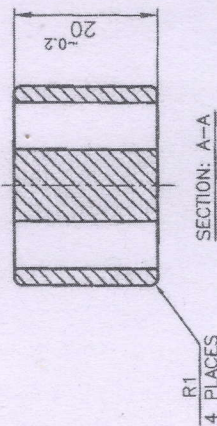
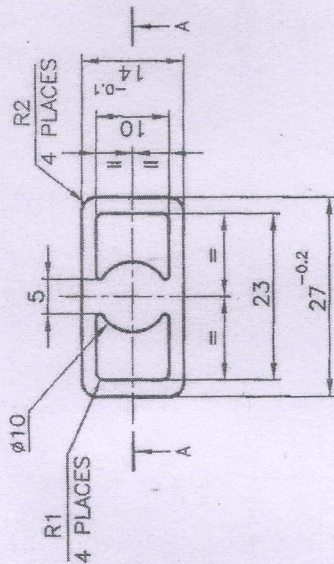


DRG. No.:



DIMENSIONS ARE IN mm.
DRAFT ANGLE FOR HOLES 1°
CASTING RADII R 1mm

UNTOLERATED DIMNS ARE AS PER IS : 11166-1984 CLASS I OF INVESTMENT CASTING. CASTING TO BE SUPPLIED IN NORMALISED CONDITION.

MATERIAL:-
BS:3146 PART -1: 1974
TYPE - CLASS: 5 GRADE-A
(NON STRESSED COMPONENT)
 $S > 0.020\%$
 $P > 0.025\%$

RADIOGRAPHIC TEST AS PER ASTM-E-192

ACCEPTENCE STANDARD:-

GAS HOLE & FOREIGN MATERIAL: LEVEL-5.
SHRINKAGE (ALL TYPES) - LEVEL 3

HARDNESS: RC 26-34

CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, SURFACE FINISH MUST BE SMOOTH.

TEN NUMBERS OF SAMPLES TO BE SUPPLIED FOR QUALITY CLEARANCE AT DFT BEFORE BULK SUPPLY.

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE 28.05.17

FOR 40mm MGL & 38mm MSL

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY

PART NO.	DESCRIPTIONS & DATE	NO OFF	MATERIAL	TREATMENT	REMARKS
	SUB: CASTING DRG				SCALE NTS
	FOR: BLOCK LOCATING				STORE DRG NO. 30P13028
	OF: 40mm MGL & 38mm MSL				33P1303
	DES. REF. NO.				OPERATION NO.
	DRG. No.: TEND 2212 *3				SHEETS: 1
					SHEET No.: 1

AMENDMENTS & DATE
 PA No. 07/17
 DL 09/05/18
 DA No. 116/13
 DL 14/09/2013
 SIG. & DATE

ORDNANCE FACTORY
TIRUCHIRAPPALLI-16.