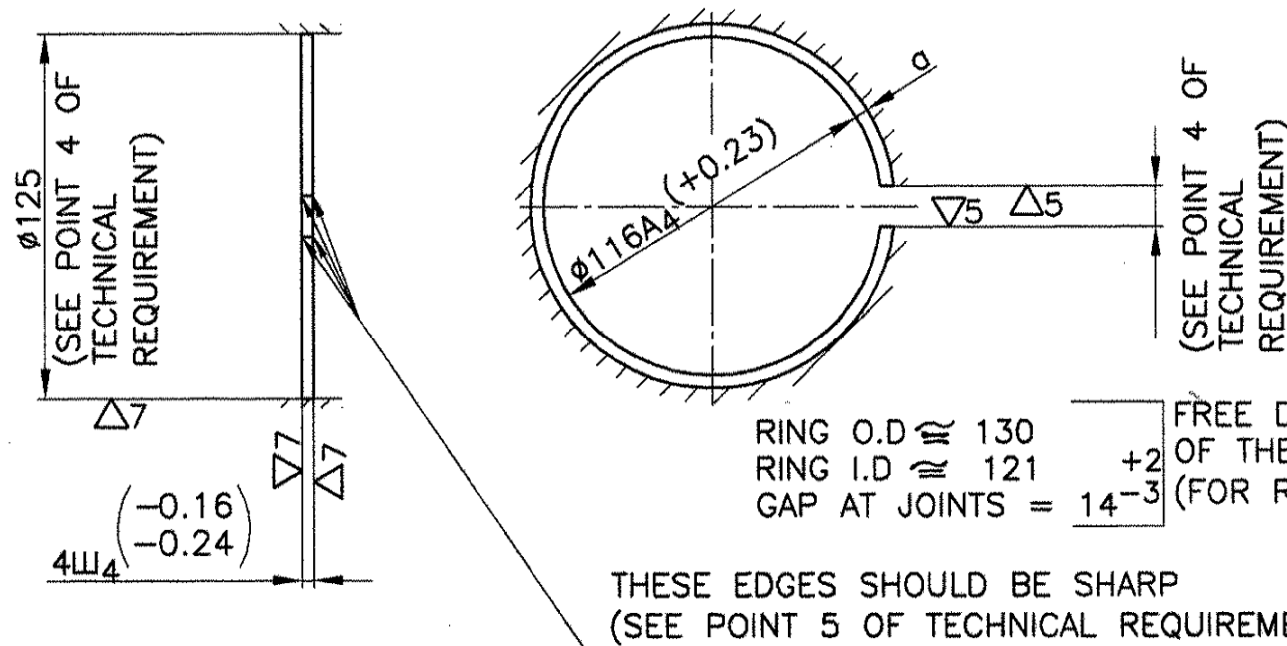


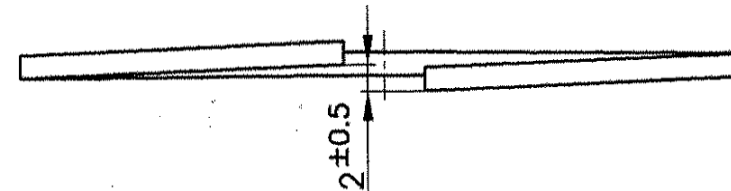
This drg. has been prepared based on AHSF drg.



$\nabla 4$ (∇)

MECHANICAL PROPERTIES			CHEMICAL COMPOSITION (%)		
DESCRIPTION	SPECIAL (GREY) CAST IRON, 54.TY-P14-2	GRADE FG-350, IS:6331-87 (REF. IS:210-93)	ELEMENT	SPECIAL (GREY) CAST IRON, 54.TY-P14-2	GRADE FG-350, IS:6331-87
TENSILE STRENGTH	-----	350 N/mm ² MIN.	C	2.7 - 3.1	3.0 - 3.30
HARDNESS BHN	217 - 302	207 - 241	Si	1.4 - 1.9	2.10 - 1.80
			Mn	1.0 - 1.6	0.70 - 1.00
			P	0.3 - 0.5	0.10 MAX.
			Ni	0.50 MAX.	-----
			Cr	0.30 MAX.	-----
			S	0.10 MAX.	0.15 MAX.
			Ti	0.07 MAX.	-----

RING IS TO BE SEPARATED TO FORM A SPIRAL AFTER THE CHECK IN COMPLIANCE WITH TECHNICAL REQUIREMENTS 172 45 TY.



