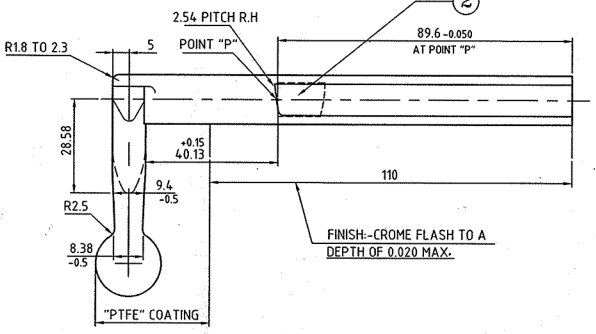
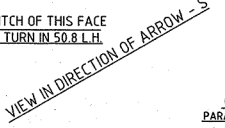
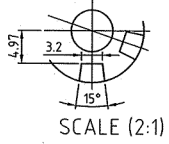
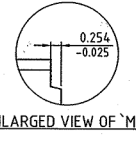


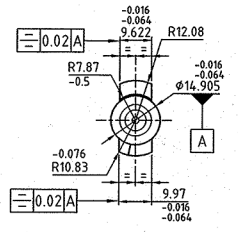
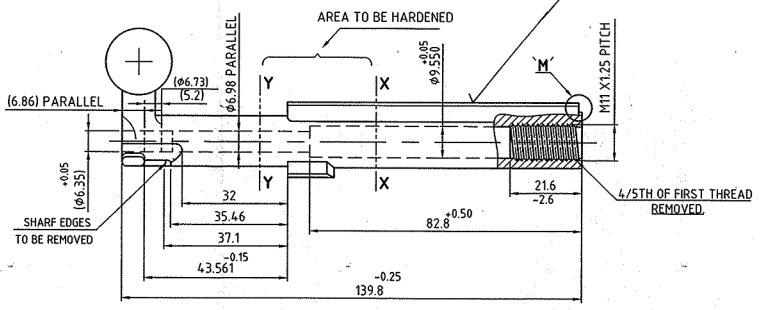
SECTION OF MILLING CUTTER 'Z'



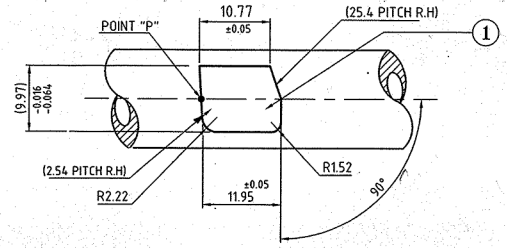
NOTE NO. 2  
 1. IN THE ZONE FOR CHROME FLASHING AND PTFE COATING, DIMENSIONALS SHOWN ARE BEFORE COATING.  
 2. CAM SHOULD BE MACHINED THROUGH CNC ROUTE ONLY.  
 3. EXTERNAL SURFACE SHOULD BE FROM TOOL MARKS AND SURFACE SHOULD BE FINISHED BY POLISHING



ENLARGED VIEW OF 'M'



ENLARGED VIEW



ENLARGED VIEW

MATERIAL :- B.S.970 Pt.1 :1983 Gr. 070 M55

NOTE FOR MACHINING THE PROFILE AT ZONE "Z":  
 TO FORM BODY SEATING AT 'Z'.  
 FIRST THE BOLT IS INVERTED AND TURNED CLOCK WISE ON ITS AXIS THROUGH AN ANGLE OF 40°45'.  
 SECOND THE AXIS OF THE BOLT IS INCLINED AT AN ANGLE OF 7°23' BY RAISING THE FRONT END.&  
 THIRD WHEN IN THE AFORESAID POSITION THE BOLT IS SET TO THE SIDES OF THE MILLING CUTTER 'Z' AT AN ANGLE OF 3°10' FROM THE REAR END.

NOTES:-  
 1. DIMENSIONS GIVEN ARE WHITE STAGE.  
 2. HELIX OF BOTH THE LUGS TO BE IDENTICAL TO ENSURE UNIFORMITY OF THE HELIX. HELIX MILLING TO BE PERFORMED ON THE CNC. POINT "P" ON THE EITHER SIDE SHOULD MAINTAIN SYMMETRICITY OF 0.025 mm.  
 3. HARDENING & TEMPERED AS FOLLOWS:-  
 SECTION LEFT OF "X-X" AND RIGHT OF LINE "Y-Y" TO A D.P.N. 300-400 (ROCKWELL 32C-41C) (1) & (2) TO HAVE A D.P.N. 440-600 (ROCKWELL 44C-54C) AND (3) A D.P.N. 300 MAX. (BRINELL IMPRESSION OF 2 mm. MIN. (USING 10mm.) (BALL WITH 1000 K.G. LOAD) BETWEEN THE POSITION OF X-X Y-Y 1,2 & 3 SHOWN.

NOTE No. 1:  
 1. THE ZONE BETWEEN 'XX' AND 'YY' TO BE INDUCTION HARDENED TO (500-600 YPN) 475-570 HB.  
 2. HARDNESS OF REMAINING PORTION SHALL BE MAINTAINED AT 280-300 HB. BY 'T' CONDITIONING BEFORE MACHINING.

FINISH:- "PTFE" COATING TO BE DONE ON THE ZONE SHOWN

DIMENSIONS ARE IN mm.  
 IMPORTANT DIMS. MARKED THUS @  
 INFORMATION MARKED THUS † TO BE MARKED ON UN TOLERATED DIMS. ASPER IS: 2102(MEDIUM)

Se. No.	1	BOLT, BREECH	1	AS ABOVE			
AWM/SKS	OIC/SRA	PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
			SIGNATURE & DATE				SCALE 1:1
			TRACED				STORE DRG. NO.
			DRAWN R. Naga				OPERATION NO. ---
			CHECKED				SHEETS: 1
			OIC/D&DO				SHEET No.: 1
			OFFICER/PRODM.				
			OFFICER/D&DO				
			SIG. & DATE				
			APPROVED ON 25/01/2008				



ORDNANCE FACTORY TRICHRAPPALLI-16.