

OS.CAT.1005-001578

DIMENSIONS IN MM

FOR EXPLANATION OF DIMENSIONING ETC. SEE D.D. NOTE SHEET NO.3 (LATEST ISSUE)

NOTE:-
CONTRACTOR'S CODE & YEAR OF MANUFACTURE IN 3 mm. SIZE TO BE STAMPED OR ENGRAVED WHERE SHOWN THUS ⊕

D.S.CAT. NO. TO BE STAMPED / ENGRAVED IN 3 mm. SIZE WHERE SHOWN THUS †

THE TEMPERING TEMPERATURE MAY BE CHANGED TO OBTAIN THE SPECIFIED HARDNESS, BUT IT SHOULD BE BETWEEN 500°C - 550°C.

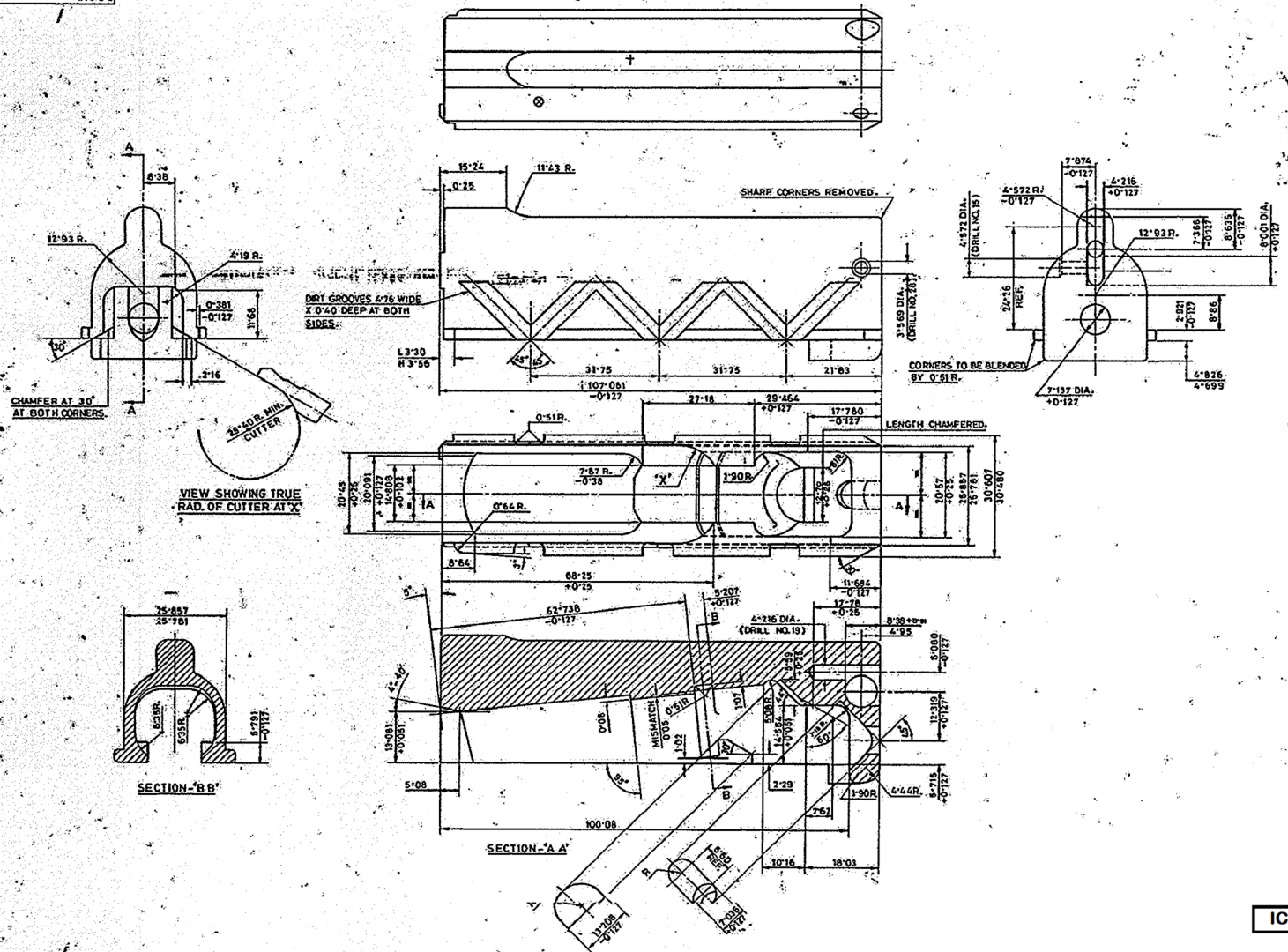
ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSIONS FOR STEEL:
1. MACRO ETCH TEST AS PER ASTM E-281
2. NMIR TEST AS PER IS: 4163-81

FOR SPECN. LATEST ISSUE SHOULD BE FOLLOWED.

