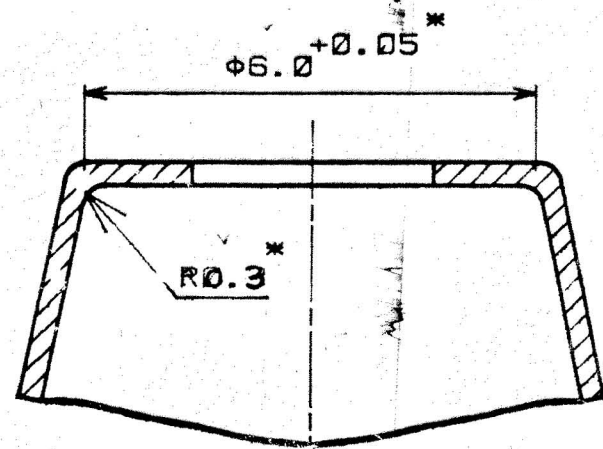
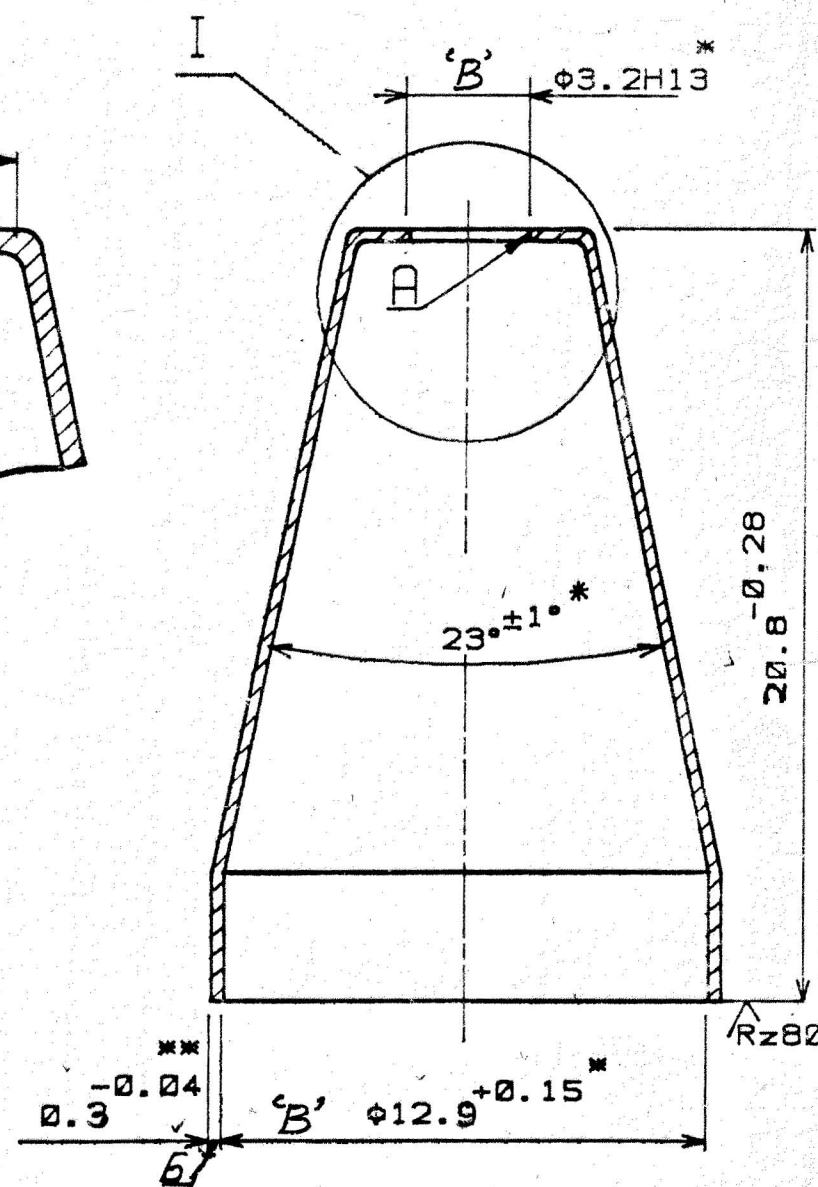


DRG.NO: FS-2498 B



VIEW AT 'I'
SCALE: 10:1



- ⊗ HARDNESS VALUE SHOULD BE BETWEEN 90 TO 110 HV.
- Part should be manufactured with single technical annealing at a temperature of 600...700°C with holding time for 25...30 minutes which is carried out before final sizing. ⊗
 - Alternate material is Band 08kπ-OM-T; 08-OM-B-08kπ-OM-T-ω Gost 503-81 not lower than second group.
 - *Dimensions ensured by tool.
 - **Dimensions for reference.
 - Disturbance of metal continuity of part by the action of 0.02 MPa pressure for 5 seconds.
 - Though surface treatment is not to be done, surface of the component should be properly protected to avoid storage and transit deterioration.
 - packing should be in roll condition.
 - Other requirements are as per GOST B84-264-81.

9. INDIGENOUS MATL:-

IS: 513-2008 Gr. CR3 OR Gd ICS OF BS: 1449 SECTION 1.1:1991.

DIA.S MARKED 'B' TO BE CONCENTRIC WITH IN 0.05.

DIMNS.	TOL.
φ3.2H13	+0.100

REV	DATE	DESCRIPTION	SIGN
B	18/10/13	NOTE NO. 9 AMENDED. AS PER DC 37327-A DTD. 18-12-2012.	ANM/FS
A	20/4/11	DC 36855A Dt 30/9/08 In note 1. Hardness value added.	ANM/FS
AMENDMENTS			

DIMENSIONS ARE IN mm.		
THIRD ANGLE PROJECTION		
SCALE: 5:1		
2004	NAME	DATE
DRAWN	ANM	27.2.04
TRACED		
CHECKED	Sushobh	27.2.04
JWM/CDO	Bernal	28.02.04
JtGM/FS	M.W.	02/3/04

MATERIAL: AS Above

NOMENCLATURE:
CAP
(With out Treatment)

MIC:
STORE:
F A 670M (30 mm)

आर्डनेंस फॅक्टरी अम्बाहारी
ORDNANCE FACTORY AMBAJHARI

ड्राइंग नं. DRG. NO:
FS-2498 B

SHEET NO.: 1

NO OF SHEETS: 1

OPERATION NO: -

COMPT.: 3-012 6082
(6WB 635.541-01)