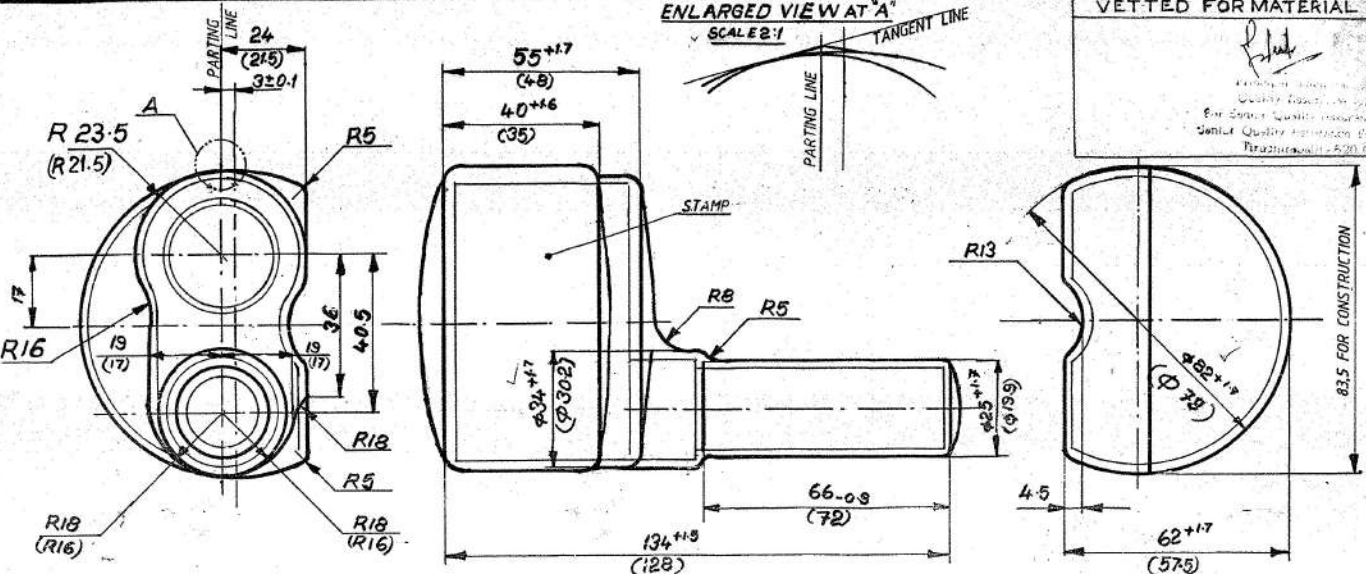


1 2 3 4 5 6 7 8



VETTED FOR MATERIAL ONLY

[Signature]

Senior Quality Assurance Officer,
 Senior Quality Assurance Officer,
 Tiruchirappalli - 620 015.

- NOTES:-
1. DIMENSIONS ARE IN mm.
 2. FIRST ANGLE PROJECTION.
 3. SCALE:- 1:1
 4. FORGING OF GROUP III AS PER GOST 8479-70, HB 217 MAX.
 5. DRAFT ANGLE 7°
 6. UN-SPECIFIED RADII 3 R.
 7. FLASH REMAINDER UP TO 1.0 mm.
 8. WARPING UP TO 0.8 mm.
 9. DIE SHIFTING UP TO 0.7 mm.
 10. CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
 11. STAMP PART NO, MELT NO. AND Q.C.D STAMP ON THE FORGINGS.
 12. 100% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
 13. WEIGHT OF THE FORGING 2.310 Kgs.

ALTERNATE MATERIAL : IS: 5517-1993 DESIGN: 42CH 40Z
 STEEL GRADE EN 19 BS 970-1955 INDEX 530 M 40
 AS PER BS 970 PART 1: 1983

OR

STEEL GRADE EN 19 BS 970-1955 INDEX 709 M 40
 AS PER BS 970 PART 1: 1983

OR

STEEL GRADE EN 19 A BS 970-1955 INDEX 706
 AS PER BS 970 PART 1: 1983

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE: 17.11.2020

Design & Drawing Office,
 Ordnance Factory,
 Tiruchirappalli-620016

MATERIAL:- STEEL 50 PA : OST 3-98-80,
 ALTERNATE MATERIAL :- STEEL 40X-a OST3-98-80, OR GOST 4543-71

COMPONENT DRG. NO. 1-4
 CHAMBER GAS.

UN CONTROLLED COPY

HEAT-TREATMENT-FORGINGS ARE NORMALIZED.
 FOR HEAT-TREATMENT SCHEDULE REFER DRAWING
 NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 4. SL.NO: 2.

DRAWING PROVISIONAL DS.CAT NO. 1005007188

D	004/201-9-17. Mult. Annotat.	
C	ALTERNATE MATL. 'EN' SERIES ADDED.	<i>[Signature]</i>
B	BI-LATERAL TOLERANCE DELETED & UNI-LATERAL TOLERANCE ADOPTED DRAWING NO. TEND 564 DELETED AND RE-NUMBERED AS 62 C 1004 200 B3 ALTERNATE MATERIAL ADDED. DRAWING UPDATED.	<i>[Signature]</i>
AMENDMENTS	DESCRIPTION / DETAILS	SIG & DATE

For Vetting, I.D. Jines Forging Die AL.No. 175, Day Month Year

<i>[Signature]</i> REDRAWN	<i>[Signature]</i> CHECKED	11/87 APPROVED	<i>[Signature]</i> I/C. D&DO	<i>[Signature]</i> D/W OFFICER	ORDNANCE FACTORY, TIRUCHIRAPALLI-16.	DRG. NO.: 62 C 1004 200 D 3
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1 2 3 4 5 6 7 8