MATERIAL:- IS: 5517-1993, DESIGN. 40NiCr4Mo3

HEAT TREATMENT TO BE CARRIED OUT ON THE FINISHED MACHINED COMPONENT AS PER FOLLOWING SCHEDULE:-

- i) NORMALISE AT 875°C.
- ii) HARDEN IN OIL BETWEEN 820°C TO 850°C
- iii) TEMPER BETWEEN 530°C TO 550°C
- iv) STRESS RELIEVE BETWEEN 200°C



ICR - 1268

METRIC.

11.06.19	1978/54	MATL. AMENDED AMEND. No. 003/15 DL 19.08.15	PUVI	DRN. SCALE: -	END.	TRD. KOMP	AHSP CQA(SA), ICHAPUR.
		METAL RE-TRACED AND DRAWING RE-SEALED.		DL 29.10.2000	APPROVED	EST. MASS. DL 19.8.82	ASSY. 1005-001577
		REVISIONS: 01-02-1978, 03-01-1978, 04-01-1978, 05-01-1978, 06-01-1978, 07-01-1978, 08-01-1978, 09-01-1978, 10-01-1978, 11-01-1978, 12-01-1978, 13-01-1978, 14-01-1978, 15-01-1978, 16-01-1978, 17-01-1978, 18-01-1978, 19-01-1978, 20-01-1978, 21-01-1978, 22-01-1978, 23-01-1978, 24-01-1978, 25-01-1978, 26-01-1978, 27-01-1978, 28-01-1978, 29-01-1978, 30-01-1978, 31-01-1978, 01-02-1978, 02-02-1978, 03-02-1978, 04-02-1978, 05-02-1978, 06-02-1978, 07-02-1978, 08-02-1978, 09-02-1978, 10-02-1978, 11-02-1978, 12-02-1978, 13-02-1978, 14-02-1978, 15-02-1978, 16-02-1978, 17-02-1978, 18-02-1978, 19-02-1978, 20-02-1978, 21-02-1978, 22-02-1978, 23-02-1978, 24-02-1978, 25-02-1978, 26-02-1978, 27-02-1978, 28-02-1978, 29-02-1978, 30-02-1978, 31-02-1978, 01-03-1978, 02-03-1978, 03-03-1978, 04-03-1978, 05-03-1978, 06-03-1978, 07-03-1978, 08-03-1978, 09-03-1978, 10-03-1978, 11-03-1978, 12-03-1978, 13-03-1978, 14-03-1978, 15-03-1978, 16-03-1978, 17-03-1978, 18-03-1978, 19-03-1978, 20-03-1978, 21-03-1978, 22-03-1978, 23-03-1978, 24-03-1978, 25-03-1978, 26-03-1978, 27-03-1978, 28-03-1978, 29-03-1978, 30-03-1978, 31-03-1978, 01-04-1978, 02-04-1978, 03-04-1978, 04-04-1978, 05-04-1978, 06-04-1978, 07-04-1978, 08-04-1978, 09-04-1978, 10-04-1978, 11-04-1978, 12-04-1978, 13-04-1978, 14-04-1978, 15-04-1978, 16-04-1978, 17-04-1978, 18-04-1978, 19-04-1978, 20-04-1978, 21-04-1978, 22-04-1978, 23-04-1978, 24-04-1978, 25-04-1978, 26-04-1978, 27-04-1978, 28-04-1978, 29-04-1978, 30-04-1978, 31-04-1978, 01-05-1978, 02-05-1978, 03-05-1978, 04-05-1978, 05-05-1978, 06-05-1978, 07-05-1978, 08-05-1978, 09-05-1978, 10-05-1978, 11-05-1978, 12-05-1978, 13-05-1978, 14-05-1978, 15-05-1978, 16-05-1978, 17-05-1978, 18-05-1978, 19-05-1978, 20-05-1978, 21-05-1978, 22-05-1978, 23-05-1978, 24-05-1978, 25-05-1978, 26-05-1978, 27-05-1978, 28-05-1978, 29-05-1978, 30-05-1978, 31-05-1978, 01-06-1978, 02-06-1978, 03-06-1978, 04-06-1978, 05-06-1978, 06-06-1978, 07-06-1978, 08-06-1978, 09-06-1978, 10-06-1978, 11-06-1978, 12-06-1978, 13-06-1978, 14-06-1978, 15-06-1978, 16-06-1978, 17-06-1978, 18-06-1978, 19-06-1978, 20-06-1978, 21-06-1978, 22-06-1978, 