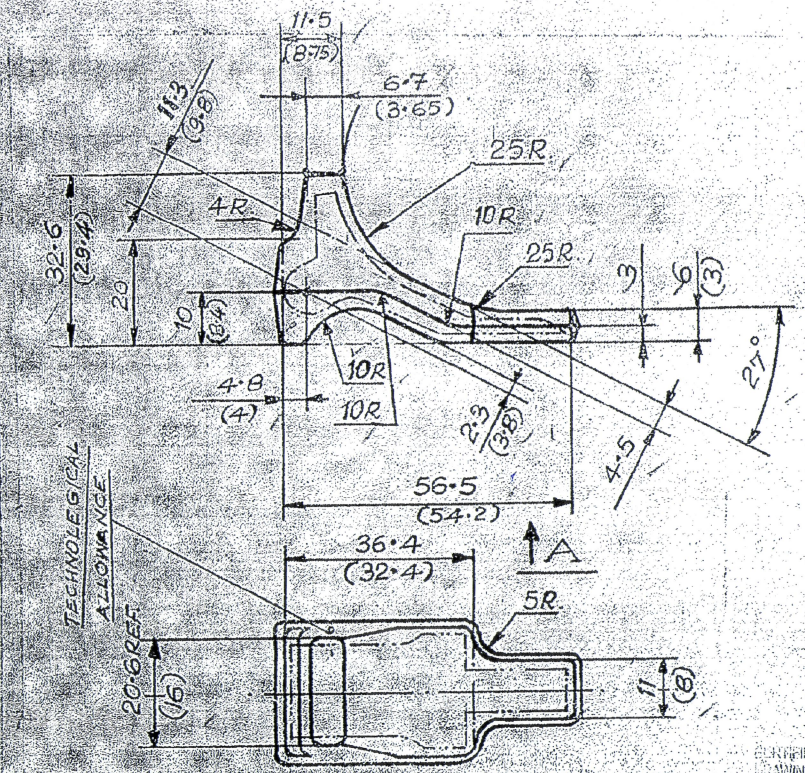
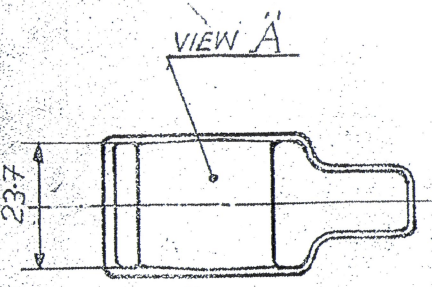
FORGING DRAWING





(4) CHEMICAL COMPOSITION OF THE MATERIAL :- 30XH2MΦA-a

C	0.27 - 0.34	Si	0.17 - 0.37
Mn	0.30 - 0.60	Cr	0.6 - 0.9
Ni	2.0 - 2.40	Mo	0.2 - 0.3
V	0.10 - 0.18	P	0.025 MAX.
S	0.025 MAX.	Cu	0.30 MAX.

(3) THE FINISHED COMPONENT SHOUD ATTAIN A HARDNESS RANGE OF HRC3 43·5 TO 51·5 AFTER FINAL HEAT TREATMENT

(4) HEAT-TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO:	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	FIXTURE	HARDNESS INSPN. %
ROCKER C 5025	30XH2MΦA	NORMALIZING HEATING	ELECTRIC CHAMBER FURNACE OR PUSHER FURNACE	850-870	3 HOURS	AIR	ON TRAY	3%, BUT NOT LESS THAN 3 PIECES.
		HIGH TEMPERING HEATING	ELECTRIC CHAMBER FURNACE OR ELECTRIC SHAFT FURNACE	660-680	5 HOURS	WITH FURNACE UP TO 500°C & IN AIR	ON TRAY	

1. DRESSING PLACES FOR CHECKING HARDNESS
2. CHECKING OF HARDNESS

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT ... DATE 13/11/24
DESIGN & DRAWING OFFICE, FACTORY, TIRUCHIRAPALLI

(5) 1-83

(4) ~~3-87~~

(3) INDIGENOUS MATERIAL: BS 970 PT ~~1 1983~~ Gde 826 M31 IN "Z" CONDITION (DR) IS 5517-93 DESIGN31 N110 CY3 MO6 LRS 63 mm (TENSILE STRENGTH 1550 MPa)

(4) A SEPERATE TEST SAMPLE IS TO BE HEAT TREATED AND TESTED IN 'Z' CONDITION. AUTHY: CQAM. LT. NO. MQA-3/TS/18 DT-02-05-97

VETTED FOR MATERIAL ONLY
AS PER LAST DC (1) No 12291W
DT 3.9.96
CM(TC) JAGADISH
Sr Scientific Officer
Sr. Quality Assurance Exam (Armts)
Tiruchirapalli-620016.

NOTES :-

1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION
3. SCALE :- 1:1
4. HEAT-TREATMENT :- NORMALIZING & HIGH-TEMPERING. HARDNESS HB 255 MAX.
5. DE-SCALING :- SHOT BLASTING OR PICKLING
6. DISPLACEMENT IN PARTING LINE SHOULD NOT BE MORE THAN 0.4 mm.
7. FLASH REMAINDER ALONG DIE PARTING LINE SHOULD NOT BE EXCEED 0.6 mm.
8. MATERIAL :- 30H2MΦA-a OST 3-98-80
9. SURFACE DEFECTS :- SHOULD NOT EXCEED 0.5 mm IN DEPTH
10. UN-SPECIFIED DRAFT ANGLE SHOULD NOT BE MORE THAN 7°
11. UN-SPECIFIED RADII 1.5 mm.
12. ALLOWANCES ARE AS PER II CLASS GOST 7505-74 : M2
13. TOLERANCES ARE AS PER II CLASS GOST 7505-74 AND AS FOLLOWS : C2
    VERTICAL $^{+0.9}_{-0.5}$
    HORIZONTAL $^{+1.1}_{-0.5}$
    DIE FORGING ON HAMMER
14. NUMBER OF PARTS OBTAINED FROM ONE DIE FORGING: ONE PIECE
15. DIMENSION BETWEEN BRACKETS ARE FOR MACHINING.
16. STAMPING OF CONVENTIONAL SEAL OF BLACK SMITH LETTERING 170-5 GOST 2930-62
17. RAW MATERIAL SIZE 260 $^{+2.3}_{-2.7}$ x 60.1 LONG (HOT ROLLED)
18. WEIGHT OF THE FORGING 0.130 Kgs.

E3 (5)	DA No.005/16, Dt.04.05.16 PP				
	(4)	DA.No. 006/98. Dt. 24-4-98.	24/4/98		
UPDATED		DA. NO. 022/97 Dt-23-3-97	23/3/97		
C (3)		DANO. 058/96 DT 27/6/96	27/6/96.		
B (2)		DA No. 027/95 Dt. 18-4-95	18-4-95		
(1)		STORE DRG. NO ADDED	(11.4.95 12.92		
SL. NO		AMENDMENTS	SIG. & DATE		

22/05/88		6.7.88		27/6/96	ORDNANCE FACTORY TIRUCHIRAPALLI-16
REDRAWN	CHECKED	APPROVED	I/C PROJ.	WM/PROJ:	

FOR COMPONENT NO (1)
2A42-05-025 - ROCKER

DRG NO:
64 C 5025 200 E 3

ALB. NO. 364/15