



- 1) THIS DOCUMENT IS THE PROPERTY OF THE GOVERNMENT OF INDIA M. OF D. AND IS ISSUED FOR PURPOSE OF DEVELOPING/MANUFACTURING STORES REQUIRED FOR DEFENCE USE.
- 2) IT MUST NOT BE REPRODUCED/DISCLOSED TO ANY THIRD PARTY OR USED FOR ANY CIVIL PURPOSES.
- 3) IT MUST BE RETURNED TO THE ISSUING AUTHORITY WHEN THE PURPOSE OF ITS ISSUE HAS BEEN SERVED.
- 4) PILOT SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.

NOTE - 1 -

- 1) FORGING DRAFTS 2°.
- 2) UNSPECIFIED FORGING RADIUS 3mm MAXIMUM.
- 3) FORGING SHOULD BE ULTRASONICALLY TESTED AS PER SPECIFICATION IS: 8791-1978 CLASS-A FOR CRACK DETECTION & FREE FROM INTERNAL & EXTERNAL DEFECTS.
- 4) MANUFACTURER'S INITIAL/CODE NO., YEAR OF MANUFACTURE SHOULD BE ENGRAVED AT SUITABLE PLACE.

NOTE--ALLOY STEEL FORGING 40 Ni6 Cr4 Mo3  
CONDITION-N TO SPEC IS: 4367-1991

ALTERNATE MATL--ARMOUR STEEL TO SPEC FVRDE IT 80F

DRG/SC/281/DRG/VETT/UC	9-2-82
DRG/SC/281/DRG/VETT/UC	20-10-10
DRG/SC/281/DRG/VETT/UC	6-3-87
DRG/VC/281/DRG/VETT/UC	26-2-05
DRG/VETT/DDO/PD/06	10-2-04

P. NO.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
(A)	DRG. VETT/AS PER DRG. NO. V348/29/6/037				10-2-04		

  

GEN. TOL. NOT SPECIFIED	0-6	0.1
LINEAR DIMENSIONS	6-30	0.3
	30-120	0.5
	120-305	0.8
	305-1200	1.2
	1200-3000	2.0
ANGULAR DIMENSIONS	0-90	±30'
	90-180	±20'
	180-270	±10'
	270-360	±10'

  

UNMACHINED	✓
ROUGH	✓
SMOOTH	✓
FINISH	✓

  

INDEX	AMENDMENTS	SIGN	DATE

  

2004	NAME	DATE	APPROVED
DRN.	JIRAM	29.01.04	
TCD.			JVM/Shog
CKD.			
PASSED			JVM/TR

  

SEC.	1 M/C	JVM/DDO
SCALE	REF. DEMD. NO. 28/PD/VF/MAT DR. 25/01/04	
1:1	REF. DRG. NO. V348/29/6/037	

  

DRG. NO. GCFMN 5417(A)	SHEET NO. 01	SHEETS
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PAD ELEVATING

CYLINDER

(FORGING)

GUN CARRIAGE FACTORY, AMRABUR