



CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE.....

17.11.2020

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY

NOTE :- ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL
I. MACRO ETCH TEST AS PER ASTM E 381 WITH ACCEPTANCE STANDARD C₁, R₂ & B₂
II. NMR TEST AS PER IS: 4163

STRESSED COMPONENT

- NOTES :-
1. DIMENSIONS ARE IN mm.
 2. FIRST ANGLE PROJECTION.
 3. SCALE:- 1:1
 4. FORGING OF GROUP III AS PER GOST 8479-70, HB 217 MAX.
 5. DRAFT ANGLE 7°.
 6. UN-SPECIFIED RADII 2.5R.
 7. FLASH REMAINDER UP TO 0.5 mm.
 8. WARPING UP TO 0.8 mm.
 9. DIE SHIFTING UP TO 0.4 mm.
 10. CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
 11. STAMP PART NO, MELT NO. AND Q.C.D STAMP
 12. 100% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
 13. WEIGHT OF THE FORGING 0.500 Kgs.

HEAT-TREATMENT:-FORGINGS ARE NORMALIZED AND TEMPERED. FOR HEAT-TREATMENT SCHEDULE REFER DRAWING NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 7 SLNO: 25.

MATERIAL:- STEEL 40X GOST 4543-71

MATERIAL FOR INDIA IS: 5517-1983 DESIGN: 41Cr4 M2 LR-30mm
 (C) BS-970-PT. 1-1983 GR. 530 M-40 (-BS-970-1955-EN-18-1)
 -OR-
 BS-970-PT. 1-1983 GR. 709 M-40 (-BS-970-1955-EN-19-1)
 -OR-
 BS-970-PT. 1-1983 GR. 708 M-40 (-BS-970-1955-EN-19-A-1)

VETTED FOR MATERIAL ONLY

[Signature]
Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Annis)
Tiruchirappalli - 620 016.

COMPONENT DRG. NO. 6P11-9-1
HANDLE COCKING

DRAWING PROVISIONAL

DS.CAT NO. 1005007413

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|------------|-------------------------------------|------------|
| C | 004/17 DF-0109-17 MATERIAL ENDED | |
| B | ALTERNATE MATL.'EN'SERIES ADDED | |
| AMENDMENTS | DESCRIPTION/DETAILS | SIG & DATE |

| | | | | | | |
|-------------------------------|-------------------------------|-------------------|----------------------------------|-----------------------------------|---|--------------------------------|
| <i>[Signature]</i> REDRAWN | <i>[Signature]</i> CHECKED | 11.87 APPROVED | <i>[Signature]</i> I/C. D&DO. | <i>[Signature]</i> DIV.OFFICER | ORDNANCE FACTORY, TIRUCHIRAPALLI-16. | DRG. NO: 62 C 3901 200. C 3 |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 |