

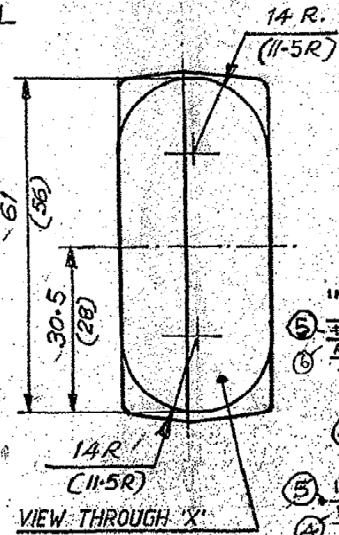
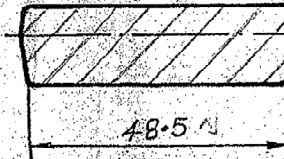
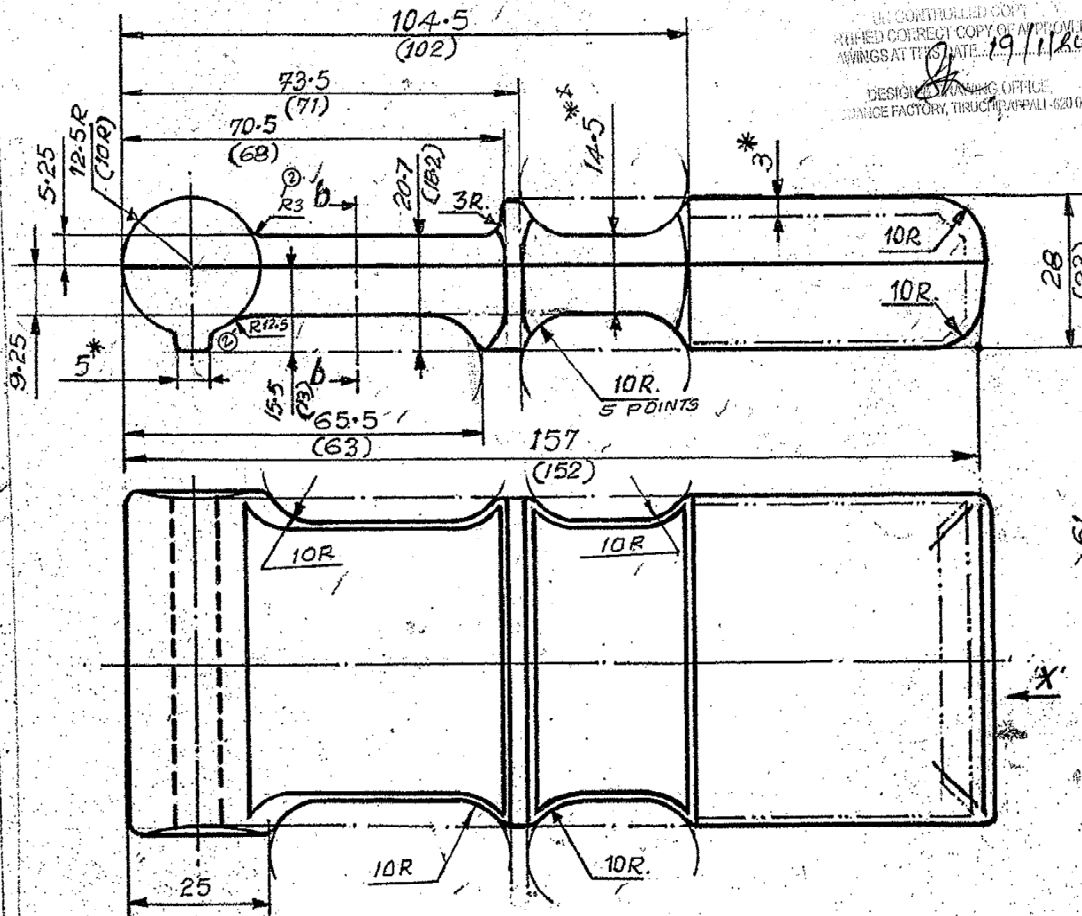
FORGING DRAWING

CHEMICAL COMPOSITION OF THE MATERIAL - 30XH2M0A

C	0.27-0.34	Si	0.17-0.37
Mn	0.3-0.6	Cr	0.6-0.9
Ni	2.0-2.4	Mo	0.2-0.3
V	0.10-0.18	P	0.025 MAX
S	0.025 MAX.	Cu	0.3 MAX.

