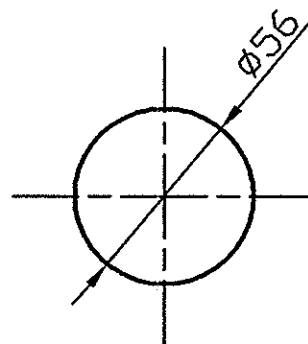
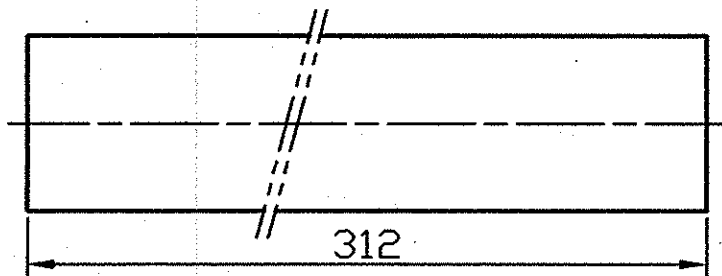


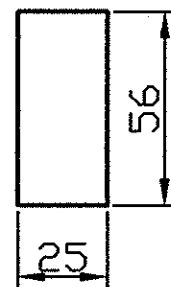
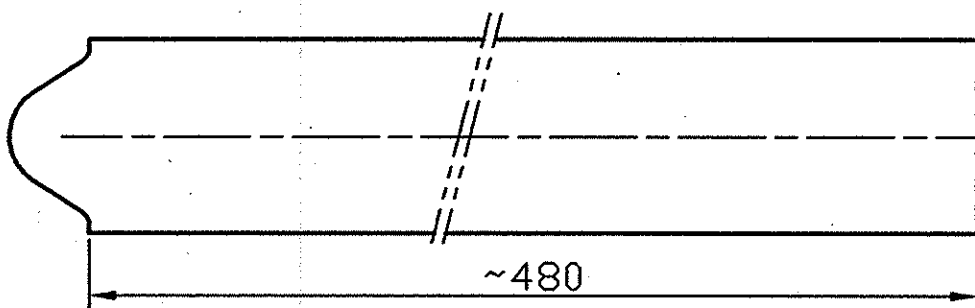
DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

BLANK BEFORE FORGING



BLUNT SHARP EDGES TO R 0.6mm

BLANK AFTER FORGING (FOR 3 COMPTS.)



MATERIAL :- 30XH2M0A OST 3-98-80

ALT. MATERIAL :- BS 970 PT. 1 1983 GR. 826 M31 CONDITION 'Z' OR IS:5517 DESIGN. 31 Ni10 Cr3 Mo6 WITH 'S' & 'P' CONTENT 0.025% MAX. EACH. LRS 63mm UTS 1550MPa MIN.

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
 TRACED DRAWN <i>gm</i> CHECKED OIC/D&DO <i>J. Venkatesh</i> OFFICER/PRODN. OFFICER/D&DO	SIGNATURE & DATE.	SUB: BLANK BEFORE & AFTER FORGING			SCALE NTS
		FOR: RIB			STORE DRG.NO. C 1079
		OF: 30mm CANNON			OPERATION NO.
		DES. REF. NO.			SHEETS: 01
		DRG. No.: TEND 2097			SHEET No.: 01
		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			
AMENDMENTS	SIG. & DATE	APPROVED ON. 04/2009			