23-06-1978, 24-06-1978, 25-06-1978, 26-06-1978, 27-06-1978, 28-06-1978, 29-06-1978, 30-06-1978, 31-06-1978, 01-07-1978, 02-07-1978, 03-07-1978, 04-07-1978, 05-07-1978, 06-07-1978, 07-07-1978, 08-07-1978, 09-07-1978, 10-07-1978, 11-07-1978, 12-07-1978, 13-07-1978, 14-07-1978, 15-07-1978, 16-07-1978, 17-07-1978, 18-07-1978, 19-07-1978, 20-07-1978, 21-07-1978, 22-07-1978, 23-07-1978, 24-07-1978, 25-07-1978, 26-07-1978, 27-07-1978, 28-07-1978, 29-07-1978, 30-07-1978, 31-07-1978, 01-08-1978, 02-08-1978, 03-08-1978, 04-08-1978, 05-08-1978, 06-08-1978, 07-08-1978, 08-08-1978, 09-08-1978, 10-08-1978, 11-08-1978, 12-08-1978, 13-08-1978, 14-08-1978, 15-08-1978, 16-08-1978, 17-08-1978, 18-08-1978, 19-08-1978, 20-08-1978, 21-08-1978, 22-08-1978, 23-08-1978, 24-08-1978, 25-08-1978, 26-08-1978, 27-08-1978, 28-08-1978, 29-08-1978, 30-08-1978, 31-08-1978, 01-09-1978, 02-09-1978, 03-09-1978, 04-09-1978, 05-09-1978, 06-09-1978, 07-09-1978, 08-09-1978, 09-09-1978, 10-09-1978, 11-09-1978, 12-09-1978, 13-09-1978, 14-09-1978, 15-09-1978, 16-09-1978, 17-09-1978, 18-09-1978, 19-09-1978, 20-09-1978, 21-09-1978, 22-09-1978, 23-09-1978, 24-09-1978, 25-09-1978, 26-09-1978, 27-09-1978, 28-09-1978, 29-09-1978, 30-09-1978, 31-09-1978, 01-10-1978, 02-10-1978, 03-10-1978, 04-10-1978, 05-10-1978, 06-10-1978, 07-10-1978, 08-10-1978, 09-10-1978, 10-10-1978, 11-10-1978, 12-10-1978, 13-10-1978, 14-10-1978, 15-10-1978, 16-10-1978, 17-10-1978, 18-10-1978, 19-10-1978, 20-10-1978, 21-10-1978, 22-10-1978, 23-10-1978, 24-10-1978, 25-10-1978, 26-10-1978, 27-10-1978, 28-10-1978, 29-10-1978, 30-10-1978, 31-10-1978, 01-11-1978, 02-11-1978, 03-11-1978, 04-11-1978, 05-11-1978, 06-11-1978, 07-11-1978, 08-11-1978, 09-11-1978, 10-11-1978, 11-11-1978, 12-11-1978, 13-11-1978, 14-11-1978, 15-11-1978, 16-11-1978, 17-11-1978, 18-11-1978, 19-11-1978, 20-11-1978, 21-11-1978, 22-11-1978, 23-11-1978, 24-11-1978, 25-11-1978, 26-11-1978, 27-11-1978, 28-11-1978, 29-11-1978, 30-11-1978, 31-11-1978, 01-12-1978, 02-12-1978, 03-12-1978, 04-12-1978, 05-12-1978, 06-12-1978, 07-12-1978, 08-12-1978, 09-12-1978, 10-12-1978, 11-12-1978, 12-12-1978, 13-12-1978, 14-12-1978, 15-12-1978, 16-12-1978, 17-12-1978, 18-12-1978, 19-12-1978, 20-12-1978, 21-12-1978, 22-12-1978, 23-12-1978, 24-12-1978, 25-12-1978, 26-12-1978, 27-12-1978, 28-12-1978, 29-12-1978, 30-12-1978, 31-12-1978	AS STATED.	ARDE NO. 657/46			
DATE AUTH.:	BRIEF RECORD.	ZONE (K/CD) G.O.	H.L/HARDNESS:- 415-465 HV. (57-60.5 HRD)				
SEALED:-	D.C. NO. 14977-5A, DL 7.01.77.	SIGN.	PROTECTIVE PHOSPHATE TO SPECN. JSS 1 0465-01-1888 CLASS I, OIL FINISH.				
NOMENCLATURE:- CARRIER BREECH BLOCK.							
PART NO. OS.CAT.1005-001578							