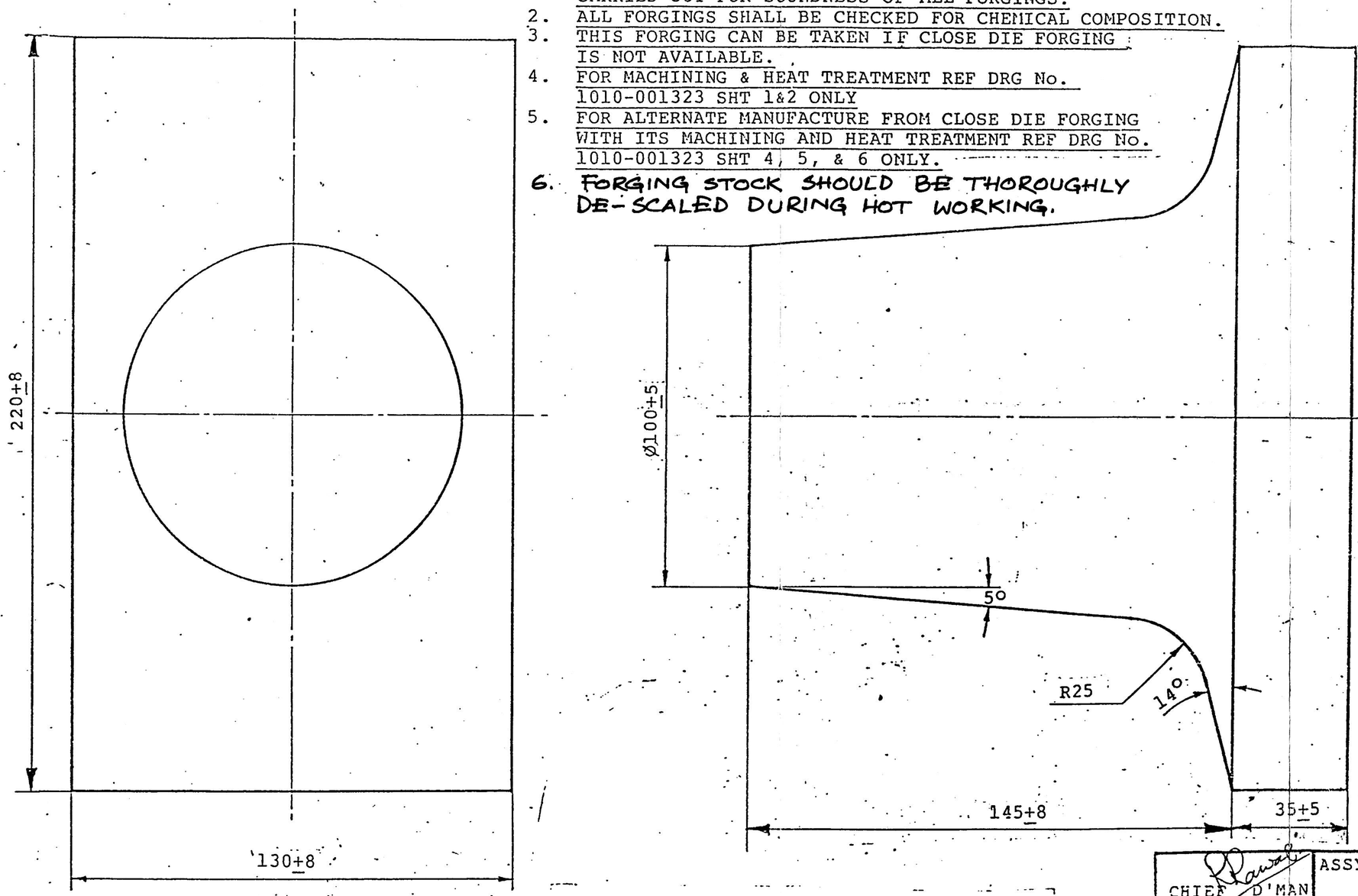
PART No/DS CAT No.	DRG CONVENTIONS CONFORM TO IS:696.
1010-001323	DIMENSIONS ARE IN mm.
6SHTS SHT3	TOLS. FOR UNTOLERANCED LINEAR DIMNS. IS:2102 (MED. CL)

NOTES:-

1. MAGNETIC CRACK DETECTION TEST SHALL BE CARRIED OUT FOR SOUNDNESS OF ALL FORGINGS.
2. ALL FORGINGS SHALL BE CHECKED FOR CHEMICAL COMPOSITION.
3. THIS FORGING CAN BE TAKEN IF CLOSE DIE FORGING IS NOT AVAILABLE.
4. FOR MACHINING & HEAT TREATMENT REF DRG No. 1010-001323 SHT 1&2 ONLY
5. FOR ALTERNATE MANUFACTURE FROM CLOSE DIE FORGING WITH ITS MACHINING AND HEAT TREATMENT REF DRG No. 1010-001323 SHT 4, 5, & 6 ONLY.
6. FORGING STOCK SHOULD BE THOROUGHLY DE-SCALED DURING HOT WORKING.



NOTE:- NON METALLIC INCLUSION RATING TEST IS TO BE CARRIED OUT AS PER IS:4163-1982 AND ACCEPTANCE STANDARD SHOULD BE AS UNDER:-

TYPE OF INCLUSION	SERIES (THIN)	SERIES (THICK)
A	2	BETTER THAN LEVEL-1
B	2	BETTER THAN LEVEL-1
C	2	BETTER THAN LEVEL-1
D	2	BETTER THAN LEVEL-1

MATERIAL:-
STEEL B.S.:970 Pt 1: 1983
GRADE 817 M40.

*ब्रीच बेस ('टी' टाइप ओपन फोर्जिंग)

FOR ROUGH MACHINING SEE 1010-001323 SHT2.

DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO
05-8-05	18927-W		PROV. SEALING CANCELLED & DRG. SEALED.		
20-9-82	15812-W		DRG. SEALED PROV.		
22-10-03	18813-W		HINDI NOMEN. ADDED.		
6.10.93	17741-W		A2 SIZE DRG REDUCED TO A3 PREV. DC(I) Nos. 15812-W, 15843-W 16222-W, 16278-W, 16431-W, 16561-W & 16603-W/19.11.87		
24-8-12 (*)	NOTE ADDED. (AS PER L/No- CQA/07/45/12) DTD 28/6/12				
18983-W 10-7-06	NOTE & CHART ADDED ON DRG.				

AMENDMENTS

CHIEF D'MAN
DO
AHSP
FOR CQA(W)
DRG SEALED:- 18927-W 05-8-05
DO CQA(W)

ASSY DRG
ESTD MASS
DATE
SCALE - NTS
DRN
CHD

CQA(W) JABALPUR

DESIGN No. ARDE 1917/3 — 3 SHTS SHT 3
PART No. IMR 477 — SHT 3
DS CAT No. 1010-001323 — 6SHTS SHT3

BREECH BASE
('T' TYPE OPEN FORGING)

REDUCED AT CQA(W) JABALPUR
PREPARED BY NSC CHECKED BY
DATE 15-4-94.