



TECHNICAL REQUIREMENTS.

- HEAT TREAT. DIA. OF IND. 3.5-3.8 mm (BHN 255-302)
- DESCALE.
- DEPTH OF SURFACE DEFECTS AND SCALE PITS UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE ARE ALLOWED.
- MISMATCH SHOULD NOT EXCEED 0.9 mm.
- RESIDUAL FIN ALONG PARTING LINE SHOULD NOT EXCEED 1.0 mm.
- FOLDING OF FIN IN PIERCED HOLE IS ALLOWED.
- BUCKLING SHOULD NOT EXCEED 0.8MM.
- MARK PART NO.
- UNSPECIFIED DRAFTS = 7°
- UNSPECIFIED RADII = R 3.0 mm.
- MACHINING DIMENSIONS ARE SHOWN IN BRACKETS.
- UNTOLERANCED DIMENSIONS ARE FOR CONSTRUCTION.
- ECCENTRICITY OF PIERCED HOLE SHOULD NOT EXCEED 1.5 mm.
- PAINT REDOXIDE
- PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

VETTED
07 DEC 2007
JWM/STG/CELL

इन आरेखों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्व अधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के मन्त्रनिदेशक 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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मूलमाप व अन्वयोजन
NOMINAL SIZE & FIT

विचलन
DEVIATION

CHEMICAL COMPOSITION (%)			MECHANICAL PROPERTIES		
ELEMENT	STEEL 38XC GOST 4543-71	STEEL 817M40 (EN-24) BS: 970-83	DESCRIPTION	STEEL 38XC GOST 4543-71	STEEL 817M40 (EN-24) BS: 970-83
C	0.34 - 0.42	0.36 - 0.44	LIMITING RULING SECTION	-----	150 mm
Si	1.00 - 1.40	-----	HEAT TREATMENT CONDITION	-----	T
Mn	0.30 - 0.60	0.45 - 0.70	TENSILE STRENGTH	95 Kg/mm ² MIN.	850-1000 MPa
Cr	1.30 - 1.60	1.00 - 1.40	YIELD STRENGTH	75 Kg/mm ² MIN.	680 MPa MIN.
Ni	0.30 MAX.	1.30 - 1.70	RELATIVE ELONGATION	12 % MIN.	13 % MIN.
Cu	0.30 MAX.	0.025 MAX.	RELATIVE COMPRESSION	-----	-----
Mo	-----	0.20 - 0.35	REDUCTION OF AREA	50 % MIN.	-----
S	0.035 MAX.	0.040 MAX.	HARDNESS BHN	255 - 302	255 - 302
P	0.035 MAX.	0.035 MAX.	IMPACT STRENGTH	7 Kg.m/cm ² MIN.	-----
			IZOD	-----	40 MIN.
			KCV (CHARPY)	-----	50 MIN.
			0.2% PROOF STRESS	-----	665 MPa MIN.

ALTERNATE MATERIAL :-
STEEL 817M40 (EN-24) TO BS: 970-83

AUTHORITY :-
CQA(HV) LETTER No.
O91/IFD/IND-V/MTPF/OE
DATED 17.03.2005

BEARING SEAT (FORGING)		STEEL 38XC	GOST 4543-71	MASS = 2.28 Kg																																
संख्या NO. OFF	विवरण DESCRIPTION	पुर्जो क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS																														
<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>10-80</td><td>±30'</td></tr> <tr><td>80-100</td><td>±20'</td></tr> <tr><td>> 100</td><td>±10'</td></tr> </table> <p>मापक 'म्यू एम' में VALUE IN 'μm'</p> <table border="1"> <tr><td>-</td><td>>25</td></tr> <tr><td>0</td><td>8-25</td></tr> <tr><td>PP</td><td>1.6-8</td></tr> <tr><td>PPP</td><td>0.025-1.6</td></tr> <tr><td>PPPP</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°	10-80	±30'	80-100	±20'	> 100	±10'	-	>25	0	8-25	PP	1.6-8	PPP	0.025-1.6	PPPP	<0.025
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	BEARING SEAT (FORGING DRG.) FOR COMPONENT DRG. NO. 172-45-148 TRANSMISSION GEAR UNIT (CODE45 / T-72 & T-90)				2005	दिनांक DATE																														
					11.11.05	नाम NAME																														
					17-11	कर्मचारी EMPLOYEE																														
						द्वारा बदल REPLACED BY																														
						केतु बदल REPLACED FOR																														
						आरेखण क्र. DRAWING NO.																														
						172-45-148 / F																														

मशीनी औजार आदि रूप फैक्टरी, अम्बरनाथ
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH

कार्यालय
OFFICE
D.O