TECHNICAL REQUIREMENT

1. THE WIDTH OF THE RING JOINT (WHEN IT IS LOOSE) SHOULD BE WITH IN 14^{-3} AFTER THE TEN FOLD PRESSING OF RING AGAINST THE STOP OF THE FACES OF THE JOINT, RESIDUAL DEFORMATIONS MAY BE WITH IN THE TOLERANCE ON THE RING JOINT WIDTH
2. VARIATION IN DIMENSION ALONG RING WIDTH 'a' MAY NOT EXCEED 0.2 mm.
3. VARIATION IN DIMENSION ALONG THICKNESS 4 MAY NOT EXCEED 0.03 mm.
4. WHEN CHECKING THE RING IN SEAT $\phi 125$ SEE TO IT THAT THE RING TIGHTLY FITS TO THE SEAT (0.04 FEELER GAUGE FAILS TO PASS), IN THIS CASE THE CLEARANCE IN THE RING JOINT SHOULD BE FROM 0.25 TO 0.4 mm.
5. SHARP EDGES OF THE OUTER AND INNER CYLINDRICAL SHOULD BLUNDED BY CHAMFER. CHAMFER ON THE OUTER CYLINDRICAL SURFACE SHOULD NOT EXCEED 0.2 mm. (OR R 0.2mm) AND ON THE INNER CYLINDRICAL SURFACE, NOT EXCEED $0.5^{+2} \times 45^\circ$ (OR R 0.5^{+2}). THERE SHOULD BE SHARP EDGES ON THE SIDE SURFACES OF THE JOINT.
6. CAVITIES, SCORES, NICKS, BURRS ARE NOT ALLOWED.
7. BHN 217-302 (IND. DIA. 3.5-4.1) IS TO BE CHECKED IN COMPLIANCE WITH THE REQUIREMENTS OF 54 TY P14-2.
8. TO BE MARKED ON THE FACES WITH ACID.

ALTERNATE MATERIAL :- GRADE FG-350 TO IS:6331-87
 AUTHORITY : CQA(HV), LETTER NO. 98704/04/ID-COORD/ALTCOM
 DATED 30-08-2005

VETTED
 23 MAR 2006
 JWM/STD-CELL

USED ON : 188-45-001 CD-3
 172-45-060 Cb Cb

PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION.

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS #
 0.034 < LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R OUTSIDE, R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

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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मूलमाप व अन्वयोजन
 NOMINAL SIZE & FIT

विचलन
 DEVIATION

3	PACKING RING	72	SPECIAL (GREY) CAST IRON	54 TY P14-2					
संख्या NO.OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS			
	सामान्य सहिष्णुता GENERAL TOLERANCE					Drg. updated		12/02/03	
	रेखिक परिमाण LINEAR DIMENSION								
	0-6								
	6-30								
	30-120								
	120-315								
	315-1000								
	1000-2000								
	कोणिक परिमाण ANGULAR DIMENSION								
	1-10								
	10-50								
	50-100								
	>100								
	मापक 'म्यू एम' में VALUE IN 'um'								
	-								
	∇								
	$\nabla\nabla$								
	$\nabla\nabla\nabla$								
	$\nabla\nabla\nabla\nabla$								
		संख्या NO.OFF	संबंधित पुर्जा का आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION		2006	दिनांक DATE	नाम NAME
								10-02	DHR
							मापमान SCALE	आरेखित DRAWN	
							NTS	जाँचा CHECKED	23.03
								अनुमोदित APPROVED	23.03
							द्वारा बदला REPLACED BY		
							हेतु बदला REPLACED FOR		
							आरेखण क्र. DRAWING NO.		
							172 - 45-020		
							कार्यालय OFFICE		
							D.O		
							मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH		