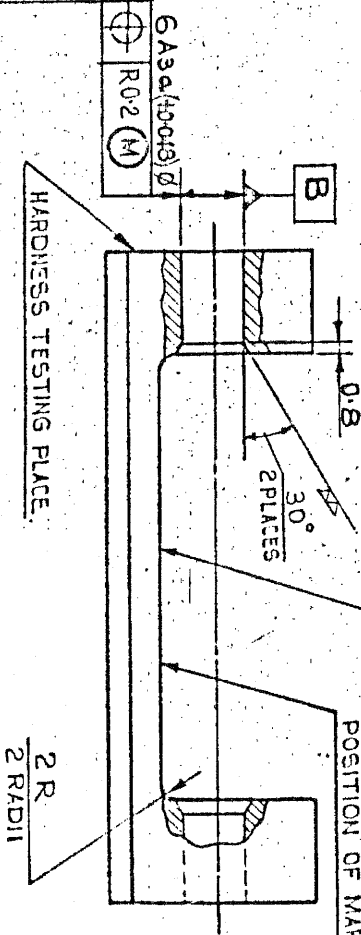
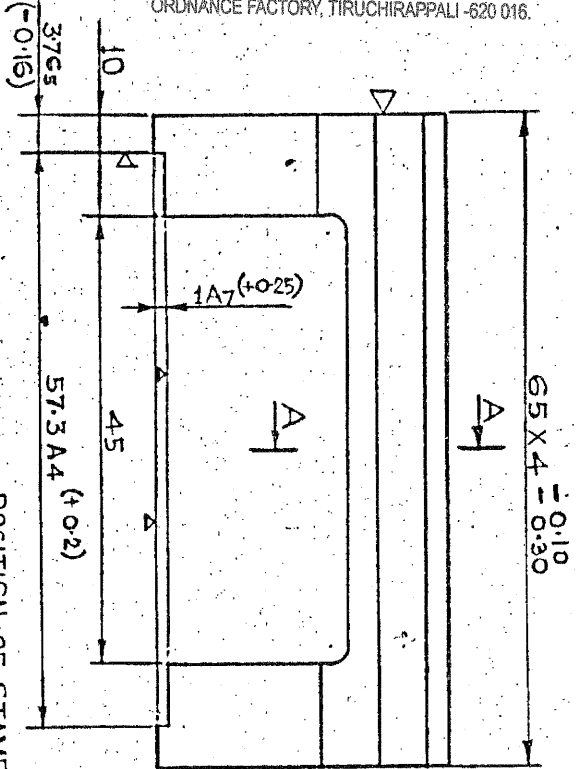


UN CONTROLLED COPY,
CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THIS DATE

DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.



LOCATIONAL TOLERANCE IN HOLE AXIS
0.2 ON RADII'S AT MMC.

MATERIAL FOR INDIA - IS:10343-1999 Gr.16Q

85-3146 BELT HLD - 306 24 12 6 R 1

RADIOGRAPHIC TEST AS PER ASTM E-192 WITH ACCEPTANCE STANDARD FOR GAS HOLE AND FOREIGN MATERIAL - LEVEL-5

SHRINKAGE (ALL TYPES) - LEVEL-3

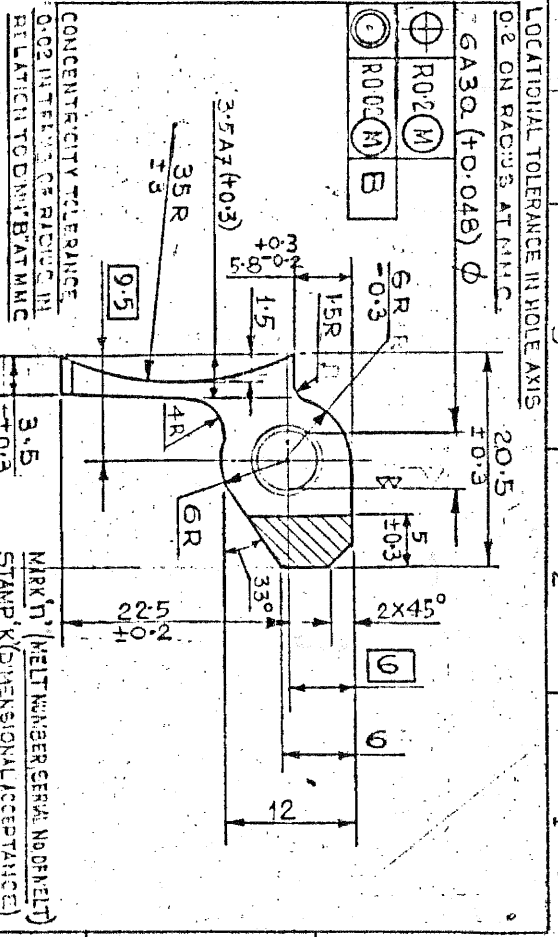
ALSO REFER GOA (MET) ICHAPUR INSPECTION INSTRUCTION NO. MDA-1104-11/12 DT.5.5-94 FOR OTHER DETAILS.