UNCONTROLLED COPY  
 WITHED CORRECT COPY OF APPROVED  
 DRAWINGS AT THIS DATE... 19/11/84  
 DESIGN & DRAWING OFFICE  
 ORDNANCE FACTORY, TIRUCHIRAPALLI-620016.

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HEAT-TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO.	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	REMARKS
HOLDER	30XH2M0A	NORMALIZATION HEATING	ELECTRIC CHAMBER FURNACE	850-970	3 HRS	AIR	ON TRAY
E. 1026		HIGH TEMPERING HEATING	ELEC. CHAMBER FURNACE OR ELEC. SHAFT FURNACE	660-680	5 HRS	WITH FURNACE UP TO 500°C & IN AIR	ON TRAY

1. DRESS THE PLACE FOR CHECKING HARDNESS  
 2. CHECK HARDNESS

INDIGENOUS MATERIAL: BS 970 PART 1-83 GR. 26 M31 C

IS: 5517 GR 30 Ni 10 Cr 8 Mo 6 LRS 30mm  
 AUTHORITY: CGA (METALS) (CHAPUR) LY. NO. MQA-3 (TS) B1  
 DE/MS-6

THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF HRC3 39.5 TO 46.5 AFTER FINAL HEAT TREATMENT

INDIGENOUS MATERIAL / BS 970 PART 1-83 GRADE 8 M31 IN 2/ CONDITION (OR) IS: 5517/93 DESIGN 30 Ni 10 Cr 8 Mo 6 LRS 30mm

A SEPARATE TEST SAMPLES IS TO BE HEAT TREATED AND TESTED IN 2 CONDITION

- DIMENSIONS ARE IN mm.
- HEAT-TREATMENT - NORMALIZATION & HIGH TEMPERING HARDNESS HB-255 MAX.
- DE-SCALING - PICKLING.
- DISPLACEMENT IN PARTING LINE SHOULD NOT BE MORE THAN 0.5 mm
- REMAINDER FLASH ALONG DIE-PARTING LINE SHOULD NOT EXCEED 0.8 mm
- FIRST ANGLE PROJECTION
- CURVATURE OF ROD SHOULD NOT EXCEED 0.8 mm
- SCALE - 1:1
- SURFACE DEFECTS SHOULD NOT EXCEED 0.5 mm DEPTH
- UN-SPECIFIED DRAFT ANGLE 7°
- UN-SPECIFIED RADII 2.5mm
- ALLOWANCES ARE AS PER II CLASS GOST 7505-74 M2
- TOLERANCES ARE AS PER II CLASS GOST 7505-74 C2 AND AS FOLLOWS

- DIE FORGING BY HAMMER
- NUMBER OF PARTS OBTAINED FROM ONE DIE FORGING: 1 PIECE
- DIMENSIONS BETWEEN BRACKETS ARE FOR MACHINING
- STAMP CONVENTIONAL STAMP OF BLACK SMITH 705 GOST 2930-62
- MATERIAL - 30XH2M0A-a OST 3-98-80
- RAW MATERIAL SIZE - 450 x 165 x 15 LONG (HOT ROLLED)
- WEIGHT OF THE FORGING 1.50 Kgs
- DIMENSIONS MARKED \* ARE TECHNOLOGICAL ALLOWENCE
- DIMENSIONS MARKED # ARE GIVEN FOR INSPECTION
- QUALITY OF ANGLE FILLING IN LAP IS NOT TO BE CHECKED

VERTICAL +1.5  
 -0.7  
 HORIZONTAL +1.7  
 -0.9

DA NO. 66/98 DT. 22/7/98	DA NO. 52/98 DT. 26/10/98
DA NO. 022/95 DT. 4/95	DA NO. 052/97 DT. 11/8/97
DA NO. 52/98 DT. 26/10/98	DA NO. 052/97 DT. 11/8/97
DA NO. 022/95 DT. 4/95	DA NO. 052/97 DT. 11/8/97

VETTED FOR MATERIAL ONLY  
 AS PER LAST DG (I) No. 18426  
 DT. 28-2-98

FOR COMPONENT NO  
 2A42-01-026 - HOLDER

Redrawn	Checked	Approved	I/C. PROJ.	WM/PROJ.	ORDNANCE FACTORY TIRUCHIRAPALLI-16	ORG NO. 64 C 1026 200
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