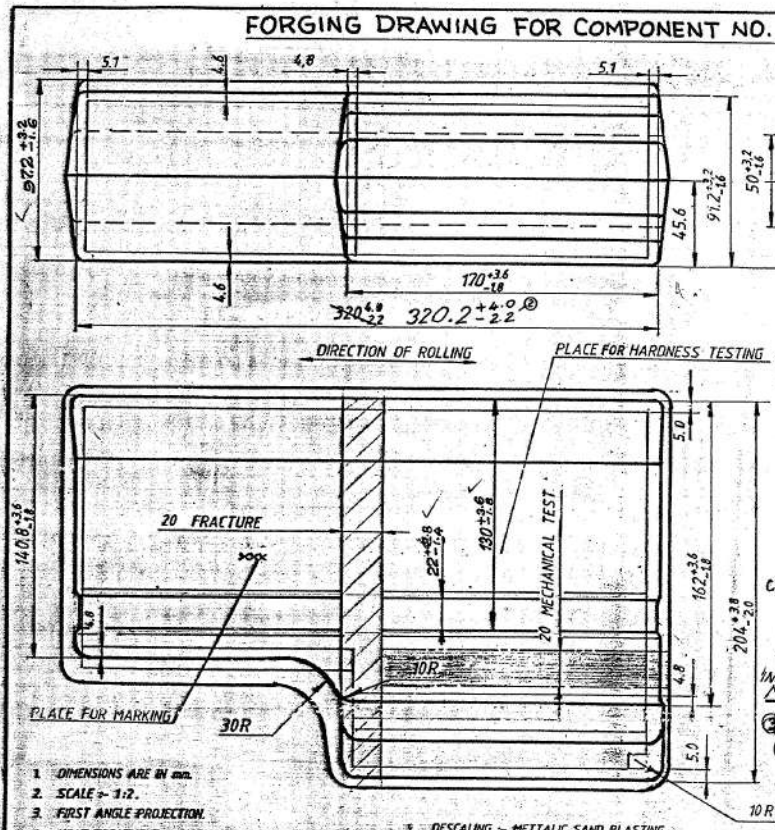
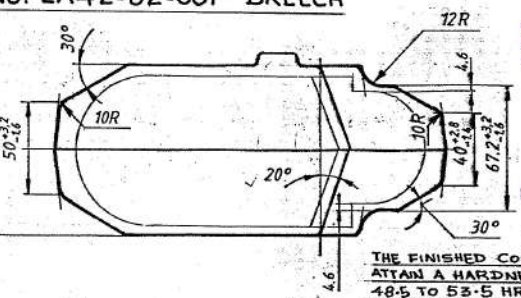
FORGING DRAWING FOR COMPONENT NO. 2A42-02-001 - BREECH





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

UN CONTROLLED COPY

(3) THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF 48.5 TO 53.5 HRC AFTER FINAL HEAT TREATMENT

(4) INDIGENOUS MATERIAL: BS 970 Pt 1 83 Gde 826 M40 WITH Si 0.010 Max, P 0.015 Max. ESR QUALITY. THE MATERIAL SHOULD ACHIEVE THE FOLLOWING MECHANICAL PROPERTIES:-

Rm	: 1763 MPa ~~MAX~~ MIN.
Re	: 1420 MPa ~~MAX~~ MIN. (5)
E%	: 10 Min

CHARPY IMPACT (U NOTCH) : 6 Kgm/Cm² Min.
MACROSTRUCTURE SHALL BE BETTER THAN OR EQUIVALENT TO C, R, S1 FOR PLATE I AND NIL FOR PLATE II TO SPECN IS 3015, NMIR 1-5 THIN SERIES, MAX. FOR A B C D AND NIL FOR THICK SERIES TO IS 4163, FIG.2
~~AUTHORITY : C&A(METALS) ICHAPUR LY.NO. MQA-3/TS/B/1, DATED 6/11-6-1997~~
AUTHORITY : C&A (METALS) ICHAPUR LY. No. MQA-3/GENL. DATED 26.06.2008

VETTED FOR MATERIAL ONLY
AS PER LAST DC (I) NO
C&A(MET) Ly.No. MQA-3/GENL DT 26.06.2008.
30/10/2008
C.RAJASEKAR
Sr. Scientific Officer II
Asst. Quality Assurance Officer
Dy. Quality Assurance Estt (Armaments)
TIRUCHIRAPALLI - 620016.
FOR SQAO
SQAE (A) TRICHY

INDIGENOUS MATL:- STEEL GRADE 826 - M40 TO BS970 PART 1 1983 CONO. '2' WITH S & P CONTENT 0.010 & 0.015 MAX. RESPECTIVELY (ESR QUALITY STEEL) (3) (4)

F (5)	DA.No. 01/08	Dt. 28.4.08	29/4
E (4)	DA.No. 048/97	Dt. 718/97	1/8/97

16. ~~REMAINING TECHNICAL REQUIREMENTS AND NG FOR~~
17. Forging corresponds to the first accuracy class, sophistication degree III as per GOST 7505-74

(MRV JAGADISH)
Sr. Scientific Officer
Sr. Quality Assurance Estt (Armts)
Tiruchirapalli-620016

VETTED FOR MATERIAL ONLY
AS PER LAST DC (I) No. LETTER NO. MQA-3/TS/B/1 dt. 6/11-6-97

1. DIMENSIONS ARE IN mm.
2. SCALE :- 1:2.
3. FIRST ANGLE PROJECTION.
4. HEAT-TREATMENT :- NORMALIZING WITH HIGH TEMPERING ; HARDNESS HB 302 MAX.
5. SURFACE DEFECTS SHOULD NOT BE EXCEED 0.5 mm OF ACTUAL ONE SIDED ALLOWANCE FOR MACHINING.
6. DRAFT ANGLE 7°.
7. NON-SPECIFIED RADII 5 mm
8. ALLOWED BURR SIZE ALONG DIE PARTING LINE SHOULD NOT EXCEED 2.2 mm.
9. DESCALING :- METTALIC SAND BLASTING
10. MIS-ALIGMENT OF DIE PARTG LINE SHOULD NOT EXCEED 14 mm.
11. ALLOWED CURVATURE DEVIATION SHOULD NOT EXCEED 15 mm
12. WEIGHT OF THE FORGING 38.20 Kgs
13. RAW MATERIAL SIZE :- (140 Sq) x 300 LONG (HOT ROLLED)
14. MATERIAL :- 35KH2M@A-V : OST 3-98-90.
15. EARGEN:- MANUFACTURER'S INITIALS, YEAR OF MANUFACTURE AND ORDER NO TO BE STAMPED ON CHAMFERED 3/32 6mm X 05mm DEEP AT PLATE MARKED

140 Ø Round bar acceptable 01/08/08

Updated	DA.No. 22/97	dt. 23-5-97	
D (5)	DA.NO 68/96	Dt. 30-7-96	
C (4)	DA.NO 80/92, Dt. 28-10-92, SIM. 3270-273 & WAR 32012.		
(1)	STORE DRG. NO ADDED		
B	FORGING DESIGN: MODIFIED		
AMENDMENTS	DESCRIPTIONS/DETAILS		DATE

Sahni 6/4/90	Sethumadhavan 6-1-1990	1-90		8/1/1990	ORDNANCE FACTORY TIRUCHIRAPALLI-16	DRG NO: 64 C 2001 200 E3 F3
DRAWN	CHECKED	APPROVED	F/M. PROJ	WM/PROJ.		

AIB NO. 947, SHT. 19.