8 7 6 5 4 3 2 1

27194 SA	08.04.19	Material Comp. added on 22.02.2020
26991 SA	13.12.16	MATERIAL AMENDED 01.03.17
24961 SA	4-3	D.S. CAT NO. 3073-003452
24193 SA	24.10.98	MATERIAL FOR INDIA AMENDED
24097 SA	5-5-98	MATERIAL FOR INDIA AMENDED
22361 SA	10-2-95	MATERIAL FOR INDIA AND HARDNESS AMENDED.
21357 SA	29.8.91	DRAWING RE-DESIGNED, RE-DESIGNED AND PROV. R. SEALED.
		PREVIOUS DT. 14.05.1985, 24.10.98, 27.05.94, 27.4.94, 21.07.94

DATE	NAME	ACSY.	D.S. CAT NO.
15.06.96	DRN.	1005-007392	
15.06.96	CHD		
15.06.96	TRD		
15.06.96	COVP		
15.06.96	DT. B. A. D. I. C. D. O.		
15.06.96	SCALE: 2:1		
15.06.96	SEALED BY: PCOV. DC(O) 18.09.95-SA		
15.06.96	DT. 19.4.86		

PAWL BELT HOLDING	DESIGNER'S REF. 6N11 5-13
	30.40-003452



LOCATIONAL TOLERANCE IN HOLE AXIS
0.2 ON RADII'S AT MMC.

CONCENTRICITY TOLERANCE
0.02 INTERSECT OF RADII IN RELATION TO DMT BY AT MMC

DRAWING CONVENTIONS CONFORM TO IS: 696.

SURFACE FINISH - AS PER IS: 3073-1957 WHERE NOT SPECIFIED SHOULD BE ACCORDING TO THE STANDARD MACHINING.

MATERIAL: STEEL 35XFC1 GOST 977-75.

TECHNICAL REQUIREMENT FOR CASTINGS ARE AS PER TY B3-85-88 GR.2.

CHEMICAL COMPOSITION AS PER GOST 977-75.

MATERIAL COMPOSITION

a) Chemical composition conforming to OEM Material Gr. Steel 35XFC1 of GOST- 977-75 to be used to achieve specified Mechanical properties of OEM OR IS:10343-1999 Gr. 16-Q

b) Material composition is as under:-

%C	1.00	%Si	0.60	%Mn	0.30	%S&P	0.040
0.40	1.30	0.80	0.90	Max.	Max.		

REMARKING TECHNICAL REQUIREMENTS ARE AS PER EN11 TY. SPECIFICATIONS. ROUGHNESS OF CAST SURFACES ARE AS PER STANDARD. 1 PATTERN DRAFTS ARE UP TO 1° UNSPECIFIED MOULD RADIUS UP TO 1 mm.

DISPLACEMENT ALONG THE PLANE OF HOUL D PARTING UP TO 0.2 mm. PLUNGER MARKS ARE PERMITTED UP TO 0.2 mm.

HARDNESS:- 261 TO 436 HB.

INTERNAL CORNERS ARE 0.2R. SHARP EDGES TO BE BLUNTED 0.2.

COATING:- ELECTROLESS ACCELERATED PHOSPHATING. OIL FINISH.

COATING/PROTECTIVE FINISH FOR WORKING PROSPHATE TO SPEC. Q. 55-1405-01:1988 CLASS II, OIL FINISH.

COA(SA) ICHAPUR

APPROVED DT. 7.1.96

NEGATIVE PREPARED

DESIGNER'S REF. 6N11 5-13

30.40-003452