DRAWN</p> <p>जाँचा CHECKED</p> <p>अनुमोदित APPROVED</p> <p>द्वारा बदला REPLACED BY</p> <p>हेतु बदला REPLACED FOR</p> <p>कार्यालय OFFICE</p> <p>D.O</p> <p>आरेखण क्र. DRAWING NO. 172-45-071-1 / F</p>																														
	मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH																																			
	मूलमाप व अन्वायोजन NOMINAL SIZE & FIT																																			
	विचलन DEVIATION																																			

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

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