



COMPONENT IS TO BE MANUFACTURED OF STEEL 32X06/J172.TY4
MAY BE MANUFACTURED OF STEEL 32X06H/J172.TY4
CASTING SHOULD BE COMPLIANCE WITH GENERAL PART OF STEEL CASTING SPECIFICATION 172.TY4
IN THIS CASE THE FOLLOWING ARE ALLOWED.

1. DRAFT ANGLE IS UP TO 3°
2. UNSPECIFIED CASTING RADII UP TO 6mm.
3. FOR TOLERANCE ON CASTING DIMENSIONS TABLE No.3 & 4 OF SPECIFICATION No. GOST 2009-55 AS PER ACCURACY CLASS III

HB 255-217 (DIAMETER OF INDENTATION 3.8 TO 4.1)
THE COMPONENT MAY BE STRAIGHTENED IN COLD CONDITION.

RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS-LEVEL-5.
SHRINKAGE (ALL TYPES) LEVEL 3
ALSO REFER CQA(MET) ICHAPUR INSTRUCTION No. MQA-1/QA-1/12 DT.05/05/94 FOR OTHER DETAILS.

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE
17.11.2020
Designed & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY

DIMENSIONS ARE IN mm.
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

3MM, 5MM HOLEZ USE WER ADDED

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
TRACED	SIGNATURE & DATE.	SUB: CASTING			SCALE NTS
DRAWN		FOR: CRADLE			STORE DRG.NO.
CHECKED		OF: TRIPOD MOUNT ASSY.			OPERATION NO.
HOS/D&DO		DES. REF. NO.			
OFFICER/PRODN.		DRG. No.: 62C 9616 250 A3			SHEETS: 01
OFFICER/D&DO		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			SHEET No.: 01
AMENDS. & DATE	SIG. & DATE	APPROVED ON :			